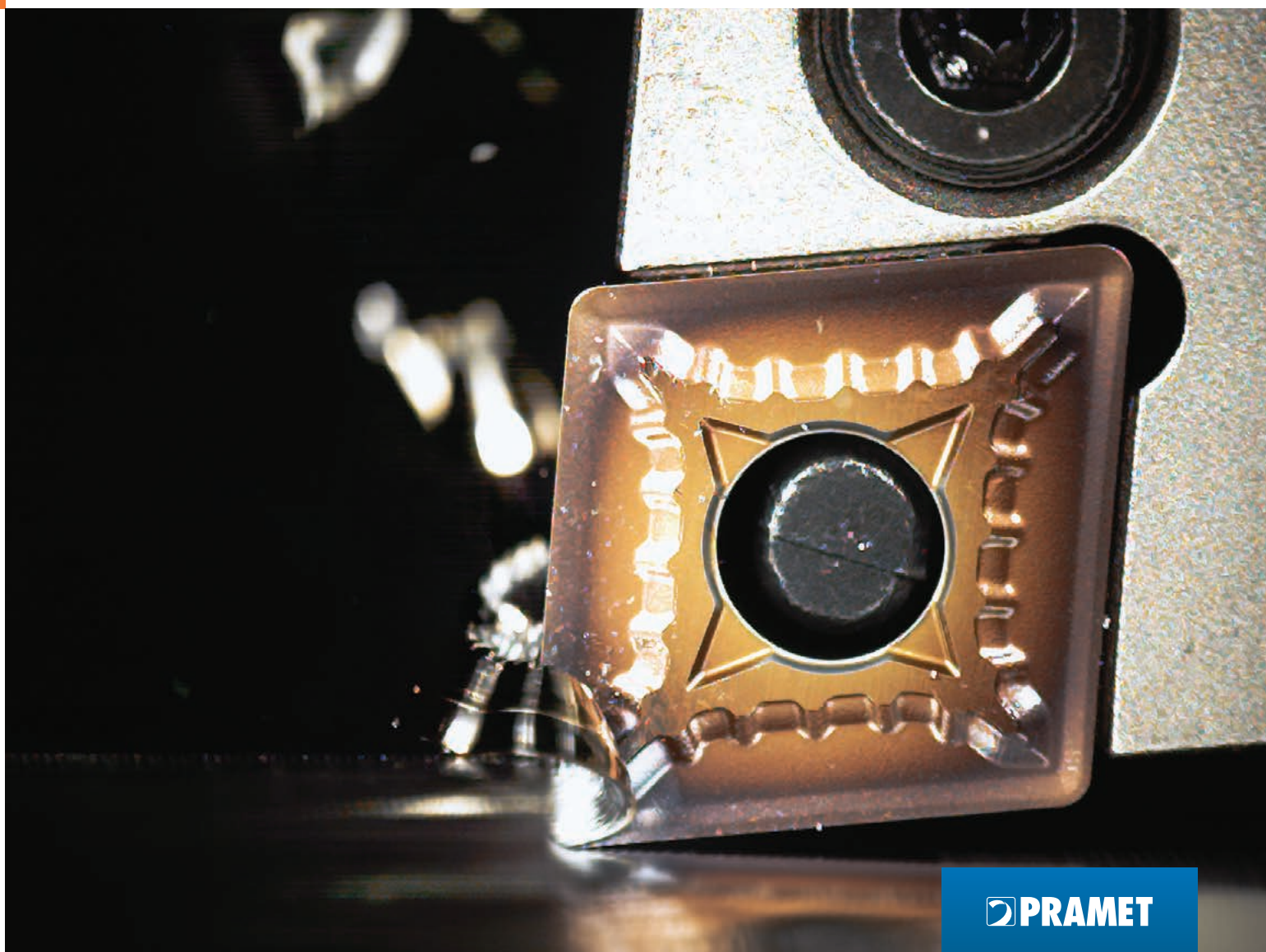
DORMER PRAMET

TURNING

2024



PRAMET

ISO TURNING

Positive inserts

		P	M	K	N	S	H	
	Chip-breakers navigators							6
FF	Fine-finishing	FF2 SF3 J.	SF3 NF1	FF2	AL SF3	SF3 SF2		13
F	Finishing	FM UR W	NF2 FM	UR FM	AL	NF2	.CMW	33
M	Medium	FM2	SI	RF	AL		.CMW	49
R	Roughing	RM	RM	RM RM3	AL			61
HR	Heavy roughing	OR DR4	OR					67
TOOLS	by insert shape	CC DC EC/EP RC SC TC VB VC WC						69
TOOLS	by clamping style	External: S P DKH / KHP		Internal: S		PSC: S		172

Negative inserts

		P	M	K	N	S	H	
	Chip-breakers navigators							180
FF	Fine-finishing	NF FF	NF	FF		SF	SF	187
F	Finishing	FM W	SF	FM		SF	.NMA	195
M	Medium	SM M SI	NMR NM	M	SF	SM	.NMA	207
R	Roughing	RM R	NRM	KR R	SF	NRM		235
HR	Heavy roughing	OR HR	NR2 923	HR2		NR2		251
TOOLS	by insert shape	CN DN KN LN RN SN TN VN WN						262
TOOLS	by clamping style	External: P D M DKH / KHP		Internal: P D		PSC: D		369

Other carbide & cermet inserts			375
Advanced materials inserts	CER (ISO-K)	PCD (ISO-N)	CBN (ISO-H)	389

GROOVING & PARTING-OFF

External grooving and parting-off	GL	LCMF	405
Blades and modular blades	GL	LFMX LFUX	441
Face grooving	GL	LFMX	463
Internal grooving	GL	LCMF 13	473
O-ring and circlips grooving		X61	483

THREAD TURNING	Threading inserts and tools	491
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INSTRUCTIONS	How to read catalogue data? (ISO 13399, icons, navigation…)	538
	Grades navigator and detail description	558
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	Workpiece material groups (WMG)	576

PRODUCT FAMILY	
C	
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C.-DDJN(RL) EXT	299
C.-DDNNN EXT	300
C.-DDUN(RL) EXT	301
C.-DDUN(RL) INT	305
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C.-DSDNN EXT	331
C.-DSKN(RL) EXT	332
C.-DSRN(RL) EXT	333
C.-DSSN(RL) EXT	334
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C.-SDNCN EXT	101
C.-SDUC(RL) INT	111
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SELP(RL) INT	114
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SVJC(RL)-DC EXT	163
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SNMG	216
TNMG	216
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CNMG	189
DNMG	189
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TNMG	190
VNMG	191
WNMG	191
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CCGT	24
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TCGT	24
SCGT	24
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SNMG	229
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WNMG	230
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CNMG	223
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SNMG	224
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VNMG	225
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NR2	255
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SNMM	257
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CCMT	63
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SNMG	239
TNMG	240
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TCMT	66
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TNMG	202
VNMG	202
WNMG	203
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VCGT	25
SF3	19
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DCGT	20
ECGT	21
SCGT	21
TCGT	21
VCGT	22
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CCGT	55
DCGT	55
TCGT	55
SI	218
CNMG	219
DNMG	219
TNMG	220
WNMG	221
SM	208
CNMG	209
DNMG	209
SNMG	210
TNMG	211
VNMG	211
WNMG	212
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DNMG	205
WNMG	205

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TN TR INT	514
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TN TR-S INT	512
TN UN EXT	503
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TN W EXT	507
TN W EXT -P1	497
TN W INT	508
TN W INT -P1	497
TPGN CER	395
TPMR	384
TPUN-IT	387
V	
VBGW CBN	400
VCMW PCD	397
VNGA CBN	401
VNGA CER	396
W	
WNGA CBN	401
X	
X 61	486
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X 61 R	487
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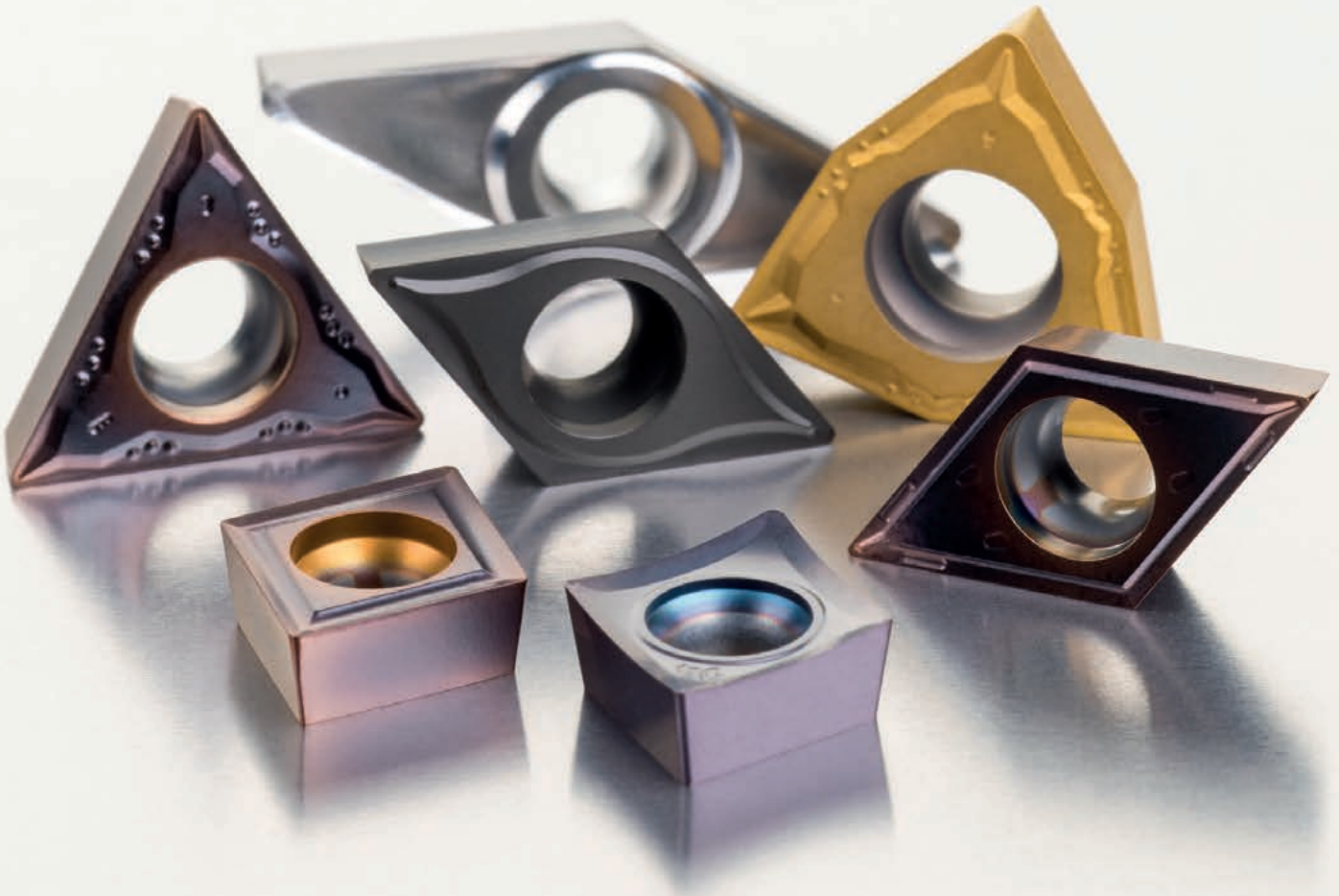


POSITIVE INSERTS

P

Very unstable working conditions

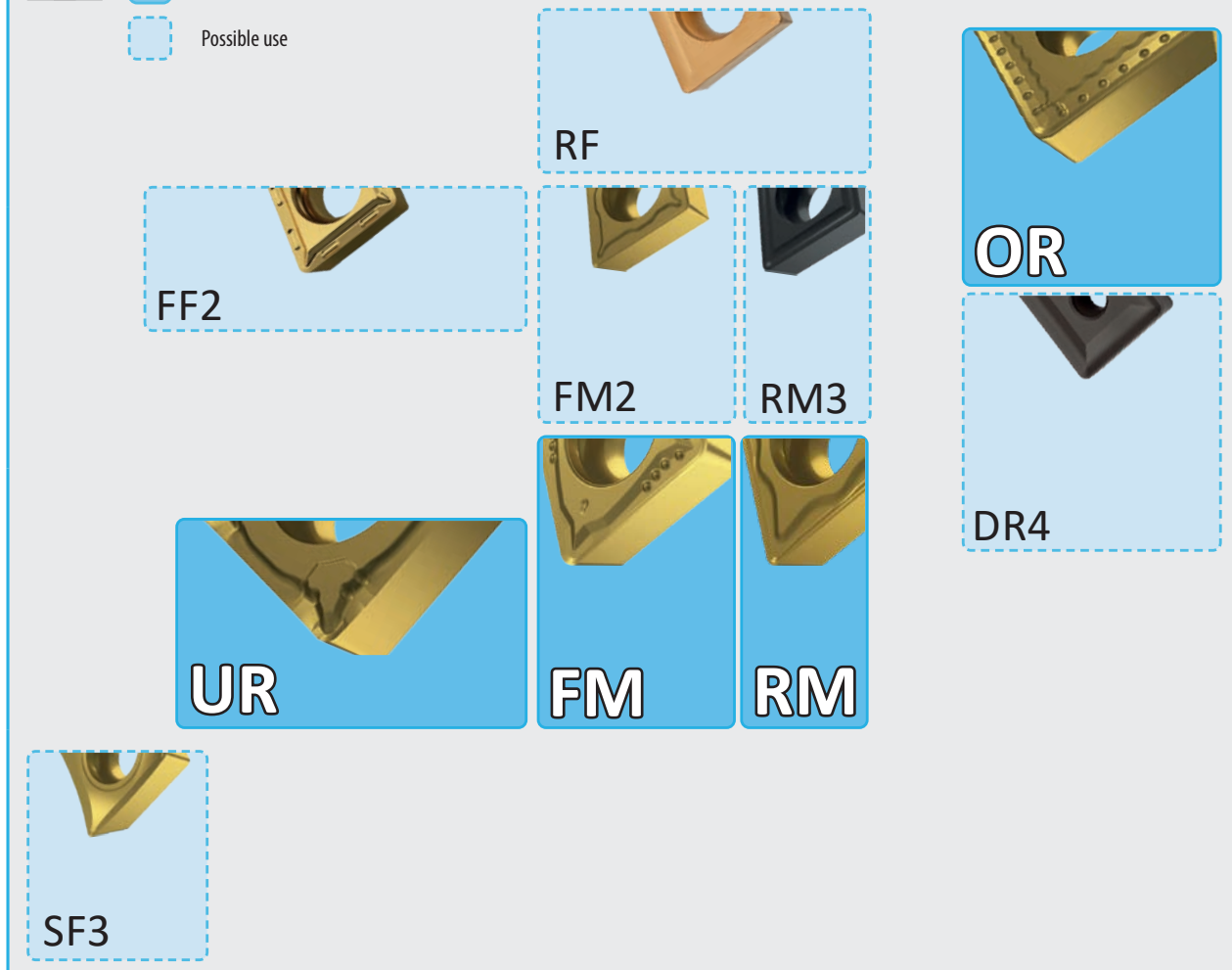
Unstable working conditions

Stable working conditions

Thin -walled and slim workpieces

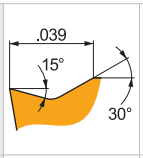
1st choice

Possible use



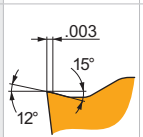
	FF	F	M	R	HR
f	.001 – .007 in/rev	.001 – .007 in/rev	.007 – .015 in/rev	.015 – .039 in/rev	> .039 in/rev
a_p	.001 – .078 in	.001 – .078 in	.078 – .157 in	.157– .393 in	> .393in

UR



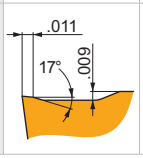
Designed for fine to finish machining, steels and cast irons and potentially stainless steel, continuous and interrupted cuts

FM



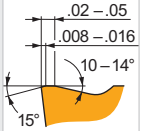
Designed for finish to semi-rough machining, steels and stainless steels, potentially cast irons and non ferrous materials, continuous and moderately interrupted cuts

RM



Designed for semi-rough machining, steels, stainless steels and cast irons, potentially super alloys and hardened materials, continuous and interrupted cuts

OR



Designed for rough and heavy rough machining, steels, stainless steels and cast irons, potentially super alloys. continuous and interrupted cuts

M

Very unstable working conditions

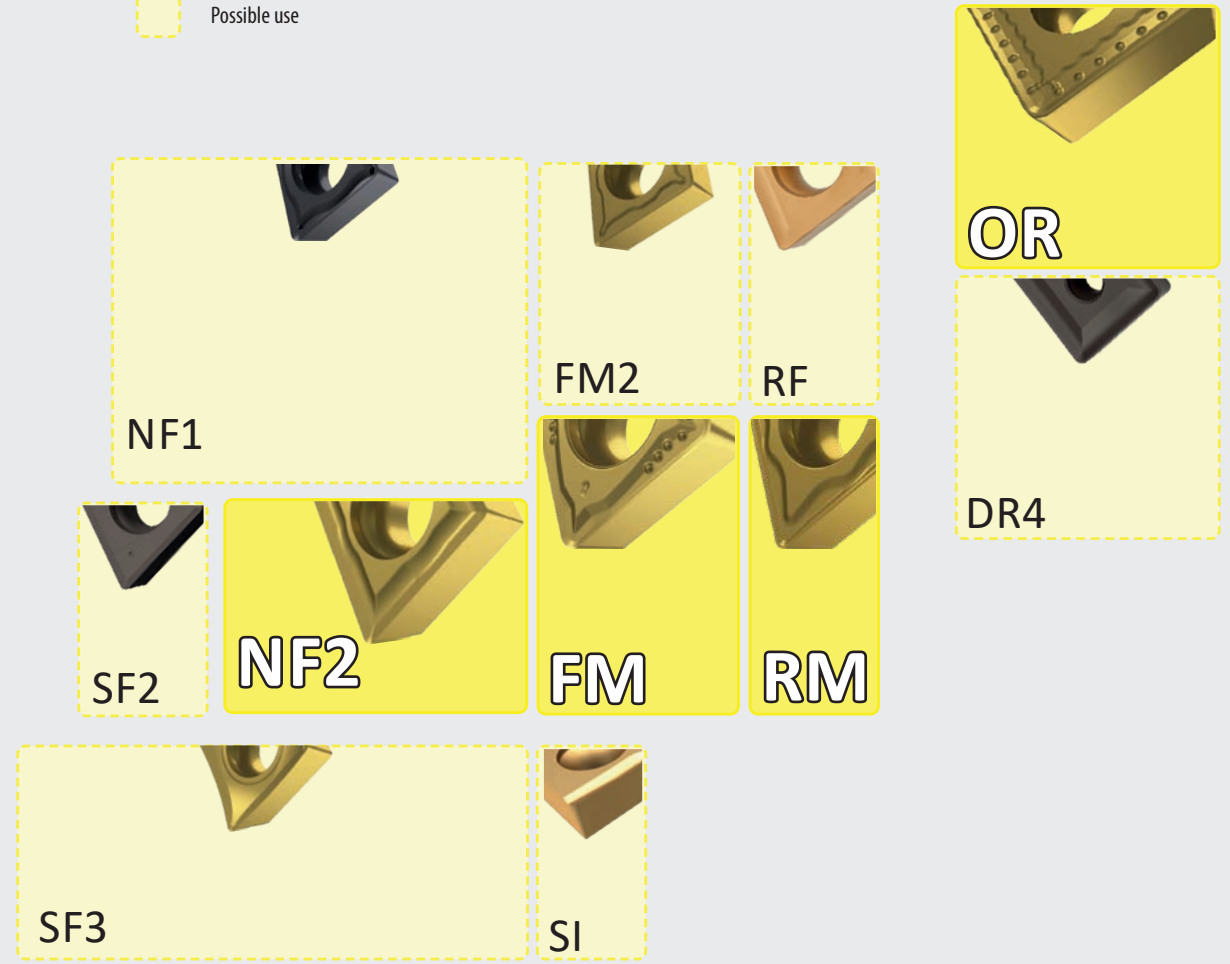
Unstable working conditions

Stable working conditions

Thin -walled and slim workpieces

1st choice

Possible use

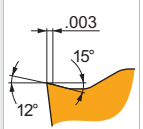


	FF	F	M	R	HR
f	.001 – .007 in/rev	.001 – .007 in/rev	.007 – .015 in/rev	.015 – .039 in/rev	> .039 in/rev
a_p	.001 – .078 in	.001 – .078 in	.078 – .157 in	.157– .393 in	> .393in

NF2

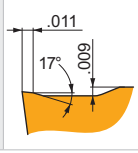
Positive design for fine-finish to semi rough machining, stainless steels and super alloys, continuous cuts

FM



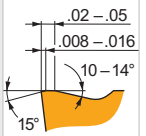
Designed for finish to semi-rough machining, steels and stainless steels, potentially cast irons and non ferrous materials, continuous and moderately interrupted cuts

RM



Designed for semi-rough machining, steels, stainless steels and cast irons, potentially super alloys and hardened materials, continuous and interrupted cuts

OR



Designed for rough and heavy rough machining, steels, stainless steels and cast irons, potentially super alloys. continuous and interrupted cuts

K

Very unstable working conditions

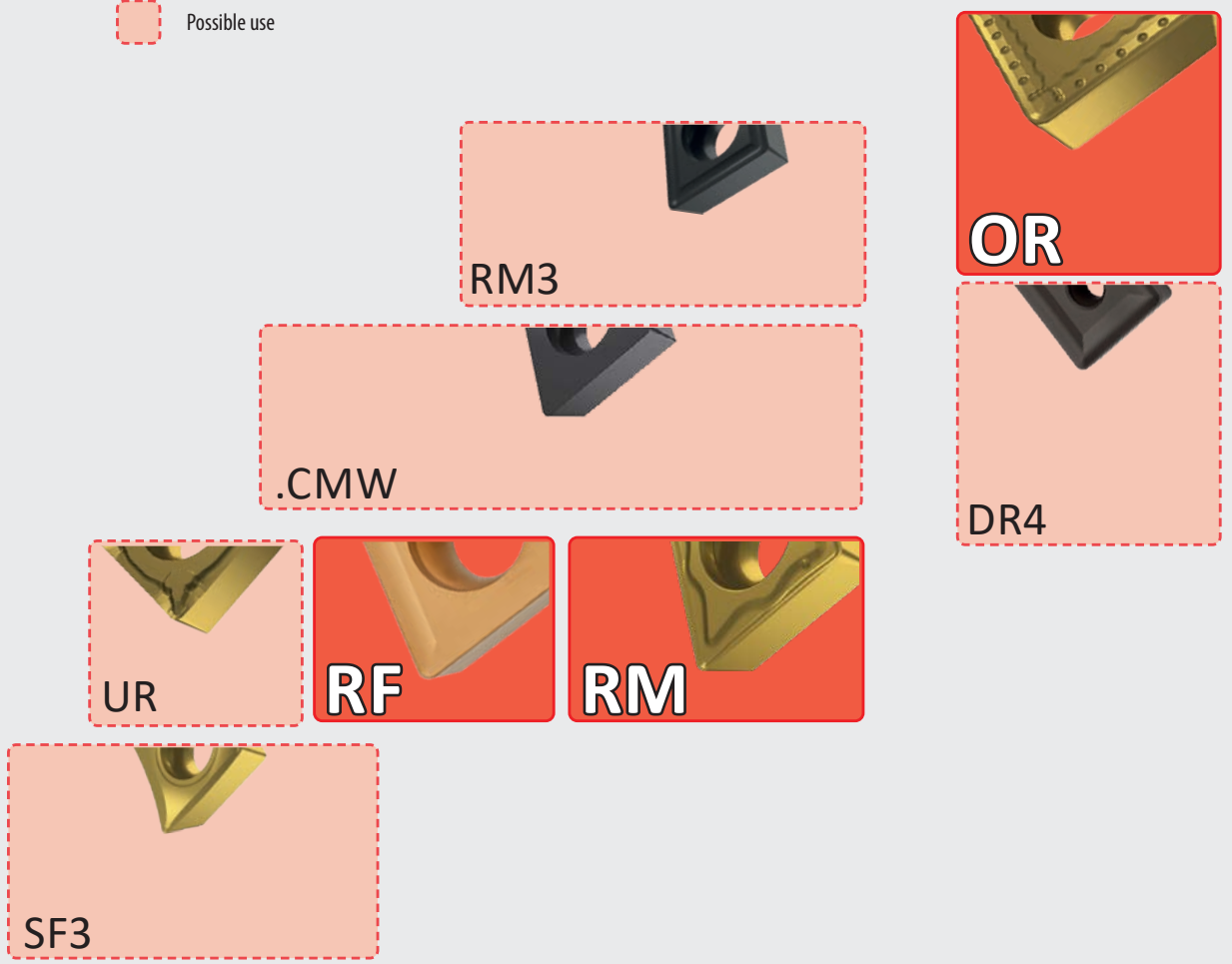
Unstable working conditions

Stable working conditions

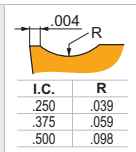
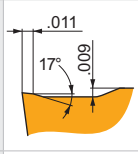
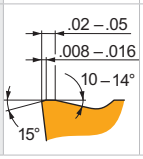
Thin -walled and slim workpieces

1st choice

Possible use



	FF	F	M	R	HR
f	.001 – .007 in/rev	.001 – .007 in/rev	.007 – .015 in/rev	.015 – .039 in/rev	> .039 in/rev
a_p	.001 – .078 in	.001 – .078 in	.078 – .157 in	.157– .393 in	> .393in

RF		Designed for rough machining, cast irons, potentially steels, stainless steels and hard materials, continuous and interrupted cuts
RM		Designed for semi-rough machining, steels, stainless steels and cast irons, potentially super alloys and hardened materials, continuous and interrupted cuts
OR		Designed for rough and heavy rough machining, steels, stainless steels and cast irons, potentially super alloys. continuous and interrupted cuts

N

Very unstable working conditions

Unstable working conditions

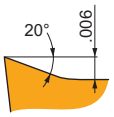
Stable working conditions

Thin -walled and slim workpieces

1st choice

Possible use

	FF	F	M	R	HR
f	.001 – .007 in/rev	.001 – .007 in/rev	.007 – .015 in/rev	.015 – .039 in/rev	> .039 in/rev
a_p	.001 – .078 in	.001 – .078 in	.078 – .157 in	.157– .393 in	> .393in

SF3		Very positive design for fine and finish machining, super alloys, stainless steels and non ferrous materials, potentially steel, cast irons and hard materials, continuous cuts
AL		Highly positive design for fine finish to rough machining, aluminium, aluminium alloys and other non ferrous materials, potentially super alloys, continuous cuts

S

Very unstable working conditions

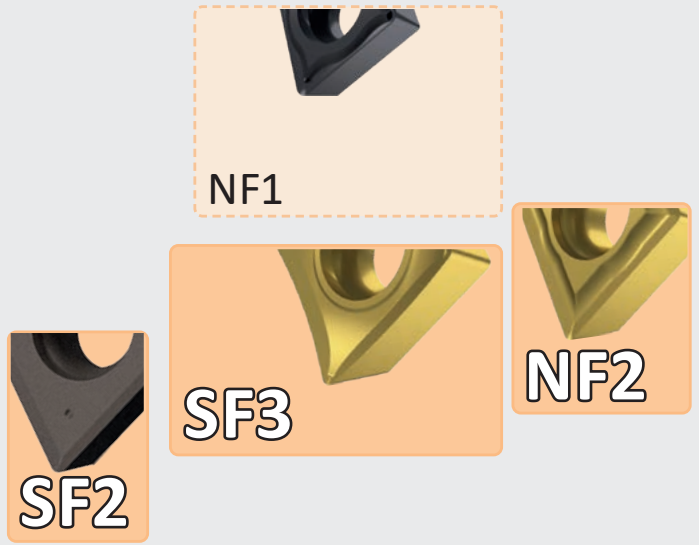
Unstable working conditions

Stable working conditions

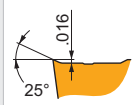
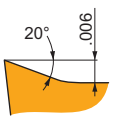
Thin -walled and slim workpieces

1st choice

Possible use



	FF	F	M	R	HR
f	.001 – .007 in/rev	.001 – .007 in/rev	.007 – .015 in/rev	.015 – .039 in/rev	> .039 in/rev
a_p	.001 – .078 in	.001 – .078 in	.078 – .157 in	.157– .393 in	> .393in

SF2		Very positive design for fine and finish machining, super alloys, potentially stainless steels, steels and non ferrous materials, continuous cuts
SF3		Very positive design for fine and finish machining, super alloys, stainless steels and non ferrous materials, potentially steel, cast irons and hard materials, continuous cuts
NF2		Positive design for fine-finish to semi rough machining, stainless steels and super alloys, continuous cuts

H

Very unstable working conditions

Unstable working conditions

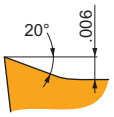
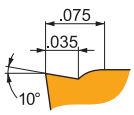
Stable working conditions

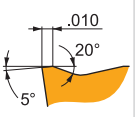
Thin -walled and slim workpieces

1st choice

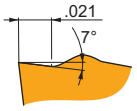
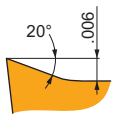
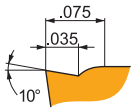
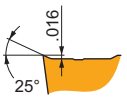
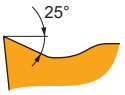
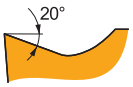
Possible use

	FF	F	M	R	HR
f ⇨	.001 – .007 in/rev	.001 – .007 in/rev	.007 – .015 in/rev	.015 – .039 in/rev	> .039 in/rev
a_p	.001 – .078 in	.001 – .078 in	.078 – .157 in	.157– .393 in	> .393in

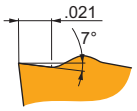
SF3		Very positive design for fine and finish machining, super alloys,stainless steels and non ferrous materials, potentially steel, cast irons and hard materials, continuous cuts
NF1		Positive design for fine-finish to medium machining, stainless steels and super alloys, potentially steels, non ferrous and hard materials, continuous cuts
.CMW		Designed for fine finish to semi rough machining, cast irons, potentially hard materials, continuous and slightly interrupted cuts

RM3		Designed for rough machining, cast irons, potentially steels, stainless steels and hard materials, continuous and interrupted cuts

FINE-FINISHING – NAVIGATOR

FF2			**FF2** chip breaker is sharp and the first choice for fine-finishing of Steels. It features slightly positive rake angle without T-land. It's also suitable for Cast irons.
SF3			**SF3** chip breaker is sharp and the first choice for fine-finishing of Stainless steels and Super-alloys. It features highly positive rake angle without T-land. It's also suitable for Non-ferrous alloys, and conditionally for Steels, Cast irons and Hard materials.
NF1			**NF1** chip breaker is sharp and designed for fine-finishing of Steels, Stainless steels and Super-alloys. It features positive rake angle without T-land. It's also conditionally suitable for Non-ferrous alloys and Hard materials.
SF2			**SF2** chip breaker is sharp and designed for fine-finishing of Stainless steels and Super-alloys. It features highly positive rake angle without T-land. It's also conditionally suitable for Steels and Non-ferrous alloys.
AL			**AL** chip breaker is sharp and the first choice for all-around machining of Non-ferrous alloys. It features highly positive rake angle without T-land. It's also conditionally suitable for Super-alloys.
JQ JR JZ			**JQ** chip breaker is sharp and designed for fine-finishing of Steels. It features highly positive rake angle without T-land. It's also conditionally suitable for Stainless steels.

FF2

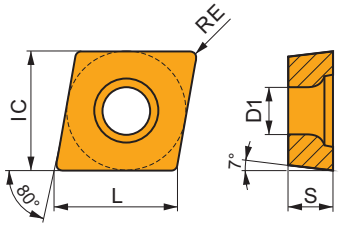


FF2 chip breaker is sharp and the first choice for fine-finishing of Steels. It features slightly positive rake angle without T-land. It's also suitable for Cast irons.

PRAMET

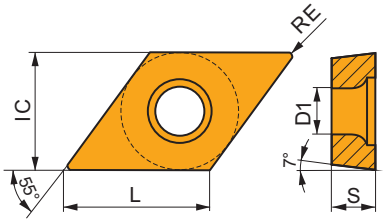
CCGT / CCMT

	IC (inch)	D1 (inch)	L (inch)	S (inch)
2.52	.313	.134	.319	.125
21.5	.250	.110	.252	.094
32.5	.375	.173	.382	.156



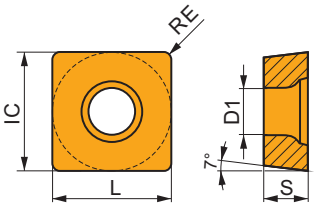
DCGT / DCMT

	IC (inch)	D1 (inch)	L (inch)	S (inch)
21.5	.250	.110	.307	.094
32.5	.375	.173	.457	.156



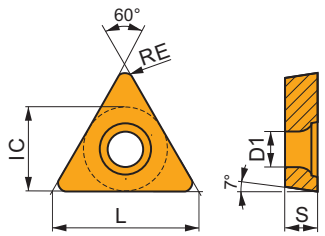
SCMT

	IC (inch)	D1 (inch)	L (inch)	S (inch)
32.5	.375	.173	.375	.156



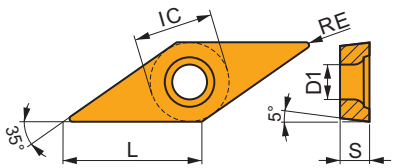
TCGT / TCMT

	IC (inch)	D1 (inch)	L (inch)	S (inch)
1.21.2	.156	.087	.272	.078
1.81.5	.219	.098	.378	.094
21.5	.250	.110	.433	.094
32.5	.375	.173	.650	.156



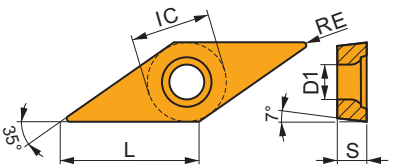
VBMT

	IC (inch)	D1 (inch)	L (inch)	S (inch)
33	.375	.173	.654	.187



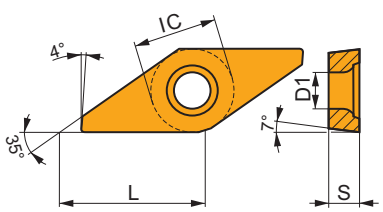
VCGT

	IC (inch)	D1 (inch)	L (inch)	S (inch)
1.21.5	.156	.087	.272	.094
2.52	.313	.134	.543	.125



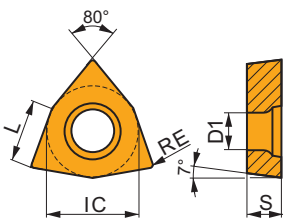
VCGX

	IC (inch)	D1 (inch)	L (inch)	S (inch)
2.52	.313	.134	.543	.125

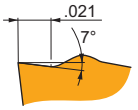
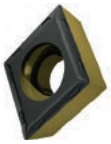
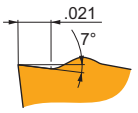
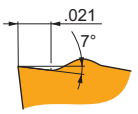


WCGT

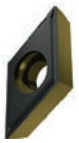
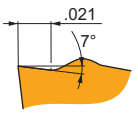
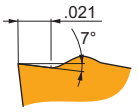
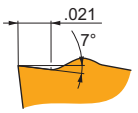
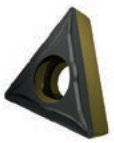
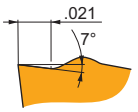
	IC (inch)	D1 (inch)	L (inch)	S (inch)
1.21	.156	.087	.106	.063



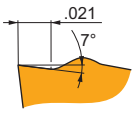
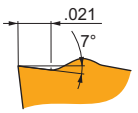
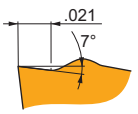
Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our cutting conditions app for further options.

Product		RE	P			M			K			N			S			H			MID
			vc (ft/min)	f (in/rev)	ap (inch)	vc (ft/min)	f (in/rev)	ap (inch)	vc (ft/min)	f (in/rev)	ap (inch)	vc (ft/min)	f (in/rev)	ap (inch)	vc (ft/min)	f (in/rev)	ap (inch)	vc (ft/min)	f (in/rev)	ap (inch)	
			**FF2** chip breaker is sharp and the first choice for fine-finishing of Steels. It features slightly positive rake angle without T-land. It's also suitable for Cast irons.																		
CCGT 32.50.5-FF2	**T9325**	.008	1132	.002	.039	–	–	–	1066	.002	.039	–	–	–	–	–	–	–	–	–	7156679
			**FF2** chip breaker is sharp and the first choice for fine-finishing of Steels. It features slightly positive rake angle without T-land. It's also suitable for Cast irons.																		
CCMT 2.520.5-FF2	**T8430**	.008	919	.002	.031	–	–	–	755	.002	.031	–	–	–	–	–	–	–	–	–	7977190
	T9325	.008	1148	.002	.031	–	–	–	1083	.002	.031	–	–	–	–	–	–	–	–	–	6755932
CCMT 2.521-FF2	**T8430**	.016	673	.0047	.039	–	–	–	558	.0047	.039	–	–	–	–	–	–	–	–	–	7977191
	T9325	.016	837	.0047	.039	–	–	–	787	.0047	.039	–	–	–	–	–	–	–	–	–	6755933
	TT010	.016	1148	.0024	.02	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	6756301
CCMT 2.522-FF2	**T8430**	.031	689	.0067	.039	–	–	–	574	.0067	.039	–	–	–	–	–	–	–	–	–	7977193
	T9325	.031	853	.0067	.039	–	–	–	804	.0067	.039	–	–	–	–	–	–	–	–	–	7156715
CCMT 21.50.5-FF2	**T8430**	.008	919	.002	.031	–	–	–	755	.002	.031	–	–	–	–	–	–	–	–	–	7977185
	T9325	.008	1148	.002	.031	–	–	–	1083	.002	.031	–	–	–	–	–	–	–	–	–	7156703
	T9415	.008	1296	.002	.031	–	–	–	1230	.002	.031	–	–	–	–	–	–	–	–	–	8345914
	TT010	.008	1132	.002	.02	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	7080612
CCMT 21.51-FF2	**T7325**	.016	623	.0047	.039	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	7156704
	T8430	.016	673	.0047	.039	–	–	–	558	.0047	.039	–	–	–	–	–	–	–	–	–	7977187
	T9325	.016	837	.0047	.039	–	–	–	787	.0047	.039	–	–	–	–	–	–	–	–	–	7156707
	T9335	.016	705	.0047	.039	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	7156708
	T9415	.016	1001	.0047	.039	–	–	–	935	.0047	.039	–	–	–	–	–	–	–	–	–	8345917
	TT010	.016	919	.0047	.02	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	7080613
CCMT 32.51-FF2	**T8430**	.016	656	.0047	.047	–	–	–	541	.0047	.047	–	–	–	–	–	–	–	–	–	7977196
	T9325	.016	820	.0047	.047	–	–	–	771	.0047	.047	–	–	–	–	–	–	–	–	–	7156719
	T9335	.016	705	.0047	.047	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	7156720
	T9415	.016	984	.0047	.047	–	–	–	935	.0047	.047	–	–	–	–	–	–	–	–	–	8345887
	TT010	.016	1148	.0024	.02	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	7080610
CCMT 32.52-FF2	**T8430**	.031	673	.0067	.047	–	–	–	558	.0067	.047	–	–	–	–	–	–	–	–	–	7977200
	T9325	.031	837	.0067	.047	–	–	–	787	.0067	.047	–	–	–	–	–	–	–	–	–	7156724
	T9415	.031	984	.0079	.047	–	–	–	935	.0079	.047	–	–	–	–	–	–	–	–	–	8345911
	TT010	.031	1148	.0039	.031	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	7080611
			**FF2** chip breaker is sharp and the first choice for fine-finishing of Steels. It features slightly positive rake angle without T-land. It's also suitable for Cast irons.																		
DCGT 32.50.5-FF2	**T8430**	.008	738	.002	.031	–	–	–	607	.002	.031	–	–	–	–	–	–	–	–	–	7977206
	T9325	.008	919	.002	.031	–	–	–	869	.002	.031	–	–	–	–	–	–	–	–	–	7156727
	TT010	.008	902	.002	.02	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	7080623

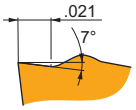
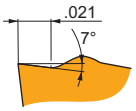
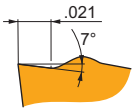
Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our cutting conditions app for further options.

Product		RE (inch)	P vc (ft/min)	P f (in/rev)	P ap (inch)	M vc (ft/min)	M f (in/rev)	M ap (inch)	K vc (ft/min)	K f (in/rev)	K ap (inch)	N vc (ft/min)	N f (in/rev)	N ap (inch)	S vc (ft/min)	S f (in/rev)	S ap (inch)	H vc (ft/min)	H f (in/rev)	H ap (inch)	MID
																					
FF2 chip breaker is sharp and the first choice for fine-finishing of Steels. It features slightly positive rake angle without T-land. It's also suitable for Cast irons.																					
DCMT 21.50.5-FF2	**T8430**	.008	738	.002	.031	–	–	–	607	.002	.031	–	–	–	–	–	–	–	–	–	7977211
	T9325	.008	919	.002	.031	–	–	–	869	.002	.031	–	–	–	–	–	–	–	–	–	7156730
	TT010	.008	902	.002	.02	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	7080626
DCMT 21.51-FF2	**T8430**	.016	558	.0047	.031	–	–	–	443	.0047	.031	–	–	–	–	–	–	–	–	–	7977213
	T9325	.016	673	.0047	.031	–	–	–	623	.0047	.031	–	–	–	–	–	–	–	–	–	7156734
	T9415	.016	820	.0047	.031	–	–	–	771	.0047	.031	–	–	–	–	–	–	–	–	–	8345939
DCMT 21.52-FF2	**T7325**	.031	558	.0067	.031	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	7156735
	T8430	.031	574	.0067	.031	–	–	–	459	.0067	.031	–	–	–	–	–	–	–	–	–	7977215
	T9325	.031	705	.0067	.031	–	–	–	656	.0067	.031	–	–	–	–	–	–	–	–	–	7156738
	T9415	.031	869	.0067	.031	–	–	–	820	.0067	.031	–	–	–	–	–	–	–	–	–	8345942
DCMT 32.51-FF2	**T7325**	.016	525	.0047	.031	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	7156739
	T8430	.016	558	.0047	.031	–	–	–	443	.0047	.031	–	–	–	–	–	–	–	–	–	7977217
	T9325	.016	673	.0047	.031	–	–	–	623	.0047	.031	–	–	–	–	–	–	–	–	–	7156742
	T9415	.016	820	.0047	.031	–	–	–	771	.0047	.031	–	–	–	–	–	–	–	–	–	8345932
	TT010	.016	919	.0024	.02	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	7080624
DCMT 32.52-FF2	**T7325**	.031	558	.0067	.031	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	7156744
	T8430	.031	574	.0067	.031	–	–	–	459	.0067	.031	–	–	–	–	–	–	–	–	–	7977221
	T9325	.031	705	.0067	.031	–	–	–	656	.0067	.031	–	–	–	–	–	–	–	–	–	7156747
	T9415	.031	869	.0067	.031	–	–	–	820	.0067	.031	–	–	–	–	–	–	–	–	–	8345935
	TT010	.031	919	.0039	.031	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	7080625
																					
FF2 chip breaker is sharp and the first choice for fine-finishing of Steels. It features slightly positive rake angle without T-land. It's also suitable for Cast irons.																					
SCMT 32.51-FF2	**T8430**	.016	689	.0047	.047	–	–	–	574	.0047	.047	–	–	–	–	–	–	–	–	–	7977237
	T9325	.016	853	.0047	.047	–	–	–	804	.0047	.047	–	–	–	–	–	–	–	–	–	7156750
SCMT 32.52-FF2	**T8430**	.031	722	.0067	.047	–	–	–	591	.0067	.047	–	–	–	–	–	–	–	–	–	7977239
	T9325	.031	869	.0067	.047	–	–	–	820	.0067	.047	–	–	–	–	–	–	–	–	–	7156753
																					
FF2 chip breaker is sharp and the first choice for fine-finishing of Steels. It features slightly positive rake angle without T-land. It's also suitable for Cast irons.																					
TCGT 1.21.20.5-FF2	**T8430**	.008	771	.002	.031	–	–	–	623	.002	.031	–	–	–	–	–	–	–	–	–	7977246
	TT010	.008	968	.002	.02	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	7080629
TCGT 1.81.50.5-FF2	**TT010**	.008	968	.002	.02	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	7080630
																					
FF2 chip breaker is sharp and the first choice for fine-finishing of Steels. It features slightly positive rake angle without T-land. It's also suitable for Cast irons.																					
TCMT 1.21.20.5-FF2	**T8430**	.008	771	.002	.031	–	–	–	623	.002	.031	–	–	–	–	–	–	–	–	–	7977250
	T9415	.008	1099	.002	.031	–	–	–	1033	.002	.031	–	–	–	–	–	–	–	–	–	8345966
TCMT 1.21.21-FF2	**T7325**	.016	558	.0047	.031	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	7156756
	T8430	.016	591	.0047	.031	–	–	–	476	.0047	.031	–	–	–	–	–	–	–	–	–	7977251
	T9325	.016	722	.0047	.031	–	–	–	673	.0047	.031	–	–	–	–	–	–	–	–	–	6756101
	T9415	.016	869	.0047	.031	–	–	–	820	.0047	.031	–	–	–	–	–	–	–	–	–	8345967
TCMT 1.81.51-FF2	**T5315**	.016	787	.0047	.039	–	–	–	738	.0047	.039	–	–	–	–	–	–	–	–	–	6756144
	T7325	.016	541	.0047	.039	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	7156758
	T8430	.016	574	.0047	.039	–	–	–	459	.0047	.039	–	–	–	–	–	–	–	–	–	7973852
	T9325	.016	705	.0047	.039	–	–	–	656	.0047	.039	–	–	–	–	–	–	–	–	–	6756120
	T9415	.016	853	.0047	.039	–	–	–	804	.0047	.039	–	–	–	–	–	–	–	–	–	8244379

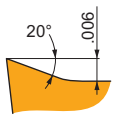
Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our cutting conditions app for further options.

Product		RE	P				M				K				N				S				H				MID
			vc (ft/min)	f (in/rev)	ap (inch)		vc (ft/min)	f (in/rev)	ap (inch)		vc (ft/min)	f (in/rev)	ap (inch)		vc (ft/min)	f (in/rev)	ap (inch)		vc (ft/min)	f (in/rev)	ap (inch)		vc (ft/min)	f (in/rev)	ap (inch)		
			**FF2** chip breaker is sharp and the first choice for fine-finishing of Steels. It features slightly positive rake angle without T-land. It's also suitable for Cast irons.																								
TCMT 21.51-FF2	**T8430**	.016	591	.0047	.031		–	–	–		476	.0047	.031		–	–	–		–	–	–		–	–	–		7973854
	T9325	.016	722	.0047	.031		–	–	–		673	.0047	.031		–	–	–		–	–	–		–	–	–		7156763
	T9335	.016	607	.0047	.031		–	–	–		–	–	–		–	–	–		–	–	–		–	–	–		7156764
	T9415	.016	869	.0047	.031		–	–	–		820	.0047	.031		–	–	–		–	–	–		–	–	–		8345977
TCMT 21.52-FF2	**T8430**	.031	607	.0067	.031		–	–	–		492	.0067	.031		–	–	–		–	–	–		–	–	–		7977252
	T9325	.031	738	.0067	.031		–	–	–		689	.0067	.031		–	–	–		–	–	–		–	–	–		7156768
	T9415	.031	919	.0067	.031		–	–	–		869	.0067	.031		–	–	–		–	–	–		–	–	–		8244381
TCMT 32.51-FF2	**T8430**	.016	591	.0047	.031		–	–	–		476	.0047	.031		–	–	–		–	–	–		–	–	–		7977254
	T9325	.016	722	.0047	.031		–	–	–		673	.0047	.031		–	–	–		–	–	–		–	–	–		7156772
	T9335	.016	607	.0047	.031		–	–	–		–	–	–		–	–	–		–	–	–		–	–	–		7156773
	T9415	.016	869	.0047	.031		–	–	–		820	.0047	.031		–	–	–		–	–	–		–	–	–		8345968
	TT010	.016	968	.0024	.02		–	–	–		–	–	–		–	–	–		–	–	–		–	–	–		7080631
TCMT 32.52-FF2	**T8430**	.031	607	.0067	.031		–	–	–		492	.0067	.031		–	–	–		–	–	–		–	–	–		7977256
	T9325	.031	738	.0067	.031		–	–	–		689	.0067	.031		–	–	–		–	–	–		–	–	–		7156777
	T9415	.031	919	.0067	.031		–	–	–		869	.0067	.031		–	–	–		–	–	–		–	–	–		8345972
			**FF2** chip breaker is sharp and the first choice for fine-finishing of Steels. It features slightly positive rake angle without T-land. It's also suitable for Cast irons.																								
VBMT 331-FF2	**T7325**	.016	476	.0047	.031		–	–	–		–	–	–		–	–	–		–	–	–		–	–	–		7156779
	T8430	.016	492	.0047	.031		–	–	–		410	.0047	.031		–	–	–		–	–	–		–	–	–		7977261
	T9325	.016	623	.0047	.031		–	–	–		591	.0047	.031		–	–	–		–	–	–		–	–	–		7156782
	T9335	.016	525	.0047	.031		–	–	–		–	–	–		–	–	–		–	–	–		–	–	–		7156783
	T9415	.016	755	.0047	.031		–	–	–		705	.0047	.031		–	–	–		–	–	–		–	–	–		8345979
			**FF2** chip breaker is sharp and the first choice for fine-finishing of Steels. It features slightly positive rake angle without T-land. It's also suitable for Cast irons.																								
VCGT 1.21.50.5-FF2	**T8415**	.008	607	.002	.031		–	–	–		541	.002	.031		–	–	–		–	–	–		–	–	–		8553267
	T8430	.008	623	.002	.031		–	–	–		509	.002	.031		–	–	–		–	–	–		–	–	–		7977270
VCGT 1.21.51-FF2	**T8415**	.016	509	.0047	.031		–	–	–		459	.0047	.031		–	–	–		–	–	–		–	–	–		8553269
	T8430	.016	476	.0047	.031		–	–	–		394	.0047	.031		–	–	–		–	–	–		–	–	–		7977271
VCGT 2.520.5-FF2	**T8430**	.008	607	.002	.039		–	–	–		492	.002	.039		–	–	–		–	–	–		–	–	–		7977272
	T9325	.008	787	.002	.039		–	–	–		738	.002	.039		–	–	–		–	–	–		–	–	–		6756090
	T9415	.008	886	.002	.039		–	–	–		837	.002	.039		–	–	–		–	–	–		–	–	–		8345983
	TT010	.008	787	.002	.02		–	–	–		–	–	–		–	–	–		–	–	–		–	–	–		6756303
VCGT 2.521-FF2	**T5315**	.016	640	.0047	.039		–	–	–		607	.0047	.039		–	–	–		–	–	–		–	–	–		6756094
	T7325	.016	443	.0047	.039		–	–	–		–	–	–		–	–	–		–	–	–		–	–	–		7156791
	T8430	.016	459	.0047	.039		–	–	–		377	.0047	.039		–	–	–		–	–	–		–	–	–		7977273
	T9325	.016	574	.0047	.039		–	–	–		541	.0047	.039		–	–	–		–	–	–		–	–	–		6756096
	T9415	.016	705	.0047	.039		–	–	–		656	.0047	.039		–	–	–		–	–	–		–	–	–		8345984
	TT010	.016	804	.0024	.02		–	–	–		–	–	–		–	–	–		–	–	–		–	–	–		6756305
VCGT 2.522-FF2	**T9325**	.031	591	.0067	.039		–	–	–		558	.0067	.039		–	–	–		–	–	–		–	–	–		6756102
	T9415	.031	738	.0067	.039		–	–	–		689	.0067	.039		–	–	–		–	–	–		–	–	–		8345986
	TT010	.031	804	.0039	.031		–	–	–		–	–	–		–	–	–		–	–	–		–	–	–		6756307

Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our cutting conditions app for further options.

Product		RE (inch)	P vc (ft/min)	P f (in/rev)	P ap (inch)	M vc (ft/min)	M f (in/rev)	M ap (inch)	K vc (ft/min)	K f (in/rev)	K ap (inch)	N vc (ft/min)	N f (in/rev)	N ap (inch)	S vc (ft/min)	S f (in/rev)	S ap (inch)	H vc (ft/min)	H f (in/rev)	H ap (inch)	MID
																					
FF2 chip breaker is sharp and the first choice for fine-finishing of Steels. It features slightly positive rake angle without T-land. It's also suitable for Cast irons.																					
VCGX 2.520.2FR-FF2	**T8315**	.004	492	.002	.039	–	–	–	459	.002	.039	–	–	–	–	–	–	–	–	–	6756217
	T8415	.004	591	.002	.039	–	–	–	525	.002	.039	–	–	–	–	–	–	–	–	–	8553287
	TT010	.004	787	.002	.020	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	6756311
VCGX 2.520FR-FF2	**T8415**	.000	591	.002	.039	–	–	–	525	.002	.039	–	–	–	–	–	–	–	–	–	8553285
	TT010	.000	787	.002	.020	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	6756310
																					
FF2 chip breaker is sharp and the first choice for fine-finishing of Steels. It features slightly positive rake angle without T-land. It's also suitable for Cast irons.																					
VCGX 2.520.2FL-FF2	**T8415**	.004	591	.002	.039	–	–	–	525	.002	.039	–	–	–	–	–	–	–	–	–	8553286
VCGX 2.520FL-FF2	**T8415**	.000	591	.002	.039	–	–	–	525	.002	.039	–	–	–	–	–	–	–	–	–	8553284
	TT010	.000	787	.002	.020	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	6756309
																					
FF2 chip breaker is sharp and the first choice for fine-finishing of Steels. It features slightly positive rake angle without T-land. It's also suitable for Cast irons.																					
WCGT 1.210.5-FF2	**HF7**	.008	–	–	–	–	–	–	689	.002	.031	–	–	–	–	–	–	–	–	–	6756166
	T8430	.008	919	.002	.031	–	–	–	755	.002	.031	–	–	–	–	–	–	–	–	–	7977277
	TT010	.008	1132	.002	.020	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	6756312
WCGT 1.211-FF2	**HF7**	.016	–	–	–	–	–	–	509	.0047	.031	–	–	–	–	–	–	–	–	–	6756167
	T8430	.016	673	.0047	.031	–	–	–	558	.0047	.031	–	–	–	–	–	–	–	–	–	7977278
	TT010	.016	1148	.0024	.020	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	6756313

SF3

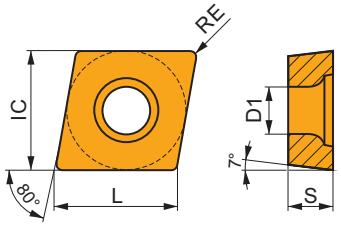


SF3 chip breaker is sharp and the first choice for fine-finishing of Stainless steels and Super-alloys. It features highly positive rake angle without T-land. It's also suitable for Non-ferrous alloys, and conditionally for Steels, Cast irons and Hard materials.

PRAMET

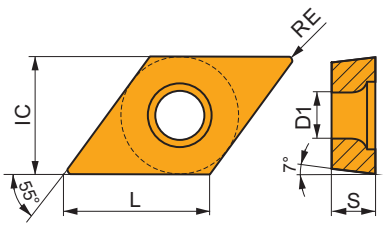
CCGT

	IC (inch)	D1 (inch)	L (inch)	S (inch)
2.52-SF3	.313	.134	.319	.135
21.5-SF3	.250	.110	.252	.102
32.5-SF3	.375	.173	.382	.166
43-SF3	.500	.217	.508	.197



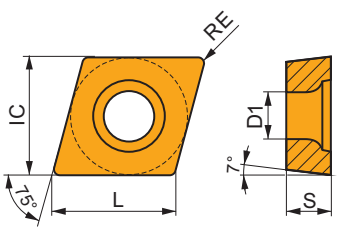
DCGT

	IC (inch)	D1 (inch)	L (inch)	S (inch)
21.5-SF3	.250	.110	.307	.102
32.5-SF3	.375	.173	.457	.166



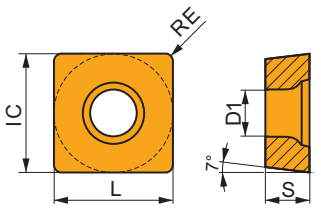
ECGT

	IC (inch)	D1 (inch)	L (inch)	S (inch)
2.52-SF3	.313	.134	.323	.135
21.5-SF3	.250	.110	.256	.102



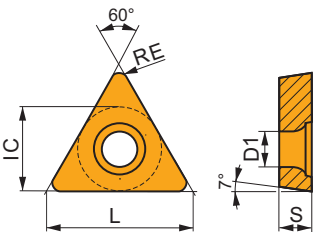
SCGT

	IC (inch)	D1 (inch)	L (inch)	S (inch)
32.5-SF3	.375	.173	.375	.166



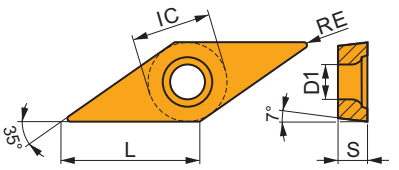
TCGT

	IC (inch)	D1 (inch)	L (inch)	S (inch)
21.5-SF3	.250	.110	.433	.102
32.5-SF3	.375	.173	.650	.166

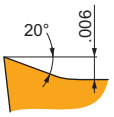
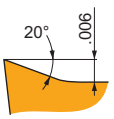


VCGT

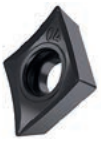
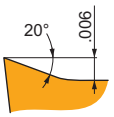
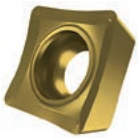
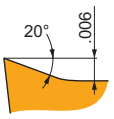
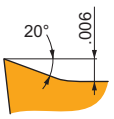
	IC (inch)	D1 (inch)	L (inch)	S (inch)
1.21.5	.156	.087	.272	.094
2.52-SF3	.313	.134	.543	.135
21.5-SF3	.250	.110	.437	.102
22-SF3	.250	.110	.437	.135
33-SF3	.375	.173	.654	.197



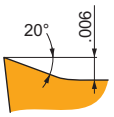
Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our cutting conditions app for further options.

Product		RE	P			M			K			N			S			H			MID
			vc (ft/min)	f (in/rev)	ap (inch)	vc (ft/min)	f (in/rev)	ap (inch)	vc (ft/min)	f (in/rev)	ap (inch)	vc (ft/min)	f (in/rev)	ap (inch)	vc (ft/min)	f (in/rev)	ap (inch)	vc (ft/min)	f (in/rev)	ap (inch)	
																					
SF3 chip breaker is sharp and the first choice for fine-finishing of Stainless steels and Super-alloys. It features highly positive rake angle without T-land. It's also suitable for Non-ferrous alloys, and conditionally for Steels, Cast irons and Hard materials.																					
CCGT 2.520.5-SF3	**T6310**	.008	673	.002	.031	476	.002	.031	541	.002	.031	2018	.0024	.031	197	.0016	.024	131	.002	.008	7168529
	T8415	.008	886	.002	.031	459	.0018	.031	804	.002	.031	2215	.0024	.031	197	.0014	.025	148	.002	.006	8553193
CCGT 2.521-SF3	**T8415**	.016	738	.0039	.039	377	.0035	.039	673	.0039	.039	1870	.0047	.039	164	.0028	.031	115	.0039	.013	8553194
CCGT 21.50.2-SF3	**T6310**	.004	656	.002	.020	459	.002	.020	525	.002	.020	1969	.0024	.020	197	.0016	.016	131	.002	.004	7600312
CCGT 21.50.5-SF3	**T6310**	.008	673	.002	.031	476	.002	.031	541	.002	.031	2018	.0024	.031	197	.0016	.024	131	.002	.008	7168524
	T8315	.008	705	.002	.031	410	.002	.031	656	.002	.031	2116	.0024	.031	164	.0016	.024	131	.002	.008	7168525
	T8415	.008	886	.002	.031	459	.0018	.031	804	.002	.031	2215	.0024	.031	197	.0014	.025	148	.002	.006	8553190
CCGT 21.51-SF3	**H07**	.016	–	–	–	312	.0035	.031	492	.0039	.031	1591	.0047	.031	148	.0028	.024	–	–	–	7168526
	T6310	.016	591	.0039	.031	410	.0035	.031	476	.0039	.031	1772	.0047	.031	164	.0028	.024	115	.0028	.012	7168527
	T8415	.016	755	.0039	.031	394	.0035	.031	689	.0039	.031	1919	.0047	.031	164	.0028	.025	131	.0028	.013	8553192
CCGT 32.50.2-SF3	**T6310**	.004	656	.002	.020	459	.002	.020	525	.002	.020	1969	.0024	.020	197	.0016	.016	131	.002	.004	7600313
CCGT 32.50.5-SF3	**T6310**	.008	673	.002	.031	476	.002	.031	541	.002	.031	2018	.0024	.031	197	.0016	.024	131	.002	.008	7168545
	T8415	.008	886	.002	.031	459	.0018	.031	804	.002	.031	2215	.0024	.031	197	.0014	.025	148	.002	.006	8553195
CCGT 32.51-SF3	**H07**	.016	–	–	–	312	.0035	.039	492	.0039	.039	1591	.0047	.039	148	.0028	.031	–	–	–	7168547
	T6310	.016	591	.0039	.039	410	.0035	.039	476	.0039	.039	1772	.0047	.039	164	.0028	.031	115	.002	.012	7168548
	T8415	.016	738	.0039	.039	377	.0035	.039	673	.0039	.039	1870	.0047	.039	164	.0028	.031	115	.002	.013	8553197
CCGT 32.52-SF3	**H07**	.031	–	–	–	361	.0035	.039	574	.0039	.039	1854	.0047	.039	180	.0031	.031	–	–	–	7168550
	T6310	.031	689	.0039	.039	492	.0035	.039	541	.0039	.039	2067	.0047	.039	197	.0031	.031	131	.0031	.028	7168551
	T8415	.031	902	.0039	.039	459	.0035	.039	820	.0039	.039	2264	.0047	.039	197	.0031	.031	148	.0031	.026	8553198
CCGT 431-SF3	**T6310**	.016	591	.0039	.039	410	.0035	.039	476	.0039	.039	1772	.0047	.039	164	.0028	.031	115	.0028	.012	7600314
	T8415	.016	738	.0039	.039	377	.0035	.039	673	.0039	.039	1870	.0047	.039	164	.0028	.031	115	.0028	.013	8553199
CCGT 432-SF3	**H07**	.031	–	–	–	344	.0047	.039	541	.0047	.039	1722	.0055	.039	164	.0043	.031	–	–	–	7168553
	T6310	.031	656	.0047	.039	459	.0047	.039	525	.0047	.039	1969	.0055	.039	197	.0043	.031	131	.0039	.028	7168554
	T8415	.031	837	.0047	.039	443	.0047	.039	755	.0047	.039	2116	.0057	.039	180	.0043	.031	148	.004	.026	8553200
																					
SF3 chip breaker is sharp and the first choice for fine-finishing of Stainless steels and Super-alloys. It features highly positive rake angle without T-land. It's also suitable for Non-ferrous alloys, and conditionally for Steels, Cast irons and Hard materials.																					
DCGT 21.50.2-SF3	**T6310**	.004	525	.002	.020	377	.002	.020	410	.002	.020	1575	.0024	.020	148	.0016	.016	98	.002	.004	7600315
DCGT 21.50.5-SF3	**T6310**	.008	541	.002	.031	377	.002	.031	427	.002	.031	1624	.0024	.031	148	.0016	.024	98	.002	.008	7168557
	T8415	.008	705	.002	.031	361	.0018	.031	640	.002	.031	1772	.0024	.031	148	.0016	.025	115	.002	.006	8553220
DCGT 21.51-SF3	**H07**	.016	–	–	–	246	.0035	.031	394	.0039	.031	1280	.0047	.031	115	.0028	.024	–	–	–	7168559
	T6310	.016	476	.0039	.031	328	.0035	.031	377	.0039	.031	1427	.0047	.031	131	.0028	.024	82	.0028	.012	7168560
	T8415	.016	607	.0039	.031	312	.0035	.031	541	.0039	.031	1526	.0047	.031	131	.0028	.025	98	.0028	.013	8553221
DCGT 32.50.2-SF3	**T6310**	.004	525	.002	.020	377	.002	.020	410	.002	.020	1575	.0024	.020	148	.0016	.016	98	.002	.004	7600316
DCGT 32.50.5-SF3	**H07**	.008	–	–	–	312	.002	.031	492	.002	.031	1591	.0024	.031	148	.0016	.024	–	–	–	7168562
	T6310	.008	541	.002	.031	377	.002	.031	427	.002	.031	1624	.0024	.031	148	.0016	.024	98	.002	.008	7168563
	T8415	.008	705	.002	.031	361	.0018	.031	640	.002	.031	1772	.0024	.031	148	.0016	.025	115	.002	.006	8553222
DCGT 32.51-SF3	**H07**	.016	–	–	–	246	.0035	.031	394	.0039	.031	1280	.0047	.031	115	.0028	.024	–	–	–	7168564
	T6310	.016	476	.0039	.031	328	.0035	.031	377	.0039	.031	1427	.0047	.031	131	.0028	.024	82	.0028	.012	7168565
	T8315	.016	509	.0039	.031	295	.0035	.031	476	.0039	.031	1526	.0047	.031	115	.0028	.024	98	.0028	.012	7168566
	T8415	.016	607	.0039	.031	312	.0035	.031	541	.0039	.031	1526	.0047	.031	131	.0028	.025	98	.0028	.013	8553223
DCGT 32.52-SF3	**H07**	.031	–	–	–	295	.0035	.031	476	.0039	.031	1493	.0047	.031	148	.0031	.024	–	–	–	7168567
	T6310	.031	558	.0039	.031	394	.0035	.031	443	.0039	.031	1673	.0047	.031	164	.0031	.024	98	.0031	.028	7168568
	T8315	.031	591	.0039	.031	344	.0035	.031	558	.0039	.031	1772	.0047	.031	148	.0031	.024	115	.0031	.028	7168569
	T8415	.031	722	.0039	.031	377	.0035	.031	656	.0039	.031	1821	.0047	.031	164	.0031	.025	115	.0031	.026	8553224

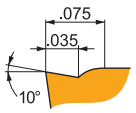
Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our cutting conditions app for further options.

Product		RE	P				M				K				N				S				H				MID
				vc (ft/min)	f (in/rev)	ap (inch)		vc (ft/min)	f (in/rev)	ap (inch)		vc (ft/min)	f (in/rev)	ap (inch)		vc (ft/min)	f (in/rev)	ap (inch)		vc (ft/min)	f (in/rev)	ap (inch)		vc (ft/min)	f (in/rev)	ap (inch)	
							**SF3** chip breaker is sharp and the first choice for fine-finishing of Stainless steels and Super-alloys. It features highly positive rake angle without T-land. It's also suitable for Non-ferrous alloys, and conditionally for Steels, Cast irons and Hard materials.																		
ECGT 2.521-SF3	**H07**	.016		–	–	–	◪	279	.0035	.039	◪	443	.0039	.039	■	1411	.0047	.039	■	131	.0028	.031		–	–	–	7168572
	T6310	.016	◪	525	.0039	.039	■	377	.0035	.039	◪	410	.0039	.039	■	1575	.0047	.039	■	148	.0028	.031	◪	98	.002	.012	7168573
	T8415	.016	◪	656	.0039	.039	■	344	.0035	.039	◪	607	.0039	.039	◪	1673	.0047	.039	■	148	.0028	.031	◪	115	.002	.013	8553238
ECGT 21.50.5-SF3	**H07**	.008		–	–	–	◪	344	.002	.031	◪	558	.002	.031	■	1772	.0024	.031	■	180	.0016	.024		–	–	–	7168570
	T6310	.008	◪	607	.002	.031	■	427	.002	.031	◪	476	.002	.031	■	1821	.0024	.031	■	180	.0016	.024	◪	115	.002	.008	7168571
	T8415	.008	◪	787	.002	.031	■	410	.0018	.031	◪	705	.002	.031	◪	1969	.0024	.031	■	180	.0014	.025	◪	131	.002	.006	8553237
							**SF3** chip breaker is sharp and the first choice for fine-finishing of Stainless steels and Super-alloys. It features highly positive rake angle without T-land. It's also suitable for Non-ferrous alloys, and conditionally for Steels, Cast irons and Hard materials.																		
SCGT 32.51-SF3	**H07**	.016		–	–	–	◪	312	.0035	.039	◪	509	.0039	.039	■	1624	.0047	.039	■	164	.0028	.031		–	–	–	7168574
	T6310	.016	◪	607	.0039	.039	■	427	.0035	.039	◪	476	.0039	.039	■	1821	.0047	.039	■	180	.0028	.031	◪	115	.002	.012	7168575
	T8415	.016	◪	787	.0039	.039	■	410	.0035	.039	◪	705	.0039	.039	◪	1969	.0047	.039	■	180	.0028	.031	◪	131	.002	.013	8553243
SCGT 32.52-SF3	**T6310**	.031	◪	689	.0047	.039	■	492	.0047	.039	◪	541	.0047	.039	■	2067	.0055	.039	■	197	.0043	.031	◪	131	.0039	.028	7168577
	T8415	.031	◪	886	.0047	.039	■	459	.0047	.039	◪	804	.0047	.039	◪	2215	.0057	.039	■	197	.0043	.031	◪	148	.004	.026	8553244
							**SF3** chip breaker is sharp and the first choice for fine-finishing of Stainless steels and Super-alloys. It features highly positive rake angle without T-land. It's also suitable for Non-ferrous alloys, and conditionally for Steels, Cast irons and Hard materials.																		
TCGT 21.50.5-SF3	**T8415**	.008	◪	738	.002	.031	■	377	.0018	.031	◪	673	.002	.031	◪	1870	.0024	.031	■	164	.0016	.025	◪	115	.002	.006	8553250
TCGT 21.51-SF3	**H07**	.016		–	–	–	◪	262	.0035	.031	◪	427	.0039	.031	■	1362	.0047	.031	■	131	.0028	.024		–	–	–	7168581
	T8415	.016	◪	640	.0039	.031	■	328	.0035	.031	◪	591	.0039	.031	◪	1624	.0047	.031	■	148	.0028	.025	◪	98	.0028	.013	8553252
TCGT 32.51-SF3	**H07**	.016		–	–	–	◪	262	.0035	.039	◪	410	.0039	.039	■	1329	.0047	.039	■	131	.0028	.031		–	–	–	7168584
	T6310	.016	◪	492	.0039	.039	■	344	.0035	.039	◪	394	.0039	.039	■	1476	.0047	.039	■	148	.0028	.031	◪	98	.0028	.012	7168585
	T8415	.016	◪	640	.0039	.039	■	328	.0035	.039	◪	591	.0039	.039	◪	1624	.0047	.039	■	148	.0028	.031	◪	98	.0028	.013	8553253
TCGT 32.52-SF3	**H07**	.031		–	–	–	◪	295	.0035	.047	◪	476	.0039	.047	■	1542	.0047	.047	■	148	.0031	.039		–	–	–	7168587
	T6310	.031	◪	574	.0039	.047	■	410	.0035	.047	◪	459	.0039	.047	■	1722	.0047	.047	■	164	.0031	.039	◪	115	.0031	.028	7168588
	T8415	.031	◪	738	.0039	.047	■	377	.0035	.047	◪	673	.0039	.047	◪	1870	.0047	.047	■	164	.0031	.038	◪	115	.0031	.026	8553254
TCGT 32.53-SF3	**T6310**	.047	◪	492	.0079	.047	■	344	.0071	.047	◪	394	.0079	.047	■	1476	.0094	.047	■	148	.0055	.039	◪	98	.0039	.035	7600317
	T8415	.047	◪	623	.0079	.047	■	328	.0071	.047	◪	558	.0079	.047	◪	1575	.0094	.047	■	131	.0055	.038	◪	98	.0039	.035	8553255

Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our cutting conditions app for further options.

Product		RE	P				M				K				N				S				H			MID
			vc (ft/min)	f (in/rev)	ap (inch)		vc (ft/min)	f (in/rev)	ap (inch)		vc (ft/min)	f (in/rev)	ap (inch)		vc (ft/min)	f (in/rev)	ap (inch)		vc (ft/min)	f (in/rev)	ap (inch)		vc (ft/min)	f (in/rev)	ap (inch)	
																										
SF3 chip breaker is sharp and the first choice for fine-finishing of Stainless steels and Super-alloys. It features highly positive rake angle without T-land. It's also suitable for Non-ferrous alloys, and conditionally for Steels, Cast irons and Hard materials.																										
VCGT 1.21.50.5-SF3	**H07**	.008		–	–	–	◩	262	.002	.031	◩	427	.002	.031	■	1362	.0024	.031	■	131	.0016	.024		–	–	–	7168590
	T6310	.008	◩	476	.002	.031	■	328	.002	.031	◩	377	.002	.031	■	1427	.0024	.031	■	131	.0016	.024	◩	82	.002	.008	7168591
	T8415	.008	◩	607	.002	.031	■	312	.0018	.031	◩	541	.002	.031	◩	1526	.0024	.031	■	131	.0014	.025	◩	98	.002	.006	8553268
VCGT 1.21.51-SF3	**T6310**	.016	◩	410	.0039	.031	■	295	.0035	.031	◩	328	.0039	.031	■	1230	.0047	.031	■	115	.0028	.024	◩	82	.0028	.012	7168592
	T8415	.016	◩	525	.0039	.031	■	279	.0035	.031	◩	476	.0039	.031	◩	1329	.0047	.031	■	115	.0028	.025	◩	82	.0028	.013	8553270
VCGT 2.520.5-SF3	**H07**	.008		–	–	–	◩	262	.002	.031	◩	427	.002	.031	■	1362	.0024	.031	■	131	.0016	.024		–	–	–	7168599
	T6310	.008	◩	476	.002	.031	■	328	.002	.031	◩	377	.002	.031	■	1427	.0024	.031	■	131	.0016	.024	◩	82	.002	.008	7168600
	T8415	.008	◩	607	.002	.031	■	312	.0018	.031	◩	541	.002	.031	◩	1526	.0024	.031	■	131	.0014	.025	◩	98	.002	.006	8553275
VCGT 2.521-SF3	**H07**	.016		–	–	–	◩	213	.0035	.039	◩	344	.0039	.039	■	1099	.0047	.039	■	98	.0028	.031		–	–	–	7168602
	T6310	.016	◩	410	.0039	.039	■	295	.0035	.039	◩	328	.0039	.039	■	1230	.0047	.039	■	115	.0028	.031	◩	82	.0028	.012	7168603
	T8415	.016	◩	525	.0039	.039	■	279	.0035	.039	◩	476	.0039	.039	◩	1329	.0047	.039	■	115	.0028	.031	◩	82	.0028	.013	8553277
VCGT 2.522-SF3	**H07**	.031		–	–	–	◩	246	.0035	.039	◩	394	.0039	.039	■	1280	.0047	.039	■	115	.0031	.031		–	–	–	7168605
	T6310	.031	◩	476	.0039	.039	■	328	.0035	.039	◩	377	.0039	.039	■	1427	.0047	.039	■	131	.0031	.031	◩	82	.0031	.028	7168606
	T8415	.031	◩	623	.0039	.039	■	328	.0035	.039	◩	558	.0039	.039	◩	1575	.0047	.039	■	131	.0031	.031	◩	98	.0031	.026	8553279
VCGT 21.50.5-SF3	**T6310**	.008	◩	476	.002	.031	■	328	.002	.031	◩	377	.002	.031	■	1427	.0024	.031	■	131	.0016	.024	◩	82	.002	.008	7168594
	T8415	.008	◩	607	.002	.031	■	312	.0018	.031	◩	541	.002	.031	◩	1526	.0024	.031	■	131	.0014	.025	◩	98	.002	.006	8553271
VCGT 21.51-SF3	**H07**	.016		–	–	–	◩	213	.0035	.031	◩	344	.0039	.031	■	1099	.0047	.031	■	98	.0028	.024		–	–	–	7168596
	T8415	.016	◩	525	.0039	.031	■	279	.0035	.031	◩	476	.0039	.031	◩	1329	.0047	.031	■	115	.0028	.025	◩	82	.0028	.013	8553272
VCGT 220.2-SF3	**T6310**	.004	◩	459	.002	.020	■	328	.002	.020	◩	361	.002	.020	■	1378	.0024	.020	■	131	.0016	.016	◩	82	.002	.004	7600319
VCGT 220.5-SF3	**T6310**	.008	◩	476	.002	.031	■	328	.002	.031	◩	377	.002	.031	■	1427	.0024	.031	■	131	.0016	.024	◩	82	.002	.008	7600320
VCGT 221-SF3	**T6310**	.016	◩	410	.0039	.031	■	295	.0035	.031	◩	328	.0039	.031	■	1230	.0047	.031	■	115	.0028	.024	◩	82	.0028	.012	7600321
	T8415	.016	◩	525	.0039	.031	■	279	.0035	.031	◩	476	.0039	.031	◩	1329	.0047	.031	■	115	.0028	.025	◩	82	.0028	.013	8553273
VCGT 330.5-SF3	**T6310**	.008	◩	476	.002	.031	■	328	.002	.031	◩	377	.002	.031	■	1427	.0024	.031	■	131	.0016	.024	◩	82	.002	.008	7600322
	T8415	.008	◩	607	.002	.031	■	312	.0018	.031	◩	541	.002	.031	◩	1526	.0024	.031	■	131	.0014	.025	◩	98	.002	.006	8553280
VCGT 331-SF3	**H07**	.016		–	–	–	◩	213	.0035	.039	◩	344	.0039	.039	■	1099	.0047	.039	■	98	.0028	.031		–	–	–	7168608
	T6310	.016	◩	410	.0039	.039	■	295	.0035	.039	◩	328	.0039	.039	■	1230	.0047	.039	■	115	.0028	.031	◩	82	.0028	.012	7168609
	T8315	.016	◩	427	.0039	.039	■	246	.0035	.039	◩	394	.0039	.039	■	1280	.0047	.039	◩	98	.0028	.031	◩	82	.0028	.012	7168610
	T8415	.016	◩	525	.0039	.039	■	279	.0035	.039	◩	476	.0039	.039	◩	1329	.0047	.039	■	115	.0028	.031	◩	82	.0028	.013	8553281
VCGT 332-SF3	**H07**	.031		–	–	–	◩	246	.0035	.047	◩	394	.0039	.047	■	1280	.0047	.047	■	115	.0031	.039		–	–	–	7168611
	T6310	.031	◩	476	.0039	.047	■	328	.0035	.047	◩	377	.0039	.047	■	1427	.0047	.047	■	131	.0031	.039	◩	82	.0031	.028	7168612
	T8315	.031	◩	509	.0039	.047	■	295	.0035	.047	◩	476	.0039	.047	■	1526	.0047	.047	◩	115	.0031	.039	◩	98	.0031	.028	7168613
	T8415	.031	◩	607	.0039	.047	■	312	.0035	.047	◩	541	.0039	.047	◩	1526	.0047	.047	■	131	.0031	.038	◩	98	.0031	.026	8553282
VCGT 333-SF3	**H07**	.047		–	–	–	◩	197	.0071	.047	◩	312	.0079	.047	■	1017	.0094	.047	■	98	.0055	.039		–	–	–	7168614
	T8415	.047	◩	525	.0079	.047	■	279	.0071	.047	◩	476	.0079	.047	◩	1329	.0094	.047	■	115	.0055	.038	◩	82	.0039	.035	8553283

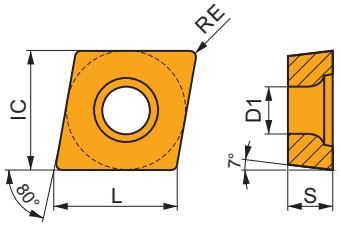
NF1



NF1 chip breaker is sharp and designed for fine-finishing of Steels, Stainless steels and Super-alloys. It features positive rake angle without T-land. It's also conditionally suitable for Non-ferrous alloys and Hard materials.

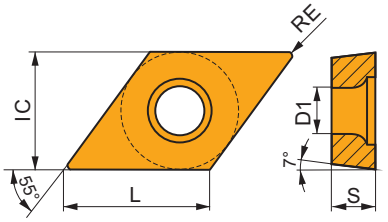
CCGT

	IC (inch)	D1 (inch)	L (inch)	S (inch)
21.5	.250	.110	.252	.094
32.5	.375	.173	.382	.156



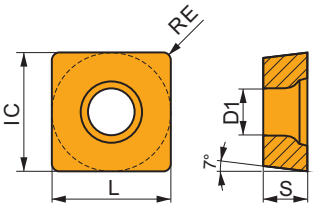
DCGT

	IC (inch)	D1 (inch)	L (inch)	S (inch)
32.5	.375	.173	.457	.156



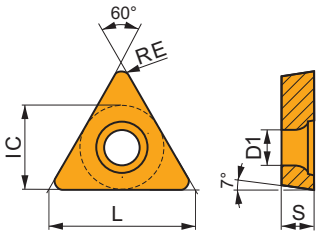
SCGT

	IC (inch)	D1 (inch)	L (inch)	S (inch)
32.5	.375	.173	.375	.156
43	.500	.217	.500	.187

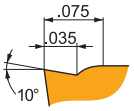


TCGT

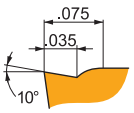
	IC (inch)	D1 (inch)	L (inch)	S (inch)
21.5	.250	.110	.433	.094



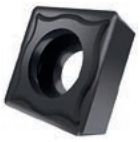
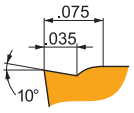
Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our cutting conditions app for further options.

Product		RE (inch)	P vc (ft/min)	P f (in/rev)	P ap (inch)	M vc (ft/min)	M f (in/rev)	M ap (inch)	K vc (ft/min)	K f (in/rev)	K ap (inch)	N vc (ft/min)	N f (in/rev)	N ap (inch)	S vc (ft/min)	S f (in/rev)	S ap (inch)	H vc (ft/min)	H f (in/rev)	H ap (inch)	MID
																					
CCGT 21.51-NF1	**T6310**	.016	591	.0039	.031	410	.0035	.031	–	–	–	1772	.0047	.031	164	.0028	.024	115	.0031	.012	7166215
	T7325	.016	689	.0039	.031	525	.0035	.031	–	–	–	–	–	–	213	.0028	.024	–	–	–	7166216
CCGT 21.52-NF1	**T6310**	.031	673	.0047	.031	476	.0043	.031	–	–	–	2018	.0055	.031	197	.0043	.024	131	.0035	.028	7166218
CCGT 32.51-NF1	**T6310**	.016	574	.0039	.047	410	.0035	.047	–	–	–	1722	.0047	.047	164	.0028	.039	115	.0031	.012	7167401
	T7325	.016	656	.0039	.047	509	.0035	.047	–	–	–	–	–	–	213	.0028	.039	–	–	–	7167402
CCGT 32.52-NF1	**T6310**	.031	623	.0055	.047	443	.0051	.047	–	–	–	1870	.0067	.047	180	.0051	.039	115	.0043	.028	7167404
	T7325	.031	705	.0055	.047	541	.0051	.047	–	–	–	–	–	–	213	.0051	.039	–	–	–	7167405

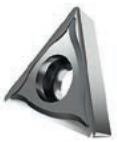
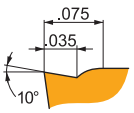
NF1 chip breaker is sharp and designed for fine-finishing of Steels, Stainless steels and Super-alloys. It features positive rake angle without T-land. It's also conditionally suitable for Non-ferrous alloys and Hard materials.

																					
DCGT 32.51-NF1	**T6310**	.016	476	.0039	.031	328	.0035	.031	–	–	–	1427	.0047	.031	131	.0028	.024	82	.0028	.012	7167407
	T7325	.016	541	.0039	.031	410	.0035	.031	–	–	–	–	–	–	164	.0028	.024	–	–	–	7167408
DCGT 32.52-NF1	**T6310**	.031	509	.0055	.031	361	.0051	.031	–	–	–	1526	.0067	.031	148	.0051	.024	98	.0039	.028	7167410
	T7325	.031	591	.0055	.031	459	.0051	.031	–	–	–	–	–	–	180	.0051	.024	–	–	–	7167411

NF1 chip breaker is sharp and designed for fine-finishing of Steels, Stainless steels and Super-alloys. It features positive rake angle without T-land. It's also conditionally suitable for Non-ferrous alloys and Hard materials.

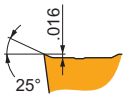
																					
SCGT 32.52-NF1	**T6310**	.031	656	.0055	.047	459	.0051	.047	–	–	–	1969	.0067	.047	197	.0051	.039	131	.0039	.028	7167413
SCGT 432-NF1	**T6310**	.031	591	.0071	.055	410	.0063	.055	–	–	–	1772	.0087	.055	164	.0063	.043	115	.0051	.028	7167416
	T7325	.031	673	.0071	.055	509	.0063	.055	–	–	–	–	–	–	213	.0063	.043	–	–	–	7167417

NF1 chip breaker is sharp and designed for fine-finishing of Steels, Stainless steels and Super-alloys. It features positive rake angle without T-land. It's also conditionally suitable for Non-ferrous alloys and Hard materials.

																					
TCGT 21.51-NF1	**T6310**	.016	509	.0039	.031	361	.0035	.031	–	–	–	1526	.0047	.031	148	.0031	.024	98	.0031	.012	7167419

NF1 chip breaker is sharp and designed for fine-finishing of Steels, Stainless steels and Super-alloys. It features positive rake angle without T-land. It's also conditionally suitable for Non-ferrous alloys and Hard materials.

SF2

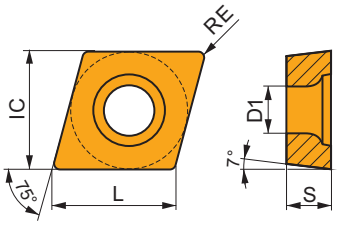


SF2 chip breaker is sharp and designed for fine-finishing of Stainless steels and Super-alloys. It features highly positive rake angle without T-land. It's also conditionally suitable for Steels and Non-ferrous alloys.

PRAMET

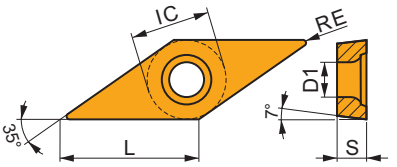
ECGT

	IC (inch)	D1 (inch)	L (inch)	S (inch)
2.52	.313	.134	.323	.125
21.5	.250	.110	.256	.094

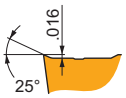
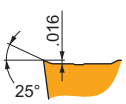


VCGT

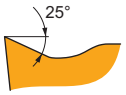
	IC (inch)	D1 (inch)	L (inch)	S (inch)
2.52	.313	.134	.543	.125



Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our cutting conditions app for further options.

Product		RE (inch)	P vc (ft/min)	P f (in/rev)	P ap (inch)	M vc (ft/min)	M f (in/rev)	M ap (inch)	K vc (ft/min)	K f (in/rev)	K ap (inch)	N vc (ft/min)	N f (in/rev)	N ap (inch)	S vc (ft/min)	S f (in/rev)	S ap (inch)	H vc (ft/min)	H f (in/rev)	H ap (inch)	MID
																					
			SF2 chip breaker is sharp and designed for fine-finishing of Stainless steels and Super-alloys. It features highly positive rake angle without T-land. It's also conditionally suitable for Steels and Non-ferrous alloys.																		
ECGT 2.520.5-SF2	**H07**	.008	–	–	–	344	.002	.039	–	–	–	1722	.0024	.039	164	.0016	.031	–	–	–	7168492
	T6310	.008	607	.002	.039	427	.002	.039	–	–	–	1821	.0024	.039	180	.0016	.031	–	–	–	7168493
ECGT 2.521-SF2	**H07**	.016	–	–	–	279	.0035	.039	–	–	–	1411	.0047	.039	131	.0028	.031	–	–	–	7168494
	T6310	.016	525	.0039	.039	377	.0035	.039	–	–	–	1575	.0047	.039	148	.0028	.031	–	–	–	7168495
ECGT 21.50.5-SF2	**H07**	.008	–	–	–	344	.002	.039	–	–	–	1722	.0024	.039	164	.0016	.031	–	–	–	7168198
	T6310	.008	607	.002	.039	427	.002	.039	–	–	–	1821	.0024	.039	180	.0016	.031	–	–	–	7168199
ECGT 21.51-SF2	**H07**	.016	–	–	–	279	.0035	.039	–	–	–	1411	.0047	.039	131	.0028	.031	–	–	–	7168490
	T6310	.016	525	.0039	.039	377	.0035	.039	–	–	–	1575	.0047	.039	148	.0028	.031	–	–	–	7168491
																					
			SF2 chip breaker is sharp and designed for fine-finishing of Stainless steels and Super-alloys. It features highly positive rake angle without T-land. It's also conditionally suitable for Steels and Non-ferrous alloys.																		
VCGT 2.520.2-SF2	**H07**	.004	–	–	–	262	.002	.039	–	–	–	1329	.0024	.039	131	.0016	.031	–	–	–	7168496
	T6310	.004	459	.002	.039	328	.002	.039	–	–	–	1378	.0024	.039	131	.0016	.031	–	–	–	7168497
VCGT 2.520.5-SF2	**H07**	.008	–	–	–	262	.002	.039	–	–	–	1329	.0024	.039	131	.0016	.031	–	–	–	7168498
	HF7	.008	–	–	–	295	.002	.039	–	–	–	1476	.0024	.039	–	–	–	–	–	–	6756088
	T6310	.008	459	.002	.039	328	.002	.039	–	–	–	1378	.0024	.039	131	.0016	.031	–	–	–	7168499
VCGT 2.521-SF2	**H07**	.016	–	–	–	213	.0035	.039	–	–	–	1099	.0047	.039	98	.0028	.031	–	–	–	7168500
	HF7	.016	–	–	–	246	.0035	.039	–	–	–	1230	.0047	.039	–	–	–	–	–	–	6756093
	T6310	.016	410	.0039	.039	295	.0035	.039	–	–	–	1230	.0047	.039	115	.0028	.031	–	–	–	7168501
VCGT 2.522-SF2	**HF7**	.031	–	–	–	279	.0035	.039	–	–	–	1427	.0047	.039	–	–	–	–	–	–	6756100
	T6310	.031	476	.0039	.039	328	.0035	.039	–	–	–	1427	.0047	.039	131	.0031	.031	–	–	–	7168503

AL

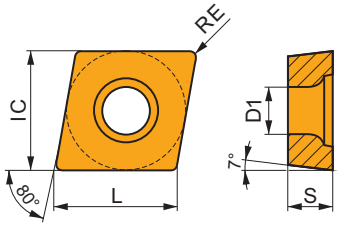


AL chip breaker is sharp and the first choice for all-around machining of Non-ferrous alloys. It features highly positive rake angle without T-land. It's also conditionally suitable for Super-alloys.

PRAMET

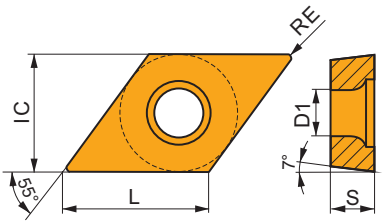
CCGT

	IC (inch)	D1 (inch)	L (inch)	S (inch)
2.52-AL	.313	.134	.319	.135
21.5	.250	.110	.252	.094
32.5	.375	.173	.382	.156
43	.500	.217	.508	.187



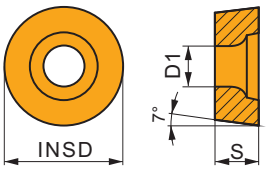
DCGT

	IC (inch)	D1 (inch)	L (inch)	S (inch)
21.5	.250	.110	.307	.094
32.5	.375	.173	.457	.156



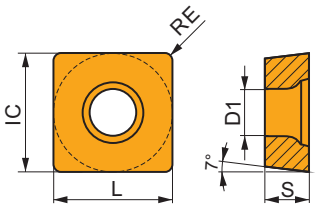
RCGT

	IC (inch)	D1 (inch)	L (inch)	S (inch)
0803	.315	.134	.125	3.97
1003	.394	.173	.125	



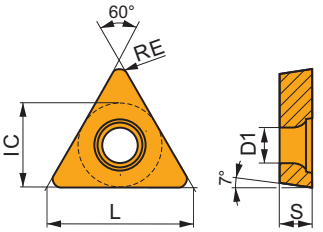
SCGT

	IC (inch)	D1 (inch)	L (inch)	S (inch)
43	.500	.217	.500	.187



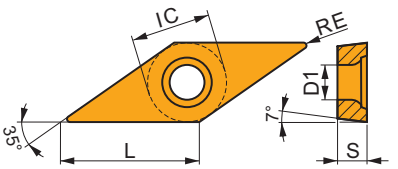
TCGT

	IC (inch)	D1 (inch)	L (inch)	S (inch)
1.81.5	.219	.098	.378	.094
21.5	.250	.110	.433	.094
32.5	.375	.173	.650	.156



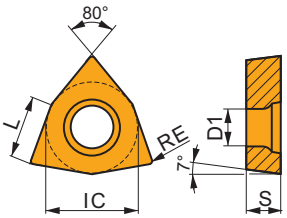
VCGT

	IC (inch)	D1 (inch)	L (inch)	S (inch)
1.21.5	.156	.087	.272	.094
2.52-AL	.313	.134	.543	.135
22	.250	.110	.437	.125
33	.375	.173	.654	.187

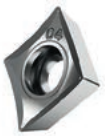
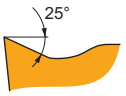
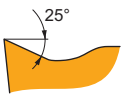
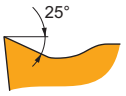
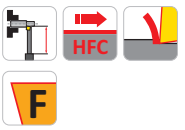


WCGT

	IC (inch)	D1 (inch)	L (inch)	S (inch)
32.5	.375	.173	.256	.156
43	.500	.217	.343	.187



Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our cutting conditions app for further options.

Product		RE	P			M			K			N			S			H			MID
		(inch)	vc (ft/min)	f (in/rev)	ap (inch)	vc (ft/min)	f (in/rev)	ap (inch)	vc (ft/min)	f (in/rev)	ap (inch)	vc (ft/min)	f (in/rev)	ap (inch)	vc (ft/min)	f (in/rev)	ap (inch)	vc (ft/min)	f (in/rev)	ap (inch)	
																					
AL chip breaker is sharp and the first choice for all-around machining of Non-ferrous alloys. It features highly positive rake angle without T-land. It's also conditionally suitable for Super-alloys.																					
CCGT 2.520.5F-AL	**T0315**	.008	–	–	–	–	–	–	–	–	–	2116	.0047	.039	–	–	–	–	–	–	6756210
CCGT 2.521F-AL	**HF7**	.016	–	–	–	–	–	–	–	–	–	1181	.0094	.039	–	–	–	–	–	–	6756212
	T0315	.016	–	–	–	–	–	–	–	–	–	1722	.0094	.039	–	–	–	–	–	–	6756213
CCGT 21.50.5F-AL	**HF7**	.008	–	–	–	–	–	–	–	–	–	1476	.0047	.039	–	–	–	–	–	–	6751796
	T0315	.008	–	–	–	–	–	–	–	–	–	2116	.0047	.039	–	–	–	–	–	–	6756135
CCGT 21.51F-AL	**HF7**	.016	–	–	–	–	–	–	–	–	–	1181	.0094	.039	–	–	–	–	–	–	6751797
	T0315	.016	–	–	–	–	–	–	–	–	–	1722	.0094	.039	–	–	–	–	–	–	6756136
CCGT 32.50.5F-AL	**HF7**	.008	–	–	–	–	–	–	–	–	–	1476	.0047	.039	–	–	–	–	–	–	6752084
	T0315	.008	–	–	–	–	–	–	–	–	–	2116	.0047	.039	–	–	–	–	–	–	6756137
CCGT 32.51F-AL	**HF7**	.016	–	–	–	–	–	–	–	–	–	1132	.0094	.059	–	–	–	–	–	–	6751705
	T0315	.016	–	–	–	–	–	–	–	–	–	1624	.0094	.059	–	–	–	–	–	–	6756138
CCGT 32.52F-AL	**HF7**	.031	–	–	–	–	–	–	–	–	–	1033	.0189	.059	–	–	–	–	–	–	6751799
	T0315	.031	–	–	–	–	–	–	–	–	–	1476	.0189	.059	–	–	–	–	–	–	6756139
CCGT 431F-AL	**HF7**	.016	–	–	–	–	–	–	–	–	–	1083	.0094	.094	–	–	–	–	–	–	6751703
	T0315	.016	–	–	–	–	–	–	–	–	–	1575	.0094	.094	–	–	–	–	–	–	6756140
CCGT 432F-AL	**HF7**	.031	–	–	–	–	–	–	–	–	–	984	.0189	.094	–	–	–	–	–	–	6751701
	T0315	.031	–	–	–	–	–	–	–	–	–	1427	.0189	.094	–	–	–	–	–	–	6756141
																					
AL chip breaker is sharp and the first choice for all-around machining of Non-ferrous alloys. It features highly positive rake angle without T-land. It's also conditionally suitable for Super-alloys.																					
DCGT 21.50.5F-AL	**HF7**	.008	–	–	–	–	–	–	–	–	–	1181	.0047	.039	–	–	–	–	–	–	6752064
	T0315	.008	–	–	–	–	–	–	–	–	–	1673	.0047	.039	–	–	–	–	–	–	6756145
DCGT 21.51F-AL	**HF7**	.016	–	–	–	–	–	–	–	–	–	935	.0094	.039	–	–	–	–	–	–	6751734
	T0315	.016	–	–	–	–	–	–	–	–	–	1378	.0094	.039	–	–	–	–	–	–	6756146
DCGT 32.50.5F-AL	**HF7**	.008	–	–	–	–	–	–	–	–	–	1132	.0047	.059	–	–	–	–	–	–	6752066
	T0315	.008	–	–	–	–	–	–	–	–	–	1624	.0047	.059	–	–	–	–	–	–	6756147
DCGT 32.51F-AL	**HF7**	.016	–	–	–	–	–	–	–	–	–	886	.0094	.059	–	–	–	–	–	–	6751736
	T0315	.016	–	–	–	–	–	–	–	–	–	1280	.0094	.059	–	–	–	–	–	–	6756148
DCGT 32.52F-AL	**HF7**	.031	–	–	–	–	–	–	–	–	–	837	.0189	.059	–	–	–	–	–	–	6752068
	T0315	.031	–	–	–	–	–	–	–	–	–	1181	.0189	.059	–	–	–	–	–	–	6756149
																					
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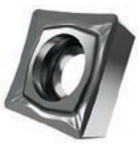
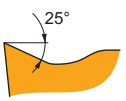
RCGT 0803MOF-AL	**HF7**	–	–	–	–	–	–	–	–	–	–	935	.0472	.039	–	–	–	–	–	–	6751738
	T0315	–	–	–	–	–	–	–	–	–	–	1378	.0472	.039	–	–	–	–	–	–	6756150
RCGT 1003MOF-AL	**HF7**	–	–	–	–	–	–	–	–	–	–	837	.0591	.039	–	–	–	–	–	–	6751740
	T0315	–	–	–	–	–	–	–	–	–	–	1280	.0591	.039	–	–	–	–	–	–	6756151
																					
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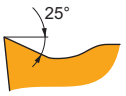
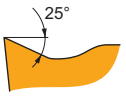
SCGT 432F-AL	**HF7**	.031	–	–	–	–	–	–	–	–	–	1033	.0189	.079	–	–	–	–	–	–	6752103
	T0315	.031	–	–	–	–	–	–	–	–	–	1526	.0189	.079	–	–	–	–	–	–	6756152

Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our cutting conditions app for further options.

Product		RE	P			M			K			N			S			H			MID
		(inch)	vc (ft/min)	f (in/rev)	ap (inch)	vc (ft/min)	f (in/rev)	ap (inch)	vc (ft/min)	f (in/rev)	ap (inch)	vc (ft/min)	f (in/rev)	ap (inch)	vc (ft/min)	f (in/rev)	ap (inch)	vc (ft/min)	f (in/rev)	ap (inch)	
																					
AL chip breaker is sharp and the first choice for all-around machining of Non-ferrous alloys. It features highly positive rake angle without T-land. It's also conditionally suitable for Super-alloys.																					
TCGT 1.81.50.5F-AL	**HF7**	.008	–	–	–	–	–	–	–	–	–	1230	.0047	.039	–	–	–	–	–	–	6751860
	T0315	.008	–	–	–	–	–	–	–	–	–	1821	.0047	.039	–	–	–	–	–	–	6756153
TCGT 1.81.51F-AL	**HF7**	.016	–	–	–	–	–	–	–	–	–	984	.0094	.039	–	–	–	–	–	–	6751861
	T0315	.016	–	–	–	–	–	–	–	–	–	1476	.0094	.039	–	–	–	–	–	–	6756154
TCGT 21.50.5F-AL	**HF7**	.008	–	–	–	–	–	–	–	–	–	1181	.0047	.059	–	–	–	–	–	–	6751862
	T0315	.008	–	–	–	–	–	–	–	–	–	1722	.0047	.059	–	–	–	–	–	–	6756155
TCGT 21.51F-AL	**HF7**	.016	–	–	–	–	–	–	–	–	–	935	.0094	.059	–	–	–	–	–	–	6751863
	T0315	.016	–	–	–	–	–	–	–	–	–	1378	.0094	.059	–	–	–	–	–	–	6756156
TCGT 21.52F-AL	**HF7**	.031	–	–	–	–	–	–	–	–	–	886	.0189	.059	–	–	–	–	–	–	6751864
TCGT 32.51F-AL	**HF7**	.016	–	–	–	–	–	–	–	–	–	935	.0094	.094	–	–	–	–	–	–	6751803
	T0315	.016	–	–	–	–	–	–	–	–	–	1329	.0094	.094	–	–	–	–	–	–	6756158
TCGT 32.52F-AL	**HF7**	.031	–	–	–	–	–	–	–	–	–	837	.0189	.094	–	–	–	–	–	–	6751804
	T0315	.031	–	–	–	–	–	–	–	–	–	1181	.0189	.094	–	–	–	–	–	–	6756159
																					
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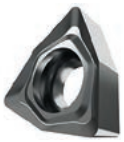
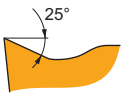
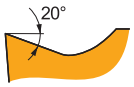
VCGT 1.21.50.5F-AL	**HF7**	.008	–	–	–	–	–	–	–	–	–	1033	.0047	.039	–	–	–	–	–	–	6756194
VCGT 2.520.5F-AL	**HF7**	.008	–	–	–	–	–	–	–	–	–	935	.0047	.067	–	–	–	–	–	–	6756198
	T0315	.008	–	–	–	–	–	–	–	–	–	1378	.0047	.067	–	–	–	–	–	–	6756199
VCGT 2.521F-AL	**HF7**	.016	–	–	–	–	–	–	–	–	–	787	.0094	.067	–	–	–	–	–	–	6756201
	T0315	.016	–	–	–	–	–	–	–	–	–	1132	.0094	.067	–	–	–	–	–	–	6756202
VCGT 2.522F-AL	**HF7**	.031	–	–	–	–	–	–	–	–	–	689	.0189	.067	–	–	–	–	–	–	6756204
	T0315	.031	–	–	–	–	–	–	–	–	–	1033	.0189	.067	–	–	–	–	–	–	6756205
VCGT 220.5F-AL	**HF7**	.008	–	–	–	–	–	–	–	–	–	984	.0047	.059	–	–	–	–	–	–	6752080
	T0315	.008	–	–	–	–	–	–	–	–	–	1526	.0047	.031	–	–	–	–	–	–	6756160
VCGT 221F-AL	**HF7**	.016	–	–	–	–	–	–	–	–	–	787	.0094	.059	–	–	–	–	–	–	6751806
	T0315	.016	–	–	–	–	–	–	–	–	–	1230	.0094	.031	–	–	–	–	–	–	6756161
VCGT 330.5F-AL	**HF7**	.008	–	–	–	–	–	–	–	–	–	935	.0047	.094	–	–	–	–	–	–	6752053
	T0315	.008	–	–	–	–	–	–	–	–	–	1378	.0047	.094	–	–	–	–	–	–	6756171
VCGT 331F-AL	**HF7**	.016	–	–	–	–	–	–	–	–	–	738	.0094	.094	–	–	–	–	–	–	6751808
	T0315	.016	–	–	–	–	–	–	–	–	–	1083	.0094	.094	–	–	–	–	–	–	6756175
VCGT 332F-AL	**HF7**	.031	–	–	–	–	–	–	–	–	–	689	.0189	.094	–	–	–	–	–	–	6751810
	T0315	.031	–	–	–	–	–	–	–	–	–	984	.0189	.094	–	–	–	–	–	–	6756176
VCGT 333F-AL	**HF7**	.047	–	–	–	–	–	–	–	–	–	591	.0283	.094	–	–	–	–	–	–	6751812
	T0315	.047	–	–	–	–	–	–	–	–	–	886	.0283	.094	–	–	–	–	–	–	6756178
																					
AL chip breaker is sharp and the first choice for all-around machining of Non-ferrous alloys. It features highly positive rake angle without T-land. It's also conditionally suitable for Super-alloys.																					
WCGT 32.50.5F-AL	**HF7**	.008	–	–	–	–	–	–	–	–	–	1476	.0047	.039	–	–	–	–	–	–	6751857
WCGT 32.51F-AL	**HF7**	.016	–	–	–	–	–	–	–	–	–	1181	.0094	.039	–	–	–	–	–	–	6751858
	T0315	.016	–	–	–	–	–	–	–	–	–	1722	.0094	.039	–	–	–	–	–	–	6756206
WCGT 32.52F-AL	**HF7**	.031	–	–	–	–	–	–	–	–	–	1033	.0189	.059	–	–	–	–	–	–	6751859
WCGT 433F-AL	**HF7**	.047	–	–	–	–	–	–	–	–	–	837	.0283	.094	–	–	–	–	–	–	6752407

JQ JR JZ

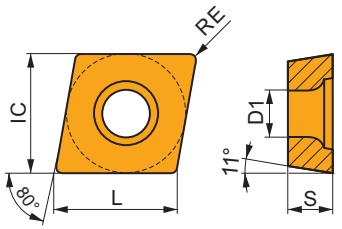


JQ, JR, JZ chip breaker is sharp and designed for fine-finishing of Steels. It features highly positive rake angle without T-land. It's also conditionally suitable for Stainless steels.

PRAMET

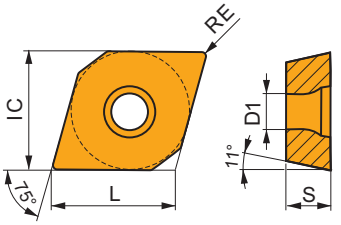
CPGX

	IC (inch)	D1 (inch)	L (inch)	S (inch)
2.52	.313	.134	.319	.125
21.5	.250	.110	.252	.094
32.5	.375	.173	.382	.156



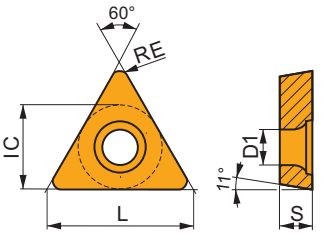
EPGX

	IC (inch)	D1 (inch)	L (inch)	S (inch)
1.81.5	.219	.098	.224	.094



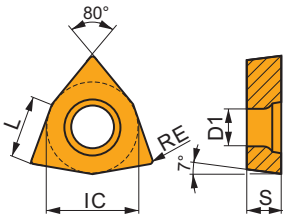
TPGX

	IC (inch)	D1 (inch)	L (inch)	S (inch)
1.81.5	.219	.098	.378	.094
21.5	.250	.110	.433	.094
32.5	.375	.173	.650	.156

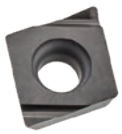
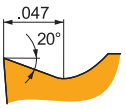
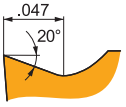
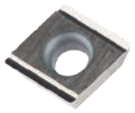
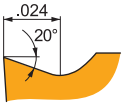
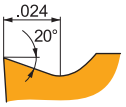
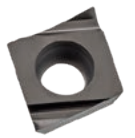
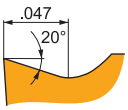
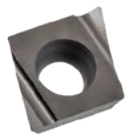
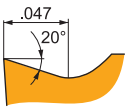
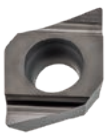
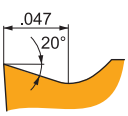
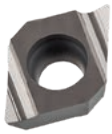
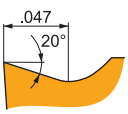


WCGX

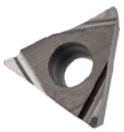
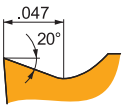
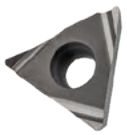
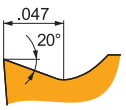
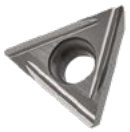
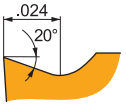
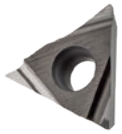
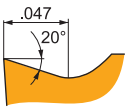
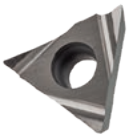
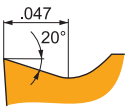
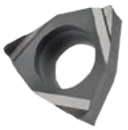
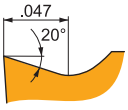
	IC (inch)	D1 (inch)	L (inch)	S (inch)
1.21	.156	.087	.106	.063



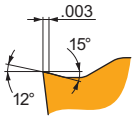
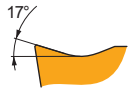
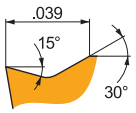
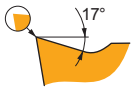
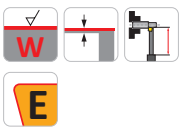
Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our cutting conditions app for further options.

Product		RE	P			M			K			N			S			H			MID
		(inch)	vc (ft/min)	f (in/rev)	ap (inch)	vc (ft/min)	f (in/rev)	ap (inch)	vc (ft/min)	f (in/rev)	ap (inch)	vc (ft/min)	f (in/rev)	ap (inch)	vc (ft/min)	f (in/rev)	ap (inch)	vc (ft/min)	f (in/rev)	ap (inch)	
																					
JQ chip breaker is sharp and designed for fine-finishing of Steels. It features highly positive rake angle without T-land. It's also conditionally suitable for Stainless steels.																					
CPGX 2.521FR-JQ	**TT010**	.016	■ 1148	.0024	.020	◪ 689	.002	.020	–	–	–	–	–	–	–	–	–	–	–	–	7080621
																					
JQ chip breaker is sharp and designed for fine-finishing of Steels. It features highly positive rake angle without T-land. It's also conditionally suitable for Stainless steels.																					
CPGX 2.521FL-JQ	**TT010**	.016	■ 1148	.0024	.020	◪ 689	.002	.020	–	–	–	–	–	–	–	–	–	–	–	–	7080619
CPGX 32.51FL-JQ	**TT010**	.016	■ 1148	.0024	.020	◪ 689	.002	.020	–	–	–	–	–	–	–	–	–	–	–	–	7080614
																					
JR chip breaker is sharp and designed for fine-finishing of Steels. It features highly positive rake angle without T-land. It's also conditionally suitable for Stainless steels.																					
CPGX 2.521FR-JR	**TT010**	.016	■ 1148	.0024	.020	◪ 689	.002	.020	–	–	–	–	–	–	–	–	–	–	–	–	7080622
CPGX 21.51FR-JR	**TT010**	.016	■ 1148	.0024	.020	◪ 689	.002	.020	–	–	–	–	–	–	–	–	–	–	–	–	7080618
																					
JR chip breaker is sharp and designed for fine-finishing of Steels. It features highly positive rake angle without T-land. It's also conditionally suitable for Stainless steels.																					
CPGX 2.521FL-JR	**TT010**	.016	■ 1148	.0024	.020	◪ 689	.002	.020	–	–	–	–	–	–	–	–	–	–	–	–	7080620
CPGX 21.51FL-JR	**TT010**	.016	■ 1148	.0024	.020	◪ 689	.002	.020	–	–	–	–	–	–	–	–	–	–	–	–	7080617
																					
JZ chip breaker is sharp and designed for fine-finishing of Steels. It features highly positive rake angle without T-land. It's also conditionally suitable for Stainless steels.																					
CPGX 21.50.5FR-JZ	**TT010**	.008	■ 1083	.0024	.020	◪ 640	.002	.020	–	–	–	–	–	–	–	–	–	–	–	–	7080616
																					
JZ chip breaker is sharp and designed for fine-finishing of Steels. It features highly positive rake angle without T-land. It's also conditionally suitable for Stainless steels.																					
CPGX 21.50.5FL-JZ	**TT010**	.008	■ 1083	.0024	.020	◪ 640	.002	.020	–	–	–	–	–	–	–	–	–	–	–	–	7080615
																					
JZ chip breaker is sharp and designed for fine-finishing of Steels. It features highly positive rake angle without T-land. It's also conditionally suitable for Stainless steels.																					
EPGX1.81.50.5FR-JZ	**TT010**	.008	■ 968	.0024	.020	◪ 574	.002	.020	–	–	–	–	–	–	–	–	–	–	–	–	7080628
																					
JZ chip breaker is sharp and designed for fine-finishing of Steels. It features highly positive rake angle without T-land. It's also conditionally suitable for Stainless steels.																					
EPGX1.81.50.5FL-JZ	**TT010**	.008	■ 968	.0024	.020	◪ 574	.002	.020	–	–	–	–	–	–	–	–	–	–	–	–	7080627

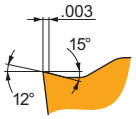
Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our cutting conditions app for further options.

Product		RE	P			M			K			N			S			H			MID
		(inch)	vc (ft/min)	f (in/rev)	ap (inch)	vc (ft/min)	f (in/rev)	ap (inch)	vc (ft/min)	f (in/rev)	ap (inch)	vc (ft/min)	f (in/rev)	ap (inch)	vc (ft/min)	f (in/rev)	ap (inch)	vc (ft/min)	f (in/rev)	ap (inch)	
																					
JQ chip breaker is sharp and designed for fine-finishing of Steels. It features highly positive rake angle without T-land. It's also conditionally suitable for Stainless steels.																					
TPGX 21.51FR-JQ	**TT010**	.016	968	.0024	.020	574	.002	.020	–	–	–	–	–	–	–	–	–	–	–	–	7080637
																					
JQ chip breaker is sharp and designed for fine-finishing of Steels. It features highly positive rake angle without T-land. It's also conditionally suitable for Stainless steels.																					
TPGX 1.81.51FL-JQ	**TT010**	.016	968	.0024	.020	574	.002	.020	–	–	–	–	–	–	–	–	–	–	–	–	7080635
TPGX 21.51FL-JQ	**TT010**	.016	968	.0024	.020	574	.002	.020	–	–	–	–	–	–	–	–	–	–	–	–	7080636
																					
JR chip breaker is sharp and designed for fine-finishing of Steels. It features highly positive rake angle without T-land. It's also conditionally suitable for Stainless steels.																					
TPGX 32.51FL-JR	**TT010**	.016	968	.0024	.020	574	.002	.020	–	–	–	–	–	–	–	–	–	–	–	–	7080632
																					
JZ chip breaker is sharp and designed for fine-finishing of Steels. It features highly positive rake angle without T-land. It's also conditionally suitable for Stainless steels.																					
TPGX1.81.50.5FR-JZ	**TT010**	.008	919	.0024	.020	541	.002	.020	–	–	–	–	–	–	–	–	–	–	–	–	7080634
																					
JZ chip breaker is sharp and designed for fine-finishing of Steels. It features highly positive rake angle without T-land. It's also conditionally suitable for Stainless steels.																					
TPGX1.81.50.5FL-JZ	**TT010**	.008	919	.0024	.020	541	.002	.020	–	–	–	–	–	–	–	–	–	–	–	–	7080633
																					
JZ chip breaker is sharp and designed for fine-finishing of Steels. It features highly positive rake angle without T-land. It's also conditionally suitable for Stainless steels.																					
WCGX 1.210.5FL-JZ	**TT010**	.008	1083	.0024	.020	640	.002	.020	–	–	–	–	–	–	–	–	–	–	–	–	7080640

FINISHING – NAVIGATOR

FM			**FM** chip breaker is versatile and the first choice for finishing of Steels. It features positive rake angle and positive, narrow T-land. It's also suitable for Stainless steels, and conditionally for Cast irons and Non-ferrous alloys.
NF2			**NF2** chip breaker is sharp and the first choice for finishing of Stainless steels. It features positive rake angle without T-land. It's also suitable for Super-alloys, and conditionally for Steels, Cast irons and Non-ferrous alloys.
UR			**UR** chip breaker is versatile and the first choice for finishing of Cast irons. It features positive rake angle without T-land. It's also suitable for Steels, and conditionally for Stainless steels.
W -FM			**W-FM** chip breaker has wiper edge and is designed for finishing of Steels, Stainless steels and Cast irons. It features positive rake angle and positive, narrow T-land.
W -UR			**W-UR** chip breaker has wiper edge and is designed for finishing of Steels and Cast irons. It features positive rake angle without T-land. It's also conditionally suitable for Stainless steels.

FM

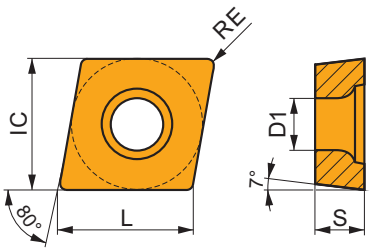


FM chip breaker is versatile and the first choice for finishing of Steels. It features positive rake angle and positive, narrow T-land. It's also suitable for Stainless steels, and conditionally for Cast irons and Non-ferrous alloys.

PRAMET

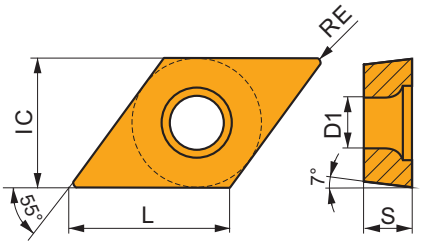
CCMT

	IC (inch)	D1 (inch)	L (inch)	S (inch)
21.5	.250	.110	.252	.094
32.5	.375	.173	.382	.156
43	.500	.217	.508	.187



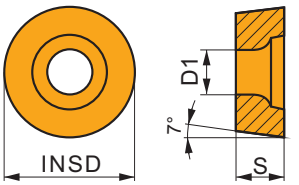
DCMT

	IC (inch)	D1 (inch)	L (inch)	S (inch)
21.5	.250	.110	.307	.094
32.5	.375	.173	.457	.156



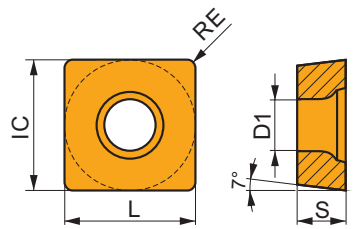
RCMT

	IC (inch)	D1 (inch)	S (inch)
0602	.236	.110	.094
0803	.315	.134	.125
10T3	.394	.173	.156
1204	.472	.173	.187



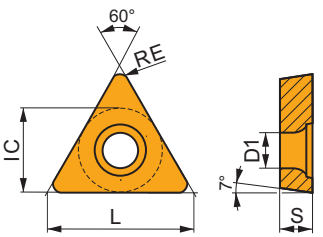
SCMT

	IC (inch)	D1 (inch)	L (inch)	S (inch)
32.5	.375	.173	.375	.156
43	.500	.217	.500	.187



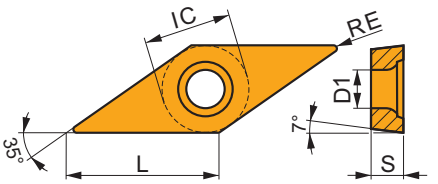
TCMT

	IC (inch)	D1 (inch)	L (inch)	S (inch)
21.5	.250	.110	.433	.094
32.5	.375	.173	.650	.156



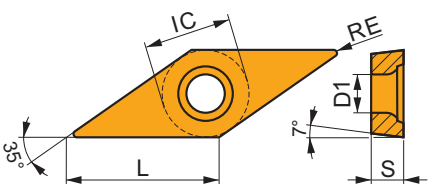
VBMT

	IC (inch)	D1 (inch)	L (inch)	S (inch)
22	.250	.110	.437	.125
33	.375	.173	.654	.187



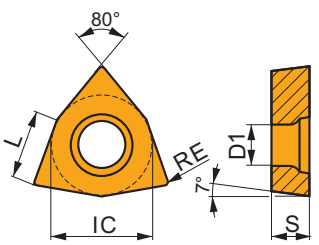
VCMT

	IC (inch)	D1 (inch)	L (inch)	S (inch)
33	.375	.173	.654	.187



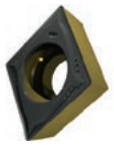
WCMT

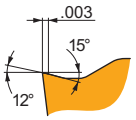
	IC (inch)	D1 (inch)	L (inch)	S (inch)
32	.375	.173	.256	.156
32.5	.375	.173	.256	.156
43	.500	.217	.343	.187



Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our cutting conditions app for further options.

Product		RE	P			M			K			N			S			H			MID
			vc (ft/min)	f (in/rev)	ap (inch)	vc (ft/min)	f (in/rev)	ap (inch)	vc (ft/min)	f (in/rev)	ap (inch)	vc (ft/min)	f (in/rev)	ap (inch)	vc (ft/min)	f (in/rev)	ap (inch)	vc (ft/min)	f (in/rev)	ap (inch)	

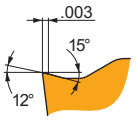
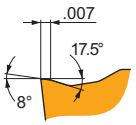




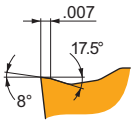
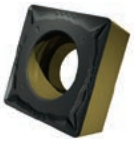
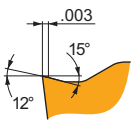
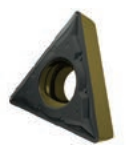
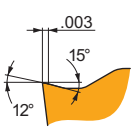
FM chip breaker is versatile and the first choice for finishing of Steels. It features positive rake angle and positive, narrow T-land. It's also suitable for Stainless steels, and conditionally for Cast irons and Non-ferrous alloys.

CCMT 21.50.5-FM	**T7325**	.008	689	.0039	.039	525	.0035	.039	–	–	–	–	–	–	–	–	–	–	–	–	7156160
	T7335	.008	689	.0039	.039	525	.0035	.039	–	–	–	–	–	–	–	–	–	–	–	–	6754732
	T8315	.008	640	.0039	.039	377	.0035	.039	607	.0039	.039	1919	.0047	.039	–	–	–	–	–	–	6753571
	T8415	.008	787	.0039	.039	410	.0035	.039	705	.0039	.039	1969	.0047	.039	–	–	–	–	–	–	8553201
	T8430	.008	755	.0039	.039	410	.0035	.039	607	.0039	.039	2067	.0047	.039	–	–	–	–	–	–	7973796
	T9325	.008	935	.0039	.039	558	.0035	.039	886	.0039	.039	–	–	–	–	–	–	–	–	–	6753864
	T9415	.008	1099	.0039	.039	–	–	–	1033	.0039	.039	–	–	–	–	–	–	–	–	–	8345915
CCMT 21.51-FM	**T7325**	.016	656	.0059	.039	509	.0059	.039	–	–	–	–	–	–	–	–	–	–	–	–	7156162
	T7335	.016	640	.0059	.039	492	.0059	.039	–	–	–	–	–	–	–	–	–	–	–	–	6754734
	T8315	.016	607	.0059	.039	361	.0055	.039	574	.0059	.039	1821	.0071	.039	–	–	–	–	–	–	6753573
	T8415	.016	738	.0059	.039	377	.0053	.039	673	.0059	.039	1870	.0071	.039	–	–	–	–	–	–	8553204
	T8430	.016	673	.0059	.039	361	.0055	.039	558	.0059	.039	1870	.0071	.039	–	–	–	–	–	–	7973799
	T9325	.016	820	.0059	.039	492	.0059	.039	771	.0059	.039	–	–	–	–	–	–	–	–	–	6753762
	T9415	.016	1017	.0059	.039	–	–	–	951	.0059	.039	–	–	–	–	–	–	–	–	–	8244360
CCMT 21.52-FM	**T7325**	.031	722	.0079	.039	558	.0071	.039	–	–	–	–	–	–	–	–	–	–	–	–	7156165
	T8430	.031	722	.0079	.039	394	.0071	.039	591	.0079	.039	1969	.0094	.039	–	–	–	–	–	–	7973811
	T9325	.031	869	.0079	.039	509	.0071	.039	820	.0079	.039	–	–	–	–	–	–	–	–	–	6753868
	T9415	.031	1099	.0079	.039	–	–	–	1033	.0079	.039	–	–	–	–	–	–	–	–	–	8244361
CCMT 32.50.5-FM	**T7325**	.008	673	.0039	.047	509	.0035	.047	–	–	–	–	–	–	–	–	–	–	–	–	7156169
	T7335	.008	673	.0039	.047	509	.0035	.047	–	–	–	–	–	–	–	–	–	–	–	–	6754736
	T8415	.008	755	.0039	.047	394	.0035	.047	689	.0039	.047	1919	.0047	.047	–	–	–	–	–	–	8553207
	T8430	.008	738	.0039	.047	394	.0035	.047	607	.0039	.047	2018	.0047	.047	–	–	–	–	–	–	7973813
	T9325	.008	902	.0039	.047	541	.0035	.047	853	.0039	.047	–	–	–	–	–	–	–	–	–	6753869
	T9415	.008	1083	.0039	.047	–	–	–	1017	.0039	.047	–	–	–	–	–	–	–	–	–	8345886
CCMT 32.51-FM	**T7325**	.016	640	.0059	.047	492	.0059	.047	–	–	–	–	–	–	–	–	–	–	–	–	7156170
	T7335	.016	623	.0059	.047	476	.0059	.047	–	–	–	–	–	–	–	–	–	–	–	–	6754737
	T8315	.016	591	.0059	.047	344	.0055	.047	558	.0059	.047	1772	.0071	.047	–	–	–	–	–	–	6753578
	T8415	.016	722	.0059	.047	377	.0053	.047	656	.0059	.047	1821	.0071	.047	–	–	–	–	–	–	8553209
	T8430	.016	656	.0059	.047	361	.0055	.047	541	.0059	.047	1821	.0071	.047	–	–	–	–	–	–	7973815
	T9325	.016	804	.0059	.047	476	.0059	.047	755	.0059	.047	–	–	–	–	–	–	–	–	–	6753764
	T9415	.016	1001	.0059	.047	–	–	–	935	.0059	.047	–	–	–	–	–	–	–	–	–	8244334
CCMT 32.52-FM	**T7325**	.031	705	.0079	.047	541	.0071	.047	–	–	–	–	–	–	–	–	–	–	–	–	7156173
	T7335	.031	673	.0079	.047	509	.0071	.047	–	–	–	–	–	–	–	–	–	–	–	–	6754740
	T8315	.031	640	.0079	.047	377	.0071	.047	607	.0079	.047	1919	.0094	.047	–	–	–	–	–	–	6753580
	T8415	.031	787	.0079	.047	410	.0071	.047	705	.0079	.047	1969	.0094	.047	–	–	–	–	–	–	8553212
	T8430	.031	689	.0079	.047	377	.0071	.047	574	.0079	.047	1919	.0094	.047	–	–	–	–	–	–	7973818
	T9325	.031	853	.0079	.047	509	.0071	.047	804	.0079	.047	–	–	–	–	–	–	–	–	–	6753767
	T9415	.031	1083	.0079	.047	–	–	–	1017	.0079	.047	–	–	–	–	–	–	–	–	–	8244337
CCMT 431-FM	**T7325**	.016	623	.0059	.067	476	.0059	.067	–	–	–	–	–	–	–	–	–	–	–	–	7156176
	T7335	.016	607	.0059	.067	459	.0059	.067	–	–	–	–	–	–	–	–	–	–	–	–	6754743
	T8315	.016	558	.0059	.067	328	.0055	.067	525	.0059	.067	1673	.0071	.067	–	–	–	–	–	–	6753582
	T8415	.016	689	.0059	.067	361	.0053	.067	623	.0059	.067	1722	.0071	.067	–	–	–	–	–	–	8553215
	T8430	.016	640	.0059	.067	344	.0055	.067	525	.0059	.067	1772	.0071	.067	–	–	–	–	–	–	7973822
	T9325	.016	787	.0059	.067	459	.0059	.067	738	.0059	.067	–	–	–	–	–	–	–	–	–	6753770
	T9415	.016	968	.0059	.067	–	–	–	919	.0059	.067	–	–	–	–	–	–	–	–	–	8244362
CCMT 432-FM	**T7325**	.031	673	.0079	.067	509	.0071	.067	–	–	–	–	–	–	–	–	–	–	–	–	7156178
	T7335	.031	656	.0079	.067	509	.0071	.067	–	–	–	–	–	–	–	–	–	–	–	–	6754744
	T8315	.031	623	.0079	.067	361	.0071	.067	591	.0079	.067	1870	.0094	.067	–	–	–	–	–	–	6753583
	T8415	.031	755	.0079	.067	394	.0071	.067	689	.0079	.067	1919	.0094	.067	–	–	–	–	–	–	8553216
	T8430	.031	673	.0079	.067	361	.0071	.067	558	.0079	.067	1870	.0094	.067	–	–	–	–	–	–	7973824
	T9325	.031	820	.0079	.067	492	.0071	.067	771	.0079	.067	–	–	–	–	–	–	–	–	–	6753772
	T9415	.031	1033	.0079	.067	–	–	–	968	.0079	.067	–	–	–	–	–	–	–	–	–	8244363
CCMT 433-FM	**T8430**	.047	623	.0106	.067	344	.0094	.067	509	.0106	.067	1722	.0126	.067	–	–	–	–	–	–	7977203
	T9325	.047	771	.0106	.067	459	.0094	.067	722	.0106	.067	–	–	–	–	–	–	–	–	–	6753872

Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our cutting conditions app for further options.

Product		RE	P				M				K				N				S				H				MID
			vc (ft/min)	f (in/rev)	ap (inch)		vc (ft/min)	f (in/rev)	ap (inch)		vc (ft/min)	f (in/rev)	ap (inch)		vc (ft/min)	f (in/rev)	ap (inch)		vc (ft/min)	f (in/rev)	ap (inch)		vc (ft/min)	f (in/rev)	ap (inch)		
																											
FM chip breaker is versatile and the first choice for finishing of Steels. It features positive rake angle and positive, narrow T-land. It's also suitable for Stainless steels, and conditionally for Cast irons and Non-ferrous alloys.																											
DCMT 21.50.5-FM	**T7325**	.008	574	.0039	.031		443	.0035	.031		–	–	–		–	–	–		–	–	–		–	–	–		7156243
	T8315	.008	525	.0039	.031		312	.0035	.031		492	.0039	.031		1575	.0047	.031		–	–	–		–	–	–		6753612
	T8415	.008	623	.0039	.031		328	.0035	.031		558	.0039	.031		1575	.0047	.031		–	–	–		–	–	–		8553225
	T8430	.008	607	.0039	.031		328	.0035	.031		492	.0039	.031		1673	.0047	.031		–	–	–		–	–	–		7973828
	T9325	.008	755	.0039	.031		443	.0035	.031		705	.0039	.031		–	–	–		–	–	–		–	–	–		6753773
	T9415	.008	902	.0039	.031		–	–	–		853	.0039	.031		–	–	–		–	–	–		–	–	–		8244371
DCMT 21.51-FM	**T7325**	.016	509	.0067	.031		394	.0059	.031		–	–	–		–	–	–		–	–	–		–	–	–		7156245
	T7335	.016	509	.0067	.031		394	.0059	.031		–	–	–		–	–	–		–	–	–		–	–	–		6754770
	T8315	.016	525	.0047	.031		312	.0043	.031		492	.0047	.031		1575	.0055	.031		–	–	–		–	–	–		6753592
	T8415	.016	623	.0047	.031		328	.0043	.031		558	.0047	.031		1575	.0057	.031		–	–	–		–	–	–		8553227
	T8430	.016	607	.0047	.031		328	.0043	.031		492	.0047	.031		1673	.0055	.031		–	–	–		–	–	–		7973829
	T9325	.016	623	.0071	.031		361	.0063	.031		591	.0071	.031		–	–	–		–	–	–		–	–	–		6753775
	T9415	.016	902	.0047	.031		–	–	–		853	.0047	.031		–	–	–		–	–	–		–	–	–		8244372
DCMT 32.50.5-FM	**T7325**	.008	574	.0039	.031		443	.0035	.031		–	–	–		–	–	–		–	–	–		–	–	–		7156247
	T8315	.008	525	.0039	.031		312	.0035	.031		492	.0039	.031		1575	.0047	.031		–	–	–		–	–	–		6753594
	T8415	.008	623	.0039	.031		328	.0035	.031		558	.0039	.031		1575	.0047	.031		–	–	–		–	–	–		8553229
	T8430	.008	607	.0039	.031		328	.0035	.031		492	.0039	.031		1673	.0047	.031		–	–	–		–	–	–		7973831
	T9325	.008	755	.0039	.031		443	.0035	.031		705	.0039	.031		–	–	–		–	–	–		–	–	–		6753934
	T9415	.008	902	.0039	.031		–	–	–		853	.0039	.031		–	–	–		–	–	–		–	–	–		8345930
DCMT 32.51-FM	**T7325**	.016	509	.0067	.031		394	.0059	.031		–	–	–		–	–	–		–	–	–		–	–	–		7156249
	T7335	.016	509	.0067	.031		394	.0059	.031		–	–	–		–	–	–		–	–	–		–	–	–		6754771
	T8315	.016	525	.0047	.031		312	.0043	.031		492	.0047	.031		1575	.0055	.031		–	–	–		–	–	–		6753596
	T8415	.016	623	.0047	.031		328	.0043	.031		558	.0047	.031		1575	.0057	.031		–	–	–		–	–	–		8553230
	T8430	.016	509	.0067	.031		279	.0059	.031		427	.0067	.031		1427	.0079	.031		–	–	–		–	–	–		7973834
	T9325	.016	623	.0071	.031		361	.0063	.031		591	.0071	.031		–	–	–		–	–	–		–	–	–		6753779
	T9415	.016	902	.0047	.031		–	–	–		853	.0047	.031		–	–	–		–	–	–		–	–	–		8183669
DCMT 32.52-FM	**T7325**	.031	607	.0067	.031		459	.0059	.031		–	–	–		–	–	–		–	–	–		–	–	–		7156251
	T7335	.031	591	.0067	.031		459	.0059	.031		–	–	–		–	–	–		–	–	–		–	–	–		6754774
	T8315	.031	558	.0067	.031		328	.0059	.031		525	.0067	.031		1673	.0079	.031		–	–	–		–	–	–		6753599
	T8415	.031	689	.0067	.031		361	.006	.031		623	.0067	.031		1722	.008	.031		–	–	–		–	–	–		8553232
	T8430	.031	623	.0067	.031		344	.0059	.031		509	.0067	.031		1722	.0079	.031		–	–	–		–	–	–		7973836
	T9310	.031	935	.0067	.031		–	–	–		886	.0067	.031		–	–	–		–	–	–		–	–	–		7763101
	T9315	.031	853	.0067	.031		–	–	–		804	.0067	.031		–	–	–		–	–	–		–	–	–		6753734
	T9325	.031	771	.0067	.031		459	.0059	.031		722	.0067	.031		–	–	–		–	–	–		–	–	–		6753785
	T9415	.031	951	.0067	.031		–	–	–		902	.0067	.031		–	–	–		–	–	–		–	–	–		8183840
DCMT 32.53-FM	**T8430**	.047	574	.0087	.047		312	.0087	.047		459	.0087	.047		1575	.0102	.047		–	–	–		–	–	–		7977223
	T9325	.047	689	.0087	.047		410	.0087	.047		640	.0087	.047		–	–	–		–	–	–		–	–	–		6753936
	T9415	.047	869	.0087	.047		–	–	–		820	.0087	.047		–	–	–		–	–	–		–	–	–		8244369
																											
FM chip breaker is versatile and the first choice for finishing of Steels. It features positive rake angle and positive, narrow T-land. It's also suitable for Stainless steels, and conditionally for Cast irons and Non-ferrous alloys.																											
RCMT 0602M0E-FM	**T7325**	–	705	.0177	.047		541	.0161	.047		–	–	–		–	–	–		–	–	–		–	–	–		7156315
	T8430	–	656	.0177	.047		361	.0161	.047		541	.0177	.047		1821	.0213	.047		–	–	–		–	–	–		7977231
	T9325	–	771	.0177	.047		459	.0161	.047		722	.0177	.047		–	–	–		–	–	–		–	–	–		6753983
	T9415	–	1050	.0177	.047		–	–	–		984	.0177	.047		–	–	–		–	–	–		–	–	–		8345950
RCMT 0803M0E-FM	**T7325**	–	623	.0236	.063		476	.0213	.063		–	–	–		–	–	–		–	–	–		–	–	–		7156317
	T8430	–	574	.0236	.063		312	.0213	.063		459	.0236	.063		1575	.0283	.063		–	–	–		–	–	–		7973840
	T9325	–	656	.0236	.063		394	.0213	.063		623	.0236	.063		–	–	–		–	–	–		–	–	–		6753984
	T9415	–	919	.0236	.063		–	–	–		869	.0236	.063		–	–	–		–	–	–		–	–	–		8345952

Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our cutting conditions app for further options.

Product		RE	P				M				K				N				S				H				MID
			vc (ft/min)	f (in/rev)	ap (inch)		vc (ft/min)	f (in/rev)	ap (inch)		vc (ft/min)	f (in/rev)	ap (inch)		vc (ft/min)	f (in/rev)	ap (inch)		vc (ft/min)	f (in/rev)	ap (inch)		vc (ft/min)	f (in/rev)	ap (inch)		
																											
RCMT 10T3M0E-FM	**T7325**	–	◪	607	.0256	.067	■	459	.0232	.067		–	–	–		–	–	–		–	–	–		–	–	–	7156319
	T8430	–	■	558	.0256	.067	■	295	.0232	.067	◪	443	.0256	.067	◪	1526	.0307	.067		–	–	–		–	–	–	7977233
	T9325	–	■	640	.0256	.067	■	377	.0232	.067	◪	607	.0256	.067		–	–	–		–	–	–		–	–	–	6753985
	T9415	–	■	902	.0256	.067		–	–	–	◪	853	.0256	.067		–	–	–		–	–	–		–	–	–	8345948
RCMT 1204M0E-FM	**T7325**	–	◪	574	.0276	.071	■	443	.0248	.071		–	–	–		–	–	–		–	–	–		–	–	–	7156321
	T8430	–	■	509	.0276	.071	■	279	.0248	.071	◪	427	.0276	.071	◪	1427	.0331	.071		–	–	–		–	–	–	7977234
	T9325	–	■	623	.0276	.071	■	361	.0248	.071	◪	591	.0276	.071		–	–	–		–	–	–		–	–	–	6753986
	T9415	–	■	853	.0276	.071		–	–	–	◪	804	.0276	.071		–	–	–		–	–	–		–	–	–	8244375
																											
SCMT 32.51-FM	**T7325**	.016	◪	673	.0059	.047	■	509	.0059	.047		–	–	–		–	–	–		–	–	–		–	–	–	7156323
	T7335	.016	◪	656	.0059	.047	■	509	.0059	.047		–	–	–		–	–	–		–	–	–		–	–	–	6754798
	T8315	.016	◪	623	.0059	.047	■	361	.0055	.047	◪	591	.0059	.047	◪	1870	.0071	.047		–	–	–		–	–	–	6753613
	T8415	.016	■	755	.0059	.047	■	394	.0053	.047	◪	689	.0059	.047	◪	1919	.0071	.047		–	–	–		–	–	–	8553245
	T8430	.016	■	689	.0059	.047	■	377	.0055	.047	◪	574	.0059	.047	◪	1919	.0071	.047		–	–	–		–	–	–	7973844
	T9325	.016	■	853	.0059	.047	■	509	.0059	.047	◪	804	.0059	.047		–	–	–		–	–	–		–	–	–	6753998
	T9415	.016	■	1050	.0059	.047		–	–	–	◪	984	.0059	.047		–	–	–		–	–	–		–	–	–	8345956
SCMT 32.52-FM	**T7325**	.031	◪	738	.0079	.047	■	574	.0071	.047		–	–	–		–	–	–		–	–	–		–	–	–	7156325
	T7335	.031	◪	705	.0079	.047	■	541	.0071	.047		–	–	–		–	–	–		–	–	–		–	–	–	6754799
	T8315	.031	◪	673	.0079	.047	■	394	.0071	.047	◪	623	.0079	.047	◪	2018	.0094	.047		–	–	–		–	–	–	6753614
	T8415	.031	■	820	.0079	.047	■	427	.0071	.047	◪	738	.0079	.047	◪	2067	.0094	.047		–	–	–		–	–	–	8553246
	T8430	.031	■	738	.0079	.047	■	394	.0071	.047	◪	607	.0079	.047	◪	2018	.0094	.047		–	–	–		–	–	–	7973846
	T9325	.031	■	902	.0079	.047	■	541	.0071	.047	◪	853	.0079	.047		–	–	–		–	–	–		–	–	–	6753833
	T9415	.031	■	1148	.0079	.047		–	–	–	◪	1083	.0079	.047		–	–	–		–	–	–		–	–	–	8345958
SCMT 431-FM	**T7325**	.016	◪	640	.0059	.063	■	492	.0059	.063		–	–	–		–	–	–		–	–	–		–	–	–	7156327
	T8415	.016	■	738	.0059	.063	■	377	.0053	.063	◪	673	.0059	.063	◪	1870	.0071	.063		–	–	–		–	–	–	8553247
	T8430	.016	■	673	.0059	.063	■	361	.0055	.063	◪	558	.0059	.063	◪	1870	.0071	.063		–	–	–		–	–	–	7977242
	T9325	.016	■	820	.0059	.063	■	492	.0059	.063	◪	771	.0059	.063		–	–	–		–	–	–		–	–	–	6753999
	T9415	.016	■	1033	.0059	.063		–	–	–	◪	968	.0059	.063		–	–	–		–	–	–		–	–	–	8345961
SCMT 432-FM	**T7325**	.031	◪	705	.0079	.063	■	541	.0071	.063		–	–	–		–	–	–		–	–	–		–	–	–	7156328
	T7335	.031	◪	689	.0079	.063	■	525	.0071	.063		–	–	–		–	–	–		–	–	–		–	–	–	6754801
	T8315	.031	◪	656	.0079	.063	■	394	.0071	.063	◪	623	.0079	.063	◪	1969	.0094	.063		–	–	–		–	–	–	6753616
	T8415	.031	■	804	.0079	.063	■	410	.0071	.063	◪	722	.0079	.063	◪	2018	.0094	.063		–	–	–		–	–	–	8553248
	T8430	.031	■	722	.0079	.063	■	394	.0071	.063	◪	591	.0079	.063	◪	1969	.0094	.063		–	–	–		–	–	–	7973848
	T9325	.031	■	869	.0079	.063	■	509	.0071	.063	◪	820	.0079	.063		–	–	–		–	–	–		–	–	–	6753835
	T9415	.031	■	1115	.0079	.063		–	–	–	◪	1050	.0079	.063		–	–	–		–	–	–		–	–	–	8345962
SCMT 433-FM	**T8430**	.047	■	656	.0106	.063	■	361	.0094	.063	◪	541	.0106	.063	◪	1821	.0126	.063		–	–	–		–	–	–	7977244
	T9325	.047	■	804	.0106	.063	■	476	.0094	.063	◪	755	.0106	.063		–	–	–		–	–	–		–	–	–	6754000
	T9415	.047	■	1050	.0106	.063		–	–	–	◪	984	.0106	.063		–	–	–		–	–	–		–	–	–	8345965
																											
TCMT 21.50.5-FM	**T7325**	.008	◪	607	.0039	.031	■	459	.0035	.031		–	–	–		–	–	–		–	–	–		–	–	–	7156368
	T7335	.008	◪	607	.0039	.031	■	459	.0035	.031		–	–	–		–	–	–		–	–	–		–	–	–	6754815
	T8315	.008	◪	558	.0039	.031	■	328	.0035	.031	◪	525	.0039	.031	◪	1673	.0047	.031		–	–	–		–	–	–	6753620
	T8415	.008	■	656	.0039	.031	■	344	.0035	.031	◪	607	.0039	.031	◪	1673	.0047	.031		–	–	–		–	–	–	8553256
	T8430	.008	■	640	.0039	.031	■	344	.0035	.031	◪	525	.0039	.031	◪	1772	.0047	.031		–	–	–		–	–	–	7973853
	T9325	.008	■	804	.0039	.031	■	476	.0035	.031	◪	755	.0039	.031		–	–	–		–	–	–		–	–	–	6754099
	T9415	.008	■	951	.0039	.031		–	–	–	◪	902	.0039	.031		–	–	–		–	–	–		–	–	–	8345976

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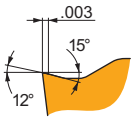
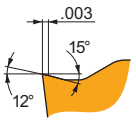
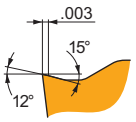
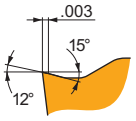
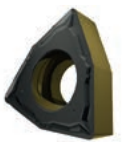
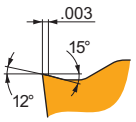
Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our cutting conditions app for further options.

Product		RE	P			M			K			N			S			H			MID
			vc (ft/min)	f (in/rev)	ap (inch)	vc (ft/min)	f (in/rev)	ap (inch)	vc (ft/min)	f (in/rev)	ap (inch)	vc (ft/min)	f (in/rev)	ap (inch)	vc (ft/min)	f (in/rev)	ap (inch)	vc (ft/min)	f (in/rev)	ap (inch)	
																					
			FM chip breaker is versatile and the first choice for finishing of Steels. It features positive rake angle and positive, narrow T-land. It's also suitable for Stainless steels, and conditionally for Cast irons and Non-ferrous alloys.																	
TCMT 21.51-FM	**T7325**	.016	525	.0075	.031	394	.0067	.031	–	–	–	–	–	–	–	–	–	–	–	–	7156369
	T7335	.016	509	.0075	.031	394	.0067	.031	–	–	–	–	–	–	–	–	–	–	–	–	6754816
	T8315	.016	558	.0047	.031	328	.0043	.031	525	.0047	.031	1673	.0055	.031	–	–	–	–	–	–	6753621
	T8415	.016	689	.0047	.031	361	.0043	.031	623	.0047	.031	1722	.0057	.031	–	–	–	–	–	–	8553257
	T8430	.016	640	.0047	.031	344	.0043	.031	525	.0047	.031	1772	.0055	.031	–	–	–	–	–	–	7973855
	T9325	.016	673	.0071	.031	394	.0063	.031	623	.0071	.031	–	–	–	–	–	–	–	–	–	6753843
	T9415	.016	968	.0047	.031	–	–	–	919	.0047	.031	–	–	–	–	–	–	–	–	–	8244380
TCMT 21.52-FM	**T7325**	.031	640	.0067	.031	492	.0059	.031	–	–	–	–	–	–	–	–	–	–	–	–	7156371
	T8430	.031	656	.0067	.031	361	.0059	.031	541	.0067	.031	1821	.0079	.031	–	–	–	–	–	–	7973858
	T9325	.031	820	.0067	.031	492	.0059	.031	771	.0067	.031	–	–	–	–	–	–	–	–	–	6755666
	T9415	.031	1017	.0067	.031	–	–	–	951	.0067	.031	–	–	–	–	–	–	–	–	–	8244382
TCMT 32.51-FM	**T7325**	.016	492	.0075	.067	377	.0067	.067	–	–	–	–	–	–	–	–	–	–	–	–	7156372
	T7335	.016	476	.0075	.067	361	.0067	.067	–	–	–	–	–	–	–	–	–	–	–	–	6754817
	T8415	.016	623	.0047	.067	328	.0043	.067	558	.0047	.067	1575	.0057	.067	–	–	–	–	–	–	8553258
	T8430	.016	591	.0047	.067	312	.0043	.067	476	.0047	.067	1624	.0055	.067	–	–	–	–	–	–	7973859
	T9325	.016	623	.0071	.067	361	.0063	.067	591	.0071	.067	–	–	–	–	–	–	–	–	–	6754101
	T9415	.016	886	.0047	.067	–	–	–	837	.0047	.067	–	–	–	–	–	–	–	–	–	8345969
TCMT 32.52-FM	**T7325**	.031	591	.0067	.067	459	.0059	.067	–	–	–	–	–	–	–	–	–	–	–	–	7156374
	T7335	.031	574	.0067	.067	443	.0059	.067	–	–	–	–	–	–	–	–	–	–	–	–	6754818
	T8315	.031	558	.0067	.067	328	.0059	.067	525	.0067	.067	1673	.0079	.067	–	–	–	–	–	–	6753623
	T8415	.031	689	.0067	.067	361	.006	.067	623	.0067	.067	1722	.008	.067	–	–	–	–	–	–	8553260
	T8430	.031	607	.0067	.067	328	.0059	.067	492	.0067	.067	1673	.0079	.067	–	–	–	–	–	–	7973861
	T9325	.031	755	.0067	.067	443	.0059	.067	705	.0067	.067	–	–	–	–	–	–	–	–	–	6753844
	T9415	.031	935	.0067	.067	–	–	–	886	.0067	.067	–	–	–	–	–	–	–	–	–	8345973
																					
			FM chip breaker is versatile and the first choice for finishing of Steels. It features positive rake angle and positive, narrow T-land. It's also suitable for Stainless steels, and conditionally for Cast irons and Non-ferrous alloys.																	
VBMT 220.5-FM	**T7325**	.008	525	.0039	.031	394	.0035	.031	–	–	–	–	–	–	–	–	–	–	–	–	7156413
	T8315	.008	476	.0039	.031	279	.0035	.031	443	.0039	.031	1427	.0047	.031	–	–	–	–	–	–	6753628
	T8415	.008	591	.0039	.031	295	.0035	.031	525	.0039	.031	1476	.0047	.031	–	–	–	–	–	–	8553263
	T8430	.008	558	.0039	.031	295	.0035	.031	443	.0039	.031	1526	.0047	.031	–	–	–	–	–	–	7973864
	T9325	.008	689	.0039	.031	410	.0035	.031	640	.0039	.031	–	–	–	–	–	–	–	–	–	6754426
VBMT 221-FM	**T7325**	.016	459	.0075	.031	344	.0067	.031	–	–	–	–	–	–	–	–	–	–	–	–	7156414
	T7335	.016	443	.0075	.031	344	.0067	.031	–	–	–	–	–	–	–	–	–	–	–	–	6754830
	T8315	.016	476	.0047	.031	279	.0043	.031	443	.0047	.031	1427	.0055	.031	–	–	–	–	–	–	6753629
	T8415	.016	591	.0047	.031	295	.0043	.031	525	.0047	.031	1476	.0057	.031	–	–	–	–	–	–	8553264
	T8430	.016	558	.0047	.031	295	.0043	.031	443	.0047	.031	1526	.0055	.031	–	–	–	–	–	–	7973865
	T9325	.016	574	.0075	.031	344	.0067	.031	541	.0075	.031	–	–	–	–	–	–	–	–	–	6754427
	T9415	.016	837	.0047	.031	–	–	–	787	.0047	.031	–	–	–	–	–	–	–	–	–	8244383
VBMT 222-FM	**T7325**	.031	558	.0067	.031	427	.0059	.031	–	–	–	–	–	–	–	–	–	–	–	–	7156415
	T8430	.031	574	.0067	.031	312	.0059	.031	459	.0067	.031	1575	.0079	.031	–	–	–	–	–	–	7973866
	T9325	.031	705	.0067	.031	410	.0059	.031	656	.0067	.031	–	–	–	–	–	–	–	–	–	6754428
	T9415	.031	886	.0067	.031	–	–	–	837	.0067	.031	–	–	–	–	–	–	–	–	–	8183842
VBMT 330.5-FM	**T7325**	.008	492	.0039	.047	377	.0035	.047	–	–	–	–	–	–	–	–	–	–	–	–	7156416
	T8430	.008	541	.0039	.047	295	.0035	.047	443	.0039	.047	1476	.0047	.047	–	–	–	–	–	–	7973867
	T9325	.008	673	.0039	.047	394	.0035	.047	623	.0039	.047	–	–	–	–	–	–	–	–	–	6754429
	T9415	.008	804	.0039	.047	–	–	–	755	.0039	.047	–	–	–	–	–	–	–	–	–	8244384

Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our cutting conditions app for further options.

Product		RE	P				M				K				N				S				H				MID
			vc (ft/min)	f (in/rev)	ap (inch)		vc (ft/min)	f (in/rev)	ap (inch)		vc (ft/min)	f (in/rev)	ap (inch)		vc (ft/min)	f (in/rev)	ap (inch)		vc (ft/min)	f (in/rev)	ap (inch)		vc (ft/min)	f (in/rev)	ap (inch)		
																											
VBMT 331-FM	**T5315**	.016	◪	738	.0047	.047		–	–	–	◪	689	.0047	.047		–	–	–		–	–	–		–	–	–	6755709
	T7325	.016	◪	427	.0075	.047	■	328	.0067	.047		–	–	–		–	–	–		–	–	–		–	–	–	7156417
	T7335	.016	◪	427	.0075	.047	■	328	.0067	.047		–	–	–		–	–	–		–	–	–		–	–	–	6754831
	T8315	.016	◪	459	.0047	.047	■	262	.0043	.047	◪	427	.0047	.047	◪	1378	.0055	.047		–	–	–		–	–	–	6753630
	T8415	.016	■	558	.0047	.047	■	295	.0043	.047	◪	509	.0047	.047	◪	1427	.0057	.047		–	–	–		–	–	–	8553265
	T8430	.016	■	541	.0047	.047	■	295	.0043	.047	◪	443	.0047	.047	◪	1476	.0055	.047		–	–	–		–	–	–	7973869
	T9325	.016	■	541	.0075	.047	■	312	.0067	.047	◪	509	.0075	.047		–	–	–		–	–	–		–	–	–	6754430
	T9415	.016	■	804	.0047	.047		–	–	–	◪	755	.0047	.047		–	–	–		–	–	–		–	–	–	8244385
VBMT 332-FM	**T5315**	.031	◪	771	.0067	.047		–	–	–	◪	722	.0067	.047		–	–	–		–	–	–		–	–	–	6755712
	T7325	.031	◪	541	.0067	.047	■	410	.0059	.047		–	–	–		–	–	–		–	–	–		–	–	–	7156419
	T7335	.031	◪	525	.0067	.047	■	394	.0059	.047		–	–	–		–	–	–		–	–	–		–	–	–	6754833
	T8315	.031	◪	492	.0067	.047	■	295	.0059	.047	◪	459	.0067	.047	◪	1476	.0079	.047		–	–	–		–	–	–	6753631
	T8415	.031	■	607	.0067	.047	■	312	.006	.047	◪	541	.0067	.047	◪	1526	.008	.047		–	–	–		–	–	–	8553266
	T8430	.031	■	558	.0067	.047	■	295	.0059	.047	◪	443	.0067	.047	◪	1526	.0079	.047		–	–	–		–	–	–	7973871
	T9315	.031	■	755	.0067	.047		–	–	–	◪	705	.0067	.047		–	–	–		–	–	–		–	–	–	6753753
	T9325	.031	■	673	.0067	.047	■	394	.0059	.047	◪	623	.0067	.047		–	–	–		–	–	–		–	–	–	6753855
	T9415	.031	■	853	.0067	.047		–	–	–	◪	804	.0067	.047		–	–	–		–	–	–		–	–	–	8244388
VBMT 333-FM	**T7325**	.047	◪	525	.0087	.047	■	394	.0087	.047		–	–	–		–	–	–		–	–	–		–	–	–	7156421
	T8430	.047	■	509	.0087	.047	■	279	.0087	.047	◪	427	.0087	.047	◪	1427	.0102	.047		–	–	–		–	–	–	7977266
	T9325	.047	■	640	.0087	.047	■	377	.0087	.047	◪	607	.0087	.047		–	–	–		–	–	–		–	–	–	6754431
	T9415	.047	■	804	.0087	.047		–	–	–	◪	755	.0087	.047		–	–	–		–	–	–		–	–	–	8244391
																											
VCMT 331-FM	**T7325**	.016	◪	410	.0075	.047	■	312	.0067	.047		–	–	–		–	–	–		–	–	–		–	–	–	7156428
	T8430	.016	■	492	.0047	.047	■	262	.0043	.047	◪	410	.0047	.047	◪	1378	.0055	.047		–	–	–		–	–	–	7973875
	T9325	.016	■	509	.0075	.047	■	295	.0067	.047	◪	476	.0075	.047		–	–	–		–	–	–		–	–	–	6755663
	T9415	.016	■	755	.0047	.047		–	–	–	◪	705	.0047	.047		–	–	–		–	–	–		–	–	–	8244394
VCMT 332-FM	**T7325**	.031	◪	509	.0067	.047	■	394	.0059	.047		–	–	–		–	–	–		–	–	–		–	–	–	7156430
	T8430	.031	■	509	.0067	.047	■	279	.0059	.047	◪	427	.0067	.047	◪	1427	.0079	.047		–	–	–		–	–	–	7973876
	T9325	.031	■	640	.0067	.047	■	377	.0059	.047	◪	607	.0067	.047		–	–	–		–	–	–		–	–	–	6755665
	T9415	.031	■	804	.0067	.047		–	–	–	◪	755	.0067	.047		–	–	–		–	–	–		–	–	–	8244395
																											
WCMT 32.51-FM	**T8415**	.016	■	722	.0059	.047	■	377	.0053	.047	◪	656	.0059	.047	◪	1821	.0071	.047		–	–	–		–	–	–	8553291
	T8430	.016	■	656	.0059	.047	■	361	.0055	.047	◪	541	.0059	.047	◪	1821	.0071	.047		–	–	–		–	–	–	7977279
	T9325	.016	■	804	.0059	.047	■	476	.0059	.047	◪	755	.0059	.047		–	–	–		–	–	–		–	–	–	6754442
	T9415	.016	■	1001	.0059	.047		–	–	–	◪	935	.0059	.047		–	–	–		–	–	–		–	–	–	8345992
WCMT 32.52-FM	**T7325**	.031	◪	705	.0079	.047	■	541	.0071	.047		–	–	–		–	–	–		–	–	–		–	–	–	7156447
	T7335	.031	◪	673	.0079	.047	■	509	.0071	.047		–	–	–		–	–	–		–	–	–		–	–	–	6754839
	T8415	.031	■	787	.0079	.047	■	410	.0071	.047	◪	705	.0079	.047	◪	1969	.0094	.047		–	–	–		–	–	–	8553292
	T8430	.031	■	689	.0079	.047	■	377	.0071	.047	◪	574	.0079	.047	◪	1919	.0094	.047		–	–	–		–	–	–	7977280
	T9325	.031	■	853	.0079	.047	■	509	.0071	.047	◪	804	.0079	.047		–	–	–		–	–	–		–	–	–	6754443
	T9415	.031	■	1083	.0079	.047		–	–	–	◪	1017	.0079	.047		–	–	–		–	–	–		–	–	–	8345993
WCMT 431-FM	**T8430**	.016	■	640	.0059	.067	■	344	.0055	.067	◪	525	.0059	.067	◪	1772	.0071	.067		–	–	–		–	–	–	7977281
	T9325	.016	■	787	.0059	.067	■	459	.0059	.067	◪	738	.0059	.067		–	–	–		–	–	–		–	–	–	6754444
WCMT 432-FM	**T8430**	.031	■	673	.0079	.067	■	361	.0071	.067	◪	558	.0079	.067	◪	1870	.0094	.067		–	–	–		–	–	–	7977282
	T9325	.031	■	820	.0079	.067	■	492	.0071	.067	◪	771	.0079	.067		–	–	–		–	–	–		–	–	–	6754445
	T9415	.031	■	1033	.0079	.067		–	–	–	◪	968	.0079	.067		–	–	–		–	–	–		–	–	–	8345994
WCMT 433-FM	**T8430**	.047	■	623	.0106	.067	■	344	.0094	.067	◪	509	.0106	.067	◪	1722	.0126	.067		–	–	–		–	–	–	7977283
	T9325	.047	■	771	.0106	.067	■	459	.0094	.067	◪	722	.0106	.067		–	–	–		–	–	–		–	–	–	6754446

FM chip breaker is versatile and the first choice for finishing of Steels. It features positive rake angle and positive, narrow T-land. It's also suitable for Stainless steels, and conditionally for Cast irons and Non-ferrous alloys.

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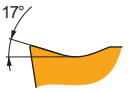
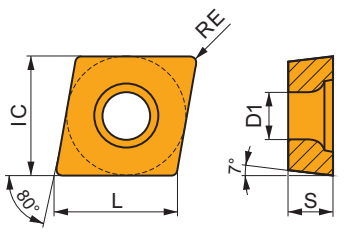
NF2



NF2 chip breaker is sharp and the first choice for finishing of Stainless steels. It features positive rake angle without T-land. It's also suitable for Super-alloys, and conditionally for Steels, Cast irons and Non-ferrous alloys.

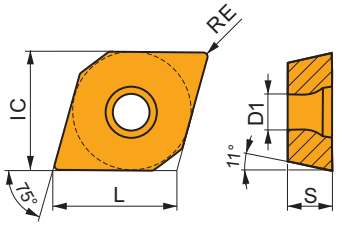
CCMT

	IC (inch)	D1 (inch)	L (inch)	S (inch)
2.52	.313	.134	.319	.125
21.5	.250	.110	.252	.094
32.5	.375	.173	.382	.156



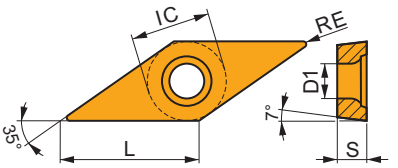
EPMT

	IC (inch)	D1 (inch)	L (inch)	S (inch)
1.81.5	.219	.098	.224	.094



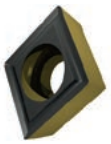
VCGT

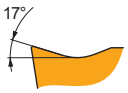
	IC (inch)	D1 (inch)	L (inch)	S (inch)
2.52	.313	.134	.543	.125



Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our cutting conditions app for further options.

Product		RE	P			M			K			N			S			H			MID
			vc (ft/min)	f (in/rev)	ap (inch)	vc (ft/min)	f (in/rev)	ap (inch)	vc (ft/min)	f (in/rev)	ap (inch)	vc (ft/min)	f (in/rev)	ap (inch)	vc (ft/min)	f (in/rev)	ap (inch)	vc (ft/min)	f (in/rev)	ap (inch)	

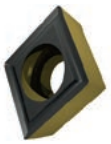
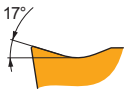
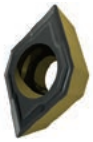
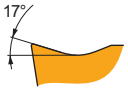
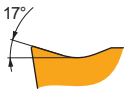




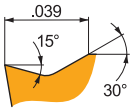
NF2 chip breaker is sharp and the first choice for finishing of Stainless steels. It features positive rake angle without T-land. It's also suitable for Super-alloys, and conditionally for Steels, Cast irons and Non-ferrous alloys.

CCMT 2.521-NF2	**T7325**	.016	◪ 623	.0047	.039	■ 476	.0043	.039	–	–	–	–	–	–	■ 197	.0043	.031	–	–	–	7156167
	T7335	.016	◪ 623	.0047	.039	■ 476	.0043	.039	–	–	–	–	–	–	■ 197	.0043	.031	–	–	–	6756082
	T9325	.016	◪ 837	.0047	.039	■ 492	.0043	.039	◪ 787	.0047	.039	–	–	–	◪ 180	.0043	.031	–	–	–	6756081
	T9415	.016	◪ 1001	.0047	.039	–	–	–	◪ 935	.0047	.039	–	–	–	–	–	–	–	–	–	8345923
CCMT 2.522-NF2	**H07**	.031	–	–	–	◪ 312	.0051	.047	◪ 492	.0055	.047	◪ 1591	.0067	.047	■ 148	.0051	.039	–	–	–	7167456
	T5315	.031	◪ 968	.0067	.039	–	–	–	◪ 919	.0067	.039	–	–	–	–	–	–	–	–	–	6756085
	T7325	.031	◪ 673	.0067	.039	■ 509	.0059	.039	–	–	–	–	–	–	■ 213	.0055	.031	–	–	–	7156168
	T7335	.031	◪ 673	.0067	.039	■ 509	.0059	.039	–	–	–	–	–	–	■ 213	.0055	.031	–	–	–	6756087
	T9325	.031	◪ 853	.0067	.039	■ 509	.0059	.039	◪ 804	.0067	.039	–	–	–	◪ 180	.0055	.031	–	–	–	6756086
CCMT 21.50.5-NF2	**T6310**	.008	◪ 558	.0039	.031	■ 394	.0035	.031	◪ 443	.0039	.031	◪ 1673	.0047	.031	■ 164	.0031	.024	–	–	–	7167423
	T7325	.008	◪ 640	.0039	.031	■ 492	.0035	.031	–	–	–	–	–	–	■ 197	.0031	.024	–	–	–	7167424
	T8415	.008	◪ 722	.0039	.031	■ 377	.0035	.031	◪ 656	.0039	.031	◪ 1821	.0047	.031	■ 164	.0031	.025	–	–	–	8553202
	T8430	.008	◪ 689	.0039	.031	■ 377	.0035	.031	◪ 574	.0039	.031	◪ 1919	.0047	.031	◪ 148	.0031	.024	–	–	–	7977186
	T9325	.008	◪ 853	.0039	.031	■ 509	.0035	.031	◪ 804	.0039	.031	–	–	–	◪ 180	.0031	.024	–	–	–	7167426
CCMT 21.51-NF2	**T6310**	.016	◪ 558	.0047	.031	■ 394	.0043	.031	◪ 443	.0047	.031	◪ 1673	.0055	.031	■ 164	.0043	.024	–	–	–	7167428
	T7325	.016	◪ 656	.0047	.031	■ 509	.0043	.031	–	–	–	–	–	–	■ 213	.0043	.024	–	–	–	7167429
	T8415	.016	◪ 722	.0047	.031	■ 377	.0043	.031	◪ 656	.0047	.031	◪ 1821	.0057	.031	■ 164	.0043	.025	–	–	–	8553205
	T8430	.016	◪ 673	.0047	.031	■ 361	.0043	.031	◪ 558	.0047	.031	◪ 1870	.0055	.031	◪ 148	.0043	.024	–	–	–	7977188
	T9325	.016	◪ 837	.0047	.031	■ 492	.0043	.031	◪ 787	.0047	.031	–	–	–	◪ 180	.0043	.024	–	–	–	7167452
	T9335	.016	◪ 722	.0047	.031	■ 427	.0043	.031	–	–	–	–	–	–	◪ 148	.0043	.024	–	–	–	7167453
	T9415	.016	◪ 1033	.0047	.031	–	–	–	◪ 968	.0047	.031	–	–	–	–	–	–	–	–	–	8345918
CCMT 32.51-NF2	**H07**	.016	–	–	–	◪ 279	.0043	.047	◪ 443	.0047	.047	◪ 1411	.0055	.047	■ 131	.0043	.039	–	–	–	7167458
	T6310	.016	◪ 541	.0047	.047	■ 377	.0043	.047	◪ 427	.0047	.047	◪ 1624	.0055	.047	■ 148	.0043	.039	–	–	–	7167459
	T7325	.016	◪ 623	.0047	.047	■ 476	.0043	.047	–	–	–	–	–	–	■ 197	.0043	.039	–	–	–	7167460
	T8415	.016	◪ 705	.0047	.047	■ 361	.0043	.047	◪ 640	.0047	.047	◪ 1772	.0057	.047	■ 148	.0043	.038	–	–	–	8553210
	T8430	.016	◪ 656	.0047	.047	■ 361	.0043	.047	◪ 541	.0047	.047	◪ 1821	.0055	.047	◪ 131	.0043	.039	–	–	–	7977198
	T9325	.016	◪ 820	.0047	.047	■ 492	.0043	.047	◪ 771	.0047	.047	–	–	–	◪ 180	.0043	.039	–	–	–	7167463
	T9415	.016	◪ 984	.0047	.047	–	–	–	◪ 935	.0047	.047	–	–	–	–	–	–	–	–	–	8345889

Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our cutting conditions app for further options.

Product		RE	P				M				K				N				S				H				MID
			vc (ft/min)	f (in/rev)	ap (inch)		vc (ft/min)	f (in/rev)	ap (inch)		vc (ft/min)	f (in/rev)	ap (inch)		vc (ft/min)	f (in/rev)	ap (inch)		vc (ft/min)	f (in/rev)	ap (inch)		vc (ft/min)	f (in/rev)	ap (inch)		
			**NF2** chip breaker is sharp and the first choice for finishing of Stainless steels. It features positive rake angle without T-land. It's also suitable for Super-alloys, and conditionally for Steels, Cast irons and Non-ferrous alloys.																								
CCMT 32.52-NF2	**H07**	.031	–	–	–	◪	312	.0051	.047	◪	492	.0055	.047	◪	1591	.0067	.047	■	148	.0051	.039		–	–	–		7167465
	T6310	.031	◪	623	.0055	.047	■	443	.0051	.047	◪	492	.0055	.047	◪	1870	.0067	.047	■	180	.0051	.039		–	–	–		7167466
	T7325	.031	◪	705	.0055	.047	■	541	.0051	.047		–	–	–		–	–	–	■	213	.0051	.039		–	–	–		7167467
	T8415	.031	◪	804	.0055	.047	■	410	.005	.047	◪	722	.0055	.047	◪	2018	.0066	.047	■	180	.005	.038		–	–	–		8553213
	T8430	.031	◪	738	.0055	.047	■	394	.0051	.047	◪	607	.0055	.047	◪	2018	.0067	.047	◪	148	.0051	.039		–	–	–		7973819
	T9325	.031	◪	902	.0055	.047	■	541	.0051	.047	◪	853	.0055	.047		–	–	–	◪	197	.0051	.039		–	–	–		7167470
	T9415	.031	◪	1115	.0055	.047		–	–	–	◪	1050	.0055	.047		–	–	–		–	–	–		–	–	–		8345913
			**NF2** chip breaker is sharp and the first choice for finishing of Stainless steels. It features positive rake angle without T-land. It's also suitable for Super-alloys, and conditionally for Steels, Cast irons and Non-ferrous alloys.																								
EPMT 1.81.50.5-NF2	**H07**	.008	–	–	–	◪	262	.0035	.031	◪	410	.0039	.031	◪	1329	.0047	.031	■	131	.0028	.024		–	–	–		7167482
	T7325	.008	◪	705	.0028	.031	■	541	.0024	.031		–	–	–		–	–	–	■	213	.0024	.024		–	–	–		7156314
	T7335	.008	◪	722	.0028	.031	■	558	.0024	.031		–	–	–		–	–	–	■	230	.0024	.024		–	–	–		6755942
	T9325	.008	◪	1001	.0028	.031	■	591	.0024	.031	◪	935	.0028	.031		–	–	–	◪	213	.0024	.024		–	–	–		6755941
	T9335	.008	◪	656	.0039	.031	■	394	.0035	.031		–	–	–		–	–	–	◪	148	.0028	.024		–	–	–		7167484
	T9415	.008	◪	1165	.002	.031		–	–	–	◪	1099	.002	.031		–	–	–		–	–	–		–	–	–		8345947
	TT010	.008	◪	1132	.002	.020	◪	673	.002	.020		–	–	–		–	–	–		–	–	–		–	–	–		6756302
			**NF2** chip breaker is sharp and the first choice for finishing of Stainless steels. It features positive rake angle without T-land. It's also suitable for Super-alloys, and conditionally for Steels, Cast irons and Non-ferrous alloys.																								
VCGT 2.520.5-NF2	**H07**	.008	–	–	–	◪	197	.0035	.039	◪	312	.0039	.039	◪	1017	.0047	.039	■	98	.0028	.031		–	–	–		7167515
	T7325	.008	◪	492	.0028	.039	■	377	.0024	.039		–	–	–		–	–	–	■	148	.0024	.031		–	–	–		7156423
	T7335	.008	◪	492	.0028	.039	■	377	.0024	.039		–	–	–		–	–	–	■	148	.0024	.031		–	–	–		6756092
	T8415	.008	◪	525	.0028	.039	■	279	.0025	.039	◪	476	.0028	.039	◪	1329	.0033	.039	■	115	.0025	.031		–	–	–		8553274
	T9325	.008	◪	689	.0028	.039	■	410	.0024	.039	◪	640	.0028	.039		–	–	–	◪	148	.0024	.031		–	–	–		6756091
	TT010	.008	◪	787	.002	.020	◪	459	.002	.020		–	–	–		–	–	–		–	–	–		–	–	–		6756304
VCGT 2.521-NF2	**H07**	.016	–	–	–	◪	197	.0043	.039	◪	312	.0047	.039	◪	1017	.0055	.039	■	98	.0043	.031		–	–	–		7167519
	T5315	.016	◪	640	.0047	.039		–	–	–	◪	607	.0047	.039		–	–	–		–	–	–		–	–	–		6756097
	T7325	.016	◪	443	.0047	.039	■	344	.0043	.039		–	–	–		–	–	–	■	131	.0031	.031		–	–	–		7156424
	T7335	.016	◪	443	.0047	.039	■	344	.0043	.039		–	–	–		–	–	–	■	131	.0031	.031		–	–	–		6756099
	T8415	.016	◪	492	.0047	.039	■	246	.0043	.039	◪	443	.0047	.039	◪	1230	.0057	.039	■	98	.0043	.031		–	–	–		8553276
	T9325	.016	◪	574	.0047	.039	■	344	.0043	.039	◪	541	.0047	.039		–	–	–	◪	115	.0031	.031		–	–	–		6756098
	T9335	.016	◪	492	.0047	.039	■	295	.0043	.039		–	–	–		–	–	–	◪	98	.0043	.031		–	–	–		7167523
	T9415	.016	◪	738	.0039	.039		–	–	–	◪	689	.0039	.039		–	–	–		–	–	–		–	–	–		8345985
	TT010	.016	◪	804	.0024	.020	◪	476	.0024	.020		–	–	–		–	–	–		–	–	–		–	–	–		6756306
VCGT 2.522-NF2	**T5315**	.031	◪	673	.0067	.039		–	–	–	◪	623	.0067	.039		–	–	–		–	–	–		–	–	–		6756104
	T7325	.031	◪	476	.0067	.039	■	361	.0059	.039		–	–	–		–	–	–	■	148	.0047	.031		–	–	–		7156425
	T7335	.031	◪	459	.0067	.039	■	344	.0059	.039		–	–	–		–	–	–	■	148	.0047	.031		–	–	–		6756106
	T8415	.031	◪	525	.0067	.039	■	279	.006	.039	◪	476	.0067	.039	◪	1329	.008	.039	■	115	.0047	.031		–	–	–		8553278
	T9325	.031	◪	591	.0067	.039	■	344	.0059	.039	◪	558	.0067	.039		–	–	–	◪	131	.0047	.031		–	–	–		6756105
	T9335	.031	◪	509	.0071	.039	■	295	.0063	.039		–	–	–		–	–	–	◪	98	.0063	.031		–	–	–		7167526
	T9415	.031	◪	738	.0067	.039		–	–	–	◪	689	.0067	.039		–	–	–		–	–	–		–	–	–		8345987
	TT010	.031	◪	804	.0039	.031	◪	476	.0035	.031		–	–	–		–	–	–		–	–	–		–	–	–		6756308

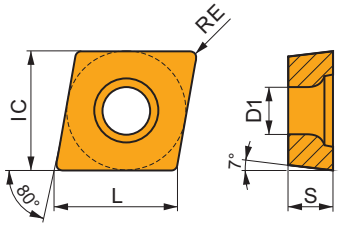
UR



UR chip breaker is versatile and the first choice for finishing of Cast irons. It features positive rake angle without T-land. It's also suitable for Steels, and conditionally for Stainless steels.

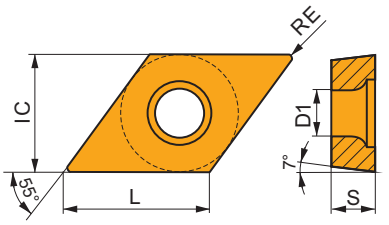
CCMT

	IC (inch)	D1 (inch)	L (inch)	S (inch)
21.5	.250	.110	.252	.094
32.5	.375	.173	.382	.156
43	.500	.217	.508	.187



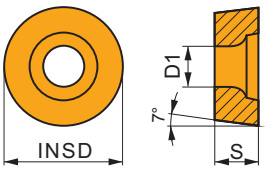
DCMT

	IC (inch)	D1 (inch)	L (inch)	S (inch)
21.5	.250	.110	.307	.094
32.5	.375	.173	.457	.156



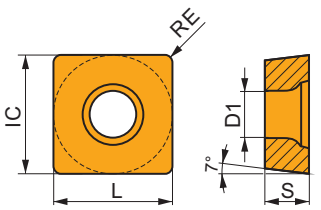
RCMT

	INSD (inch)	D1 (inch)	S (inch)
0602	.236	.110	.094
0803	.315	.134	.125
10T3	.394	.173	.156
1204	.472	.173	.187



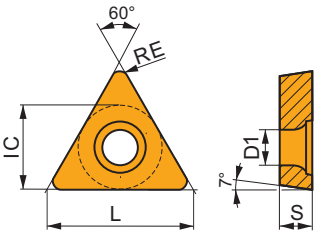
SCMT

	IC (inch)	D1 (inch)	L (inch)	S (inch)
32.5	.375	.173	.375	.156
43	.500	.217	.500	.187



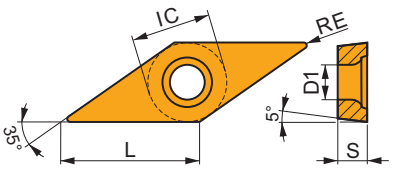
TCMT

	IC (inch)	D1 (inch)	L (inch)	S (inch)
21.5	.250	.110	.433	.094
32.5	.375	.173	.650	.156



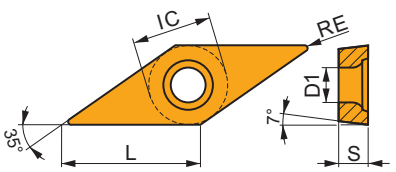
VBMT

	IC (inch)	D1 (inch)	L (inch)	S (inch)
21.5	.250	.110	.437	.094
33	.375	.173	.654	.187



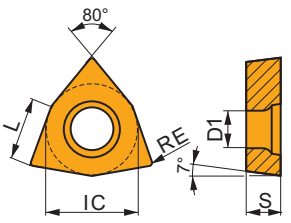
VCMT

	IC (inch)	D1 (inch)	L (inch)	S (inch)
22	.250	.110	.437	.125
33	.375	.173	.654	.187



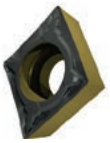
WCMT

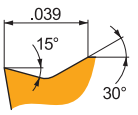
	IC (inch)	D1 (inch)	L (inch)	S (inch)
32.5	.375	.173	.256	.156

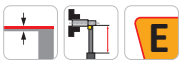


Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our cutting conditions app for further options.

Product		RE	P			M			K			N			S			H			MID
			vc (ft/min)	f (in/rev)	ap (inch)	vc (ft/min)	f (in/rev)	ap (inch)	vc (ft/min)	f (in/rev)	ap (inch)	vc (ft/min)	f (in/rev)	ap (inch)	vc (ft/min)	f (in/rev)	ap (inch)	vc (ft/min)	f (in/rev)	ap (inch)	





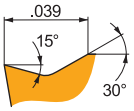


UR chip breaker is versatile and the first choice for finishing of Cast irons. It features positive rake angle without T-land. It's also suitable for Steels, and conditionally for Stainless steels.

CCMT 21.50.5-UR	**T8415**	.008	■ 689	.0039	.031	◪ 361	.0035	.031	■ 623	.0039	.031	–	–	–	–	–	–	–	–	–	8553203
	T8430	.008	■ 656	.0039	.031	◪ 361	.0035	.031	◪ 541	.0039	.031	–	–	–	–	–	–	–	–	–	7973797
	T9325	.008	■ 820	.0039	.031	◪ 492	.0035	.031	◪ 771	.0039	.031	–	–	–	–	–	–	–	–	–	6753865
	T9415	.008	■ 968	.0039	.031	–	–	–	◪ 919	.0039	.031	–	–	–	–	–	–	–	–	–	8345916
	TT310	.008	■ 902	.0039	.020	◪ 541	.0035	.020	–	–	–	–	–	–	–	–	–	–	–	–	6756274
CCMT 21.51-UR	**T5315**	.016	◪ 804	.0059	.039	–	–	–	■ 755	.0059	.039	–	–	–	–	–	–	–	–	–	6755833
	T7335	.016	◪ 558	.0059	.039	◪ 427	.0059	.039	–	–	–	–	–	–	–	–	–	–	–	–	6754735
	T8415	.016	■ 623	.0059	.039	◪ 328	.0053	.039	■ 558	.0059	.039	–	–	–	–	–	–	–	–	–	8553206
	T8430	.016	■ 574	.0059	.039	◪ 312	.0055	.039	◪ 459	.0059	.039	–	–	–	–	–	–	–	–	–	7973810
	T9325	.016	■ 705	.0059	.039	◪ 410	.0059	.039	◪ 656	.0059	.039	–	–	–	–	–	–	–	–	–	6753763
	T9415	.016	■ 886	.0059	.039	–	–	–	◪ 837	.0059	.039	–	–	–	–	–	–	–	–	–	8345919
	TT310	.016	■ 837	.0059	.020	◪ 492	.0055	.020	–	–	–	–	–	–	–	–	–	–	–	–	6756252
CCMT 21.52-UR	**T5315**	.031	◪ 886	.0079	.039	–	–	–	■ 837	.0079	.039	–	–	–	–	–	–	–	–	–	6755834
	T8430	.031	■ 607	.0079	.039	◪ 328	.0071	.039	◪ 492	.0079	.039	–	–	–	–	–	–	–	–	–	7973812
	T9325	.031	■ 755	.0079	.039	◪ 443	.0071	.039	◪ 705	.0079	.039	–	–	–	–	–	–	–	–	–	6754667
	T9415	.031	■ 951	.0079	.039	–	–	–	◪ 902	.0079	.039	–	–	–	–	–	–	–	–	–	8345921
CCMT 32.50.5-UR	**T6310**	.008	■ 525	.0039	.039	◪ 377	.0035	.039	■ 410	.0039	.039	–	–	–	–	–	–	–	–	–	7763056
	T8415	.008	■ 656	.0039	.039	◪ 344	.0035	.039	■ 607	.0039	.039	–	–	–	–	–	–	–	–	–	8553208
	T8430	.008	■ 640	.0039	.039	◪ 344	.0035	.039	◪ 525	.0039	.039	–	–	–	–	–	–	–	–	–	7977195
	TT310	.008	■ 837	.0039	.039	◪ 492	.0035	.039	–	–	–	–	–	–	–	–	–	–	–	–	6756254
CCMT 32.51-UR	**T5315**	.016	◪ 804	.0059	.047	–	–	–	■ 755	.0059	.047	–	–	–	–	–	–	–	–	–	6755836
	T7325	.016	◪ 558	.0059	.047	◪ 427	.0059	.047	–	–	–	–	–	–	–	–	–	–	–	–	7156171
	T7335	.016	◪ 541	.0059	.047	◪ 410	.0059	.047	–	–	–	–	–	–	–	–	–	–	–	–	6754739
	T8415	.016	■ 623	.0059	.047	◪ 328	.0053	.047	■ 558	.0059	.047	–	–	–	–	–	–	–	–	–	8553211
	T8430	.016	■ 574	.0059	.047	◪ 312	.0055	.047	◪ 459	.0059	.047	–	–	–	–	–	–	–	–	–	7973817
	T9325	.016	■ 705	.0059	.047	◪ 410	.0059	.047	◪ 656	.0059	.047	–	–	–	–	–	–	–	–	–	6753766
	T9415	.016	■ 869	.0059	.047	–	–	–	◪ 820	.0059	.047	–	–	–	–	–	–	–	–	–	8244336
	TT310	.016	■ 771	.0059	.047	◪ 459	.0055	.047	–	–	–	–	–	–	–	–	–	–	–	–	6756255
CCMT 32.52-UR	**T5315**	.031	◪ 869	.0079	.047	–	–	–	■ 820	.0079	.047	–	–	–	–	–	–	–	–	–	6755838
	T7325	.031	◪ 607	.0079	.047	◪ 459	.0071	.047	–	–	–	–	–	–	–	–	–	–	–	–	7156174
	T7335	.031	◪ 574	.0079	.047	◪ 443	.0071	.047	–	–	–	–	–	–	–	–	–	–	–	–	6754742
	T8315	.031	◪ 558	.0079	.047	◪ 328	.0071	.047	■ 525	.0079	.047	–	–	–	–	–	–	–	–	–	6753581
	T8415	.031	■ 656	.0079	.047	◪ 344	.0071	.047	■ 607	.0079	.047	–	–	–	–	–	–	–	–	–	8553214
	T8430	.031	■ 607	.0079	.047	◪ 328	.0071	.047	◪ 492	.0079	.047	–	–	–	–	–	–	–	–	–	7973821
	T9325	.031	■ 738	.0079	.047	◪ 443	.0071	.047	◪ 689	.0079	.047	–	–	–	–	–	–	–	–	–	6753769
	T9415	.031	■ 935	.0079	.047	–	–	–	◪ 886	.0079	.047	–	–	–	–	–	–	–	–	–	8244339
	TT310	.031	■ 837	.0079	.047	◪ 492	.0071	.047	–	–	–	–	–	–	–	–	–	–	–	–	6756256
CCMT 431-UR	**T5315**	.016	◪ 771	.0059	.067	–	–	–	■ 722	.0059	.067	–	–	–	–	–	–	–	–	–	6755839
	T7325	.016	◪ 525	.0059	.067	◪ 394	.0059	.067	–	–	–	–	–	–	–	–	–	–	–	–	7156177
	T8430	.016	■ 558	.0059	.067	◪ 295	.0055	.067	◪ 443	.0059	.067	–	–	–	–	–	–	–	–	–	7973823
	T9325	.016	■ 673	.0059	.067	◪ 394	.0059	.067	◪ 623	.0059	.067	–	–	–	–	–	–	–	–	–	6753871
	T9415	.016	■ 837	.0059	.067	–	–	–	◪ 787	.0059	.067	–	–	–	–	–	–	–	–	–	8345925
CCMT 432-UR	**T5315**	.031	◪ 837	.0079	.067	–	–	–	■ 787	.0079	.067	–	–	–	–	–	–	–	–	–	6755841
	T8430	.031	■ 591	.0079	.067	◪ 312	.0071	.067	◪ 476	.0079	.067	–	–	–	–	–	–	–	–	–	7973827
	T9325	.031	■ 705	.0079	.067	◪ 410	.0071	.067	◪ 656	.0079	.067	–	–	–	–	–	–	–	–	–	6753774
	T9415	.031	■ 902	.0079	.067	–	–	–	◪ 853	.0079	.067	–	–	–	–	–	–	–	–	–	8345927
CCMT 433-UR	**T5315**	.047	◪ 787	.0106	.067	–	–	–	■ 738	.0106	.067	–	–	–	–	–	–	–	–	–	6755842
	T8430	.047	■ 541	.0106	.067	◪ 295	.0094	.067	◪ 443	.0106	.067	–	–	–	–	–	–	–	–	–	7977205
	T9325	.047	■ 673	.0106	.067	◪ 394	.0094	.067	◪ 623	.0106	.067	–	–	–	–	–	–	–	–	–	6753874
	T9415	.047	■ 869	.0106	.067	–	–	–	◪ 820	.0106	.067	–	–	–	–	–	–	–	–	–	8345929

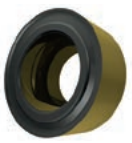
Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our cutting conditions app for further options.

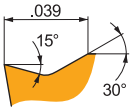
Product	RE (inch)	P vc (ft/min)	P f (in/rev)	P ap (inch)	M vc (ft/min)	M f (in/rev)	M ap (inch)	K vc (ft/min)	K f (in/rev)	K ap (inch)	N vc (ft/min)	N f (in/rev)	N ap (inch)	S vc (ft/min)	S f (in/rev)	S ap (inch)	H vc (ft/min)	H f (in/rev)	H ap (inch)	MID



UR chip breaker is versatile and the first choice for finishing of Cast irons. It features positive rake angle without T-land. It's also suitable for Steels, and conditionally for Stainless steels.

DCMT 21.50.5-UR	**T7325**	.008	492	.0039	.031	377	.0035	.031	–	–	–	–	–	–	–	–	–	–	–	–	7156244
	T8415	.008	541	.0039	.031	279	.0035	.031	492	.0039	.031	–	–	–	–	–	–	–	–	–	8553226
	T8430	.008	509	.0039	.031	279	.0035	.031	427	.0039	.031	–	–	–	–	–	–	–	–	–	7977212
	T9325	.008	656	.0039	.031	394	.0035	.031	623	.0039	.031	–	–	–	–	–	–	–	–	–	6753933
	T9415	.008	771	.0039	.031	–	–	–	722	.0039	.031	–	–	–	–	–	–	–	–	–	8345938
DCMT 21.51-UR	**T8415**	.016	541	.0047	.031	279	.0043	.031	492	.0047	.031	–	–	–	–	–	–	–	–	–	8553228
	T8430	.016	509	.0047	.031	279	.0043	.031	427	.0047	.031	–	–	–	–	–	–	–	–	–	7973830
	T9325	.016	541	.0071	.031	312	.0063	.031	509	.0071	.031	–	–	–	–	–	–	–	–	–	6753777
	T9415	.016	787	.0047	.031	–	–	–	738	.0047	.031	–	–	–	–	–	–	–	–	–	8345941
DCMT 32.50.5-UR	**T7325**	.008	492	.0039	.031	377	.0035	.031	–	–	–	–	–	–	–	–	–	–	–	–	7156248
	T8430	.008	509	.0039	.031	279	.0035	.031	427	.0039	.031	–	–	–	–	–	–	–	–	–	7973832
	T9325	.008	656	.0039	.031	394	.0035	.031	623	.0039	.031	–	–	–	–	–	–	–	–	–	6753935
	T9415	.008	771	.0039	.031	–	–	–	722	.0039	.031	–	–	–	–	–	–	–	–	–	8345931
	TT310	.008	689	.0039	.031	410	.0035	.031	–	–	–	–	–	–	–	–	–	–	–	–	6756275
DCMT 32.51-UR	**T5315**	.016	722	.0047	.031	–	–	–	673	.0047	.031	–	–	–	–	–	–	–	–	–	6755847
	T7325	.016	443	.0067	.031	344	.0059	.031	–	–	–	–	–	–	–	–	–	–	–	–	7156250
	T8315	.016	443	.0047	.031	262	.0043	.031	410	.0047	.031	–	–	–	–	–	–	–	–	–	6753597
	T8415	.016	541	.0047	.031	279	.0043	.031	492	.0047	.031	–	–	–	–	–	–	–	–	–	8553231
	T8430	.016	509	.0047	.031	279	.0043	.031	427	.0047	.031	–	–	–	–	–	–	–	–	–	7973835
	T9325	.016	541	.0071	.031	312	.0063	.031	509	.0071	.031	–	–	–	–	–	–	–	–	–	6753784
	T9415	.016	787	.0047	.031	–	–	–	738	.0047	.031	–	–	–	–	–	–	–	–	–	8345934
	TT310	.016	689	.0047	.031	410	.0043	.031	–	–	–	–	–	–	–	–	–	–	–	–	6756261
DCMT 32.52-UR	**T5315**	.031	755	.0067	.031	–	–	–	705	.0067	.031	–	–	–	–	–	–	–	–	–	6755849
	T7325	.031	525	.0067	.031	394	.0059	.031	–	–	–	–	–	–	–	–	–	–	–	–	7156252
	T7335	.031	509	.0067	.031	394	.0059	.031	–	–	–	–	–	–	–	–	–	–	–	–	6754776
	T8415	.031	591	.0067	.031	295	.006	.031	525	.0067	.031	–	–	–	–	–	–	–	–	–	8553233
	T8430	.031	541	.0067	.031	295	.0059	.031	443	.0067	.031	–	–	–	–	–	–	–	–	–	7973838
	T9325	.031	656	.0067	.031	394	.0059	.031	623	.0067	.031	–	–	–	–	–	–	–	–	–	6753787
	T9415	.031	820	.0067	.031	–	–	–	771	.0067	.031	–	–	–	–	–	–	–	–	–	8244368
	TT310	.031	738	.0067	.031	443	.0059	.031	–	–	–	–	–	–	–	–	–	–	–	–	6756276
DCMT 32.53-UR	**T9325**	.047	591	.0087	.047	344	.0079	.047	558	.0087	.047	–	–	–	–	–	–	–	–	–	6753938
	T9415	.047	755	.0087	.047	–	–	–	705	.0087	.047	–	–	–	–	–	–	–	–	–	8345937

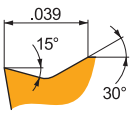
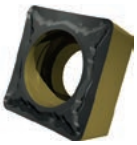
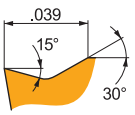
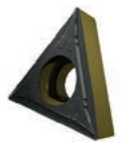
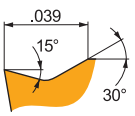




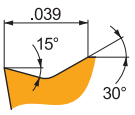
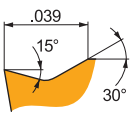
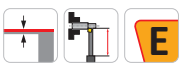
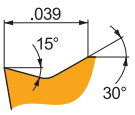
UR chip breaker is versatile and the first choice for finishing of Cast irons. It features positive rake angle without T-land. It's also suitable for Steels, and conditionally for Stainless steels.

RCMT 0602MOE-UR	**T8415**	–	722	.0157	.047	377	.0142	.047	656	.0157	.047	–	–	–	–	–	–	–	–	–	8553239
	T8430	–	591	.0157	.047	312	.0142	.047	476	.0157	.047	–	–	–	–	–	–	–	–	–	7977232
	T9325	–	705	.0157	.047	410	.0142	.047	656	.0157	.047	–	–	–	–	–	–	–	–	–	6754665
	T9415	–	935	.0157	.047	–	–	–	886	.0157	.047	–	–	–	–	–	–	–	–	–	8345951
RCMT 0803MOE-UR	**T7325**	–	591	.0177	.063	459	.0161	.063	–	–	–	–	–	–	–	–	–	–	–	–	7156318
	T8415	–	656	.0177	.063	344	.0159	.063	607	.0177	.063	–	–	–	–	–	–	–	–	–	8553240
	T8430	–	558	.0177	.063	295	.0161	.063	443	.0177	.063	–	–	–	–	–	–	–	–	–	7973841
	T9325	–	656	.0177	.063	394	.0161	.063	623	.0177	.063	–	–	–	–	–	–	–	–	–	6754666
	T9415	–	869	.0177	.063	–	–	–	820	.0177	.063	–	–	–	–	–	–	–	–	–	8244374
RCMT 10T3MOE-UR	**T6310**	–	525	.0197	.055	377	.0177	.055	410	.0197	.055	–	–	–	–	–	–	–	–	–	7168661
	T7325	–	574	.0197	.055	443	.0177	.055	–	–	–	–	–	–	–	–	–	–	–	–	7156320
	T8415	–	656	.0197	.055	344	.0177	.055	607	.0197	.055	–	–	–	–	–	–	–	–	–	8553241
	T8430	–	541	.0197	.055	295	.0177	.055	443	.0197	.055	–	–	–	–	–	–	–	–	–	7973842
	T9325	–	623	.0197	.055	361	.0177	.055	591	.0197	.055	–	–	–	–	–	–	–	–	–	6754690
	T9415	–	853	.0197	.055	–	–	–	804	.0197	.055	–	–	–	–	–	–	–	–	–	8345949

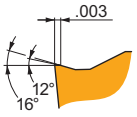
Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our cutting conditions app for further options.

Product		RE	P			M			K			N			S			H			MID
			vc (ft/min)	f (in/rev)	ap (inch)	vc (ft/min)	f (in/rev)	ap (inch)	vc (ft/min)	f (in/rev)	ap (inch)	vc (ft/min)	f (in/rev)	ap (inch)	vc (ft/min)	f (in/rev)	ap (inch)	vc (ft/min)	f (in/rev)	ap (inch)	
			**UR** chip breaker is versatile and the first choice for finishing of Cast irons. It features positive rake angle without T-land. It's also suitable for Steels, and conditionally for Stainless steels.																		
RCMT 1204M0E-UR	**T6310**	–	■ 492	.0217	.071	◪ 344	.0197	.071	■ 394	.0217	.071	–	–	–	–	–	–	–	–	–	7168662
	T8415	–	■ 623	.0217	.071	◪ 328	.0195	.071	■ 558	.0217	.071	–	–	–	–	–	–	–	–	–	8553242
	T8430	–	■ 476	.0217	.071	◪ 262	.0197	.071	◪ 394	.0217	.071	–	–	–	–	–	–	–	–	–	7973843
	T9315	–	■ 656	.0217	.071	–	–	–	◪ 623	.0217	.071	–	–	–	–	–	–	–	–	–	6922900
	T9325	–	■ 591	.0217	.071	◪ 344	.0197	.071	◪ 558	.0217	.071	–	–	–	–	–	–	–	–	–	6754691
	T9415	–	■ 804	.0217	.071	–	–	–	◪ 755	.0217	.071	–	–	–	–	–	–	–	–	–	8244376
			**UR** chip breaker is versatile and the first choice for finishing of Cast irons. It features positive rake angle without T-land. It's also suitable for Steels, and conditionally for Stainless steels.																		
SCMT 32.51-UR	**T8430**	.016	■ 591	.0059	.047	◪ 312	.0055	.047	◪ 476	.0059	.047	–	–	–	–	–	–	–	–	–	7973845
	T9325	.016	■ 738	.0059	.047	◪ 443	.0059	.047	◪ 689	.0059	.047	–	–	–	–	–	–	–	–	–	6754662
	T9415	.016	■ 919	.0059	.047	–	–	–	◪ 869	.0059	.047	–	–	–	–	–	–	–	–	–	8345957
SCMT 32.52-UR	**T5315**	.031	◪ 919	.0079	.047	–	–	–	■ 869	.0079	.047	–	–	–	–	–	–	–	–	–	6755763
	T8430	.031	■ 623	.0079	.047	◪ 344	.0071	.047	◪ 509	.0079	.047	–	–	–	–	–	–	–	–	–	7973847
	T9325	.031	■ 771	.0079	.047	◪ 459	.0071	.047	◪ 722	.0079	.047	–	–	–	–	–	–	–	–	–	6754688
	T9415	.031	■ 984	.0079	.047	–	–	–	◪ 935	.0079	.047	–	–	–	–	–	–	–	–	–	8345960
	TT310	.031	■ 886	.0079	.047	◪ 525	.0071	.047	–	–	–	–	–	–	–	–	–	–	–	–	6756262
SCMT 432-UR	**T8430**	.031	■ 607	.0079	.063	◪ 328	.0071	.063	◪ 492	.0079	.063	–	–	–	–	–	–	–	–	–	7973850
	T9325	.031	■ 755	.0079	.063	◪ 443	.0071	.063	◪ 705	.0079	.063	–	–	–	–	–	–	–	–	–	6754663
SCMT 433-UR	**T8430**	.047	■ 574	.0106	.063	◪ 312	.0094	.063	◪ 459	.0106	.063	–	–	–	–	–	–	–	–	–	7977245
			**UR** chip breaker is versatile and the first choice for finishing of Cast irons. It features positive rake angle without T-land. It's also suitable for Steels, and conditionally for Stainless steels.																		
TCMT 21.51-UR	**T8430**	.016	■ 558	.0047	.031	◪ 295	.0043	.031	◪ 443	.0047	.031	–	–	–	–	–	–	–	–	–	7973857
	T9325	.016	■ 574	.0071	.031	◪ 344	.0063	.031	◪ 541	.0071	.031	–	–	–	–	–	–	–	–	–	6754100
	T9415	.016	■ 837	.0047	.031	–	–	–	◪ 787	.0047	.031	–	–	–	–	–	–	–	–	–	8345978
TCMT 32.51-UR	**T8430**	.016	■ 558	.0047	.031	◪ 295	.0043	.031	◪ 443	.0047	.031	–	–	–	–	–	–	–	–	–	7973860
	T9325	.016	■ 574	.0071	.031	◪ 344	.0063	.031	◪ 541	.0071	.031	–	–	–	–	–	–	–	–	–	6754102
	T9415	.016	■ 837	.0047	.031	–	–	–	◪ 787	.0047	.031	–	–	–	–	–	–	–	–	–	8345971
	TT310	.016	■ 738	.0047	.031	◪ 443	.0043	.031	–	–	–	–	–	–	–	–	–	–	–	–	6756263
TCMT 32.52-UR	**T5315**	.031	◪ 804	.0067	.031	–	–	–	■ 755	.0067	.031	–	–	–	–	–	–	–	–	–	6755782
	T7325	.031	◪ 558	.0067	.031	◪ 427	.0059	.031	–	–	–	–	–	–	–	–	–	–	–	–	7156375
	T8430	.031	■ 574	.0067	.031	◪ 312	.0059	.031	◪ 459	.0067	.031	–	–	–	–	–	–	–	–	–	7973863
	T9325	.031	■ 705	.0067	.031	◪ 410	.0059	.031	◪ 656	.0067	.031	–	–	–	–	–	–	–	–	–	6753845
	T9415	.031	■ 869	.0067	.031	–	–	–	◪ 820	.0067	.031	–	–	–	–	–	–	–	–	–	8345975

Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our cutting conditions app for further options.

Product		RE	P			M			K			N			S			H			MID
		(inch)	vc (ft/min)	f (in/rev)	ap (inch)	vc (ft/min)	f (in/rev)	ap (inch)	vc (ft/min)	f (in/rev)	ap (inch)	vc (ft/min)	f (in/rev)	ap (inch)	vc (ft/min)	f (in/rev)	ap (inch)	vc (ft/min)	f (in/rev)	ap (inch)	
			**UR** chip breaker is versatile and the first choice for finishing of Cast irons. It features positive rake angle without T-land. It's also suitable for Steels, and conditionally for Stainless steels.																	
VBMT 21.50.5-UR	**TT310**	.008	640	.0039	.031	377	.0035	.031	–	–	–	–	–	–	–	–	–	–	–	–	6756277
VBMT 21.51-UR	**T8430**	.016	476	.0047	.031	262	.0043	.031	394	.0047	.031	–	–	–	–	–	–	–	–	–	7977260
	T9325	.016	492	.0075	.031	295	.0067	.031	459	.0075	.031	–	–	–	–	–	–	–	–	–	6754425
VBMT 330.5-UR	**T8430**	.008	459	.0039	.047	246	.0035	.047	377	.0039	.047	–	–	–	–	–	–	–	–	–	7973868
VBMT 331-UR	**T5315**	.016	640	.0047	.047	–	–	–	607	.0047	.047	–	–	–	–	–	–	–	–	–	6755711
	T7325	.016	377	.0075	.047	279	.0067	.047	–	–	–	–	–	–	–	–	–	–	–	–	7156418
	T8430	.016	459	.0047	.047	246	.0043	.047	377	.0047	.047	–	–	–	–	–	–	–	–	–	7973870
	T9325	.016	476	.0071	.047	279	.0063	.047	443	.0071	.047	–	–	–	–	–	–	–	–	–	6753854
	T9415	.016	689	.0047	.047	–	–	–	640	.0047	.047	–	–	–	–	–	–	–	–	–	8244387
	TT310	.016	607	.0047	.047	361	.0043	.047	–	–	–	–	–	–	–	–	–	–	–	–	6756265
VBMT 332-UR	**T5315**	.031	673	.0067	.047	–	–	–	623	.0067	.047	–	–	–	–	–	–	–	–	–	6755714
	T8430	.031	476	.0067	.047	262	.0059	.047	394	.0067	.047	–	–	–	–	–	–	–	–	–	7973872
	T9310	.031	722	.0067	.047	–	–	–	673	.0067	.047	–	–	–	–	–	–	–	–	–	6755076
	T9325	.031	591	.0067	.047	344	.0059	.047	558	.0067	.047	–	–	–	–	–	–	–	–	–	6753857
	T9415	.031	738	.0067	.047	–	–	–	689	.0067	.047	–	–	–	–	–	–	–	–	–	8244390
	TT310	.031	656	.0067	.047	394	.0059	.047	–	–	–	–	–	–	–	–	–	–	–	–	6756278
VBMT 333-UR	**T8430**	.047	443	.0087	.047	246	.0079	.047	361	.0087	.047	–	–	–	–	–	–	–	–	–	7977269
	T9325	.047	558	.0087	.047	328	.0079	.047	525	.0087	.047	–	–	–	–	–	–	–	–	–	6754433
	T9415	.047	689	.0087	.047	–	–	–	640	.0087	.047	–	–	–	–	–	–	–	–	–	8244393
	 		**UR** chip breaker is versatile and the first choice for finishing of Cast irons. It features positive rake angle without T-land. It's also suitable for Steels, and conditionally for Stainless steels.																	
VCMT 221-UR	**T7325**	.016	361	.0075	.031	279	.0067	.031	–	–	–	–	–	–	–	–	–	–	–	–	7156426
	T8430	.016	443	.0047	.031	246	.0043	.031	361	.0047	.031	–	–	–	–	–	–	–	–	–	7973873
	T9325	.016	459	.0075	.031	262	.0067	.031	427	.0075	.031	–	–	–	–	–	–	–	–	–	6755623
	T9415	.016	689	.0047	.031	–	–	–	640	.0047	.031	–	–	–	–	–	–	–	–	–	8345988
VCMT 222-UR	**T7325**	.031	459	.0067	.031	344	.0059	.031	–	–	–	–	–	–	–	–	–	–	–	–	7156427
	T8430	.031	459	.0067	.031	246	.0059	.031	377	.0067	.031	–	–	–	–	–	–	–	–	–	7973874
	T9325	.031	574	.0067	.031	344	.0059	.031	541	.0067	.031	–	–	–	–	–	–	–	–	–	6755625
	T9415	.031	722	.0067	.031	–	–	–	673	.0067	.031	–	–	–	–	–	–	–	–	–	8345989
VCMT 331-UR	**T7325**	.016	361	.0075	.047	279	.0067	.047	–	–	–	–	–	–	–	–	–	–	–	–	7156429
	T8430	.016	427	.0047	.047	230	.0043	.047	344	.0047	.047	–	–	–	–	–	–	–	–	–	7977275
	T9325	.016	443	.0075	.047	262	.0067	.047	410	.0075	.047	–	–	–	–	–	–	–	–	–	6755619
	T9415	.016	656	.0047	.047	–	–	–	623	.0047	.047	–	–	–	–	–	–	–	–	–	8345990
VCMT 332-UR	**T8430**	.031	443	.0067	.047	246	.0059	.047	361	.0067	.047	–	–	–	–	–	–	–	–	–	7977276
	T9325	.031	558	.0067	.047	328	.0059	.047	525	.0067	.047	–	–	–	–	–	–	–	–	–	6755621
	T9415	.031	689	.0067	.047	–	–	–	640	.0067	.047	–	–	–	–	–	–	–	–	–	8345991
			**UR** chip breaker is versatile and the first choice for finishing of Cast irons. It features positive rake angle without T-land. It's also suitable for Steels, and conditionally for Stainless steels.																	
WCMT 32.52-UR	**T9325**	.031	738	.0079	.047	443	.0071	.047	689	.0079	.047	–	–	–	–	–	–	–	–	–	6754661

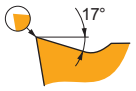
W -FM

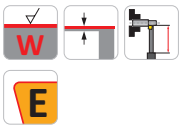


W-FM chip breaker has wiper edge and is designed for finishing of Steels, Stainless steels and Cast irons. It features positive rake angle and positive, narrow T-land.

PRAMET

W -UR



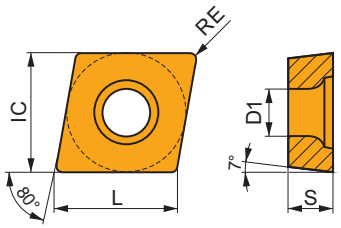


W-UR chip breaker has wiper edge and is designed for finishing of Steels and Cast irons. It features positive rake angle without T-land. It's also conditionally suitable for Stainless steels.

PRAMET

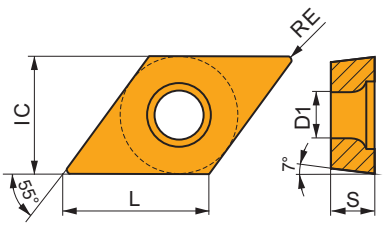
CCMT

	IC (inch)	D1 (inch)	L (inch)	S (inch)
21.5	.250	.110	.252	.094
32.5	.375	.173	.382	.156

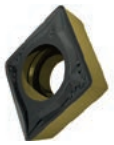
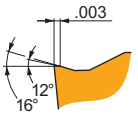
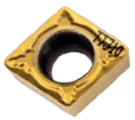
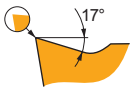
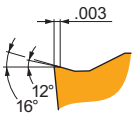


DCMX

	IC (inch)	D1 (inch)	L (inch)	S (inch)
32.5	.375	.173	.457	.156

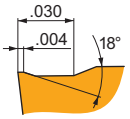


Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our cutting conditions app for further options.

Product		RE (inch)	P vc (ft/min)	P f (in/rev)	P ap (inch)	M vc (ft/min)	M f (in/rev)	M ap (inch)	K vc (ft/min)	K f (in/rev)	K ap (inch)	N vc (ft/min)	N f (in/rev)	N ap (inch)	S vc (ft/min)	S f (in/rev)	S ap (inch)	H vc (ft/min)	H f (in/rev)	H ap (inch)	MID
																					
W-FM chip breaker has wiper edge and is designed for finishing of Steels, Stainless steels and Cast irons. It features positive rake angle and positive, narrow T-land.																					
CCMT 21.51W-FM	**T8430**	.016	541	.0118	.031	295	.0106	.031	443	.0118	.031	–	–	–	–	–	–	–	–	–	7977189
	T9325	.016	623	.0118	.031	361	.0106	.031	591	.0118	.031	–	–	–	–	–	–	–	–	–	7034000
	T9415	.016	820	.0118	.031	–	–	–	771	.0118	.031	–	–	–	–	–	–	–	–	–	8345920
CCMT 32.51W-FM	**T8430**	.016	541	.0118	.031	295	.0106	.031	443	.0118	.031	–	–	–	–	–	–	–	–	–	7977199
	T9325	.016	623	.0118	.031	361	.0106	.031	591	.0118	.031	–	–	–	–	–	–	–	–	–	7034003
	T9415	.016	1001	.0059	.047	–	–	–	935	.0059	.047	–	–	–	–	–	–	–	–	–	8345910
CCMT 32.52W-FM	**T8430**	.031	558	.0157	.039	295	.0142	.039	443	.0157	.039	–	–	–	–	–	–	–	–	–	7977202
	T9325	.031	656	.0157	.039	394	.0142	.039	623	.0157	.039	–	–	–	–	–	–	–	–	–	7034006
																					
W-UR chip breaker has wiper edge and is designed for finishing of Steels and Cast irons. It features positive rake angle without T-land. It's also conditionally suitable for Stainless steels.																					
CCMT 21.51W-UR	**TT310**	.016	837	.0059	.020	492	.0055	.020	–	–	–	–	–	–	–	–	–	–	–	–	6756253
																					
W-FM chip breaker has wiper edge and is designed for finishing of Steels, Stainless steels and Cast irons. It features positive rake angle and positive, narrow T-land.																					
DCMX 32.51W-FM	**T7325**	.016	427	.0118	.031	328	.0106	.031	–	–	–	–	–	–	–	–	–	–	–	–	7156255
	T8430	.016	427	.0118	.031	230	.0106	.031	344	.0118	.031	–	–	–	–	–	–	–	–	–	7977226
	T9325	.016	509	.0118	.031	295	.0106	.031	476	.0118	.031	–	–	–	–	–	–	–	–	–	7034018
	T9415	.016	656	.0118	.031	–	–	–	623	.0118	.031	–	–	–	–	–	–	–	–	–	8345943
DCMX 32.52W-FM	**T8430**	.031	427	.0157	.039	230	.0142	.039	344	.0157	.039	–	–	–	–	–	–	–	–	–	7977227
	T9325	.031	525	.0157	.039	312	.0142	.039	492	.0157	.039	–	–	–	–	–	–	–	–	–	7034021

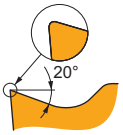
MEDIUM – NAVIGATOR

FM2



FM2 chip breaker is robust and the first choice for medium machining of Steels. It features positive rake angle and stable, moderate T-land. It's also suitable for Cast irons, and conditionally for Stainless steels.

SI



SI chip breaker is sharp and the first choice for medium machining of Stainless steels. It features highly positive rake angle without T-land. It's also suitable for Steels and Super-alloys, and conditionally for Cast irons.

RF

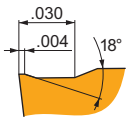
I.C.	R
.250	.039
.375	.059
.500	.098

RF chip breaker is robust and the first choice for medium machining of Cast irons. It features slightly positive rake angle and stable, moderate T-land. It's also suitable for Steels, and conditionally for Stainless steels and Hard materials.

.CMW

.CMW flat insert is designed for medium machining of Cast irons. It features neutral rake angle without T-land. It's also conditionally suitable for Hard materials.

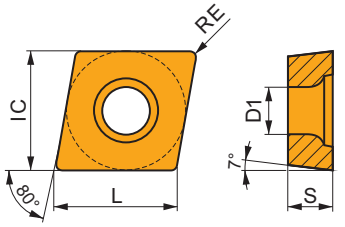
FM2



FM2 chip breaker is robust and the first choice for medium machining of Steels. It features positive rake angle and stable, moderate T-land. It's also suitable for Cast irons, and conditionally for Stainless steels.

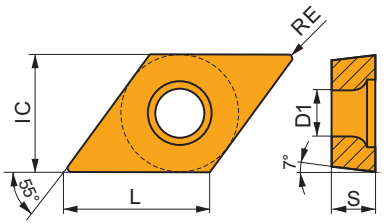
CCMT

	IC (inch)	D1 (inch)	L (inch)	S (inch)
2.52	.313	.134	.319	.125
32.5	.375	.173	.382	.156
43	.500	.217	.508	.187



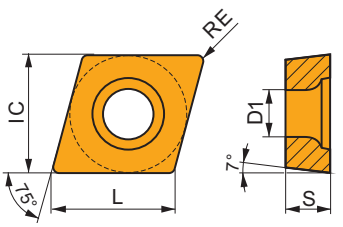
DCMT

	IC (inch)	D1 (inch)	L (inch)	S (inch)
21.5	.250	.110	.307	.094
32.5	.375	.173	.457	.156
43	.500	.217	.610	.187



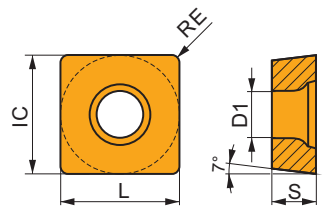
ECMT

	IC (inch)	D1 (inch)	L (inch)	S (inch)
2.52	.313	.134	.323	.125
21.5	.250	.110	.256	.094



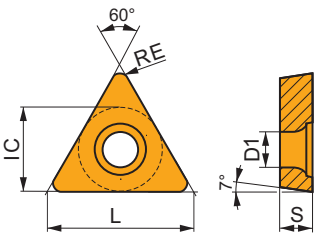
SCMT

	IC (inch)	D1 (inch)	L (inch)	S (inch)
32.5	.375	.173	.375	.156



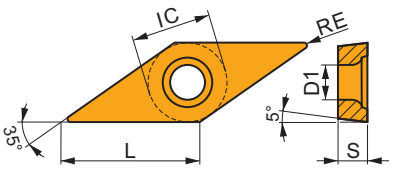
TCMT

	IC (inch)	D1 (inch)	L (inch)	S (inch)
21.5	.250	.110	.433	.094
32.5	.375	.173	.650	.156



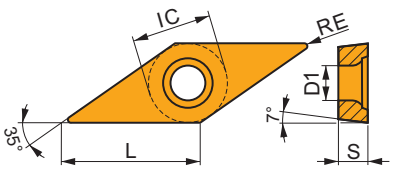
VBMT

	IC (inch)	D1 (inch)	L (inch)	S (inch)
33	.375	.173	.654	.187



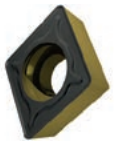
VCGT

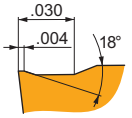
	IC (inch)	D1 (inch)	L (inch)	S (inch)
1303	7.940	3.40	13.80	3.18



Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our cutting conditions app for further options.

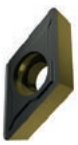
Product		RE	P						M						K						N						S						H						MID
			vc		f		ap		vc		f		ap		vc		f		ap		vc		f		ap		vc		f		ap		vc		f		ap	
		(inch)	(ft/min)		(in/rev)		(inch)		(ft/min)		(in/rev)		(inch)		(ft/min)		(in/rev)		(inch)		(ft/min)		(in/rev)		(inch)		(ft/min)		(in/rev)		(inch)		(ft/min)		(in/rev)		(inch)	

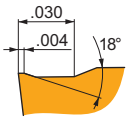




FM2 chip breaker is robust and the first choice for medium machining of Steels. It features positive rake angle and stable, moderate T-land. It's also suitable for Cast irons, and conditionally for Stainless steels.

CCMT 2.521-FM2	**T8430**	.016	■	673	.0047	.039	◪	361	.0043	.039	◪	558	.0047	.039	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	7977192
	T9325	.016	■	837	.0047	.039	◪	492	.0043	.039	◪	787	.0047	.039	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	6756077
	T9335	.016	■	705	.0047	.039	◪	410	.0043	.039		–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	6756078
	T9415	.016	■	1001	.0047	.039		–	–	–	◪	935	.0047	.039	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	8345922
CCMT 2.522-FM2	**T8430**	.031	■	689	.0067	.039	◪	377	.0059	.039	◪	574	.0067	.039	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	7977194
	T9325	.031	■	853	.0067	.039	◪	509	.0059	.039	◪	804	.0067	.039	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	6756083
	T9335	.031	■	738	.0067	.039	◪	443	.0059	.039		–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	6756084
CCMT 32.51-FM2	**T6310**	.016	■	541	.0047	.039	◪	377	.0043	.039	■	427	.0047	.039	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	7156866
	T8430	.016	■	673	.0047	.039	◪	361	.0043	.039	◪	558	.0047	.039	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	7977197
	T9325	.016	■	837	.0047	.039	◪	492	.0043	.039	◪	787	.0047	.039	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	7156869
	T9415	.016	■	1001	.0047	.039		–	–	–	◪	935	.0047	.039	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	8345888
CCMT 32.52-FM2	**T6310**	.031	■	591	.0067	.039	◪	410	.0059	.039	■	476	.0067	.039	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	7156870
	T7325	.031	◪	673	.0067	.039	◪	509	.0059	.039		–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	7156871
	T8430	.031	■	689	.0067	.039	◪	377	.0059	.039	◪	574	.0067	.039	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	7977201
	T9325	.031	■	853	.0067	.039	◪	509	.0059	.039	◪	804	.0067	.039	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	7156874
	T9335	.031	■	738	.0067	.039	◪	443	.0059	.039		–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	7156875
	T9415	.031	■	1050	.0067	.039		–	–	–	◪	984	.0067	.039	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	8345912
CCMT 432-FM2	**T7325**	.031	◪	623	.0079	.059	◪	476	.0071	.059		–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	7156876
	T8430	.031	■	623	.0079	.059	◪	344	.0071	.059	◪	509	.0079	.059	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	7973825
	T9325	.031	■	771	.0079	.059	◪	459	.0071	.059	◪	722	.0079	.059	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	7156878
	T9335	.031	■	656	.0079	.059	◪	394	.0071	.059		–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	7156879

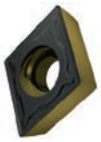
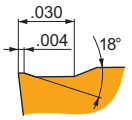
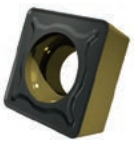
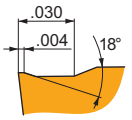
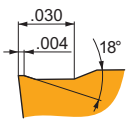




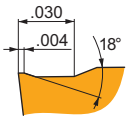
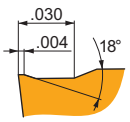
FM2 chip breaker is robust and the first choice for medium machining of Steels. It features positive rake angle and stable, moderate T-land. It's also suitable for Cast irons, and conditionally for Stainless steels.

DCMT 21.51-FM2	**T6310**	.016	■	443	.0047	.031	◪	312	.0043	.031	■	344	.0047	.031	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	7156880
	T7325	.016	◪	525	.0047	.031	◪	394	.0043	.031		–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	7156881
	T8430	.016	■	558	.0047	.031	◪	295	.0043	.031	◪	443	.0047	.031	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	7977214
	T9325	.016	■	673	.0047	.031	◪	394	.0043	.031	◪	623	.0047	.031	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	7156884
	T9415	.016	■	820	.0047	.031		–	–	–	◪	771	.0047	.031	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	8345940
DCMT 32.51-FM2	**T6310**	.016	■	443	.0047	.031	◪	312	.0043	.031	■	344	.0047	.031	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	7156885
	T7325	.016	◪	525	.0047	.031	◪	394	.0043	.031		–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	7156886
	T8430	.016	■	558	.0047	.031	◪	295	.0043	.031	◪	443	.0047	.031	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	7977218
	T9325	.016	■	673	.0047	.031	◪	394	.0043	.031	◪	623	.0047	.031	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	7156889
	T9335	.016	■	574	.0047	.031	◪	344	.0043	.031		–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	7156890
	T9415	.016	■	820	.0047	.031		–	–	–	◪	771	.0047	.031	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	8345933
DCMT 32.52-FM2	**T6310**	.031	■	492	.0067	.031	◪	344	.0059	.031	■	394	.0067	.031	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	7156891
	T7325	.031	◪	558	.0067	.031	◪	427	.0059	.031		–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	7156892
	T8430	.031	■	574	.0067	.031	◪	312	.0059	.031	◪	459	.0067	.031	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	7977222
	T9325	.031	■	705	.0067	.031	◪	410	.0059	.031	◪	656	.0067	.031	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	7156895
	T9335	.031	■	591	.0067	.031	◪	344	.0059	.031		–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	7156896
	T9415	.031	■	869	.0067	.031		–	–	–	◪	820	.0067	.031	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	8345936
DCMT 32.53-FM2	**T8430**	.047	■	509	.0087	.047	◪	279	.0079	.047	◪	427	.0087	.047	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	7977224
	T9325	.047	■	623	.0087	.047	◪	361	.0079	.047	◪	591	.0087	.047	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	7156899
DCMT 432-FM2	**T9325**	.031	■	607	.0079	.059	◪	361	.0071	.059	◪	574	.0079	.059	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	7156901
	T9335	.031	■	525	.0079	.059	◪	312	.0071	.059		–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	7156902

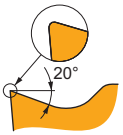
Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our cutting conditions app for further options.

Product		RE (inch)	P vc (ft/min)	P f (in/rev)	P ap (inch)	M vc (ft/min)	M f (in/rev)	M ap (inch)	K vc (ft/min)	K f (in/rev)	K ap (inch)	N vc (ft/min)	N f (in/rev)	N ap (inch)	S vc (ft/min)	S f (in/rev)	S ap (inch)	H vc (ft/min)	H f (in/rev)	H ap (inch)	MID
																					
FM2 chip breaker is robust and the first choice for medium machining of Steels. It features positive rake angle and stable, moderate T-land. It's also suitable for Cast irons, and conditionally for Stainless steels.																					
ECMT 2.521-FM2	**T5315**	.016	919	.0047	.039	–	–	–	869	.0047	.039	–	–	–	–	–	–	–	–	–	6755936
	T7325	.016	558	.0047	.039	427	.0043	.039	–	–	–	–	–	–	–	–	–	–	–	–	7156905
	T8430	.016	673	.0047	.039	361	.0043	.039	558	.0047	.039	–	–	–	–	–	–	–	–	–	7977229
	T9325	.016	837	.0047	.039	492	.0043	.039	787	.0047	.039	–	–	–	–	–	–	–	–	–	6755937
	T9335	.016	705	.0047	.039	410	.0043	.039	–	–	–	–	–	–	–	–	–	–	–	–	6755938
	T9415	.016	902	.0047	.039	–	–	–	853	.0047	.039	–	–	–	–	–	–	–	–	–	8345945
ECMT 2.522-FM2	**T7325**	.031	607	.0067	.039	459	.0059	.039	–	–	–	–	–	–	–	–	–	–	–	–	7156907
	T8430	.031	689	.0067	.039	377	.0059	.039	574	.0067	.039	–	–	–	–	–	–	–	–	–	7977230
	T9325	.031	853	.0067	.039	509	.0059	.039	804	.0067	.039	–	–	–	–	–	–	–	–	–	6755939
	T9335	.031	738	.0067	.039	443	.0059	.039	–	–	–	–	–	–	–	–	–	–	–	–	6755940
	T9415	.031	951	.0067	.039	–	–	–	902	.0067	.039	–	–	–	–	–	–	–	–	–	8345946
ECMT 21.51-FM2	**T7325**	.016	591	.0047	.031	459	.0043	.031	–	–	–	–	–	–	–	–	–	–	–	–	7156903
	T8430	.016	673	.0047	.031	361	.0043	.031	558	.0047	.031	–	–	–	–	–	–	–	–	–	7977228
	T9325	.016	837	.0047	.031	492	.0043	.031	787	.0047	.031	–	–	–	–	–	–	–	–	–	6755934
	T9335	.016	722	.0047	.031	427	.0043	.031	–	–	–	–	–	–	–	–	–	–	–	–	6755935
	T9415	.016	935	.0047	.031	–	–	–	886	.0047	.031	–	–	–	–	–	–	–	–	–	8345944
																					
FM2 chip breaker is robust and the first choice for medium machining of Steels. It features positive rake angle and stable, moderate T-land. It's also suitable for Cast irons, and conditionally for Stainless steels.																					
SCMT 32.51-FM2	**T8430**	.016	722	.0047	.039	394	.0043	.039	591	.0047	.039	–	–	–	–	–	–	–	–	–	7977238
	T9325	.016	869	.0047	.039	509	.0043	.039	820	.0047	.039	–	–	–	–	–	–	–	–	–	7156911
SCMT 32.52-FM2	**T8430**	.031	738	.0067	.039	394	.0059	.039	607	.0067	.039	–	–	–	–	–	–	–	–	–	7977240
	T9325	.031	886	.0067	.039	525	.0059	.039	837	.0067	.039	–	–	–	–	–	–	–	–	–	7156915
	T9415	.031	1115	.0067	.039	–	–	–	1050	.0067	.039	–	–	–	–	–	–	–	–	–	8183841
																					
FM2 chip breaker is robust and the first choice for medium machining of Steels. It features positive rake angle and stable, moderate T-land. It's also suitable for Cast irons, and conditionally for Stainless steels.																					
TCMT 21.51-FM2	**T8430**	.016	591	.0047	.031	312	.0043	.031	476	.0047	.031	–	–	–	–	–	–	–	–	–	7973856
	T9325	.016	722	.0047	.031	427	.0043	.031	673	.0047	.031	–	–	–	–	–	–	–	–	–	7156918
TCMT 21.52-FM2	**T8430**	.031	607	.0067	.031	328	.0059	.031	492	.0067	.031	–	–	–	–	–	–	–	–	–	7977253
	T9325	.031	738	.0067	.031	443	.0059	.031	689	.0067	.031	–	–	–	–	–	–	–	–	–	7156920
TCMT 32.52-FM2	**T7325**	.031	558	.0079	.039	427	.0071	.039	–	–	–	–	–	–	–	–	–	–	–	–	7156922
	T8430	.031	558	.0079	.039	295	.0071	.039	443	.0079	.039	–	–	–	–	–	–	–	–	–	7977257
	T9325	.031	673	.0079	.039	394	.0071	.039	623	.0079	.039	–	–	–	–	–	–	–	–	–	7156924
	T9335	.031	574	.0079	.039	344	.0071	.039	–	–	–	–	–	–	–	–	–	–	–	–	7156925

Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our cutting conditions app for further options.

Product		RE (inch)	P vc (ft/min)	P f (in/rev)	P ap (inch)	M vc (ft/min)	M f (in/rev)	M ap (inch)	K vc (ft/min)	K f (in/rev)	K ap (inch)	N vc (ft/min)	N f (in/rev)	N ap (inch)	S vc (ft/min)	S f (in/rev)	S ap (inch)	H vc (ft/min)	H f (in/rev)	H ap (inch)	MID
																					
FM2 chip breaker is robust and the first choice for medium machining of Steels. It features positive rake angle and stable, moderate T-land. It's also suitable for Cast irons, and conditionally for Stainless steels.																					
VBMT 331-FM2	**T6310**	.016	■ 394	.0047	.047	◪ 279	.0043	.047	■ 312	.0047	.047	–	–	–	–	–	–	–	–	–	7156926
	T7325	.016	◪ 459	.0047	.047	◪ 344	.0043	.047	–	–	–	–	–	–	–	–	–	–	–	–	7156927
	T8430	.016	■ 476	.0047	.047	◪ 262	.0043	.047	◪ 394	.0047	.047	–	–	–	–	–	–	–	–	–	7977262
	T9325	.016	■ 607	.0047	.047	◪ 361	.0043	.047	◪ 574	.0047	.047	–	–	–	–	–	–	–	–	–	7156930
	T9335	.016	■ 509	.0047	.047	◪ 295	.0043	.047	–	–	–	–	–	–	–	–	–	–	–	–	7156931
	T9415	.016	■ 722	.0047	.047	–	–	–	◪ 673	.0047	.047	–	–	–	–	–	–	–	–	–	8345980
VBMT 332-FM2	**T6310**	.031	■ 410	.0079	.047	◪ 295	.0071	.047	■ 328	.0079	.047	–	–	–	–	–	–	–	–	–	7156932
	T7325	.031	◪ 476	.0079	.047	◪ 361	.0071	.047	–	–	–	–	–	–	–	–	–	–	–	–	7156933
	T8430	.031	■ 459	.0079	.047	◪ 246	.0071	.047	◪ 377	.0079	.047	–	–	–	–	–	–	–	–	–	7977264
	T9325	.031	■ 574	.0079	.047	◪ 344	.0071	.047	◪ 541	.0079	.047	–	–	–	–	–	–	–	–	–	7156936
	T9335	.031	■ 492	.0079	.047	◪ 295	.0071	.047	–	–	–	–	–	–	–	–	–	–	–	–	7156937
	T9415	.031	■ 722	.0079	.047	–	–	–	◪ 673	.0079	.047	–	–	–	–	–	–	–	–	–	8345981
VBMT 333-FM2	**T8430**	.047	■ 476	.0087	.047	◪ 262	.0079	.047	◪ 394	.0087	.047	–	–	–	–	–	–	–	–	–	7977267
	T9315	.047	■ 640	.0087	.047	–	–	–	◪ 607	.0087	.047	–	–	–	–	–	–	–	–	–	7156939
	T9325	.047	■ 574	.0087	.047	◪ 344	.0079	.047	◪ 541	.0087	.047	–	–	–	–	–	–	–	–	–	7156940
	T9415	.047	■ 738	.0087	.047	–	–	–	◪ 689	.0087	.047	–	–	–	–	–	–	–	–	–	8345982
																					
FM2 chip breaker is robust and the first choice for medium machining of Steels. It features positive rake angle and stable, moderate T-land. It's also suitable for Cast irons, and conditionally for Stainless steels.																					
VCGT 2.522-FM2	**T8430**	.031	■ 476	.0067	.039	◪ 262	.0059	.039	◪ 394	.0067	.039	–	–	–	–	–	–	–	–	–	7977274
	T9325	.031	■ 591	.0067	.039	◪ 344	.0059	.039	◪ 558	.0067	.039	–	–	–	–	–	–	–	–	–	6756103

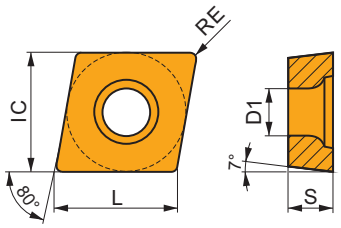
SI



SI chip breaker is sharp and the first choice for medium machining of Stainless steels. It features highly positive rake angle without T-land. It's also suitable for Steels and Super-alloys, and conditionally for Cast irons.

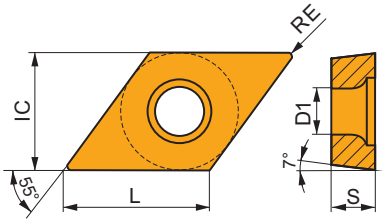
CCGT

	IC (inch)	D1 (inch)	L (inch)	S (inch)
21.5	.250	.110	.252	.094
32.5	.375	.173	.382	.156
43	.500	.217	.508	.187



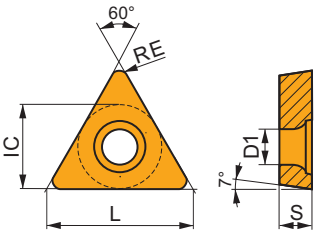
DCGT

	IC (inch)	D1 (inch)	L (inch)	S (inch)
32.5	.375	.173	.457	.156

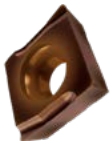
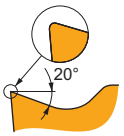
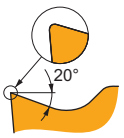
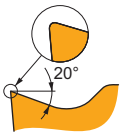
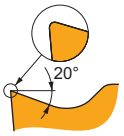
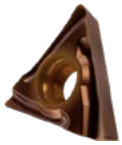
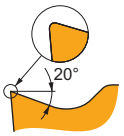
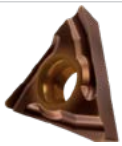
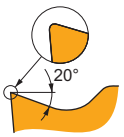


TCGT

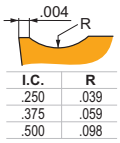
	IC (inch)	D1 (inch)	L (inch)	S (inch)
21.5	.250	.110	.433	.094



Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our cutting conditions app for further options.

Product		RE	P				M				K				N				S				H				MID
			vc (ft/min)	f (in/rev)	ap (inch)		vc (ft/min)	f (in/rev)	ap (inch)		vc (ft/min)	f (in/rev)	ap (inch)		vc (ft/min)	f (in/rev)	ap (inch)		vc (ft/min)	f (in/rev)	ap (inch)		vc (ft/min)	f (in/rev)	ap (inch)		
						**SI** chip breaker is sharp and the first choice for medium machining of Stainless steels. It features highly positive rake angle without T-land. It's also suitable for Steels and Super-alloys, and conditionally for Cast irons.																				
CCGT 21.50.5R-SI	**T8430**	.008	853	.0039	.031		459	.0035	.031		705	.0039	.031		–	–	–		180	.0031	.024		–	–	–		7977180
CCGT 21.51R-SI	**T8430**	.016	853	.0047	.031		459	.0043	.031		705	.0047	.031		–	–	–		180	.0039	.024		–	–	–		7977181
CCGT 32.51R-SI	**T8315**	.016	673	.0067	.031		394	.0059	.031		623	.0067	.031		–	–	–		164	.0059	.024		–	–	–		6922721
	T8430	.016	755	.0067	.031		410	.0059	.031		607	.0067	.031		–	–	–		148	.0059	.024		–	–	–		7973795
CCGT 432R-SI	**T8430**	.031	755	.0094	.039		410	.0087	.039		607	.0094	.039		–	–	–		148	.0087	.031		–	–	–		7977183
						**SI** chip breaker is sharp and the first choice for medium machining of Stainless steels. It features highly positive rake angle without T-land. It's also suitable for Steels and Super-alloys, and conditionally for Cast irons.																				
CCGT 21.50.5L-SI	**T8430**	.008	853	.0039	.031		459	.0035	.031		705	.0039	.031		–	–	–		180	.0031	.024		–	–	–		7977179
CCGT 21.51L-SI	**T8415**	.016	902	.0047	.031		459	.0043	.031		820	.0047	.031		–	–	–		197	.0038	.025		–	–	–		8553191
	T8430	.016	853	.0047	.031		459	.0043	.031		705	.0047	.031		–	–	–		180	.0039	.024		–	–	–		7973793
CCGT 32.51L-SI	**T8415**	.016	820	.0067	.031		427	.006	.031		738	.0067	.031		–	–	–		180	.006	.025		–	–	–		8553196
	T8430	.016	755	.0067	.031		410	.0059	.031		607	.0067	.031		–	–	–		148	.0059	.024		–	–	–		7973794
CCGT 432L-SI	**T8430**	.031	755	.0094	.039		410	.0087	.039		607	.0094	.039		–	–	–		148	.0087	.031		–	–	–		7977182
						**SI** chip breaker is sharp and the first choice for medium machining of Stainless steels. It features highly positive rake angle without T-land. It's also suitable for Steels and Super-alloys, and conditionally for Cast irons.																				
DCGT 32.51R-SI	**T8430**	.016	673	.0047	.031		361	.0043	.031		558	.0047	.031		–	–	–		148	.0039	.024		–	–	–		7977208
DCGT 32.52R-SI	**T8430**	.031	623	.0087	.039		344	.0079	.039		509	.0087	.039		–	–	–		131	.0071	.031		–	–	–		7977210
						**SI** chip breaker is sharp and the first choice for medium machining of Stainless steels. It features highly positive rake angle without T-land. It's also suitable for Steels and Super-alloys, and conditionally for Cast irons.																				
DCGT 32.51L-SI	**T8430**	.016	673	.0047	.031		361	.0043	.031		558	.0047	.031		–	–	–		148	.0039	.024		–	–	–		7977207
DCGT 32.52L-SI	**T8430**	.031	623	.0087	.039		344	.0079	.039		509	.0087	.039		–	–	–		131	.0071	.031		–	–	–		7977209
						**SI** chip breaker is sharp and the first choice for medium machining of Stainless steels. It features highly positive rake angle without T-land. It's also suitable for Steels and Super-alloys, and conditionally for Cast irons.																				
TCGT 21.50.5R-SI	**T8430**	.008	738	.0039	.031		394	.0035	.031		607	.0039	.031		–	–	–		148	.0031	.024		–	–	–		7977247
TCGT 21.51R-SI	**T8430**	.016	738	.0047	.031		394	.0043	.031		607	.0047	.031		–	–	–		148	.0039	.024		–	–	–		7977249
						**SI** chip breaker is sharp and the first choice for medium machining of Stainless steels. It features highly positive rake angle without T-land. It's also suitable for Steels and Super-alloys, and conditionally for Cast irons.																				
TCGT 21.50.5L-SI	**T8415**	.008	755	.0039	.031		394	.0035	.031		689	.0039	.031		–	–	–		164	.0031	.025		–	–	–		8553249
	T8430	.008	738	.0039	.031		394	.0035	.031		607	.0039	.031		–	–	–		148	.0031	.024		–	–	–		7973851
TCGT 21.51L-SI	**T8415**	.016	755	.0047	.031		394	.0043	.031		689	.0047	.031		–	–	–		164	.0038	.025		–	–	–		8553251
	T8430	.016	738	.0047	.031		394	.0043	.031		607	.0047	.031		–	–	–		148	.0039	.024		–	–	–		7977248

RF

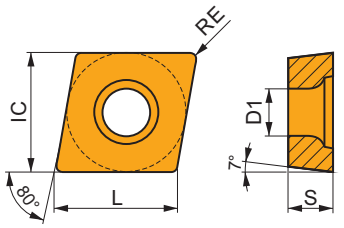


I.C.	R
.250	.039
.375	.059
.500	.098

RF chip breaker is robust and the first choice for medium machining of Cast irons. It features slightly positive rake angle and stable, moderate T-land. It's also suitable for Steels, and conditionally for Stainless steels and Hard materials.

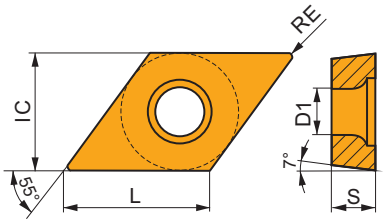
CCMT

	IC (inch)	D1 (inch)	L (inch)	S (inch)
21.5	.250	.110	.252	.094
32.5	.375	.173	.382	.156
43	.500	.217	.508	.187



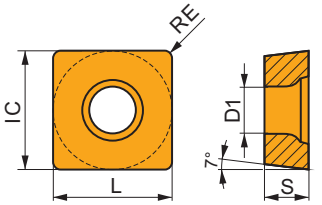
DCMT

	IC (inch)	D1 (inch)	L (inch)	S (inch)
32.5	.375	.173	.457	.156



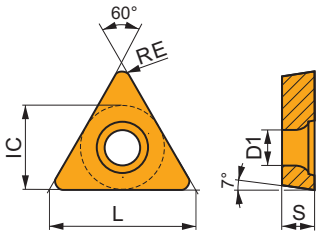
SCMT

	IC (inch)	D1 (inch)	L (inch)	S (inch)
32.5	.375	.173	.375	.156
43	.500	.217	.500	.187



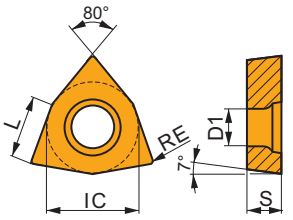
TCMT

	IC (inch)	D1 (inch)	L (inch)	S (inch)
32.5	.375	.173	.650	.156

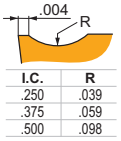


WCMT

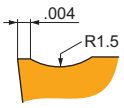
	IC (inch)	D1 (inch)	L (inch)	S (inch)
32.5	.375	.173	.256	.156
43	.500	.217	.343	.187



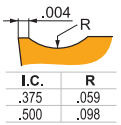
Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our cutting conditions app for further options.

Product		RE	P				M				K				N				S				H				MID
			vc (ft/min)	f (in/rev)	ap (inch)		vc (ft/min)	f (in/rev)	ap (inch)		vc (ft/min)	f (in/rev)	ap (inch)		vc (ft/min)	f (in/rev)	ap (inch)		vc (ft/min)	f (in/rev)	ap (inch)		vc (ft/min)	f (in/rev)	ap (inch)		
																											
CCMT 21.50.5-RF	**T7335**	.008	◪	492	.0059	.039	◪	377	.0055	.039		–	–	–		–	–	–		–	–	–		–	–	–	6756021
CCMT 21.51-RF	**T5315**	.016	◪	771	.0059	.039		–	–	–	■	722	.0059	.039		–	–	–		–	–	–	◪	148	.0043	.012	6756024
	T7335	.016	◪	525	.0059	.039	◪	394	.0059	.039		–	–	–		–	–	–		–	–	–		–	–	–	6756023
	T9325	.016	■	673	.0059	.039	◪	394	.0059	.039	◪	623	.0059	.039		–	–	–		–	–	–		–	–	–	8014935
CCMT 32.51-RF	**T7335**	.016	◪	443	.0079	.059	◪	344	.0071	.059		–	–	–		–	–	–		–	–	–		–	–	–	6756026
	T9325	.016	■	574	.0079	.059	◪	344	.0071	.059	◪	541	.0079	.059		–	–	–		–	–	–		–	–	–	8014936
CCMT 32.52-RF	**T5315**	.031	◪	804	.0079	.059		–	–	–	■	755	.0079	.059		–	–	–		–	–	–	◪	148	.0055	.028	6756029
	T7335	.031	◪	541	.0079	.059	◪	410	.0071	.059		–	–	–		–	–	–		–	–	–		–	–	–	6756028
	T9325	.031	■	689	.0079	.059	◪	410	.0071	.059	◪	640	.0079	.059		–	–	–		–	–	–		–	–	–	8014937
CCMT 432-RF	**T5315**	.031	◪	755	.0087	.087		–	–	–	■	705	.0087	.087		–	–	–		–	–	–	◪	148	.0051	.028	6756032
	T7335	.031	◪	492	.0087	.087	◪	377	.0087	.087		–	–	–		–	–	–		–	–	–		–	–	–	6756031
	T9325	.031	■	640	.0087	.087	◪	377	.0087	.087	◪	607	.0087	.087		–	–	–		–	–	–		–	–	–	8014938

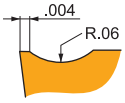
RF chip breaker is robust and the first choice for medium machining of Cast irons. It features slightly positive rake angle and stable, moderate T-land. It's also suitable for Steels, and conditionally for Stainless steels and Hard materials.

																											
DCMT 32.51-RF	**T5315**	.016	◪	574	.0079	.031		–	–	–	■	541	.0079	.031		–	–	–		–	–	–	◪	115	.0055	.012	6756035
	T7335	.016	◪	377	.0079	.031	◪	279	.0071	.031		–	–	–		–	–	–		–	–	–		–	–	–	6756034
	T9325	.016	■	492	.0079	.031	◪	295	.0071	.031	◪	459	.0079	.031		–	–	–		–	–	–		–	–	–	8014939
DCMT 32.52-RF	**T5315**	.031	◪	673	.0079	.031		–	–	–	■	623	.0079	.031		–	–	–		–	–	–	◪	131	.0039	.028	6756038
	T7335	.031	◪	459	.0079	.031	◪	344	.0071	.031		–	–	–		–	–	–		–	–	–		–	–	–	6756037
	T9325	.031	■	574	.0079	.031	◪	344	.0071	.031	◪	541	.0079	.031		–	–	–		–	–	–		–	–	–	8014990

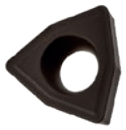
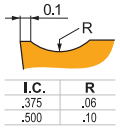
RF chip breaker is robust and the first choice for medium machining of Cast irons. It features slightly positive rake angle and stable, moderate T-land. It's also suitable for Steels, and conditionally for Stainless steels and Hard materials.

																											
SCMT 32.52-RF	**T9325**	.031	■	722	.0079	.059	◪	427	.0071	.059	◪	673	.0079	.059		–	–	–		–	–	–		–	–	–	8014995
SCMT 432-RF	**T5315**	.031	◪	787	.0087	.087		–	–	–	■	738	.0087	.087		–	–	–		–	–	–	◪	148	.0051	.028	6756044
	T7335	.031	◪	525	.0087	.087	◪	394	.0087	.087		–	–	–		–	–	–		–	–	–		–	–	–	6756043
	T9325	.031	■	673	.0087	.087	◪	394	.0087	.087	◪	623	.0087	.087		–	–	–		–	–	–		–	–	–	8014996

RF chip breaker is robust and the first choice for medium machining of Cast irons. It features slightly positive rake angle and stable, moderate T-land. It's also suitable for Steels, and conditionally for Stainless steels and Hard materials.

																											
TCMT 32.52-RF	**T9325**	.031	■	574	.0079	.059	◪	344	.0071	.059	◪	541	.0079	.059		–	–	–		–	–	–		–	–	–	8014997

RF chip breaker is robust and the first choice for medium machining of Cast irons. It features slightly positive rake angle and stable, moderate T-land. It's also suitable for Steels, and conditionally for Stainless steels and Hard materials.

																											
WCMT 32.52-RF	**T7335**	.031	◪	541	.0079	.059	◪	410	.0071	.059		–	–	–		–	–	–		–	–	–		–	–	–	6756046
WCMT 433-RF	**T7335**	.047	◪	525	.0087	.087	◪	394	.0087	.087		–	–	–		–	–	–		–	–	–		–	–	–	6756047

RF chip breaker is robust and the first choice for medium machining of Cast irons. It features slightly positive rake angle and stable, moderate T-land. It's also suitable for Steels, and conditionally for Stainless steels and Hard materials.

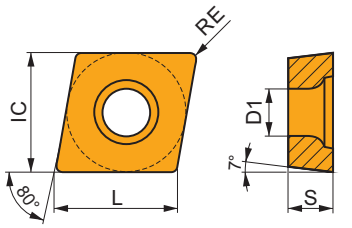
.CMW

.CMW flat insert is designed for medium machining of Cast irons. It features neutral rake angle without T-land. It's also conditionally suitable for Hard materials.

PRAMET

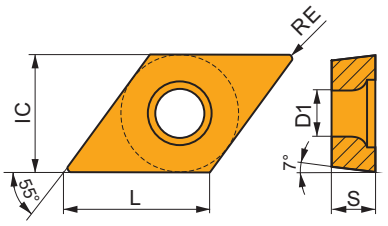
CCMW

	IC (inch)	D1 (inch)	L (inch)	S (inch)
21.5	.250	.110	.252	.094
32.5	.375	.173	.382	.156
43	.500	.217	.508	.187



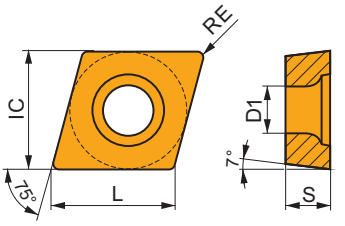
DCMW

	IC (inch)	D1 (inch)	L (inch)	S (inch)
21.5	.250	.110	.307	.094
32.5	.375	.173	.457	.156



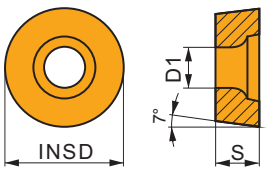
ECMW

	IC (inch)	D1 (inch)	L (inch)	S (inch)
2.52	.313	.134	.323	.125
21.5	.250	.110	.256	.094



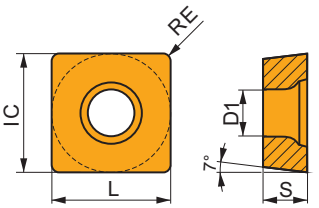
RCMW

	INSD (inch)	D1 (inch)	S (inch)
0602	.236	.110	.094
0803	.315	.134	.125
10T3	.394	.173	.156
1204	.472	.173	.187



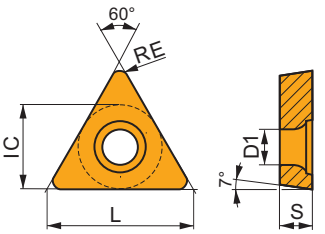
SCMW

	IC (inch)	D1 (inch)	L (inch)	S (inch)
32.5	.375	.173	.375	.156
43	.500	.217	.500	.187



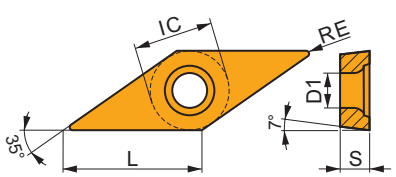
TCMW

	IC (inch)	D1 (inch)	L (inch)	S (inch)
21.5	.250	.110	.433	.094
32.5	.375	.173	.650	.156



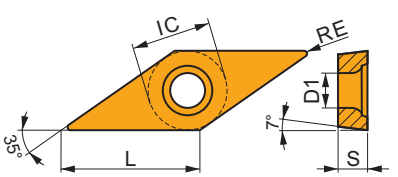
VCGW

	IC (inch)	D1 (inch)	L (inch)	S (inch)
2.52	.313	.134	.543	.125



VCMW

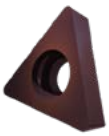
	IC (inch)	D1 (inch)	L (inch)	S (inch)
22	.250	.110	.437	.125
33	.375	.173	.654	.187



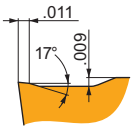
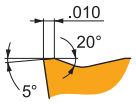
Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our cutting conditions app for further options.

Product		RE	P			M			K			N			S			H			MID
		(inch)	vc (ft/min)	f (in/rev)	ap (inch)	vc (ft/min)	f (in/rev)	ap (inch)	vc (ft/min)	f (in/rev)	ap (inch)	vc (ft/min)	f (in/rev)	ap (inch)	vc (ft/min)	f (in/rev)	ap (inch)	vc (ft/min)	f (in/rev)	ap (inch)	
.CMW flat insert is designed for medium machining of Cast irons. It features neutral rake angle without T-land. It's also conditionally suitable for Hard materials.																					
CCMW 21.50.5	**T5305**	.008	–	–	–	–	–	–	755	.0031	.079	–	–	–	–	–	–	148	.0031	.008	6755718
CCMW 21.51	**T5305**	.016	–	–	–	–	–	–	755	.0039	.079	–	–	–	–	–	–	148	.0039	.012	6755719
	T5315	.016	–	–	–	–	–	–	640	.0039	.079	–	–	–	–	–	–	131	.0039	.012	6922806
	T6310	.016	–	–	–	–	–	–	312	.0039	.079	–	–	–	–	–	–	66	.0039	.012	7168644
	T8415	.016	–	–	–	–	–	–	476	.0039	.079	–	–	–	–	–	–	82	.0039	.013	8553217
CCMW 32.51	**T5305**	.016	–	–	–	–	–	–	705	.0039	.118	–	–	–	–	–	–	148	.0039	.012	6755720
	T5315	.016	–	–	–	–	–	–	623	.0039	.118	–	–	–	–	–	–	131	.0039	.012	6922807
	T8415	.016	–	–	–	–	–	–	443	.0039	.118	–	–	–	–	–	–	82	.0039	.013	8553218
CCMW 32.52	**T5305**	.031	–	–	–	–	–	–	656	.0079	.118	–	–	–	–	–	–	131	.0043	.028	6755721
	T5315	.031	–	–	–	–	–	–	591	.0079	.118	–	–	–	–	–	–	115	.0043	.028	6922808
	T8415	.031	–	–	–	–	–	–	443	.0079	.118	–	–	–	–	–	–	82	.0043	.026	8553219
CCMW 431	**T5305**	.016	–	–	–	–	–	–	689	.0039	.157	–	–	–	–	–	–	148	.0039	.012	6755722
	T5315	.016	–	–	–	–	–	–	607	.0039	.157	–	–	–	–	–	–	115	.0039	.012	6922809
CCMW 432	**T5305**	.031	–	–	–	–	–	–	640	.0079	.157	–	–	–	–	–	–	131	.0043	.028	6755723
	T5315	.031	–	–	–	–	–	–	574	.0079	.157	–	–	–	–	–	–	115	.0043	.028	6922810
.CMW flat insert is designed for medium machining of Cast irons. It features neutral rake angle without T-land. It's also conditionally suitable for Hard materials.																					
DCMW 21.50.5	**T5305**	.008	–	–	–	–	–	–	656	.0031	.031	–	–	–	–	–	–	131	.0031	.008	6755817
DCMW 21.51	**T5305**	.016	–	–	–	–	–	–	640	.0039	.031	–	–	–	–	–	–	131	.0039	.012	6755818
	T8415	.016	–	–	–	–	–	–	410	.0039	.031	–	–	–	–	–	–	66	.0039	.013	8553234
DCMW 32.51	**T5305**	.016	–	–	–	–	–	–	623	.0039	.047	–	–	–	–	–	–	131	.0039	.012	6755819
	T5315	.016	–	–	–	–	–	–	541	.0039	.047	–	–	–	–	–	–	115	.0039	.012	6922813
	T8415	.016	–	–	–	–	–	–	394	.0039	.047	–	–	–	–	–	–	66	.0039	.013	8553235
DCMW 32.52	**T5305**	.031	–	–	–	–	–	–	607	.0071	.047	–	–	–	–	–	–	115	.0043	.028	6755820
	T5315	.031	–	–	–	–	–	–	525	.0071	.047	–	–	–	–	–	–	98	.0043	.028	6922814
	T6310	.031	–	–	–	–	–	–	262	.0071	.047	–	–	–	–	–	–	66	.0043	.028	7168648
	T8415	.031	–	–	–	–	–	–	410	.0071	.047	–	–	–	–	–	–	66	.0043	.026	8553236
.CMW flat insert is designed for medium machining of Cast irons. It features neutral rake angle without T-land. It's also conditionally suitable for Hard materials.																					
ECMW 2.521	**H07**	.016	–	–	–	–	–	–	328	.0039	.098	–	–	–	–	–	–	–	–	–	7168664
ECMW 21.51	**H07**	.016	–	–	–	–	–	–	328	.0039	.079	–	–	–	–	–	–	–	–	–	7168663
.CMW flat insert is designed for medium machining of Cast irons. It features neutral rake angle without T-land. It's also conditionally suitable for Hard materials.																					
RCMW 0602M0	**T5305**	–	–	–	–	–	–	–	919	.0098	.024	–	–	–	–	–	–	180	.0067	.016	6755830
	T5315	–	–	–	–	–	–	–	820	.0098	.024	–	–	–	–	–	–	164	.0067	.016	6922815
RCMW 0803M0	**T5305**	–	–	–	–	–	–	–	837	.0118	.031	–	–	–	–	–	–	164	.0067	.020	6755831
RCMW 10T3M0	**T5305**	–	–	–	–	–	–	–	738	.0157	.039	–	–	–	–	–	–	148	.0079	.028	6755832
RCMW 1204M0	**T5305**	–	–	–	–	–	–	–	673	.0177	.047	–	–	–	–	–	–	131	.0079	.031	6755843

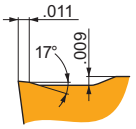
Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our cutting conditions app for further options.

Product		RE (inch)	P vc (ft/min)	P f (in/rev)	P ap (inch)	M vc (ft/min)	M f (in/rev)	M ap (inch)	K vc (ft/min)	K f (in/rev)	K ap (inch)	N vc (ft/min)	N f (in/rev)	N ap (inch)	S vc (ft/min)	S f (in/rev)	S ap (inch)	H vc (ft/min)	H f (in/rev)	H ap (inch)	MID
.CMW flat insert is designed for medium machining of Cast irons. It features neutral rake angle without T-land. It's also conditionally suitable for Hard materials.																					
SCMW 32.51	**T5305**	.016	–	–	–	–	–	–	787	.0039	.079	–	–	–	–	–	–	164	.0039	.012	6755854
SCMW 32.52	**T5305**	.031	–	–	–	–	–	–	722	.0079	.079	–	–	–	–	–	–	148	.0043	.028	6755855
	T5315	.031	–	–	–	–	–	–	623	.0079	.079	–	–	–	–	–	–	131	.0043	.028	6922820
SCMW 432	**T5305**	.031	–	–	–	–	–	–	673	.0079	.157	–	–	–	–	–	–	131	.0043	.028	6755856
																					
.CMW flat insert is designed for medium machining of Cast irons. It features neutral rake angle without T-land. It's also conditionally suitable for Hard materials.																					
TCMW 21.51	**T5305**	.016	–	–	–	–	–	–	656	.0039	.047	–	–	–	–	–	–	131	.0039	.012	6755882
	T5315	.016	–	–	–	–	–	–	591	.0039	.047	–	–	–	–	–	–	115	.0039	.012	6922822
TCMW 32.51	**T5305**	.016	–	–	–	–	–	–	640	.0039	.059	–	–	–	–	–	–	131	.0039	.012	6755883
	T5315	.016	–	–	–	–	–	–	574	.0039	.059	–	–	–	–	–	–	115	.0039	.012	6922823
TCMW 32.52	**T5305**	.031	–	–	–	–	–	–	623	.0071	.059	–	–	–	–	–	–	131	.0043	.028	6755884
	T5315	.031	–	–	–	–	–	–	541	.0071	.059	–	–	–	–	–	–	115	.0043	.028	6922824
	T8415	.031	–	–	–	–	–	–	410	.0071	.059	–	–	–	–	–	–	66	.0043	.026	8553262
.CMW flat insert is designed for medium machining of Cast irons. It features neutral rake angle without T-land. It's also conditionally suitable for Hard materials.																					
VCGW 2.520.5	**T5305**	.008	–	–	–	–	–	–	558	.0031	.051	–	–	–	–	–	–	115	.0031	.008	6756218
VCGW 2.521	**T5305**	.016	–	–	–	–	–	–	541	.0039	.051	–	–	–	–	–	–	115	.0039	.012	6756219
.CMW flat insert is designed for medium machining of Cast irons. It features neutral rake angle without T-land. It's also conditionally suitable for Hard materials.																					
VCMW 220.5	**T5305**	.008	–	–	–	–	–	–	558	.0031	.047	–	–	–	–	–	–	115	.0031	.008	6755902
VCMW 221	**T5305**	.016	–	–	–	–	–	–	541	.0039	.047	–	–	–	–	–	–	115	.0039	.012	6755903
	T8415	.016	–	–	–	–	–	–	344	.0039	.047	–	–	–	–	–	–	66	.0039	.013	8553288
VCMW 331	**T5305**	.016	–	–	–	–	–	–	541	.0039	.059	–	–	–	–	–	–	115	.0039	.012	6755904
	T8415	.016	–	–	–	–	–	–	328	.0039	.059	–	–	–	–	–	–	49	.0039	.013	8553289
VCMW 332	**T5305**	.031	–	–	–	–	–	–	509	.0071	.059	–	–	–	–	–	–	98	.0043	.028	6755905
	T5315	.031	–	–	–	–	–	–	443	.0071	.059	–	–	–	–	–	–	82	.0043	.028	6922828
	T6310	.031	–	–	–	–	–	–	230	.0071	.059	–	–	–	–	–	–	49	.0043	.028	7168656
	T8415	.031	–	–	–	–	–	–	328	.0071	.059	–	–	–	–	–	–	49	.0043	.026	8553290

ROUGHING – NAVIGATOR

RM			**RM** chip breaker is robust and the first choice for roughing of Steels and Cast irons. It features positive rake angle and stable, wide T-land. It's also suitable for Stainless steels, and conditionally for Super-alloys and Hard materials.
RM3			**RM3** chip breaker is robust and designed for roughing of Steels and Cast irons. It features positive rake angle and negative, wide T-land. It's also conditionally suitable for Stainless steels and Hard materials.

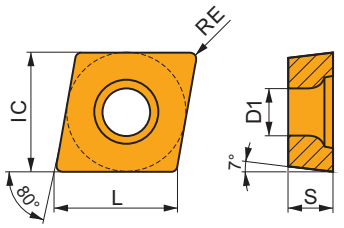
RM



RM chip breaker is robust and the first choice for roughing of Steels and Cast irons. It features positive rake angle and stable, wide T-land. It's also suitable for Stainless steels, and conditionally for Super-alloys and Hard materials.

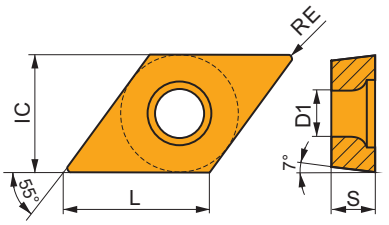
CCMT

	IC (inch)	D1 (inch)	L (inch)	S (inch)
32.5	.375	.173	.382	.156
43	.500	.217	.508	.187



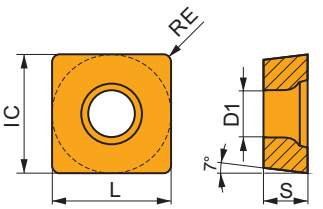
DCMT

	IC (inch)	D1 (inch)	L (inch)	S (inch)
32.5	.375	.173	.457	.156
43	.500	.217	.610	.187



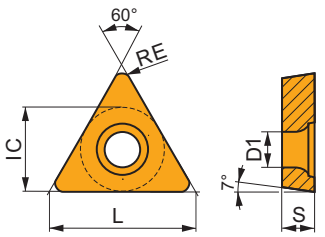
SCMT

	IC (inch)	D1 (inch)	L (inch)	S (inch)
32.5	.375	.173	.375	.156
43	.500	.217	.500	.187



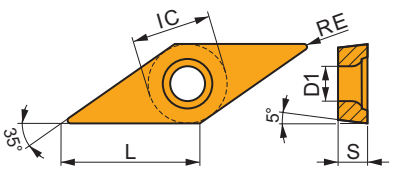
TCMT

	IC (inch)	D1 (inch)	L (inch)	S (inch)
32.5	.375	.173	.650	.156



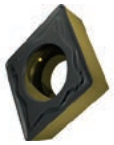
VBMT

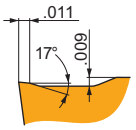
	IC (inch)	D1 (inch)	L (inch)	S (inch)
33	.375	.173	.654	.187



Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our cutting conditions app for further options.

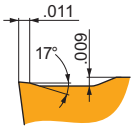
Product		RE	P vc (ft/min)	P f (in/rev)	P ap (inch)	M vc (ft/min)	M f (in/rev)	M ap (inch)	K vc (ft/min)	K f (in/rev)	K ap (inch)	N vc (ft/min)	N f (in/rev)	N ap (inch)	S vc (ft/min)	S f (in/rev)	S ap (inch)	H vc (ft/min)	H f (in/rev)	H ap (inch)	MID





RM chip breaker is robust and the first choice for roughing of Steels and Cast irons. It features positive rake angle and stable, wide T-land. It's also suitable for Stainless steels, and conditionally for Super-alloys and Hard materials.

CCMT 32.51-RM	**T5305**	.016	853	.0098	.087	–	–	–	804	.0098	.087	–	–	–	–	–	–	164	.0071	.012	6755715
	T5315	.016	771	.0098	.087	–	–	–	722	.0098	.087	–	–	–	–	–	–	148	.0071	.012	6755835
	T7335	.016	525	.0098	.087	394	.0091	.087	–	–	–	–	–	–	164	.0071	.071	–	–	–	6754738
	T8430	.016	509	.0098	.087	279	.0091	.087	427	.0098	.087	–	–	–	98	.0071	.071	82	.0071	.012	7973816
	T9325	.016	640	.0098	.087	377	.0091	.087	607	.0098	.087	–	–	–	131	.0071	.071	–	–	–	6753765
	T9415	.016	837	.0098	.087	–	–	–	787	.0098	.087	–	–	–	–	–	–	164	.0071	.012	8244335
CCMT 32.52-RM	**T5305**	.031	951	.0118	.087	–	–	–	902	.0118	.087	–	–	–	–	–	–	180	.0059	.028	6755716
	T5315	.031	869	.0118	.087	–	–	–	820	.0118	.087	–	–	–	–	–	–	164	.0059	.028	6755837
	T7335	.031	574	.0118	.087	443	.0106	.087	–	–	–	–	–	–	180	.0094	.071	–	–	–	6754741
	T8430	.031	591	.0118	.087	312	.0106	.087	476	.0118	.087	–	–	–	115	.0094	.071	98	.0059	.028	7973820
	T9325	.031	705	.0118	.087	410	.0106	.087	656	.0118	.087	–	–	–	148	.0094	.071	–	–	–	6753768
	T9415	.031	935	.0118	.087	–	–	–	886	.0118	.087	–	–	–	–	–	–	180	.0059	.028	8244338
CCMT 432-RM	**T5305**	.031	951	.0118	.106	–	–	–	902	.0118	.106	–	–	–	–	–	–	180	.0059	.028	6755717
	T5315	.031	853	.0118	.106	–	–	–	804	.0118	.106	–	–	–	–	–	–	164	.0059	.028	6755840
	T7335	.031	574	.0118	.106	443	.0106	.106	–	–	–	–	–	–	180	.0094	.087	–	–	–	6754745
	T8430	.031	574	.0118	.106	312	.0106	.106	459	.0118	.106	–	–	–	115	.0094	.087	98	.0059	.028	7973826
	T9325	.031	689	.0118	.106	410	.0106	.106	640	.0118	.106	–	–	–	148	.0094	.087	–	–	–	6753771
	T9415	.031	919	.0118	.106	–	–	–	869	.0118	.106	–	–	–	–	–	–	180	.0059	.028	8244364
CCMT 433-RM	**T8430**	.047	591	.013	.106	312	.0118	.106	476	.013	.106	–	–	–	115	.0091	.087	98	.0067	.039	7977204
	T9325	.047	705	.013	.106	410	.0118	.106	656	.013	.106	–	–	–	148	.0091	.087	–	–	–	6753873
	T9415	.047	919	.013	.106	–	–	–	869	.013	.106	–	–	–	–	–	–	180	.0067	.039	8244365



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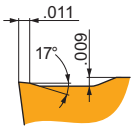
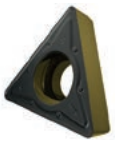
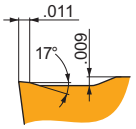
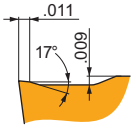
DCMT 32.51-RM	**T5305**	.016	820	.0079	.039	–	–	–	771	.0079	.039	–	–	–	–	–	–	164	.0055	.012	6755815
	T5315	.016	722	.0079	.039	–	–	–	673	.0079	.039	–	–	–	–	–	–	131	.0055	.012	6755846
	T7335	.016	476	.0079	.039	361	.0071	.039	–	–	–	–	–	–	148	.0055	.031	–	–	–	6754772
	T8430	.016	492	.0079	.039	262	.0071	.039	410	.0079	.039	–	–	–	98	.0055	.031	82	.0055	.012	7977219
	T9325	.016	607	.0079	.039	361	.0071	.039	574	.0079	.039	–	–	–	131	.0055	.031	–	–	–	6753782
	T9415	.016	771	.0079	.039	–	–	–	722	.0079	.039	–	–	–	–	–	–	148	.0055	.012	8244366
DCMT 32.52-RM	**T5305**	.031	886	.0106	.031	–	–	–	837	.0106	.031	–	–	–	–	–	–	164	.0055	.028	6755816
	T5315	.031	787	.0106	.031	–	–	–	738	.0106	.031	–	–	–	–	–	–	148	.0055	.028	6755848
	T7335	.031	541	.0106	.031	410	.0094	.031	–	–	–	–	–	–	164	.0075	.024	–	–	–	6754775
	T8430	.031	541	.0106	.031	295	.0094	.031	443	.0106	.031	–	–	–	115	.0075	.024	82	.0055	.028	7973837
	T9325	.031	656	.0106	.031	394	.0094	.031	623	.0106	.031	–	–	–	148	.0075	.024	–	–	–	6753786
	T9415	.031	837	.0106	.039	–	–	–	787	.0106	.039	–	–	–	–	–	–	164	.0055	.028	8244367
DCMT 32.53-RM	**T8430**	.047	558	.0106	.047	295	.0094	.047	443	.0106	.047	–	–	–	115	.0075	.047	82	.0055	.035	7977225
	T9325	.047	656	.0106	.047	394	.0094	.047	623	.0106	.047	–	–	–	148	.0075	.047	–	–	–	6753937
	T9415	.047	853	.0106	.047	–	–	–	804	.0106	.047	–	–	–	–	–	–	164	.0055	.035	8244370
DCMT 432-RM	**T8430**	.031	492	.0106	.075	262	.0094	.075	410	.0106	.075	–	–	–	98	.0087	.059	82	.0055	.028	7973839
	T9325	.031	591	.0106	.075	344	.0094	.075	558	.0106	.075	–	–	–	131	.0087	.059	–	–	–	6755615
	T9415	.031	771	.0106	.075	–	–	–	722	.0106	.075	–	–	–	–	–	–	148	.0055	.028	8244373

Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our cutting conditions app for further options.

Product		RE	P						M						K						N						S						H						MID
			vc		f		ap		vc		f		ap		vc		f		ap		vc		f		ap		vc		f		ap		vc		f		ap		
		(inch)	(ft/min)		(in/rev)		(inch)		(ft/min)		(in/rev)		(inch)		(ft/min)		(in/rev)		(inch)		(ft/min)		(in/rev)		(inch)		(ft/min)		(in/rev)		(inch)		(ft/min)		(in/rev)		(inch)		
																																						
SCMT 32.52-RM	**T5315**	.031	902	.0118	.079		–	–	–		853	.0118	.079		–	–	–		–	.0197	.0094	.063		180	.0059	.028	6755762
	T7335	.031	623	.0118	.079		476	.0106	.079		–	–	–		–	–	–		197	.0094	.063		–	–	–		6754800
	T8430	.031	623	.0118	.079		344	.0106	.079		509	.0118	.079		–	–	–		131	.0094	.063		98	.0059	.028	7977241
	T9325	.031	755	.0118	.079		443	.0106	.079		705	.0118	.079		–	–	–		164	.0094	.063		–	–	–		6753834
	T9415	.031	968	.0118	.079		–	–	–		919	.0118	.079		–	–	–		–	–	–		180	.0059	.028	8345959
SCMT 432-RM	**T5305**	.031	1001	.0118	.091		–	–	–		935	.0118	.091		–	–	–		–	–	–		197	.0059	.028	6755853
	T5315	.031	902	.0118	.091		–	–	–		853	.0118	.091		–	–	–		–	–	–		180	.0059	.028	6755765
	T7335	.031	607	.0118	.091		459	.0106	.091		–	–	–		–	–	–		197	.0094	.071		–	–	–		6754802
	T8430	.031	623	.0118	.091		344	.0106	.091		509	.0118	.091		–	–	–		131	.0094	.071		98	.0059	.028	7973849
	T9325	.031	738	.0118	.091		443	.0106	.091		689	.0118	.091		–	–	–		164	.0094	.071		–	–	–		6753836
	T9415	.031	968	.0118	.091		–	–	–		919	.0118	.091		–	–	–		–	–	–		180	.0059	.028	8345963
																																						
TCMT 32.52-RM	**T5305**	.031	869	.0106	.075		–	–	–		820	.0106	.075		–	–	–		–	–	–		164	.0055	.028	6755880
	T5315	.031	771	.0106	.075		–	–	–		722	.0106	.075		–	–	–		–	–	–		148	.0055	.028	6755781
	T7335	.031	509	.0106	.075		394	.0094	.075		–	–	–		–	–	–		164	.0075	.059		–	–	–		6754819
	T8430	.031	541	.0106	.075		295	.0094	.075		443	.0106	.075		–	–	–		115	.0075	.059		82	.0055	.028	7973862
	T9325	.031	640	.0106	.075		377	.0094	.075		607	.0106	.075		–	–	–		131	.0075	.059		–	–	–		6754103
	T9415	.031	820	.0106	.075		–	–	–		771	.0106	.075		–	–	–		–	–	–		164	.0055	.028	8244377
TCMT 32.53-RM	**T5315**	.047	820	.0106	.075		–	–	–		771	.0106	.075		–	–	–		–	–	–		164	.0055	.035	6755783
	T8430	.047	558	.0106	.075		295	.0094	.075		443	.0106	.075		–	–	–		115	.0075	.059		82	.0055	.035	7977259
	T9325	.047	673	.0106	.075		394	.0094	.075		623	.0106	.075		–	–	–		148	.0075	.059		–	–	–		6754104
	T9415	.047	869	.0106	.075		–	–	–		820	.0106	.075		–	–	–		–	–	–		164	.0055	.035	8244378
																																						
VBMT 331-RM	**T5305**	.016	886	.0047	.047		–	–	–		837	.0047	.047		–	–	–		–	–	–		164	.0047	.012	6755900
	T5315	.016	771	.0047	.047		–	–	–		722	.0047	.047		–	–	–		–	–	–		148	.0047	.012	6755710
	T7335	.016	459	.0071	.047		344	.0063	.047		–	–	–		–	–	–		148	.0063	.039		–	–	–		6754832
	T8430	.016	558	.0047	.047		295	.0043	.047		443	.0047	.047		–	–	–		115	.0043	.039		82	.0047	.012	7977263
	T9325	.016	558	.0079	.047		328	.0071	.047		525	.0079	.047		–	–	–		115	.0071	.039		–	–	–		6753853
	T9415	.016	837	.0047	.047		–	–	–		787	.0047	.047		–	–	–		–	–	–		164	.0047	.012	8244386
VBMT 332-RM	**T5305**	.031	935	.0067	.047		–	–	–		886	.0067	.047		–	–	–		–	–	–		180	.0043	.028	6755901
	T5315	.031	820	.0067	.047		–	–	–		771	.0067	.047		–	–	–		–	–	–		164	.0043	.028	6755713
	T7335	.031	509	.0079	.047		394	.0071	.047		–	–	–		–	–	–		164	.0071	.039		–	–	–		6754834
	T8430	.031	574	.0067	.047		312	.0059	.047		459	.0067	.047		–	–	–		115	.0047	.039		98	.0043	.028	7977265
	T9325	.031	656	.0079	.047		394	.0071	.047		623	.0079	.047		–	–	–		148	.0071	.039		–	–	–		6753856
	T9415	.031	886	.0067	.047		–	–	–		837	.0067	.047		–	–	–		–	–	–		164	.0047	.028	8244389
VBMT 333-RM	**T7335**	.047	492	.0106	.047		377	.0094	.047		–	–	–		–	–	–		148	.0075	.039		–	–	–		6754835
	T8430	.047	509	.0106	.047		279	.0094	.047		427	.0106	.047		–	–	–		98	.0075	.039		82	.0055	.035	7977268
	T9325	.047	607	.0106	.047		361	.0094	.047		574	.0106	.047		–	–	–		131	.0075	.039		–	–	–		6754432
	T9415	.047	787	.0106	.047		–	–	–		738	.0106	.047		–	–	–		–	–	–		148	.0055	.035	8244392

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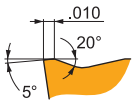
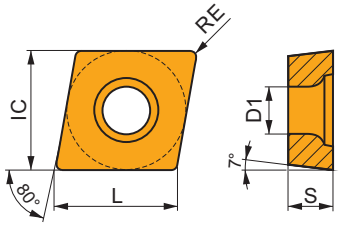
RM3



RM3 chip breaker is robust and designed for roughing of Steels and Cast irons. It features positive rake angle and negative, wide T-land. It's also conditionally suitable for Stainless steels and Hard materials.

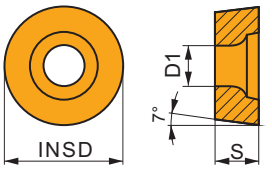
CCMT

	IC (inch)	D1 (inch)	L (inch)	S (inch)
43	.500	.217	.508	.187



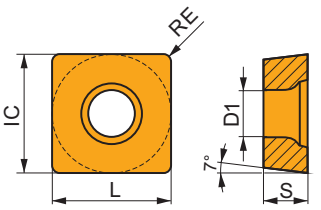
RCMT

	INSD (inch)	D1 (inch)	S (inch)
0803	.315	.134	.125
1204	.472	.173	.187
1606	.630	.217	.250



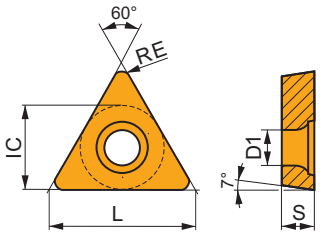
SCMT

	IC (inch)	D1 (inch)	L (inch)	S (inch)
43	.500	.217	.500	.187

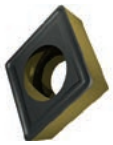
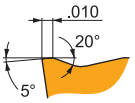


TCMT

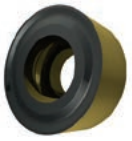
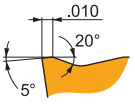
	IC (inch)	D1 (inch)	L (inch)	S (inch)
32.5	.375	.173	.650	.156



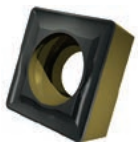
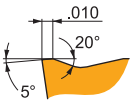
Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our cutting conditions app for further options.

Product		RE	P				M				K				N				S				H				MID
			vc (ft/min)	f (in/rev)	ap (inch)		vc (ft/min)	f (in/rev)	ap (inch)		vc (ft/min)	f (in/rev)	ap (inch)		vc (ft/min)	f (in/rev)	ap (inch)		vc (ft/min)	f (in/rev)	ap (inch)		vc (ft/min)	f (in/rev)	ap (inch)		
																											
CCMT 431-RM3	**T9325**	.016	541	.0098	.098		312	.0098	.098		509	.0098	.098		–	–	–		–	–	–		–	–	–		7248703
	T9415	.016	705	.0098	.098		–	–	–		656	.0098	.098		–	–	–		–	–	–		131	.0051	.012		8345924
CCMT 432-RM3	**T6310**	.031	476	.0106	.098		328	.0106	.098		377	.0106	.098		–	–	–		–	–	–		82	.0055	.028		7248704
	T9325	.031	640	.0106	.098		377	.0106	.098		607	.0106	.098		–	–	–		–	–	–		–	–	–		7248707
	T9415	.031	820	.0106	.098		–	–	–		771	.0106	.098		–	–	–		–	–	–		164	.0055	.028		8345926
CCMT 433-RM3	**T9415**	.047	837	.0118	.098		–	–	–		787	.0118	.098		–	–	–		–	–	–		164	.0059	.039		8345928

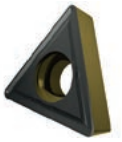
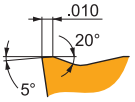
RM3 chip breaker is robust and designed for roughing of Steels and Cast irons. It features positive rake angle and negative, wide T-land. It's also conditionally suitable for Stainless steels and Hard materials.

																											
RCMT 0803M0E-RM3	**T9415**	–	902	.0197	.051		–	–	–		853	.0197	.051		–	–	–		–	–	–		180	.0098	.020		8345953
RCMT 1204M0E-RM3	**H07**	–	–	–	–		213	.0213	.071		344	.0236	.071		–	–	–		–	–	–		–	–	–		7248713
	T7325	–	541	.0236	.071		410	.0213	.071		–	–	–		–	–	–		–	–	–		–	–	–		7248714
	T8430	–	492	.0236	.071		262	.0213	.071		410	.0236	.071		–	–	–		–	–	–		82	.0118	.031		7977235
	T9415	–	837	.0236	.071		–	–	–		787	.0236	.071		–	–	–		–	–	–		164	.0118	.031		8345954
RCMT 1606M0E-RM3	**T7325**	–	525	.0256	.079		394	.0232	.079		–	–	–		–	–	–		–	–	–		–	–	–		7248717
	T8430	–	476	.0256	.079		262	.0232	.079		394	.0256	.079		–	–	–		–	–	–		82	.013	.043		7977236
	T9415	–	804	.0256	.079		–	–	–		755	.0256	.079		–	–	–		–	–	–		148	.013	.043		8239165

RM3 chip breaker is robust and designed for roughing of Steels and Cast irons. It features positive rake angle and negative, wide T-land. It's also conditionally suitable for Stainless steels and Hard materials.

																											
SCMT 432-RM3	**T8430**	.031	558	.0106	.091		295	.0106	.091		443	.0106	.091		–	–	–		–	–	–		82	.0055	.028		7977243
	T9325	.031	673	.0106	.091		394	.0106	.091		623	.0106	.091		–	–	–		–	–	–		–	–	–		7248725
	T9335	.031	574	.0106	.091		344	.0106	.091		–	–	–		–	–	–		–	–	–		–	–	–		7248726
	T9415	.031	869	.0106	.091		–	–	–		820	.0106	.091		–	–	–		–	–	–		164	.0055	.028		8345964
SCMT 433-RM3	**T9325**	.047	673	.0118	.091		394	.0106	.091		623	.0118	.091		–	–	–		–	–	–		–	–	–		7248728

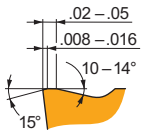
RM3 chip breaker is robust and designed for roughing of Steels and Cast irons. It features positive rake angle and negative, wide T-land. It's also conditionally suitable for Stainless steels and Hard materials.

																											
TCMT 32.51-RM3	**T8415**	.016	492	.0079	.079		246	.0079	.079		443	.0079	.079		–	–	–		–	–	–		82	.0055	.013		8553259
	T8430	.016	427	.0079	.079		230	.0079	.079		344	.0079	.079		–	–	–		–	–	–		66	.0055	.012		7977255
	T9325	.016	476	.0098	.079		279	.0098	.079		443	.0098	.079		–	–	–		–	–	–		–	–	–		7248733
	T9335	.016	410	.0098	.079		246	.0098	.079		–	–	–		–	–	–		–	–	–		–	–	–		7248734
	T9415	.016	673	.0079	.079		–	–	–		623	.0079	.079		–	–	–		–	–	–		131	.0055	.012		8345970
TCMT 32.52-RM3	**T6310**	.031	410	.0106	.079		295	.0106	.079		328	.0106	.079		–	–	–		–	–	–		82	.0055	.028		7248735
	T8415	.031	525	.0106	.079		279	.0106	.079		476	.0106	.079		–	–	–		–	–	–		82	.0053	.026		8553261
	T8430	.031	443	.0106	.079		246	.0106	.079		361	.0106	.079		–	–	–		–	–	–		66	.0055	.028		7977258
	T9325	.031	558	.0106	.079		328	.0106	.079		525	.0106	.079		–	–	–		–	–	–		–	–	–		7248739
	T9335	.031	476	.0106	.079		279	.0106	.079		–	–	–		–	–	–		–	–	–		–	–	–		7248740
	T9415	.031	722	.0106	.079		–	–	–		673	.0106	.079		–	–	–		–	–	–		131	.0055	.028		8345974

RM3 chip breaker is robust and designed for roughing of Steels and Cast irons. It features positive rake angle and negative, wide T-land. It's also conditionally suitable for Stainless steels and Hard materials.

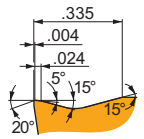
HEAVY ROUGHING – NAVIGATOR

OR



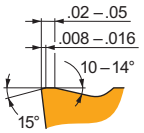
OR chip breaker is robust and the first choice for heavy roughing of Stainless steels. It features positive rake angle and negative/stable, extra-wide double T-land. It's also suitable for Steels, Cast irons, and conditionally for Super-alloys.

DR4



DR4 chip breaker is robust and the first choice for heavy roughing of Steels. It features positive rake angle and negative/stable, extra-wide double T-land. It's also suitable for Cast irons, and conditionally for Stainless steels.

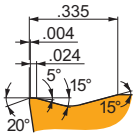
OR



OR chip breaker is robust and the first choice for heavy roughing of Stainless steels. It features positive rake angle and negative/stable, extra-wide double T-land. It's also suitable for Steels, Cast irons, and conditionally for Super-alloys.

PRAMET

DR4

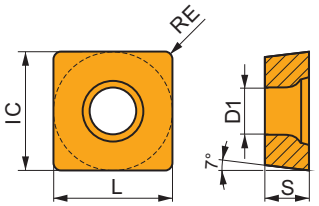


DR4 chip breaker is robust and the first choice for heavy roughing of Steels. It features positive rake angle and negative/stable, extra-wide double T-land. It's also suitable for Cast irons, and conditionally for Stainless steels.

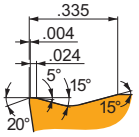
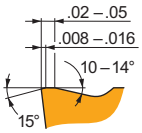
PRAMET

SCMT

	IC (inch)	D1 (inch)	L (inch)	S (inch)
126	1.500	.343	1.500	.375
86	1.000	.343	1.000	.375



Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our cutting conditions app for further options.

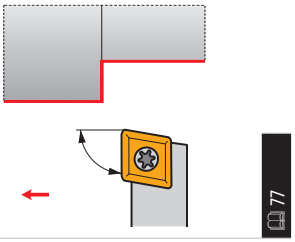
Product		RE (inch)	P vc (ft/min)	P f (in/rev)	P ap (inch)	M vc (ft/min)	M f (in/rev)	M ap (inch)	K vc (ft/min)	K f (in/rev)	K ap (inch)	N vc (ft/min)	N f (in/rev)	N ap (inch)	S vc (ft/min)	S f (in/rev)	S ap (inch)	H vc (ft/min)	H f (in/rev)	H ap (inch)	MID
																					
			DR4 chip breaker is robust and the first choice for heavy roughing of Steels. It features positive rake angle and negative/stable, extra-wide double T-land. It's also suitable for Cast irons, and conditionally for Stainless steels.																		
SCMT 1268-DR4	**T9335**	.126	■ 164	.0524	.630	◪ 98	.0472	.630	–	–	–	–	–	–	–	–	–	–	–	–	6754928
																					
			OR chip breaker is robust and the first choice for heavy roughing of Stainless steels. It features positive rake angle and negative/stable, extra-wide double T-land. It's also suitable for Steels, Cast irons, and conditionally for Super-alloys.																		
SCMT 1268-OR	**6635**	.126	■ 197	.0472	.709	■ 115	.0425	.709	–	–	–	–	–	–	◪ 49	.0425	.390	–	–	–	6752234
	T9315	.126	■ 279	.0472	.709	–	–	–	◪ 262	.0472	.709	–	–	–	–	–	–	–	–	–	6933566
	T9325	.126	■ 262	.0472	.709	■ 148	.0425	.709	◪ 246	.0472	.709	–	–	–	◪ 49	.0425	.390	–	–	–	6754003
	T9335	.126	■ 197	.0472	.709	■ 115	.0425	.709	–	–	–	–	–	–	◪ 33	.0425	.390	–	–	–	6754929
SCMT 866-OR	**T9226**	.094	■ 262	.0394	.394	■ 148	.0354	.394	◪ 246	.0394	.394	–	–	–	◪ 49	.0276	.315	–	–	–	6931863
	T9325	.094	■ 295	.0394	.394	■ 164	.0354	.394	◪ 279	.0394	.394	–	–	–	◪ 66	.0276	.315	–	–	–	6754001
	T9335	.094	■ 230	.0394	.394	■ 131	.0354	.394	–	–	–	–	–	–	◪ 49	.0276	.315	–	–	–	6754926

CC

ISO TURNING – EXTERNAL – NAVIGATOR

SCAC(RL) EXT 90°

CC..



77

SCBC(RL) EXT 75°

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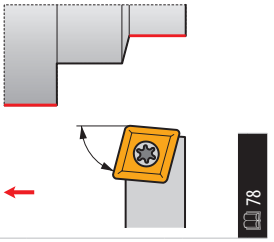
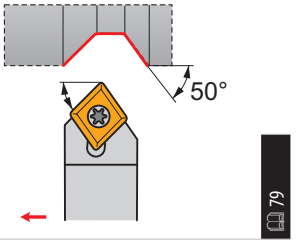


78

SCDCR EXT 45°

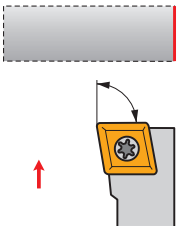
CC..



79

SCFC(RL) EXT 90°

CC..



80

SCLC(RL) EXT 95°

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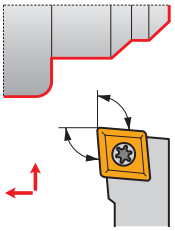
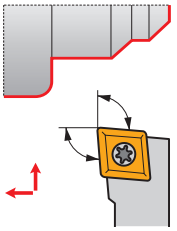


81

ISCLC(RL) EXT 95°

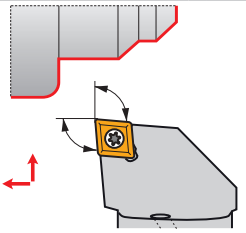
CC..



83

C.-SCLC(RL) EXT 95°

CC..



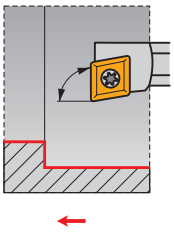
84

CC

ISO TURNING – INTERNAL – NAVIGATOR

SCFC(RL) INT 90°

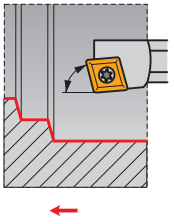
CC..



85

SCKC(RL) INT 75°

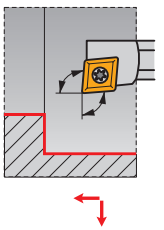
CC..



86

SCLC(RL) INT 45°

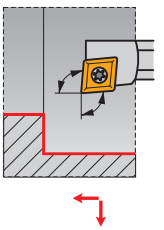
CC..



87

ISCLC(RL) INT 45°

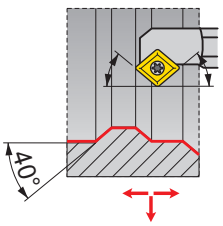
CC..



89

SCXC(RL) INT 90°

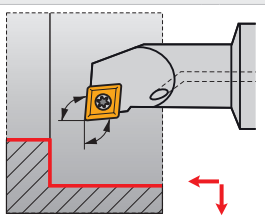
CC..



90

C.-SCLC(RL) INT 95°

CC..

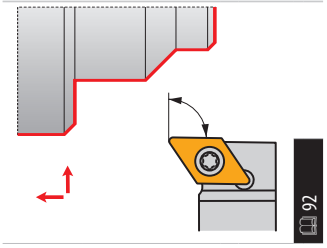


91

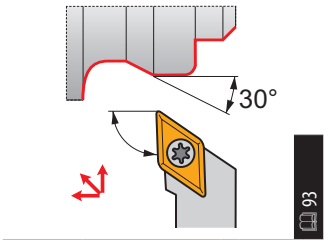
DC

ISO TURNING – EXTERNAL – NAVIGATOR

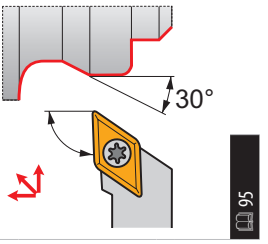
SDFC(RL) EXT 91°
DC..



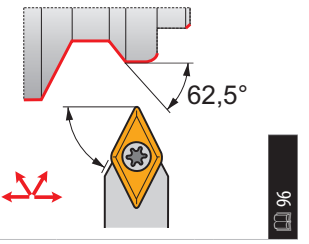
SDJC(RL) EXT 93°
DC..



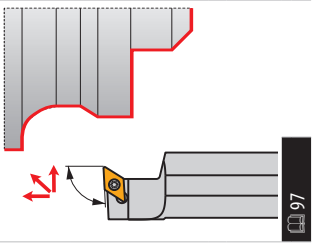
ISDJC(RL) EXT 93°
DC..



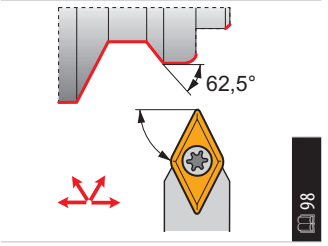
SDNCN EXT 62°30´
DC..



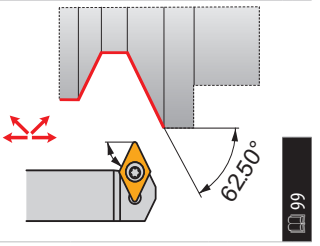
SDUCL EXT 93°
DC..



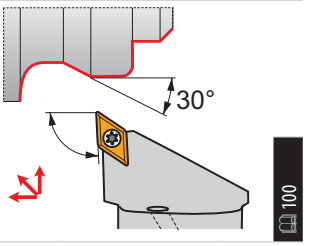
ISDPCN EXT
DC..



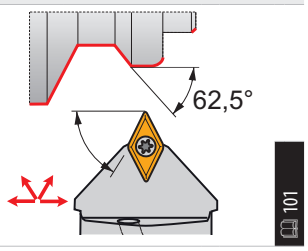
SDXC(RL) EXT 62°30´
DC..



C.-SDJC(RL) EXT 93°
DC..



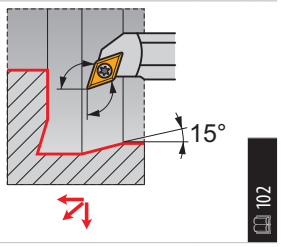
C.-SDNCN EXT 62°30´
DC..



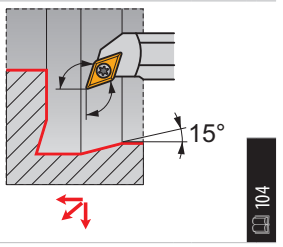
DC

ISO TURNING – INTERNAL – NAVIGATOR

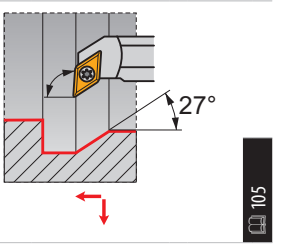
SDQC(RL) INT 95°
DC..



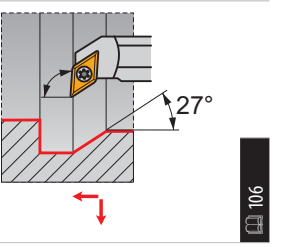
ISDQC(RL) INT 95°
DC..



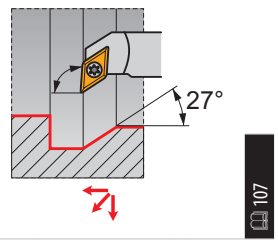
SDUC(RL) INT 93°
DC..



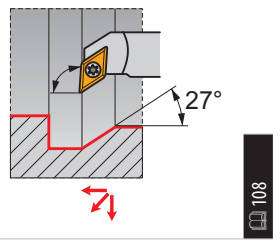
ISDUC(RL) INT 93°
DC..



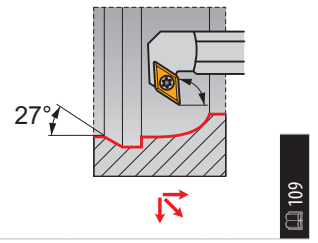
SDUC(RL)-E INT 62°30´
DC..



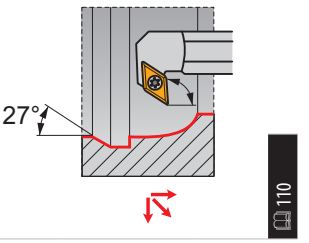
ISDUC(RL)-E INT 62°30´
DC..



SDZC(RL) INT 90°
DC..

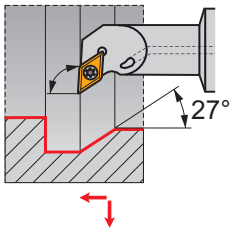


ISDZC(RL) INT 90°
DC..



C.-SDUC(RL) INT 93°

DC..

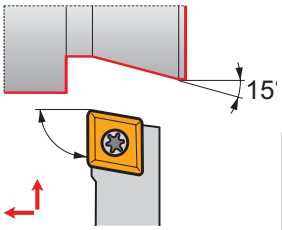


111

EC ISO TURNING – EXTERNAL – NAVIGATOR

SEGC(RL) EXT 90°

EC..

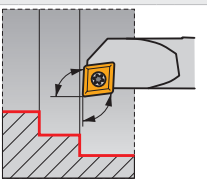


112

EC ISO TURNING – INTERNAL – NAVIGATOR

SEUC(RL) INT 93°

EC..

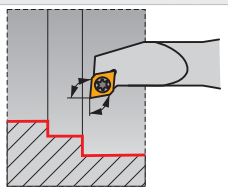


113

EP ISO TURNING – INTERNAL – NAVIGATOR

SELP(RL) INT 95°

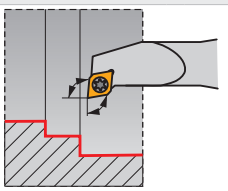
EP..



114

SELP(RL)-E INT 95°

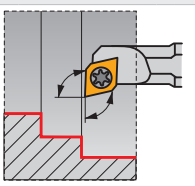
EP..



115

SEUP(RL) INT 93°

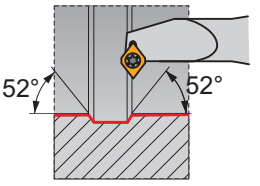
EP..



116

SEXP(RL) INT 52°30´

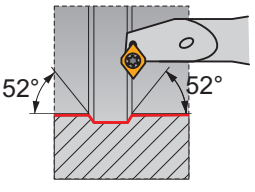
EP..



117

SEXP(RL)-E INT 52°30´

EP..



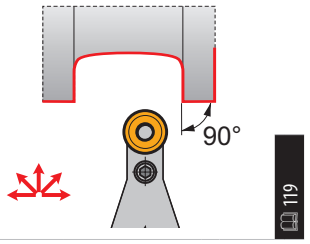
118

RC

ISO TURNING – EXTERNAL – NAVIGATOR

PRDCN EXT

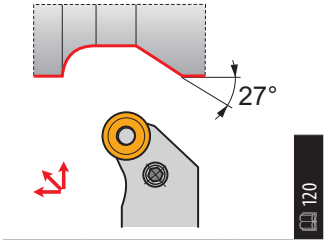
RC..



119

PRSC(RL) EXT

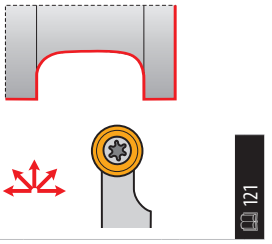
RC..



120

SRDC(RL) EXT

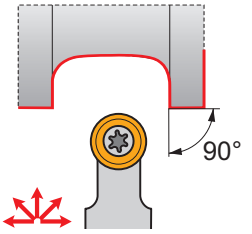
RC..



121

SRDCN EXT

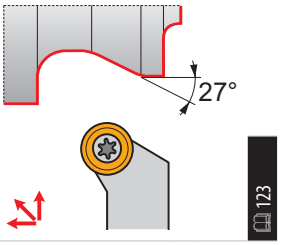
RC..



122

SRCS(RL) EXT

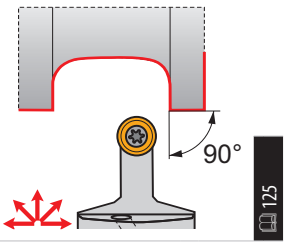
RC..



123

C.-SRDCN EXT

RC..



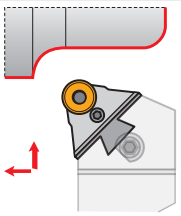
125

RC

ISO TURNING – HEAVY ROUGHING – NAVIGATOR

KHP-RSCR/L

RC..



126

DKH(RL)

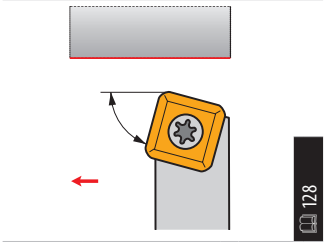
127

SC

ISO TURNING – EXTERNAL – NAVIGATOR

SSBC(RL) EXT 75°

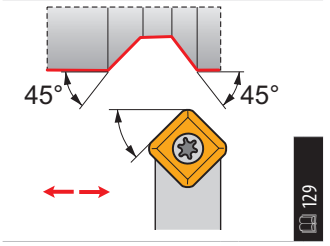
SC..



128

SSDCN EXT 45°

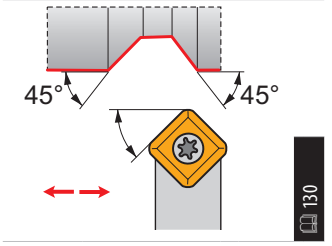
SC..



129

ISSDCN EXT 45°

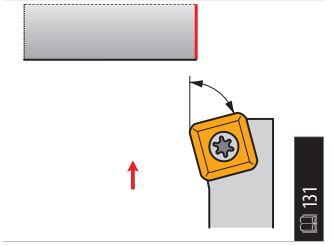
SC..



130

SSKC(RL) EXT 75°

SC..



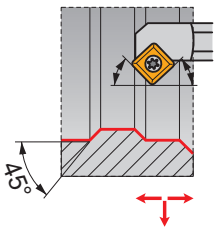
131

SC

ISO TURNING – INTERNAL – NAVIGATOR

SSSC(RL) INT 45°

SC..



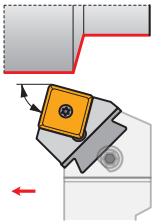
132

SC

ISO TURNING – HEAVY ROUGHING – NAVIGATOR

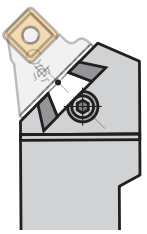
KHS-SBCR 75°

SC..



133

DKH(RL)



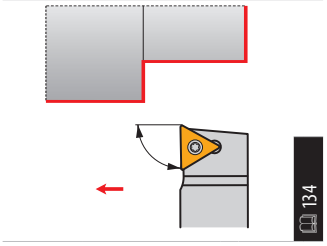
127

TC

ISO TURNING – EXTERNAL – NAVIGATOR

STAC(RL) EXT 90°

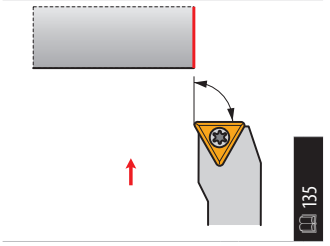
TC..



134

STFC(RL) EXT 90°

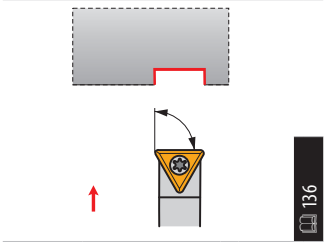
TC..



135

STFC(RL)-A EXT 90°

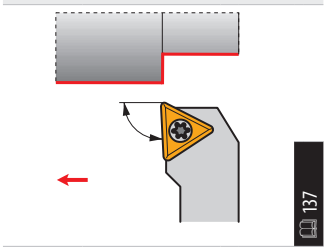
TC..



136

ISTGC(RL) EXT

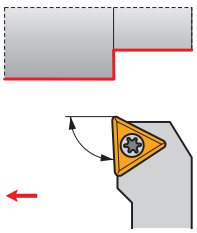
TC..



137

STJC(RL) EXT 93°

TC..



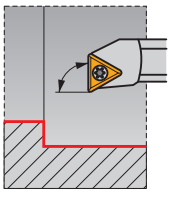
138

TC

ISO TURNING – INTERNAL – NAVIGATOR

STFC(RL) INT 90°

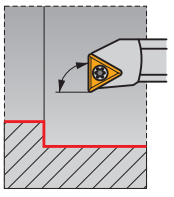
TC..



139

ISTFC(RL) INT 90°

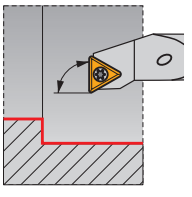
TC..



141

STFC(RL)-E INT 90°

TC..



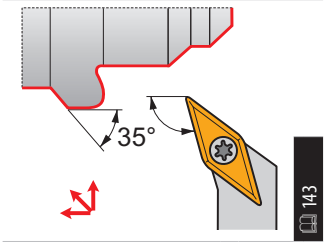
142

VB

ISO TURNING – EXTERNAL – NAVIGATOR

SVHB(C)(RL) EXT 107°30´

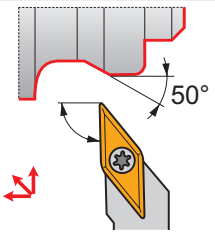
VB, VC..



143

SVJB(C)(RL) EXT 93°

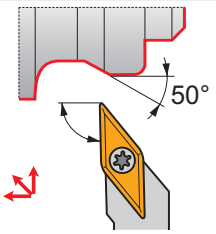
VB, VC..



144

ISVJB(C)(RL) EXT 93°

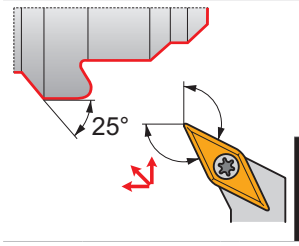
VB, VC..



146

SVPB(C)(RL) EXT 117°30´

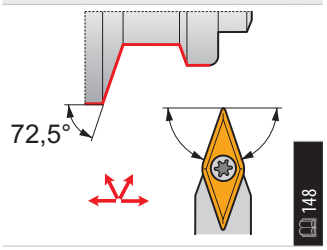
VB, VC..



147

SVVB(C)N EXT 72°30´

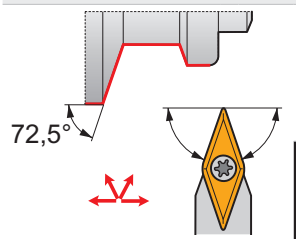
VB, VC..



148

ISVVB(C)N EXT 72°30´

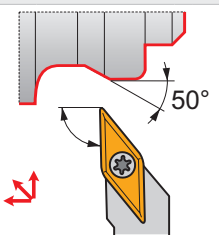
VB, VC..



149

SVXB(C)(RL) EXT 98°

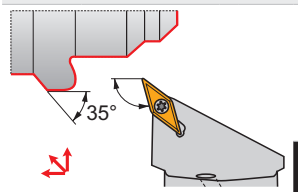
VB, VC..



150

C.-SVHB(RL) EXT 107°30´

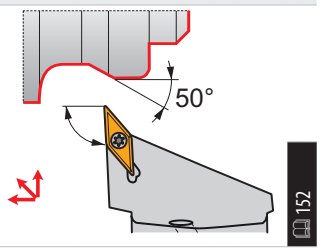
VB, VC..



151

C.-SVJB(RL) EXT 93°

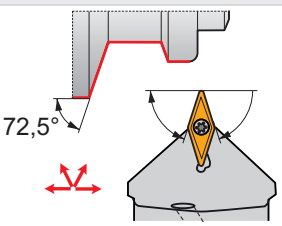
VB, VC..



152

C.-SVVBN EXT 72°30´

VB, VC..



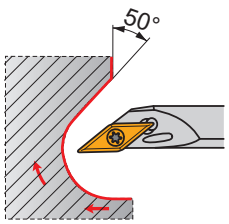
153

VB

ISO TURNING – INTERNAL – NAVIGATOR

SVJB(RL) INT 93°

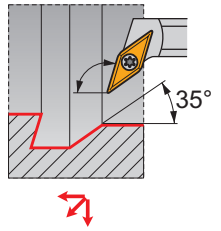
VB, VC..



154

SVQB(C)(RL) INT 107°30´

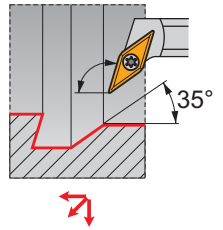
VB, VC..



155

ISVQB(C)(RL) INT 107°30´

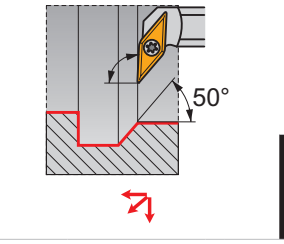
VB, VC..



157

SVUB(C)(RL) INT 93°

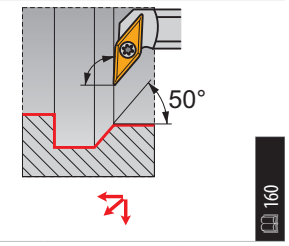
VB, VC..



158

ISVUB(C)(RL) INT 93°

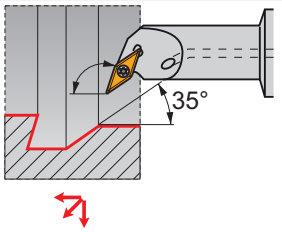
VB, VC..



160

C.-SVQB(C)(RL) INT 108°

VB, VC..



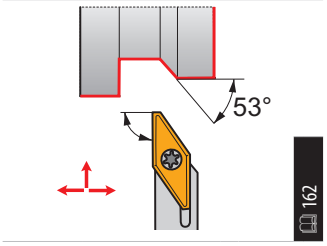
161

VC

ISO TURNING – EXTERNAL – NAVIGATOR

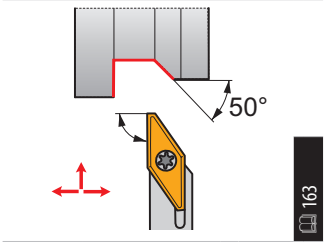
SVAC(RL)-DC EXT 90°

VC..



SVJC(RL)-DC EXT 93°

VC..

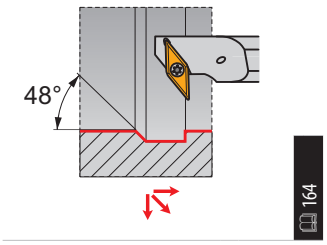


VC

ISO TURNING – INTERNAL – NAVIGATOR

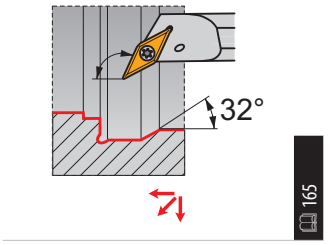
SVLC(RL) INT 95°

VC..



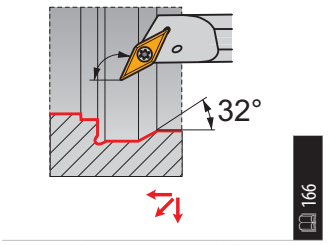
SVXC(RL) INT 113°

VC..



SVXC(RL)-E INT 113°

VC..

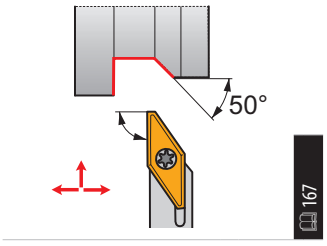


WC

ISO TURNING – EXTERNAL – NAVIGATOR

SWLC(RL) EXT 95°

WC..

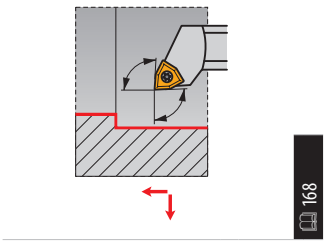


WC

ISO TURNING – INTERNAL – NAVIGATOR

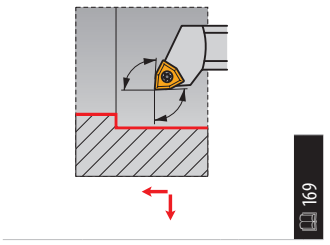
SWLC(RL) INT 95°

WC..



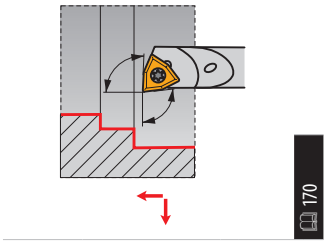
ISWLC(RL) INT 95°

WC..



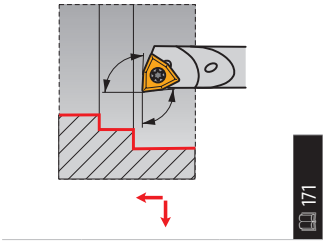
SWUC(RL) INT 93°

WC..



SWUC(RL)-E INT 93°

WC..



SCAC(RL) EXT

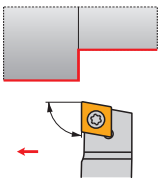
P M K N S H

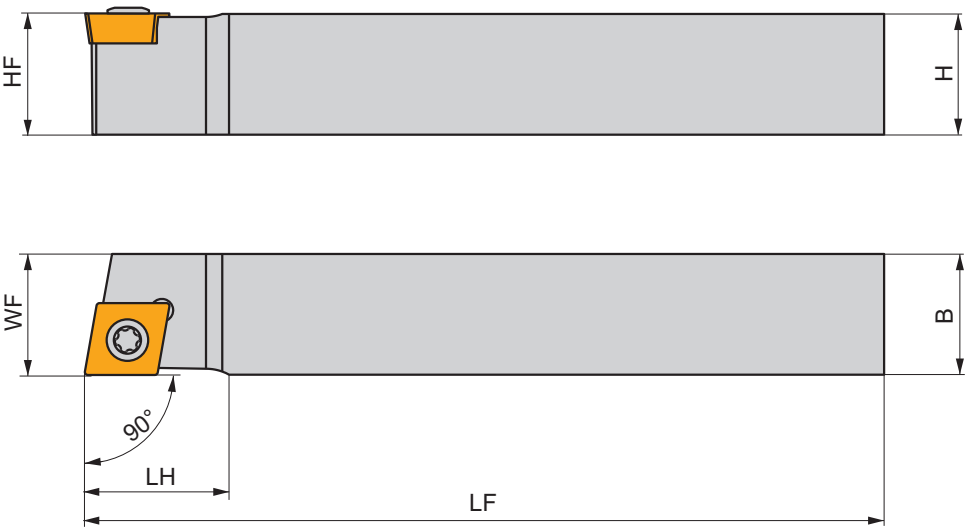
PRAMET

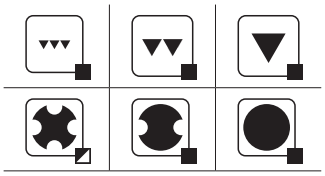
S

External Screw Lock Tool Holder with 90° Cutting Angle for CC.. Inserts

External Right/Left hand tool holder with 90° cutting angle for screw type positive CC.. inserts. Suited for external longitudinal, taper and chamfer turning. with some usable for sliding head machines. Body treated for longer tool life.







	Product	H (mm)	B (mm)	HF (mm)	WF (mm)	LF (mm)	LH (mm)	LAMS (°)	GAMO (°)	lbs			MID
R	SCACR 0808 D 06	8	8	8	8.5	60	–	0	0	.09	GI045	S07	6756799
	SCACR 1010 E 06	10	10	10	10.5	70	–	0	0	.17	GI045	S07	6756778
	SCACR 1212 F 09	12	12	12	12.5	80	–	0	0	.25	GI041	S04	6756912
	SCACR 1212 K 09-S	12	12	12	12	125	19.0	0	0	.30	GI041	S04	8181032
	SCACR 1616 H 09	16	16	16	16.5	100	–	0	0	.49	GI041	S04	6756779
	SCACR 1616 K 09-S	16	16	16	16	125	19.0	0	0	.53	GI041	S04	8181033
L	SCACL 0808 D 06	8	8	8	8.5	60	–	0	0	.12	GI045	S07	6757096
	SCACL 1010 E 06	10	10	10	10.5	70	–	0	0	.13	GI045	S07	6756880
	SCACL 1212 F 09	12	12	12	12.5	80	–	0	0	.25	GI041	S04	6756881
	SCACL 1212 K 09-S	12	12	12	12	125	19.0	0	0	.30	GI041	S04	8181030
	SCACL 1616 H 09	16	16	16	16.5	100	–	0	0	.49	GI041	S04	6756795
	SCACL 1616 K 09-S	16	16	16	16	125	19.0	0	0	.53	GI041	S04	8181031

GI041	CC.. 32.5.. (CC.. 09T3..)
GI045	CC.. 21.5.. (CC.. 0602..)

		Nm			
S04	US 3510-T15P	3.0	M 3.5	0.417	FLAG T15P
S07	US 2506-T07P	0.9	M 2.5	0.248	FLAG T07P

SCBC(RL) EXT

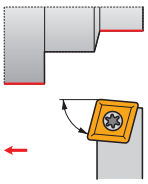
P M K N S H

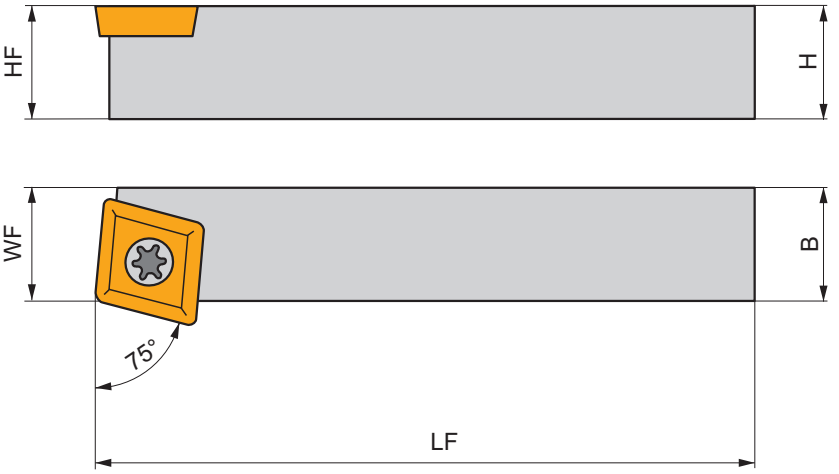
PRAMET

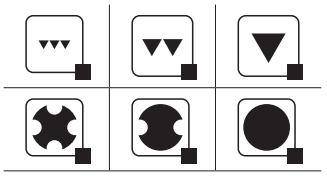
S

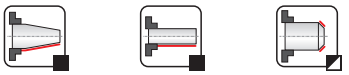
External Screw Lock Tool Holder with 75° Cutting Angle for CC.. Inserts

External Right/Left hand tool holder with 75° cutting angle for screw type positive CC.. inserts. Suited for external longitudinal without shoulder and chamfer turning. Body treated for longer tool life.









	Product	H (mm)	B (mm)	HF (mm)	WF (mm)	LF (mm)	LAMS (°)	GAMO (°)	lbs			MID
R	SCBCR 1212 F 09	12	12	12	11	80	0	0	.22	GI041	S08	6757183
	SCBCR 1616 H 09	16	16	16	13	100	0	0	.44	GI041	S08	6756886
	SCBCR 2020 K 12-M-A	20	20	20	17	125	0	0	.99	GI011	SC20	6756576
	SCBCR 2525 M 12-M-A	25	25	25	22	150	0	0	1.35	GI011	SC20	6756577
L	SCBCL 1212 F 09	12	12	12	11	80	0	0	.22	GI041	S08	6756992
	SCBCL 1616 H 09	16	16	16	13	100	0	0	.49	GI041	S08	6756892
	SCBCL 2020 K 12-M-A	20	20	20	17	125	0	0	.95	GI011	SC20	6756574
	SCBCL 2525 M 12-M-A	25	25	25	22	150	0	0	1.65	GI011	SC20	6756575

GI011	CC.. 43.. (CC.. 1204..)
GI041	CC.. 32.5.. (CC.. 09T3..)

		Nm						
SC20	US 5012-T15P	5.0	M 5	0.48	SCN 120304	MS 5008	FLAG T15P	HXK 5
S08	US 3510-T15P	3.0	M 3.5	0.417	–	–	FLAG T15P	–

SCDCR EXT

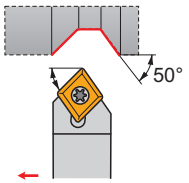
P M K N S H

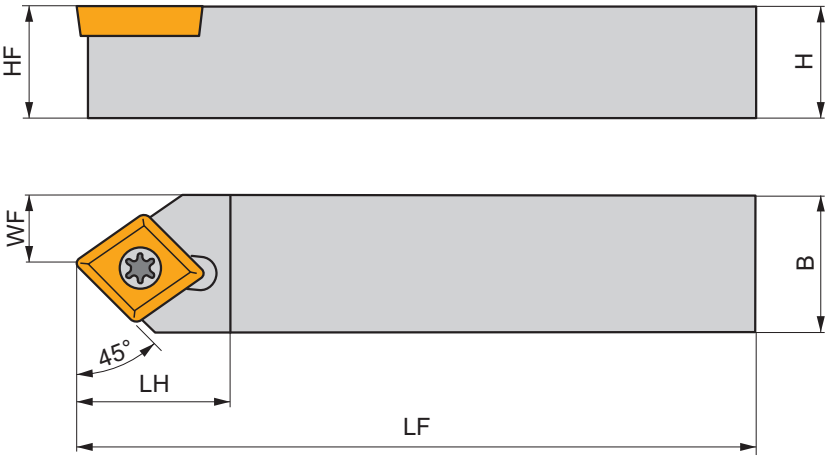
PRAMET

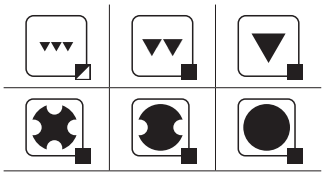
S

External Screw Lock Tool Holder with 45° Cutting Angle for CC.. Inserts

External right hand tool holder with 45° cutting angle for screw type positive CC.. inserts. Suited for external longitudinal without shoulder, taper, multi-directional copy, and chamfer turning. Body treated for longer tool life.







	Product	H (mm)	B (mm)	HF (mm)	WF (mm)	LF (mm)	LH (mm)	LAMS (°)	GAMO (°)	lbs			MID
R	SCDCR 1010 E 06	10	10	10	5.11	70	11.0	0	0	.13	GI045	SC21	6760923

GI045	CC.. 21.5.. (CC.. 0602..)

SC21	5513 020-03	0.8	M 2.5	0.256	PT-8001

SCFC(RL) EXT

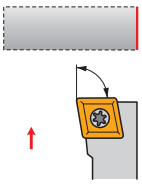
P M K N S H

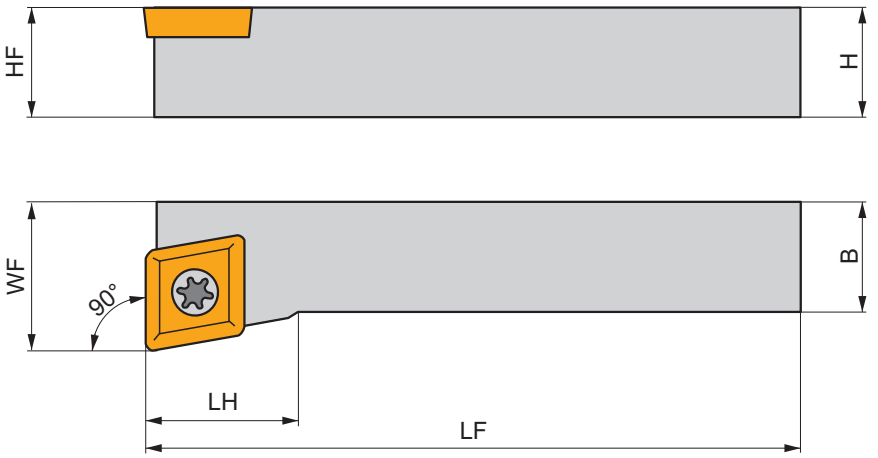
PRAMET

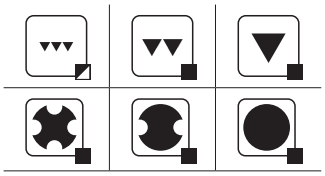
S

External Screw Lock Tool Holder with 90° Cutting Angle for CC.. Inserts

External Right/Left hand tool holder with 90° cutting angle for screw type positive CC.. inserts. Suited for external face and longitudinal turning with shoulder, taper and chamfer turning. Body treated for longer tool life.







	Product	H (mm)	B (mm)	HF (mm)	WF (mm)	LF (mm)	LH (mm)	LAMS (°)	GAMO (°)	lbs	GI	SO	MID
R	SCFCR 0808 D 06	8	8	8	10	60	8.0	0	0	.09	GI045	S07	6756800
	SCFCR 1010 E 06	10	10	10	12	70	8.0	0	0	.14	GI045	S07	6756783
	SCFCR 1212 F 09	12	12	12	16	80	16.0	0	0	.26	GI041	S04	6756804
	SCFCR 1616 H 09	16	16	16	20	100	16.0	0	0	.49	GI041	S04	6756810
L	SCFCL 1010 E 06	10	10	10	12	70	8.0	0	0	.13	GI045	S07	6756891
	SCFCL 1212 F 09	12	12	12	16	80	16.0	0	0	.22	GI041	S04	6756796
	SCFCL 1616 H 09	16	16	16	20	100	16.0	0	0	.49	GI041	S04	6756807

GI	
GI041	CC.. 32.5.. (CC.. 09T3..)
GI045	CC.. 21.5.. (CC.. 0602..)

SO		Nm			
S04	US 3510-T15P	3.0	M 3.5	0.417	FLAG T15P
S07	US 2506-T07P	0.9	M 2.5	0.248	FLAG T07P

SCLC(RL) EXT

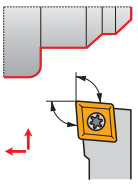
P M K N S H

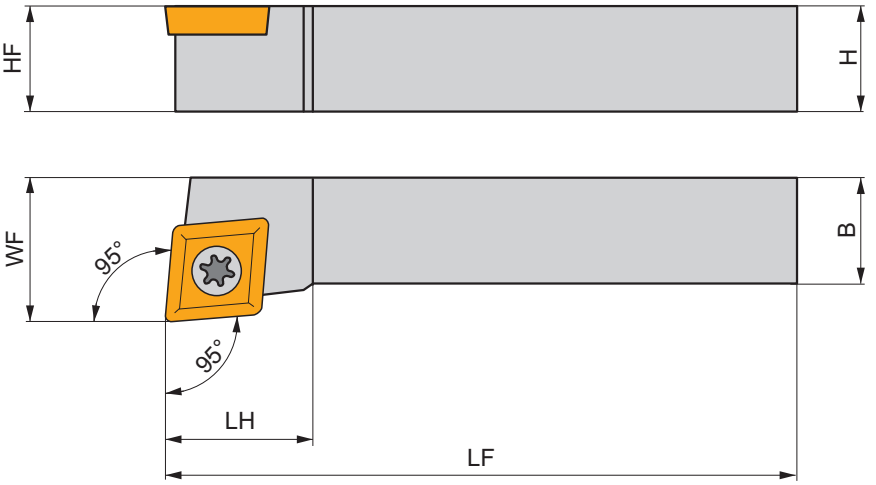
PRAMET

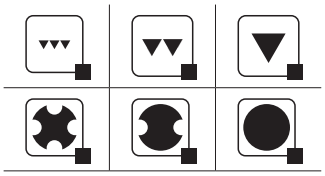
S

External Screw Lock Tool Holder with 95° Cutting Angle for CC.. Inserts

External Right/Left hand tool holder with 95° cutting angle for screw type positive CC.. inserts. Suited for external longitudinal shoulder, taper and chamfer turning. with some usable for sliding head machines. Body treated for longer tool life.







	Product	H (mm)	B (mm)	HF (mm)	WF (mm)	LF (mm)	LH (mm)	LAMS (°)	GAMO (°)	lbs			MID
R	SCLCR 0808 D 06	8	8	8	10	60	8.0	0	0	.12	GI045	S01	6756808
	SCLCR 1010 E 06	10	10	10	12	70	8.0	0	0	.20	GI045	S01	6756745
	SCLCR 1010 E 08	10	10	10	12	70	13.2	0	0	.17	GI232	SC22	6760924
	SCLCR 1212 F 08	12	12	12	16	80	13.4	0	0	.25	GI232	SC22	6760926
	SCLCR 1212 F 09	12	12	12	16	80	16.0	0	0	.26	GI041	S08	6756801
	SCLCR 1212 K 09-S	12	12	12	12	125	21.3	0	0	.30	GI041	S08	8181036
	SCLCR 1616 H 08	16	16	16	20	100	15.2	0	0	.49	GI232	SC22	6760928
	SCLCR 1616 H 09	16	16	16	20	100	16.0	0	0	.49	GI041	S08	6756746
	SCLCR 1616 K 09-S	16	16	16	16	125	21.3	0	0	.53	GI041	S08	8181037
	SCLCR 2020 K 12-M-A	20	20	20	25	125	20.0	0	0	.95	GI011	SC20	6756580
	SCLCR 2525 M 12-M-A	20	25	20	32	150	20.0	0	0	1.70	GI011	SC20	6756581
L	SCLCL 0808 D 06	8	8	8	10	60	8.0	0	0	.12	GI045	S01	6756793
	SCLCL 1010 E 06	10	10	10	12	70	8.0	0	0	.13	GI045	S01	6756879
	SCLCL 1212 F 08	12	12	12	16	80	13.4	0	0	.25	GI232	SC22	6760925
	SCLCL 1212 F 09	12	12	12	16	80	16.0	0	0	.22	GI041	S08	6756794
	SCLCL 1212 K 09-S	12	12	12	12	125	21.3	0	0	.30	GI041	S08	8181034
	SCLCL 1616 H 08	16	16	16	20	100	15.2	0	0	.51	GI232	SC22	6760927
	SCLCL 1616 H 09	16	16	16	20	100	16.0	0	0	.49	GI041	S08	6756768
	SCLCL 1616 K 09-S	16	16	16	16	125	21.3	0	0	.53	GI041	S08	8181035
	SCLCL 2020 K 12-M-A	20	20	20	25	125	20.0	0	0	.88	GI011	SC20	6756578
	SCLCL 2525 M 12-M-A	25	25	25	32	150	20.0	0	0	1.70	GI011	SC20	6756579

GI011	CC.. 43.. (CC.. 1204..)
GI041	CC.. 32.5.. (CC.. 09T3..)
GI045	CC.. 21.5.. (CC.. 0602..)
GI232	CC.. 2.52.. (CC.. 0803..)

SC20	US 5012-T15P	5.0	M 5	0.48	SCN 120304	MS 5008	FLAG T15P	HXK 5
SC22	5513 020-04	1.5	M 3	0.283	–	–	PT-8003	–
S01	US 2506-T07P	0.9	M 2.5	0.248	–	–	FLAG T07P	–
S08	US 3510-T15P	3.0	M 3.5	0.417	–	–	FLAG T15P	–

ISCLC(RL) EXT

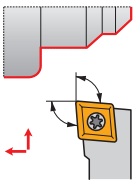
P M K N S H

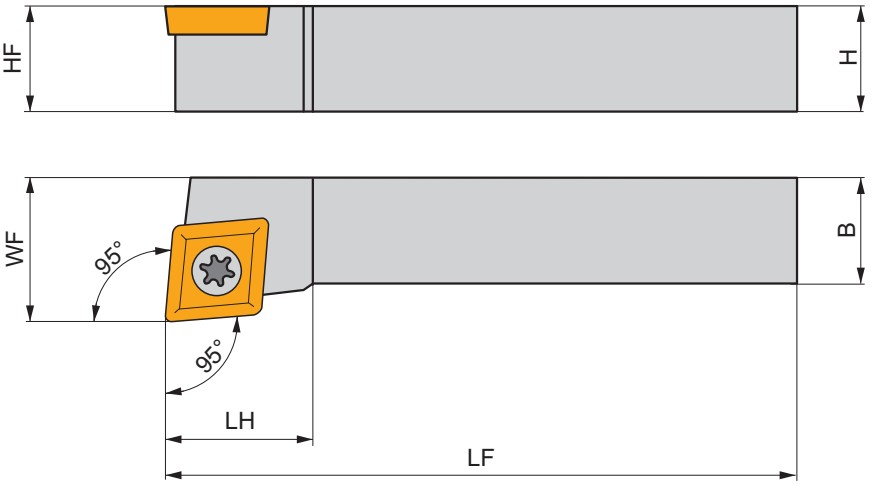
PRAMET

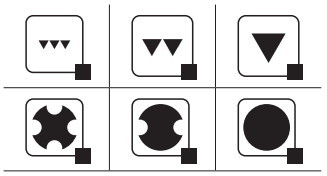
S

External Screw Lock Tool Holder with 95° Cutting Angle for CC.. Inserts

External Right/Left hand tool holder with 95° cutting angle for screw type positive CC.. inserts. Suited for external longitudinal shoulder, taper and chamfer turning. with some usable for sliding head machines. Body treated for longer tool life.







	Product	H (inch)	B (inch)	HF (inch)	WF (inch)	LF (inch)	LH (inch)	LAMS (°)	GAMO (°)	lbs			MID
R	SCLCR 06 2	.375	.375	.375	.500	2.500	.390	0	0	.24	GI045	SC06	6788656
	SCLCR 08 3	.500	.500	.500	.625	3.500	.390	0	0	.33	GI041	SC09	6788657
	SCLCR 10 3	.625	.625	.625	.750	4.000	.630	0	0	.62	GI041	SC095	6788658
	SCLCR 12 4B	.750	.750	.750	1.000	4.500	.830	0	0	.88	GI011	SC12	6788659
	SCLCR 16 4D	1.000	1.000	1.000	1.250	6.000	.830	0	0	1.54	GI011	SC12	6788660
L	SCLCL 06 2	.375	.375	.375	.500	2.500	.390	0	0	.24	GI045	SC06	6788651
	SCLCL 08 3	.500	.500	.500	.625	3.500	.390	0	0	.33	GI041	SC09	6788652
	SCLCL 10 3	.625	.625	.625	.750	4.000	.630	0	0	.62	GI041	SC095	6788653
	SCLCL 12 4B	.750	.750	.750	1.000	4.500	.830	0	0	.88	GI011	SC12	6788654
	SCLCL 16 4D	1.000	1.000	1.000	1.250	6.000	.830	0	0	1.54	GI011	SC12	6788655

GI011	CC.. 43.. (CC.. 1204..)
GI041	CC.. 32.5.. (CC.. 09T3..)
GI045	CC.. 21.5.. (CC.. 0602..)

		Nm					
SC06	US 2003-T07P	0.8	M 2.5	0.256	–	–	FLAG T07P
SC09	US 2010-T15P	3.0	M 3.5	0.398	–	–	FLAG T15P/3,5
SC095	US 2001-T15P	3.0	M 3.5	0.476	SCS 232-01	MS 9001	FLAG T15P/3,5
SC12	US 2018-T15P	3.0	M 4	0.551	SCS 232-02	MS 9003	FLAG T15P/4

C.-SCLC(RL) EXT

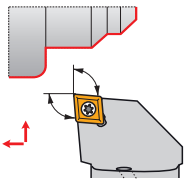
P M K N S H

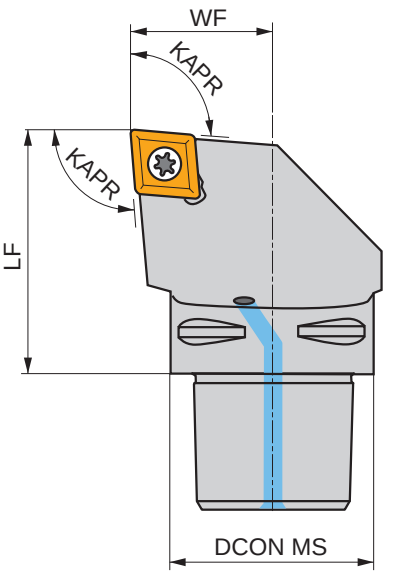
PRAMET

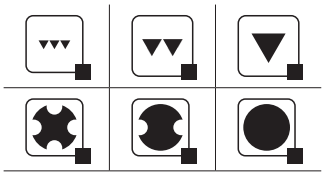
S

External PSC Quick Change Tool, Screw Lock, 95° Cutting Angle for CC.. Inserts

External Right/Left hand tool, through coolant, with 95° cutting angle for screw type positive CC.. inserts. Suited for external longitudinal turning with shoulder, taper and chamfer turning. Polygon Shank Coupling. Body treated for longer tool life.







	Product	DCON MS (mm)	WF (mm)	LF (mm)	KAPR (°)	LAMS (°)	GAMO (°)		lbs			MID
R	C3-SCLCR-22040-09	32	22	40	95	0	0	✓	.46	GI041	C-SC09S	7809827
	C4-SCLCR-27050-09	40	27	50	95	0	0	✓	.87	GI041	C-SC09S	7809829
	C4-SCLCR-27050-12	40	27	50	95	0	0	✓	.88	GI011	C-SC12-1	7809830
	C5-SCLCR-35060-12	50	35	60	95	0	0	✓	1.59	GI011	C-SC12-2	7809832
L	C3-SCLCL-22040-09	32	22	40	95	0	0	✓	.46	GI041	C-SC09S	7809826
	C4-SCLCL-27050-09	40	27	50	95	0	0	✓	.87	GI041	C-SC09S	7809828
	C5-SCLCL-35060-12	50	35	60	95	0	0	✓	1.60	GI011	C-SC12-2	7809831

GI011	CC.. 43.. (CC.. 1204..)
GI041	CC.. 32.5.. (CC.. 09T3..)

		Nm						
C-SC09S	US 2001-T15P	3.0	M 3.5	0.476	SCS 232-01	MS 9001	FLAG T15P/3,5	CN 034-01
C-SC12-1	US 2018-T15P	3.0	M 4	0.551	SCS 232-02	MS 9003	FLAG T15P/4	CN 034-01
C-SC12-2	US 2018-T15P	3.0	M 4	0.551	SCS 232-02	MS 9003	FLAG T15P/4	CN 034-02

SCFC(RL) INT

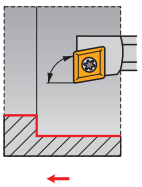
P M K N S H

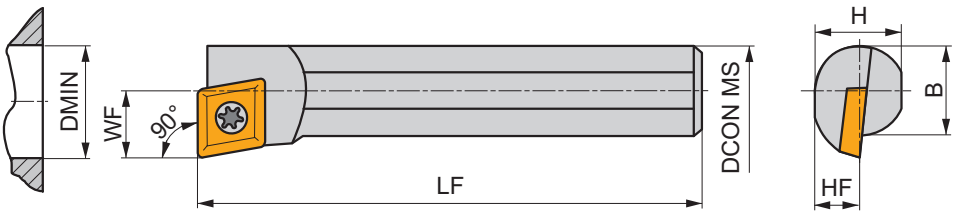
PRAMET

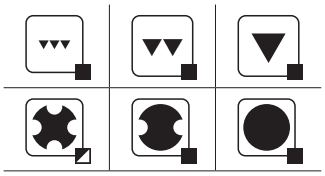
S

Internal Screw Lock Boring Bar with 90° Cutting Angle for CC.. Inserts

Internal Right/Left hand boring bar with 90° cutting angle for screw type CC.. inserts. Suited for internal face and longitudinal turning with shoulder, taper and chamfer turning. Body treated for longer tool life.







	Product	DCON MS (mm)	DMIN (mm)	WF (mm)	H (mm)	B (mm)	LF (mm)	LAMS (°)	GAMO (°)	lbs			MID
R	S10H-SCFCR 06	10	13	7	9	9.5	100	-10	0	.17	GI045	S06	6756830
	S12K-SCFCR 06	12	16	9	11	11.5	125	-7	0	.24	GI045	S06	6756969
L	S10H-SCFCL 06	10	13	7	9	9.5	100	-10	0	.17	GI045	S06	6756859
	S12K-SCFCL 06	12	16	9	11	11.5	125	-7	0	.28	GI045	S06	6757188

GI045	CC.. 21.5.. (CC.. 0602..)

S06	US 2505-T07P	0.9	M 2.5	0.205	FLAG T07P

SCKC(RL) INT

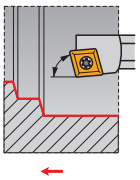
P M K N S H

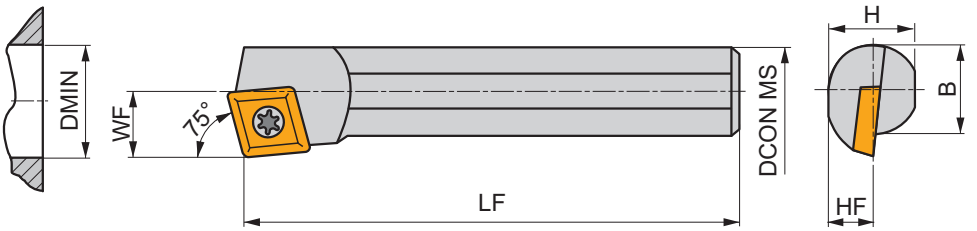
PRAMET

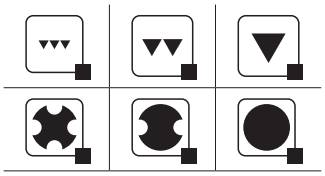
S

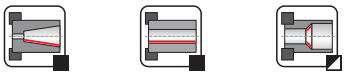
Internal Screw Lock Boring Bar with 75° Cutting Angle for CC.. Inserts

Internal Right/Left hand boring bar with 75° cutting angle for screw type CC.. inserts. Suited for internal longitudinal turning without shoulder, taper and chamfer turning. Body treated for longer tool life.









	Product	DCON MS (mm)	DMIN (mm)	WF (mm)	H (mm)	B (mm)	LF (mm)	LAMS (°)	GAMO (°)	lbs			MID
R	S08F-SCKCR 06	8	11	6	7.2	7.6	80	-12	0	.07	GI045	S02	6757295
	S12K-SCKCR 06	12	16	9	11	11.5	125	-8	0	.24	GI045	S02	6756871
	S16M-SCKCR 09-A	16	20	11	14.5	15	150	-8	0	.55	GI041	S05	6756712
	S20S-SCKCR 09	20	25	13	18.5	18.5	250	-5	0	1.32	GI041	S08	6756999
	S25T-SCKCR 09	25	32	17	23	23	300	-3	0	2.54	GI041	S08	6757000
	S32U-SCKCR 12-A	32	40	22	30	30	350	-10	0	4.63	GI011	SC20	6756649
L	S20S-SCKCL 09	20	25	13	18.5	18.5	250	-5	0	1.32	GI041	S08	6757017

GI011	CC.. 43.. (CC.. 1204..)
GI041	CC.. 32.5.. (CC.. 09T3..)
GI045	CC.. 21.5.. (CC.. 0602..)

		Nm						
SC20	US 5012-T15P	5.0	M 5	0.48	SCN 120304	MS 5008	FLAG T15P	HXK 5
S02	US 2505-T07P	0.9	M 2.5	0.205	–	–	FLAG T07P	–
S05	US 4008-T15P	3.5	M 4	0.315	–	–	FLAG T15P	–
S08	US 3510-T15P	3.0	M 3.5	0.417	–	–	FLAG T15P	–

SCLC(RL) INT

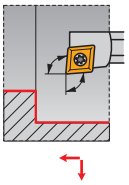
P M K N S H

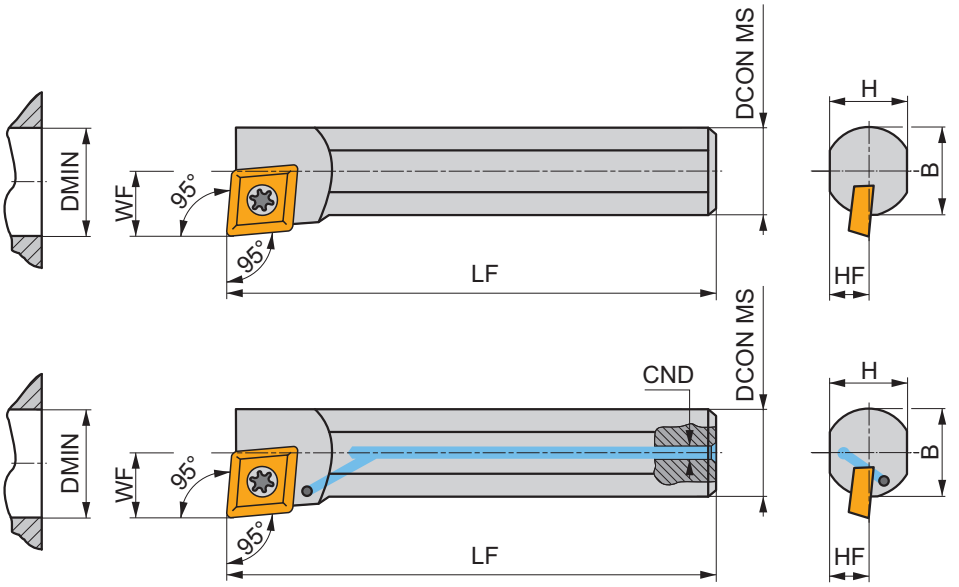
PRAMET

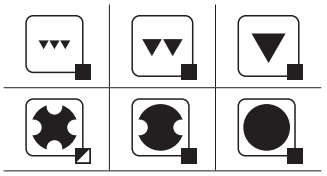
S

Internal Screw Lock Boring Bar with 95° Cutting Angle for CC.. Inserts

Internal Right/Left hand boring bar, through coolant available, 95° cutting angle for screw type CC.. inserts. For internal longitudinal turning with shoulder, taper and chamfer turning. Body treated for longer tool life.







	Product	DCON MS (mm)	DMIN (mm)	WF (mm)	H (mm)	B (mm)	LF (mm)	CND (mm)	LAMS (°)	GAMO (°)		lbs			MID
R	A08H-SCLCR 06	8	11	6	7.2	7.6	100	3.5	-13	0	✓	.08	GI045	S02	6760285
	S08F-SCLCR 06	8	11	6	7.2	7.6	80	–	-13	0	–	.12	GI045	S02	6756967
	A10H-SCLCR 06	10	13	7	9	–	100	4	-10	0	✓	.16	GI045	S02	6756827
	S10H-SCLCR 06	10	13	7	9	9.5	100	–	-10	0	–	.15	GI045	S02	6756939
	A12K-SCLCR 06	12	16	9	11	–	125	5	-8	0	✓	.20	GI045	S01	6756828
	S12K-SCLCR 06	12	16	9	11	11.5	125	–	-8	0	–	.26	GI045	S01	6757023
	S16M-SCLCR 06	16	20	11	14.5	15	150	–	-8	0	–	.53	GI045	S01	6756829
	A10K-SCLCR 08	10	12	6	9	9.5	125	4	-14	0	✓	.20	GI232	SC22	6760896
	A12M-SCLCR 08	12	16	9	11	11.5	150	5	-5	0	✓	.30	GI232	SC22	6760898
	A16R-SCLCR 08	16	20	11	14	15	200	6	-8	0	✓	.61	GI232	SC22	6760900
	A16M-SCLCR 09-A	16	20	11	14.5	–	150	6	-8	0	✓	.49	GI041	S05	6756716
	S16M-SCLCR 09-A	16	20	11	14.5	15	150	–	-8	0	–	.54	GI041	S05	6756714
	A20Q-SCLCR 09	20	25	13	18	–	180	8	-5	0	✓	.77	GI041	S08	6757212
	S20S-SCLCR 09	20	25	13	18	18.5	250	–	-5	0	–	1.31	GI041	S08	6757089
	A25R-SCLCR 09	25	32	17	23	23	200	8	-3	0	✓	1.33	GI041	S08	6756870
	S25T-SCLCR 09	25	32	17	23	23	300	–	-3	0	–	2.39	GI041	S08	6756925
	A32S-SCLCR 12-A	32	40	22	30	30	250	8	-10	0	✓	2.98	GI011	SC20	6756641
	S32U-SCLCR 12-A	32	40	22	30	30	350	–	-10	0	–	4.63	GI011	SC20	6756651
L	A08H-SCLCL 06	8	11	6	7.2	7.6	100	–	-13	0	✓	.11	GI045	S02	6761028
	S08F-SCLCL 06	8	11	6	7.2	7.6	80	–	-13	0	–	.12	GI045	S02	6756902
	A10H-SCLCL 06	10	13	7	9	–	100	4	-10	0	✓	.13	GI045	S02	6756872
	S10H-SCLCL 06	10	13	7	9	9.5	100	–	-10	0	–	.13	GI045	S02	6756963
	A12K-SCLCL 06	12	16	9	11	–	125	5	-8	0	✓	.22	GI045	S01	6756869

	Product	DCON MS (mm)	DMIN (mm)	WF (mm)	H (mm)	B (mm)	LF (mm)	CND (mm)	LAMS (°)	GAMO (°)		lbs			MID
L	**S12K-SCLCL 06**	12	16	9	11	11.5	125	–	-8	0	–	.24	GI045	S01	6756957
	S16M-SCLCL 06	16	20	11	14.5	15	150	–	-8	0	–	.54	GI045	S01	6756855
	A10K-SCLCL 08	10	12	6	9	9.5	125	4	-14	0	✓	.20	GI232	SC22	6760895
	A12M-SCLCL 08	12	16	9	11	11.5	150	5	-5	0	✓	.31	GI232	SC22	6760897
	A16R-SCLCL 08	16	20	11	14	15	200	6	-8	0	✓	.66	GI232	SC22	6760899
	A16M-SCLCL 09-A	16	20	11	14.5	–	150	6	-8	0	✓	.49	GI041	S05	6756717
	S16M-SCLCL 09-A	16	20	11	14.5	15	150	–	-8	0	–	.53	GI041	S05	6756715
	A20Q-SCLCL 09	20	25	13	18	–	180	8	-5	0	✓	.83	GI041	S08	6756856
	S20S-SCLCL 09	20	25	13	18	18.5	250	–	-5	0	–	1.32	GI041	S08	6757148
	A25R-SCLCL 09	25	32	17	23	23	200	8	-3	0	✓	1.47	GI041	S08	6756874
	S25T-SCLCL 09	25	32	17	23	23	300	–	-3	0	–	2.39	GI041	S08	6756878
	A32S-SCLCL 12-A	32	40	22	30	30	250	8	-10	0	✓	2.98	GI011	SC20	6756640

GI011	CC.. 43.. (CC.. 1204..)
GI041	CC.. 32.5.. (CC.. 09T3..)
GI045	CC.. 21.5.. (CC.. 0602..)
GI232	CC.. 2.52.. (CC.. 0803..)

		Nm						
SC20	US 5012-T15P	5.0	M 5	0.48	SCN 120304	MS 5008	FLAG T15P	HXK 5
SC22	5513 020-04	1.5	M 3	0.283	–	–	PT-8003	–
S01	US 2506-T07P	0.9	M 2.5	0.248	–	–	FLAG T07P	–
S02	US 2505-T07P	0.9	M 2.5	0.205	–	–	FLAG T07P	–
S05	US 4008-T15P	3.5	M 4	0.315	–	–	FLAG T15P	–
S08	US 3510-T15P	3.0	M 3.5	0.417	–	–	FLAG T15P	–

ISCLC(RL) INT

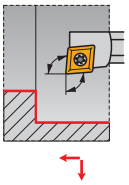
P M K N S H

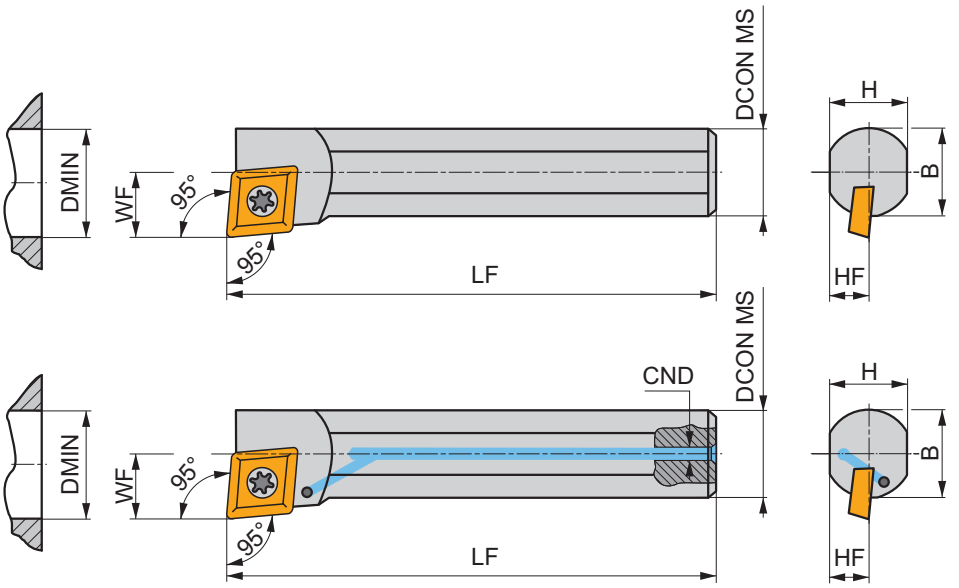
PRAMET

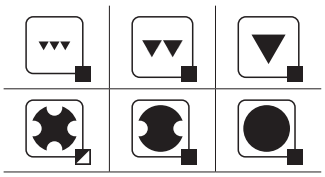
S

Internal Screw Lock Boring Bar with 95° Cutting Angle for CC.. Inserts

Internal Right/Left hand boring bar, through coolant available, 95° cutting angle for screw type CC.. inserts. For internal longitudinal turning with shoulder, taper and chamfer turning. Body treated for longer tool life.







	Product	DCON MS (inch)	DMIN (inch)	WF (inch)	H (inch)	LF (inch)	LAMS (°)	GAMO (°)		lbs			MID
R	A06M-SCLCR 2	.375	.480	.250	.336	6.000	-11	0	✓	.13	GI045	SC06M	6788442
	A08M-SCLCR 2	.500	.598	.312	.460	6.000	-8	0	✓	.33	GI045	SC06	6788448
	A10R-SCLCR 3	.625	.772	.406	.562	8.000	-9	0	✓	.66	GI041	SC09M	6788456
	A12S-SCLCR 3	.750	.929	.500	.709	10.000	-6	0	✓	1.21	GI041	SC09M	6788469
	A16T-SCLCR 3	1.000	1.201	.640	.906	12.000	-4	0	✓	1.54	GI041	SC09	6788485
	A20T-SCLCR 4	1.250	1.468	.765	1.181	12.000	-11	0	✓	3.08	GI011	SC12	6788501
L	A06M-SCLCL 2	.375	.480	.250	.336	6.000	-11	0	✓	.13	GI045	SC06M	6788441
	A08M-SCLCL 2	.500	.598	.312	.460	6.000	-8	0	✓	.33	GI045	SC06	6788447
	A10R-SCLCL 3	.625	.772	.406	.562	8.000	-9	0	✓	.66	GI041	SC09M	6788455
	A12S-SCLCL 3	.750	.929	.500	.709	10.000	-6	0	✓	1.21	GI041	SC09M	6788468
	A16T-SCLCL 3	1.000	1.201	.640	.906	12.000	-4	0	✓	1.54	GI041	SC09	6788484
	A20T-SCLCL 4	1.250	1.468	.765	1.181	12.000	-11	0	✓	3.08	GI011	SC12	6788500

GI011	CC.. 43.. (CC.. 1204..)
GI041	CC.. 32.5.. (CC.. 09T3..)
GI045	CC.. 21.5.. (CC.. 0602..)

		Nm					
SC06	US 2003-T07P	0.8	M 2.5	0.256	–	–	FLAG T07P
SC06M	US 2046-T07P	0.9	M 2.5	0.2	–	–	FLAG T07P
SC09	US 2010-T15P	3.0	M 3.5	0.398	–	–	FLAG T15P/3,5
SC09M	US 2009-T15P	3.0	M 3.5	0.319	FLAG T15P/3,5	–	–
SC12	US 2018-T15P	3.0	M 4	0.551	SCS 232-02	MS 9003	FLAG T15P/4

SCXC(RL) INT

P M K N S H

PRAMET

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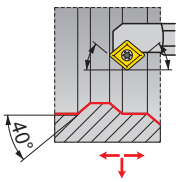
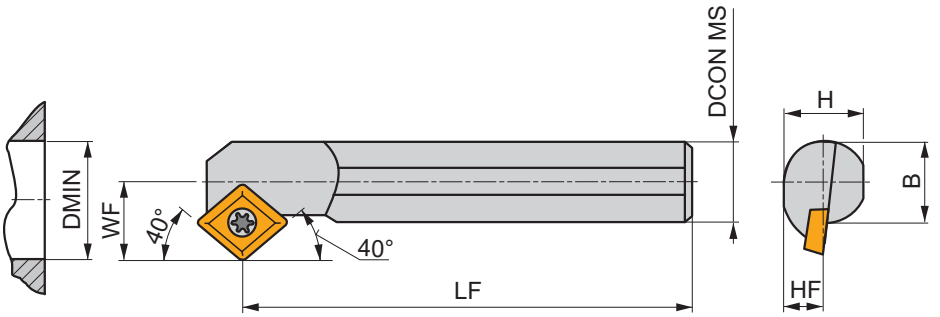
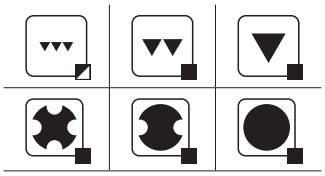
Internal Screw Lock Boring Bar with 40° Cutting Angle for CC.. Inserts

Internal Right/Left hand boring bar, 40° cutting angle for screw type CC.. inserts. Suited for internal front and back chamfering, longitudinal turning without shoulder and taper turning. Body treated for longer tool life.







	Product	DCON MS (mm)	DMIN (mm)	WF (mm)	H (mm)	B (mm)	LF (mm)	LAMS (°)	GAMO (°)	lbs			MID
R	**S10H-SCXCR 06**	10	13	7	9	9.5	100	-10	0	.13	GI045	S06	6757147
	S12K-SCXCR 06	12	16	9	11	11.5	125	-8	0	.24	GI045	S06	6757184
	S16Q-SCXCR 06	16	20	11	14.5	15	180	-7	0	.64	GI045	S07	6757186
L	**S10H-SCXCL 06**	10	13	7	9	9.5	100	-10	0	.13	GI045	S06	6757019
	S12K-SCXCL 06	12	16	9	11	11.5	125	-8	0	.24	GI045	S06	6757021
	S16Q-SCXCL 06	16	20	11	14.5	15	180	-7	0	.66	GI045	S07	6757022

GI045	CC.. 21.5.. (CC.. 0602..)

		Nm			
S06	US 2505-T07P	0.9	M 2.5	0.205	FLAG T07P
S07	US 2506-T07P	0.9	M 2.5	0.248	FLAG T07P

C.-SCLC(RL) INT

P M K N S H

PRAMET

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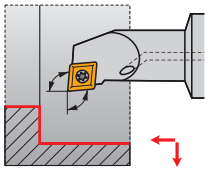
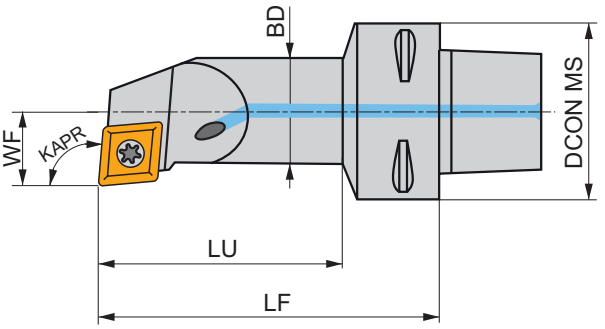
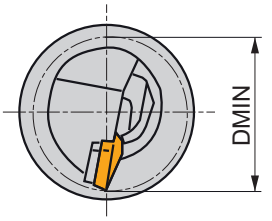
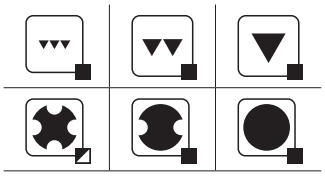
Internal PSC Quick Change Tool, Screw Lock, 95° Cutting Angle for CC.. Inserts

Internal Right/Left hand tool, through coolant, with 95° cutting angle for screw type CC.. inserts. Suited for a wide range of internal turning applications. Polygon Shank Coupling with choice of lengths. Body treated for longer tool life.









	Product	DCON MS (mm)	DMIN (mm)	WF (mm)	LF (mm)	LU (mm)	BD (mm)	KAPR (°)	LAMS (°)	GAMO (°)		lbs			MID
R	C3-SCLCR-11065-09	32	20	11	65	48	16	95	-8.4	0	✓	.46	GI041	SC09M	7809875
	C3-SCLCR-13075-09	32	25	13	75	58	20	95	-5.8	0	✓	.57	GI041	SC09M	7809876
	C4-SCLCR-11070-09	40	20	11	70	47	16	95	-8.4	0	✓	.79	GI041	SC09M	7809878
	C4-SCLCR-13080-09	40	25	13	80	57	20	95	-5.8	0	✓	.91	GI041	SC09M	7809880
	C4-SCLCR-17090-09	40	32	17	90	68	25	95	-3.4	0	✓	1.09	GI041	SC09M	7809881
	C5-SCLCR-11070-09	50	20	11	70	46	16	95	-8.4	0	✓	1.21	GI041	SC09M	7809883
	C5-SCLCR-13080-09	50	25	13	80	56	20	95	-5.8	0	✓	1.32	GI041	SC09M	7809885
L	C4-SCLCL-11070-09	40	20	11	70	47	16	95	-8.4	0	✓	.79	GI041	SC09M	7809877
	C4-SCLCL-13080-09	40	25	13	80	57	20	95	-5.8	0	✓	.90	GI041	SC09M	7809879
	C5-SCLCL-11070-09	50	20	11	70	46	16	95	-8.4	0	✓	1.21	GI041	SC09M	7809882
	C5-SCLCL-13080-09	50	25	13	80	56	20	95	-5.8	0	✓	1.32	GI041	SC09M	7809884

GI041	CC.. 32.5.. (CC.. 09T3..)

SC09M	US 2009-T15P	3.0	M 3.5	0.319	FLAG T15P/3,5

SDFC(RL) EXT

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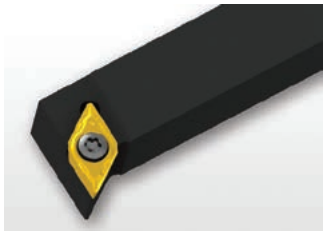
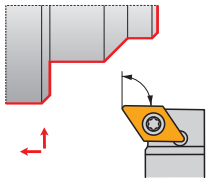
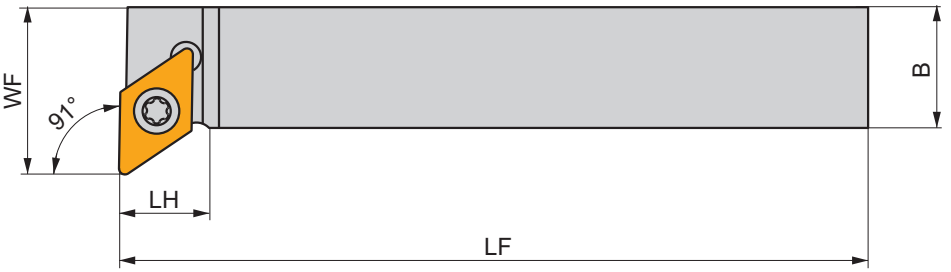
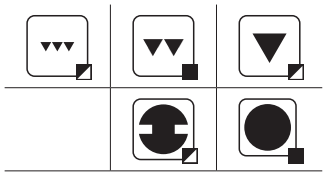


External Screw Lock Tool Holder with 91° Cutting Angle for DC.. Inserts

External Right/Left hand tool holder with 91° cutting angle for screw type positive DC.. inserts. Suited for external longitudinal shoulder, copy, face, taper and chamfer turning. and usable for sliding head machines. Body treated for longer tool life.







	Product	H (mm)	B (mm)	HF (mm)	WF (mm)	LF (mm)	LH (mm)	LAMS (°)	GAMO (°)	lbs			MID
R	**SDFCR 1212 K 07-S**	12	12	12	16	125	8.8	0	0	.31	GI052	S01	8181040
	SDFCR 1616 K 11-S	16	16	16	22	125	11.9	0	0	.54	GI012	S08	8181041
L	**SDFCL 1212 K 07-S**	12	12	12	16	125	8.8	0	0	.31	GI052	S01	8181038
	SDFCL 1616 K 11-S	16	16	16	22	125	11.9	0	0	.54	GI012	S08	8181039

GI012	DC.. 32.5.. (DC.. 11T3..)
GI052	DC.. 21.5.. (DC.. 0702..)

		Nm			
S01	US 2506-T07P	0.9	M 2.5	0.248	FLAG T07P
S08	US 3510-T15P	3.0	M 3.5	0.417	FLAG T15P

SDJC(RL) EXT

P M K N S H

PRAMET

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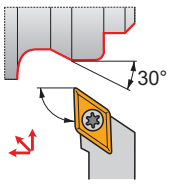
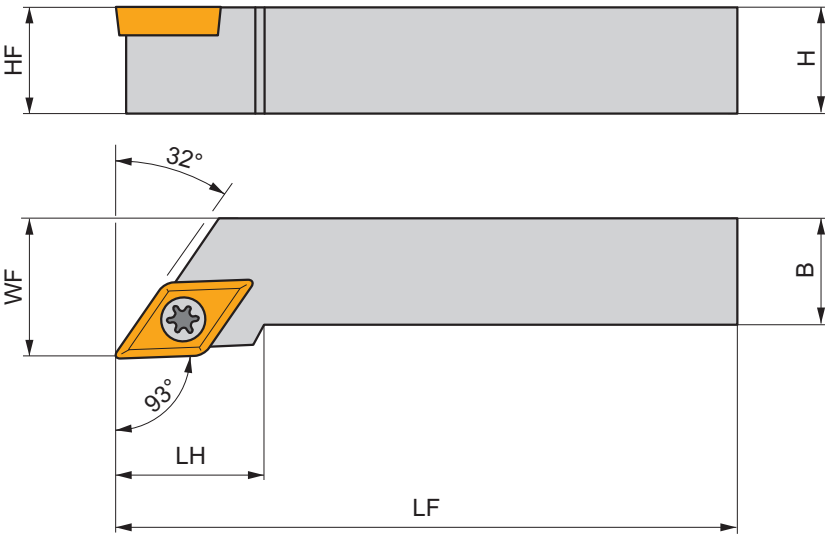
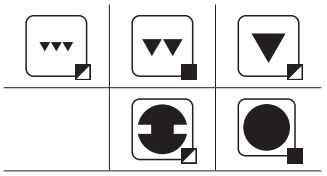
External Screw Lock Tool Holder with 93° Cutting Angle for DC.. Inserts

External Right/Left hand tool holder with 93° cutting angle for screw type positive DC.. inserts. Suited for external longitudinal shoulder, copy, taper and chamfer turning. with some usable for sliding head machines. Body treated for longer tool life.







	Product	H (mm)	B (mm)	HF (mm)	WF (mm)	LF (mm)	LH (mm)	LAMS (°)	GAMO (°)	lbs			MID
R	SDJCR 0808 D 07	8	8	8	10	60	14.0	0	0	.12	GI052	S01	6756781
	SDJCR 1010 E 07	10	10	10	12	70	14.0	0	0	.12	GI052	S01	6756883
	SDJCR 1212 F 07	12	12	12	16	80	14.0	0	0	.24	GI052	S01	6756782
	SDJCR 1212 F 11	12	12	12	16	80	20.0	0	0	.22	GI012	S08	6756767
	SDJCR 1212 K 07-S	12	12	12	12	125	18.2	0	0	.30	GI052	S01	8181045
	SDJCR 1212 K 11-S	12	12	12	12	125	22.6	0	0	.29	GI012	S08	8181046
	SDJCR 1616 H 11	16	16	16	20	100	20.0	0	0	.49	GI012	S08	6756901
	SDJCR 1616 K 11-S	16	16	16	16	125	22.6	0	0	.51	GI012	S08	8165675
	SDJCR 2020 K 11-M-A	20	20	20	25	125	20.0	0	0	.88	GI012	SD10	6756584
	SDJCR 2525 M 11-M-A	25	25	25	32	150	20.0	0	0	1.60	GI012	SD10	6756585
	SDJCR 2525 M 15	25	25	25	32	150	28.0	0	0	1.63	GI243	SD11	6761037
L	SDJCL 0808 D 07	8	8	8	10	60	14.0	0	0	.09	GI052	S01	6756990
	SDJCL 1010 E 07	10	10	10	12	70	14.0	0	0	.16	GI052	S01	6756915
	SDJCL 1212 F 07	12	12	12	16	80	14.0	0	0	.24	GI052	S01	6756792
	SDJCL 1212 F 11	12	12	12	16	80	20.0	0	0	.25	GI012	S08	6756797
	SDJCL 1212 K 07-S	12	12	12	12	125	18.2	0	0	.30	GI052	S01	8181042
	SDJCL 1212 K 11-S	12	12	12	12	125	22.6	0	0	.29	GI012	S08	8181043
	SDJCL 1616 H 11	16	16	16	20	100	20.0	0	0	.44	GI012	S08	6756882
	SDJCL 1616 K 11-S	16	16	16	16	125	22.6	0	0	.51	GI012	S08	8181044
	SDJCL 2020 K 11-M-A	20	20	20	25	125	20.0	0	0	.91	GI012	SD10	6756582
	SDJCL 2525 M 11-M-A	25	25	25	32	150	20.0	0	0	1.60	GI012	SD10	6756583
	SDJCL 2525 M 15	25	25	25	32	150	28.0	0	0	.16	GI243	SD11	6761038

GI012	DC.. 32.5.. (DC.. 11T3..)
GI052	DC.. 21.5.. (DC.. 0702..)
GI243	DC.. 43.. (DC.. 1504..)

SD10	US 3510-T15P	3.0	M 3.5	0.417	SDN 110304	MS 3510	FLAG T15P	HXK 3.5
SD11	US 64518-T15P	5.0	M 4.5	0.709	SDN 150304	MS 4512	FLAG T15P	HXK 5
S01	US 2506-T07P	0.9	M 2.5	0.248	–	–	FLAG T07P	–
S08	US 3510-T15P	3.0	M 3.5	0.417	–	–	FLAG T15P	–

ISDJC(RL) EXT

P M K N S H

PRAMET

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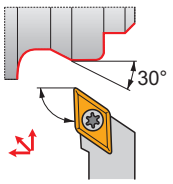
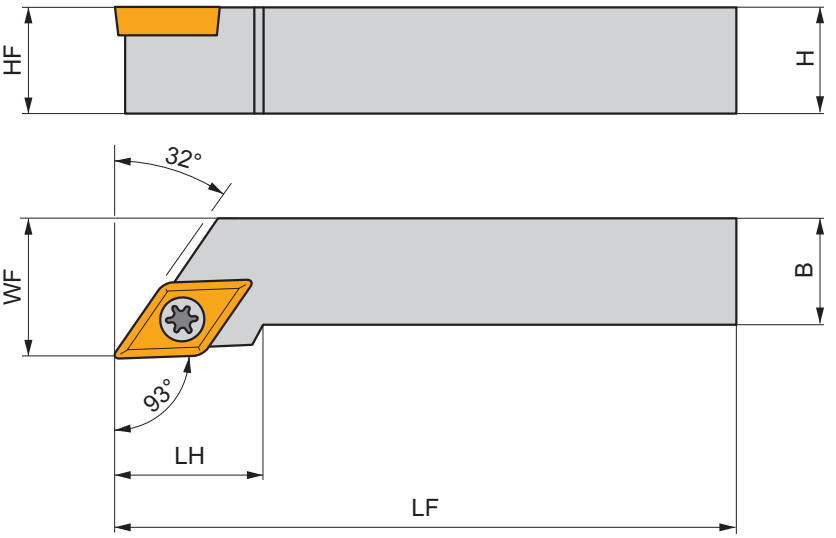
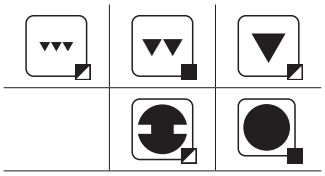
External Screw Lock Tool Holder with 93° Cutting Angle for DC.. Inserts

External Right/Left hand tool holder with 93° cutting angle for screw type positive DC.. inserts. Suited for external longitudinal shoulder, copy, taper and chamfer turning. with some usable for sliding head machines. Body treated for longer tool life.







	Product	H (inch)	B (inch)	HF (inch)	WF (inch)	LF (inch)	LH (inch)	LAMS (°)	GAMO (°)	lbs			MID
R	SDJCR 06 2	.375	.375	.375	.500	2.500	.590	0	0	.24	GI052	SD07	6788665
	SDJCR 08 2	.500	.500	.500	.625	3.500	.670	0	0	.33	GI052	SD07	6788666
	SDJCR 12 3B	.750	.750	.750	1.000	4.500	.940	0	0	.88	GI012	SD11V	6788667
	SDJCR 16 3D	1.000	1.000	1.000	1.250	6.000	1.100	0	0	1.54	GI012	SD11V	6788668
L	SDJCL 06 2	.375	.375	.375	.500	2.500	.590	0	0	.24	GI052	SD07	6788661
	SDJCL 08 2	.500	.500	.500	.625	3.500	.670	0	0	.33	GI052	SD07	6788662
	SDJCL 12 3B	.750	.750	.750	1.000	4.500	.940	0	0	.88	GI012	SD11V	6788663
	SDJCL 16 3D	1.000	1.000	1.000	1.250	6.000	1.100	0	0	1.54	GI012	SD11V	6788664

GI012	DC.. 32.5.. (DC.. 11T3..)
GI052	DC.. 21.5.. (DC.. 0702..)

		Nm					
SD07	US 2003-T07P	0.8	M 2.5	0.256	–	–	FLAG T07P
SD11V	US 2001-T15P	3.0	M 3.5	0.476	SDS 263-01	MS 9001	FLAG T15P/3,5

SDNCN EXT

P M K N S H

PRAMET

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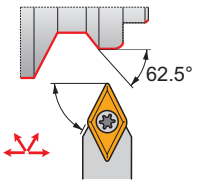
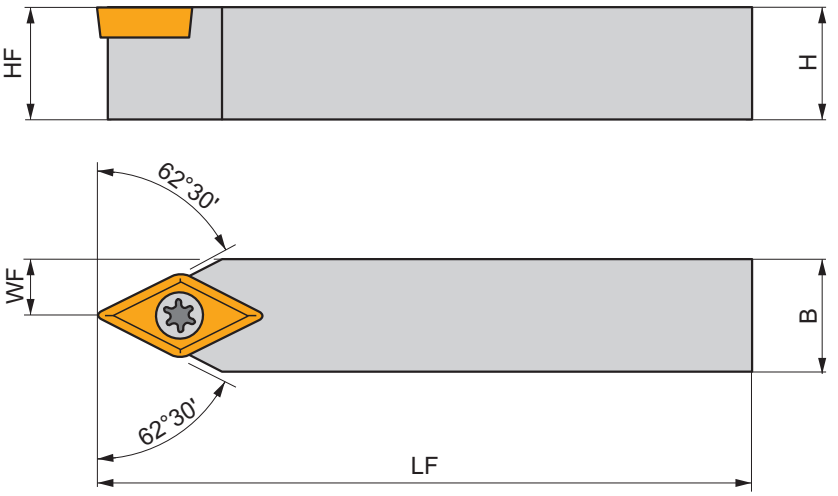
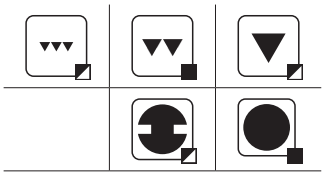
External Screw Lock Tool Holder with 62.5° Cutting Angle for DC.. Inserts

External neutral tool holder with 62.5° cutting angle for screw type positive DC.. inserts. Suited for external longitudinal turning without shoulder, copy, taper and chamfer turning. Body treated for longer tool life.







	Product	H (mm)	B (mm)	HF (mm)	WF (mm)	LF (mm)	LAMS (°)	GAMO (°)	lbs			MID
N	**SDNCN 0808 D 07**	8	8	8	4	60	0	0	.11	GI052	S01	6756885
	SDNCN 1010 E 07	10	10	10	5	70	0	0	.16	GI052	S01	6756860
	SDNCN 1212 F 07	12	12	12	6	80	0	0	.23	GI052	S01	6756861
	SDNCN 1212 F 11	12	12	12	6	80	0	0	.24	GI012	S08	6756862
	SDNCN 1616 H 11	16	16	16	8	100	0	0	.45	GI012	S08	6756803
	SDNCN 2020 K 11-M-A	20	20	20	10	125	0	0	.77	GI012	SD10	6756586
	SDNCN 2525 M 11-M-A	25	25	25	12.5	150	0	0	1.54	GI012	SD10	6756587

GI012	DC.. 32.5.. (DC.. 11T3..)
GI052	DC.. 21.5.. (DC.. 0702..)

		Nm						
SD10	US 3510-T15P	3.0	M 3.5	0.417	SDN 110304	MS 3510	FLAG T15P	HXK 3.5
S01	US 2506-T07P	0.9	M 2.5	0.248	–	–	FLAG T07P	–
S08	US 3510-T15P	3.0	M 3.5	0.417	–	–	FLAG T15P	–

SDUCL EXT

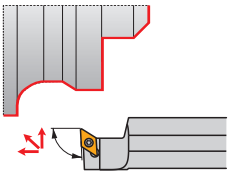
P M K N S H

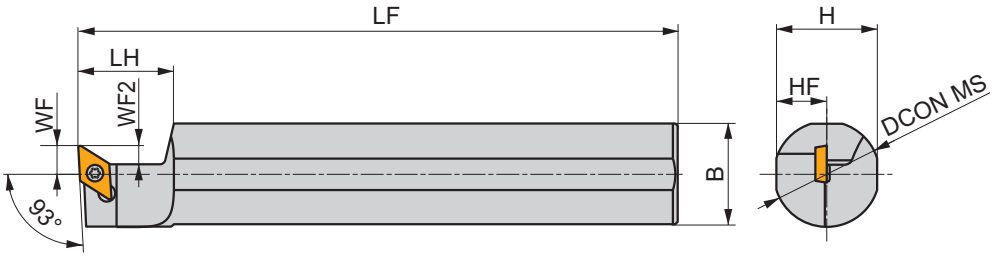
PRAMET

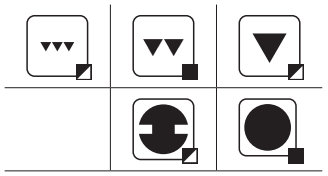
S

External Screw Lock Tool Holder with 93° Cutting Angle for DC.. Inserts

External Right/Left hand tool holder with 93° cutting angle for screw type positive DC.. inserts. Suited for external longitudinal shoulder, copy, face turning, taper and chamfer turning. and usable for sliding head machines. Body treated for longer tool life.







	Product	DCON MS (mm)	H (mm)	B (mm)	HF (mm)	WF (mm)	LF (mm)	LH (mm)	WF2 (mm)	LAMS (°)	GAMO (°)	lbs			MID
L	S20K-SDUCL07-S	20	19	19	9.5	6	125	18.0	4	0	0	.51	GI052	S01	8181047
	S22K-SDUCL07-S	22	21	21	10.5	6	125	18.0	4	0	0	.59	GI052	S01	8181048

GI052	DC.. 21.5.. (DC.. 0702..)

S01	US 2506-T07P	0.9	M 2.5	0.248	FLAG T07P

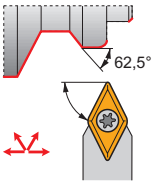
ISDPCN EXT

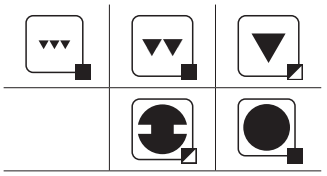
P M K N S H

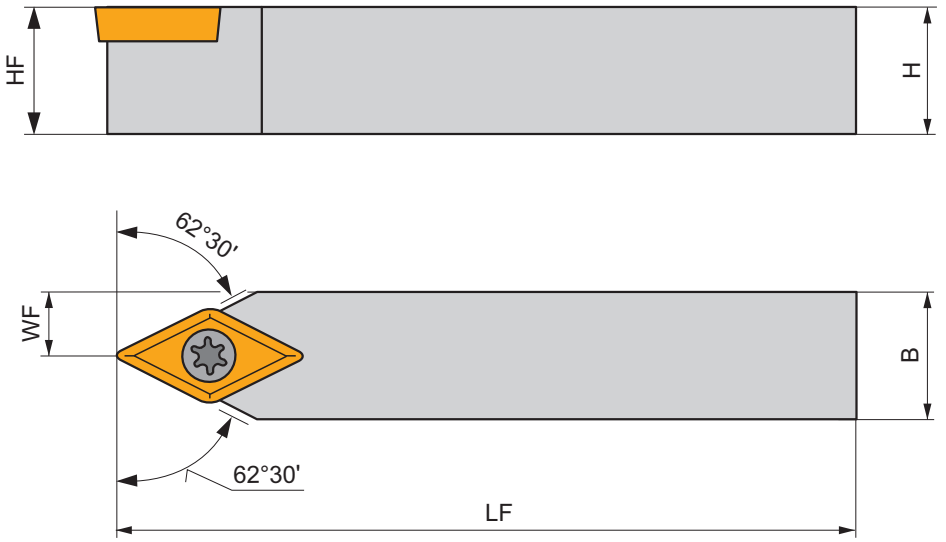
PRAMET

External Screw Lock Tool Holder with 62.5° Cutting Angle for DC.. Inserts

External neutral tool holder with 62.5° cutting angle for screw type positive DC.. inserts. Suited for external longitudinal turning without shoulder, copy, taper and chamfer turning. Body treated for longer tool life.







	Product	H (inch)	B (inch)	HF (inch)	WF (inch)	LF (inch)	LH (inch)	LAMS (°)	GAMO (°)	lbs			MID
N	**SDPCN 06 2**	.375	.375	.375	.216	2.500	.571	0	0	.24	GI052	SD07	6788669
	SDPCN 08 2	.500	.500	.500	.279	3.482	.571	0	0	.33	GI052	SD07	6788670
	SDPCN 10 3	.625	.625	.625	.341	4.000	.862	0	0	.62	GI012	SD11V	6788671
	SDPCN 12 3B	.750	.750	.750	.404	4.500	.862	0	0	.88	GI012	SD11V	6788672
	SDPCN 16 3C	1.000	1.000	1.000	.529	5.000	.890	0	0	1.54	GI012	SD11V	6788673

GI012	DC.. 32.5.. (DC.. 11T3..)
GI052	DC.. 21.5.. (DC.. 0702..)

		Nm					
SD07	US 2003-T07P	0.8	M 2.5	0.256	–	–	FLAG T07P
SD11V	US 2001-T15P	3.0	M 3.5	0.476	SDS 263-01	MS 9001	FLAG T15P/3,5

SDXC(RL) EXT

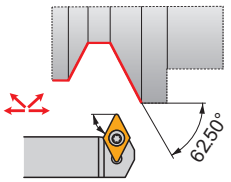
P M K N S H

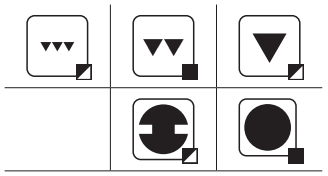
PRAMET

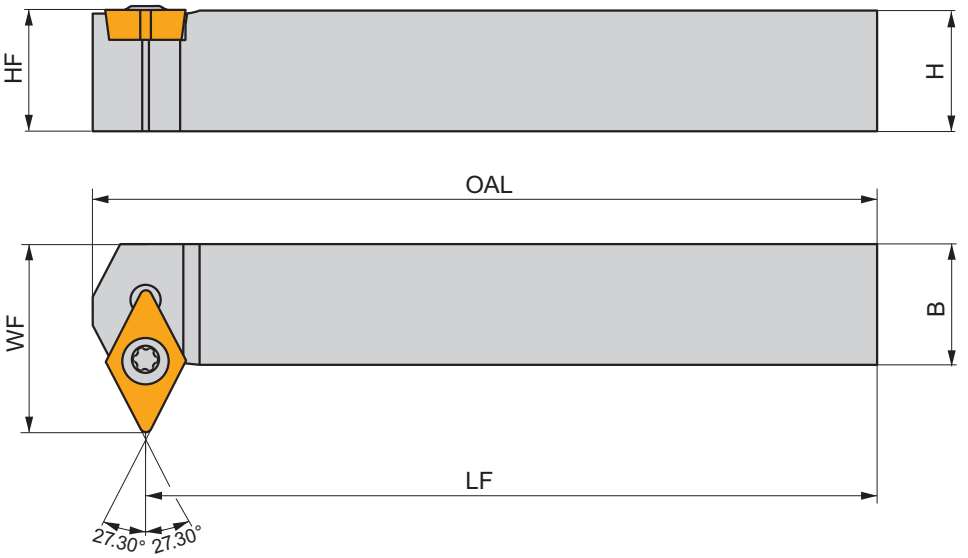
S

External Screw Lock Tool Holder with 62.5° Cutting Angle for DC.. Inserts

External Right/Left hand tool holder with 62.5° cutting angle for screw type positive DC.. inserts. Suited for external longitudinal shoulder, copy, taper and chamfer turning. and usable for sliding head machines. Body treated for longer tool life.







	Product	H (mm)	B (mm)	HF (mm)	WF (mm)	LF (mm)	OAL (mm)	LAMS (°)	GAMO (°)	lbs			MID
R	SDXCR 1212 K 07-S	12	12	12	18	125	130	0	0	.32	GI052	S01	8181051
	SDXCR 1616 K 11-S	16	16	16	25	125	132	0	0	.58	GI012	S08	8181052
L	SDXCL 1212 K 07-S	12	12	12	18	125	130	0	0	.32	GI052	S01	8181049
	SDXCL 1616 K 11-S	16	16	16	25	125	132	0	0	.58	GI012	S08	8181050

GI012	DC.. 32.5.. (DC.. 11T3..)
GI052	DC.. 21.5.. (DC.. 0702..)

		Nm			
S01	US 2506-T07P	0.9	M 2.5	0.248	FLAG T07P
S08	US 3510-T15P	3.0	M 3.5	0.417	FLAG T15P

C.-SDJC(RL) EXT

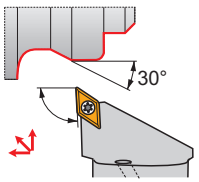
P M K N S H

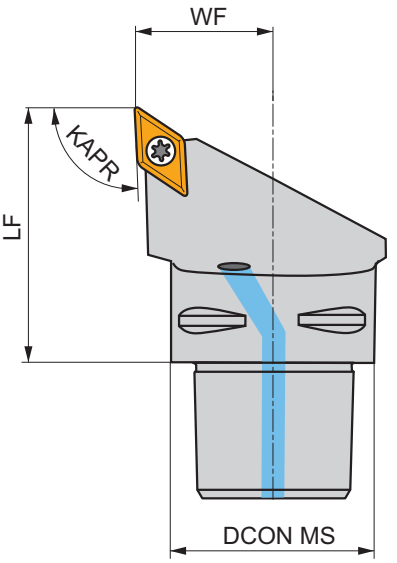
PRAMET

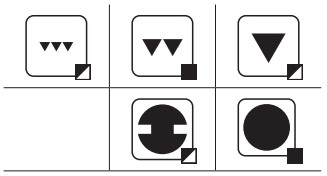
S

External PSC Quick Change Tool, Screw Lock, 93° Cutting Angle for DC.. Inserts

External Right/Left hand tool, through coolant, with 93° cutting angle for screw type positive DC.. inserts. Suited for external longitudinal turning with shoulder, copy, taper and chamfer turning. Polygon Shank Coupling. Body treated for longer tool life.







	Product	DCON MS (mm)	WF (mm)	LF (mm)	KAPR (°)	LAMS (°)	GAMO (°)		lbs			MID
R	C3-SDJCR-22040-11	32	22	40	93	0	0	✓	.45	GI012	C-SD11V-1	7809834
	C4-SDJCR-27050-11	40	27	50	93	0	0	✓	.83	GI012	C-SD11V-1	7809836
	C5-SDJCR-35060-11	50	35	60	93	0	0	✓	1.52	GI012	C-SD11V-2	7809838
L	C3-SDJCL-22040-11	32	22	40	93	0	0	✓	.45	GI012	C-SD11V-1	7809833
	C4-SDJCL-27050-11	40	27	50	93	0	0	✓	.83	GI012	C-SD11V-1	7809835
	C5-SDJCL-35060-11	50	35	60	93	0	0	✓	1.53	GI012	C-SD11V-2	7809837

GI012	DC.. 32.5.. (DC.. 11T3..)

		Nm						
C-SD11V-1	US 2001-T15P	3.0	M 3.5	0.476	SDS 263-01	MS 9001	FLAG T15P/3,5	CN 034-01
C-SD11V-2	US 2001-T15P	3.0	M 3.5	0.476	SDS 263-01	MS 9001	FLAG T15P/3,5	CN 034-02

C.-SDNCN EXT

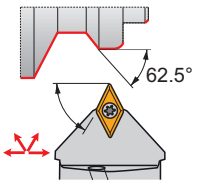
P M K N S H

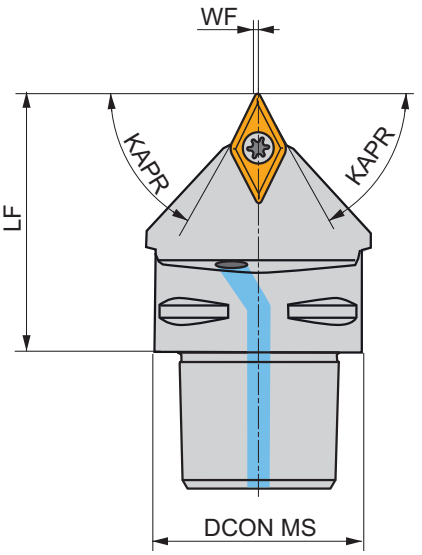
PRAMET

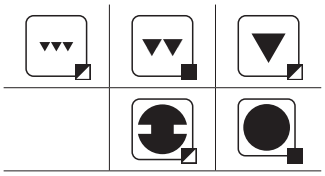
S

External PSC Quick Change Tool, Screw Lock, 62.5° Cutting Angle, DC.. Inserts

External Right/Left hand tool, through coolant, with 62.5° cutting angle for screw type positive DC.. inserts. Suited for external longitudinal turning without shoulder, copy, taper and chamfer turning. Polygon Shank Coupling. Body treated for longer tool life.







	Product	DCON MS (mm)	WF (mm)	LF (mm)	KAPR (°)	LAMS (°)	GAMO (°)		lbs			MID
N	**C4-SDNCN-00050-11**	40	0.5	50	62.5	0	0	✓	.78	GI012	C-SD11V-1	7809839
	C5-SDNCN-00060-11	50	0.5	60	62.5	0	0	✓	1.36	GI012	C-SD11V-2	7809840

GI012	DC.. 32.5.. (DC.. 11T3..)

		Nm						
C-SD11V-1	US 2001-T15P	3.0	M 3.5	0.476	SDS 263-01	MS 9001	FLAG T15P/3,5	CN 034-01
C-SD11V-2	US 2001-T15P	3.0	M 3.5	0.476	SDS 263-01	MS 9001	FLAG T15P/3,5	CN 034-02

SDQC(RL) INT

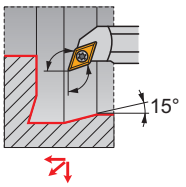
P M K N S H

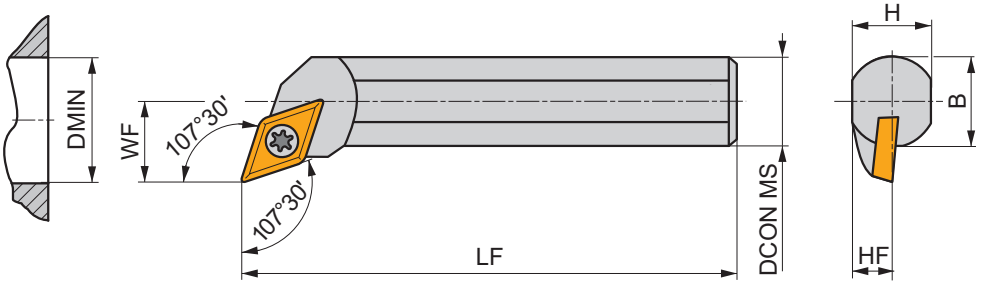
PRAMET

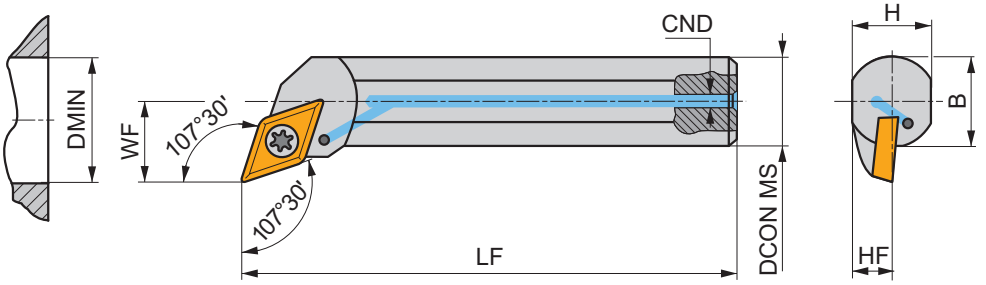
S

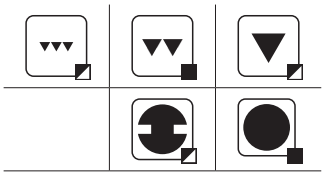
Internal Screw Lock Boring Bar with 107.5° Cutting Angle for DC.. Inserts

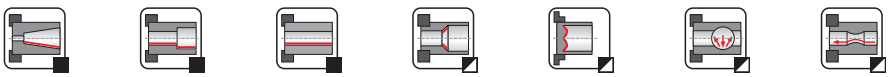
Internal Right/Left hand boring bar, through coolant available, 107.5° cutting angle for screw type DC.. inserts. For internal longitudinal turning with shoulder, taper, copying and chamfer turning. Body treated for longer tool life.











	Product	DCON MS (mm)	DMIN (mm)	WF (mm)	H (mm)	B (mm)	LF (mm)	CND (mm)	LAMS (°)	GAMO (°)		lbs			MID
R	A10H-SDQCR 07	10	13	7	9	–	100	4	-10	0	✓	.16	GI052	S02	6756996
	A12K-SDQCR 07	12	16	9	11	–	125	5	-7	0	✓	.22	GI052	S02	6757020
	A16M-SDQCR 07	16	20	11	14.5	–	150	6	-7	0	✓	.48	GI052	S01	6756997
	A20Q-SDQCR 11	20	25	13	18	–	180	8	-5	0	✓	.79	GI012	S08	6757001
	S20S-SDQCR 11	20	25	13	18	18.5	250	–	-5	0	–	1.32	GI012	S08	6756831
	A25R-SDQCR 11	25	32	17	23	23	200	8	-3	0	✓	1.44	GI012	S08	6757002
	S25T-SDQCR 11	25	32	17	23	23	300	–	-3	0	–	2.37	GI012	S08	6756851
	A32S-SDQCR 11-A	32	40	22	30	30	250	8	-10	0	✓	2.76	GI012	SD10	6756643
	S32U-SDQCR 11-A	32	40	22	30	30	350	–	-10	0	–	4.63	GI012	SD10	6756653
L	A10H-SDQCL 07	10	13	7	9	–	100	4	-10	0	✓	.13	GI052	S02	6757007
	A12K-SDQCL 07	12	16	9	11	–	125	5	-7	0	✓	.24	GI052	S02	6757008
	A16M-SDQCL 07	16	20	11	14.5	–	150	6	-7	0	✓	.48	GI052	S01	6757009
	A20Q-SDQCL 11	20	25	13	18	–	180	8	-5	0	✓	.81	GI012	S08	6757297
	S20S-SDQCL 11	20	25	13	18	18.5	250	–	-5	0	–	1.39	GI012	S08	6756841
	A25R-SDQCL 11	25	32	17	23	23	200	8	-3	0	✓	1.40	GI012	S08	6757298
	S25T-SDQCL 11	25	32	17	23	23	300	–	-3	0	–	2.54	GI012	S08	6756865
	A32S-SDQCL 11-A	32	40	22	30	30	250	8	-10	0	✓	2.90	GI012	SD10	6756642
	S32U-SDQCL 11-A	32	40	22	30	30	350	–	-10	0	–	4.57	GI012	SD10	6756652

GI012	DC.. 32.5.. (DC.. 11T3..)
GI052	DC.. 21.5.. (DC.. 0702..)

		Nm						
SD10	US 3510-T15P	3.0	M 3.5	0.417	SDN 110304	MS 3510	FLAG T15P	HXK 3.5
S01	US 2506-T07P	0.9	M 2.5	0.248	–	–	FLAG T07P	–
S02	US 2505-T07P	0.9	M 2.5	0.205	–	–	FLAG T07P	–
S08	US 3510-T15P	3.0	M 3.5	0.417	–	–	FLAG T15P	–

ISDQC(RL) INT

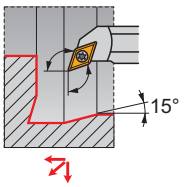
P M K N S H

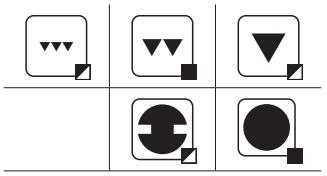
PRAMET

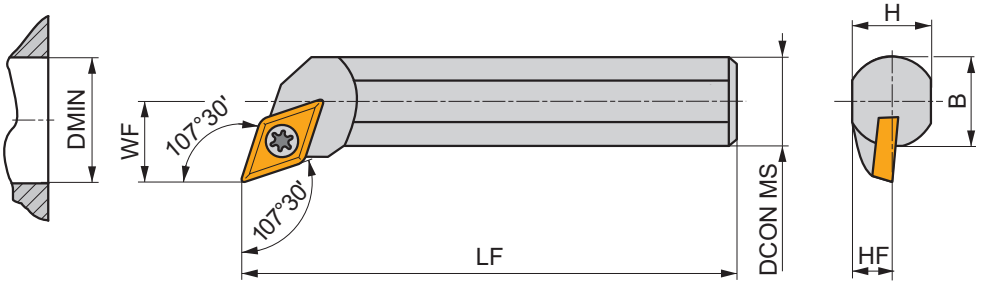
S

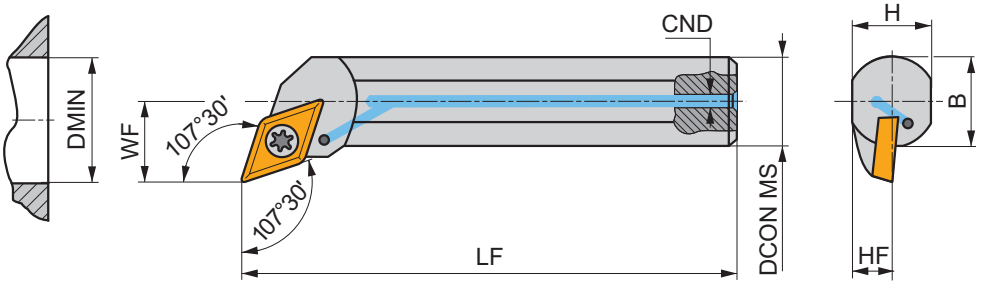
Internal Screw Lock Boring Bar with 107.5° Cutting Angle for DC.. Inserts

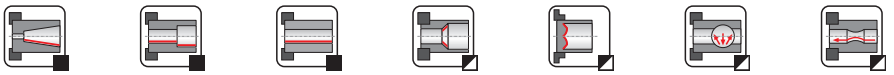
Internal Right/Left hand boring bar, through coolant available, 107.5° cutting angle for screw type DC.. inserts. For internal longitudinal turning with shoulder, taper, copying and chamfer turning. Body treated for longer tool life.











	Product	DCON MS (inch)	DMIN (inch)	WF (inch)	H (inch)	LF (inch)	LAMS (°)	GAMO (°)		lbs			MID
R	A06M-SDQCR 2	.375	.598	.375	.336	6.000	-8	0	✓	.13	GI052	SD07	6788444
	A08M-SDQCR 2	.500	.728	.437	.460	6.000	-6	0	✓	.33	GI052	SD07	6788450
	A10R-SDQCR 2	.625	.850	.500	.562	8.000	-4	0	✓	.66	GI052	SD07	6788458
	A12S-SDQCR 3	.750	.980	.562	.709	10.000	-6	0	✓	1.21	GI012	SD11M	6788471
	A16T-SDQCR 3	1.000	1.299	.750	.906	12.000	-3	0	✓	1.54	GI012	SD11I	6788487
L	A06M-SDQCL 2	.375	.598	.375	.336	6.000	-8	0	✓	.13	GI052	SD07	6788443
	A08M-SDQCL 2	.500	.728	.437	.460	6.000	-6	0	✓	.33	GI052	SD07	6788449
	A12S-SDQCL 3	.750	.980	.562	.709	10.000	-6	0	✓	1.21	GI012	SD11M	6788470
	A16T-SDQCL 3	1.000	1.299	.750	.906	12.000	-3	0	✓	1.54	GI012	SD11I	6788486

GI012	DC.. 32.5.. (DC.. 11T3..)
GI052	DC.. 21.5.. (DC.. 0702..)

		Nm			
SD07	US 2003-T07P	0.8	M 2.5	0.256	FLAG T07P
SD11I	US 2010-T15P	3.0	M 3.5	0.398	FLAG T15P/3,5
SD11M	US 2009-T15P	3.0	M 3.5	0.319	FLAG T15P/3,5

SDUC(RL) INT

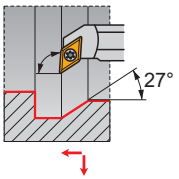
P M K N S H

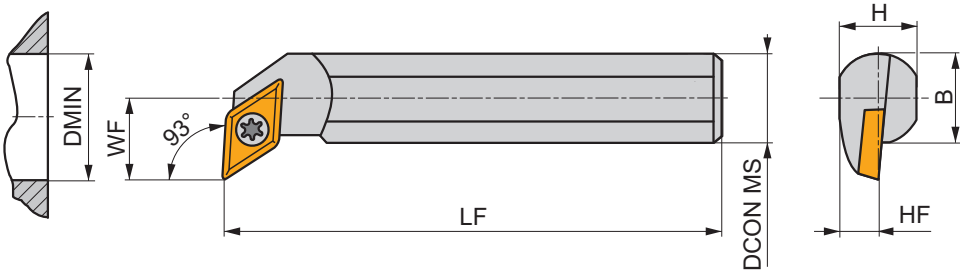
PRAMET

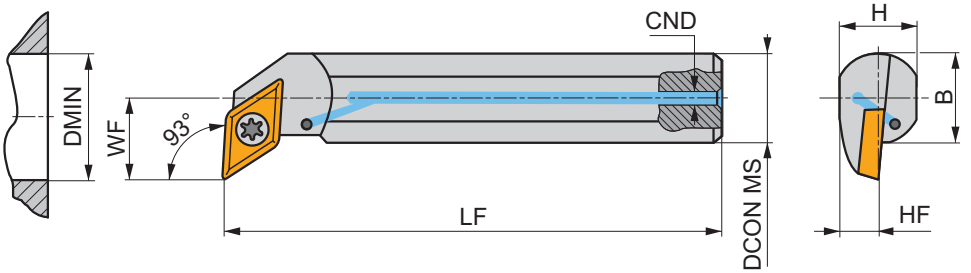
S

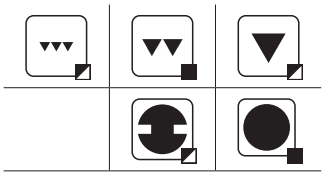
Internal Screw Lock Boring Bar with 93° Cutting Angle for DC.. Inserts

Internal Right/Left hand boring bar, through coolant available, 93° cutting angle for screw type DC.. inserts. For internal longitudinal turning with shoulder, taper, copying and chamfer turning. Body treated for longer tool life.









	Product	DCON MS (mm)	DMIN (mm)	WF (mm)	H (mm)	B (mm)	LF (mm)	CND (mm)	LAMS (°)	GAMO (°)		lbs			MID
R	A10H-SDUCR 07	10	13	7	9	–	100	4	-10	0	✓	.16	GI052	S02	6757102
	A12K-SDUCR 07	12	16	9	11	–	125	5	-7	0	✓	.26	GI052	S02	6757103
	A16M-SDUCR 07	16	20	11	14.5	–	150	6	-7	0	✓	.48	GI052	S01	6757104
	A20Q-SDUCR 11	20	25	13	18	–	180	8	-3	0	✓	.82	GI012	S08	6757105
	S20S-SDUCR 11	20	25	13	18	18.5	250	–	-5	0	–	1.32	GI012	S08	6756824
	A25R-SDUCR 11	25	32	17	23	23	200	8	-3	0	✓	1.33	GI012	S08	6757107
	S25T-SDUCR 11	25	32	17	23	23	300	–	-3	0	–	2.39	GI012	S08	6757108
	A32S-SDUCR 11-A	32	40	22	30	30	250	8	-10	0	✓	2.87	GI012	SD10	6756645
	S32U-SDUCR 11-A	32	40	22	30	30	350	–	-10	0	–	4.63	GI012	SD10	6756655
L	A10H-SDUCL 07	10	13	7	9	–	100	4	-10	0	✓	.16	GI052	S02	6757005
	A12K-SDUCL 07	12	16	9	11	–	125	5	-7	0	✓	.24	GI052	S02	6757006
	A16M-SDUCL 07	16	20	11	14.5	–	150	6	-7	0	✓	.48	GI052	S01	6757151
	A20Q-SDUCL 11	20	25	13	18	–	180	8	-3	0	✓	.82	GI012	S08	6757152
	S20S-SDUCL 11	20	25	13	18	18.5	250	–	-5	0	–	1.32	GI012	S08	6756916
	A25R-SDUCL 11	25	32	17	23	23	200	8	-3	0	✓	1.45	GI012	S08	6756857
	S25T-SDUCL 11	25	32	17	23	23	300	–	-3	0	–	2.40	GI012	S08	6756853
	A32S-SDUCL 11-A	32	40	22	30	30	250	8	-10	0	✓	2.97	GI012	SD10	6756644
	S32U-SDUCL 11-A	32	40	22	30	30	350	–	-10	0	–	4.61	GI012	SD10	6756654

GI012	DC.. 32.5.. (DC.. 11T3..)
GI052	DC.. 21.5.. (DC.. 0702..)

ISDUC(RL) INT

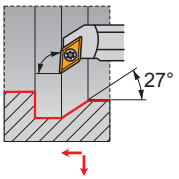
P M K N S H

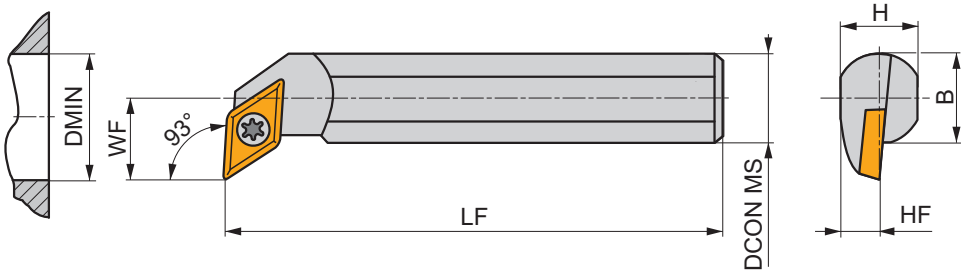
PRAMET

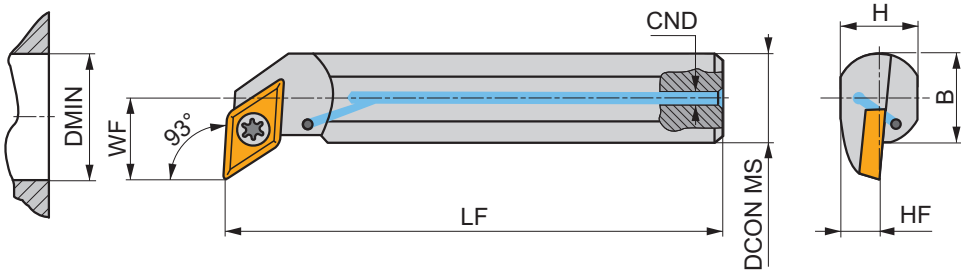
S

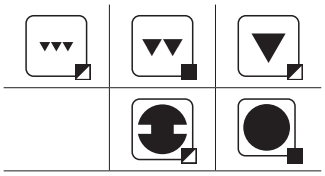
Internal Screw Lock Boring Bar with 93° Cutting Angle for DC.. Inserts

Internal Right/Left hand boring bar, through coolant available, 93° cutting angle for screw type DC.. inserts. For internal longitudinal turning with shoulder, taper, copying and chamfer turning. Body treated for longer tool life.









	Product	DCON MS (inch)	DMIN (inch)	WF (inch)	H (inch)	B (inch)	LF (inch)	CND (inch)	LAMS (°)	GAMO (°)		lbs			MID
R	A06M-SDUCR 2	.375	.598	.375	.336	–	6.000	–	-7	0	✓	.13	GI052	SD07	6788446
	A08M-SDUCR 2	.500	.728	.438	.460	–	6.000	–	-5	0	✓	.33	GI052	SD07	6788452
	A10R-SDUCR 2	.625	.850	.500	.562	–	8.000	–	-4	0	✓	.66	GI052	SD07	6788460
	A12S-SDUCR 3	.750	1.051	.625	.709	–	10.000	–	-5	0	✓	1.21	GI012	SD11M	6788473
	A16T-SDUCR 3	1.000	1.299	.750	.906	–	12.000	–	-3	0	✓	1.54	GI012	SD11I	6788489
	A20T-SDUCR 3	1.250	1.579	.875	1.181	–	12.000	–	-8	0	✓	3.08	GI012	SD11V	6788503
L	A08M-SDUCL 2	.500	.728	.438	.460	–	6.000	–	-5	0	✓	.33	GI052	SD07	6788451
	A10R-SDUCL 2	.625	.850	.500	.562	–	8.000	–	-4	0	✓	.66	GI052	SD07	6788459
	A12S-SDUCL 3	.750	1.051	.625	.709	–	10.000	–	-5	0	✓	1.21	GI012	SD11M	6788472
	A16T-SDUCL 3	1.000	1.299	.750	.906	–	12.000	–	-3	0	✓	1.54	GI012	SD11I	6788488
	A20T-SDUCL 3	1.250	1.579	.875	1.181	–	12.000	–	-8	0	✓	3.08	GI012	SD11V	6788502

GI012	DC.. 32.5.. (DC.. 11T3..)
GI052	DC.. 21.5.. (DC.. 0702..)

		Nm					
SD07	US 2003-T07P	0.8	M 2.5	0.256	–	–	FLAG T07P
SD11I	US 2010-T15P	3.0	M 3.5	0.398	–	–	FLAG T15P/3,5
SD11M	US 2009-T15P	3.0	M 3.5	0.319	–	–	FLAG T15P/3,5
SD11V	US 2001-T15P	3.0	M 3.5	0.476	SDS 263-01	MS 9001	FLAG T15P/3,5

SDUC(RL)-E INT

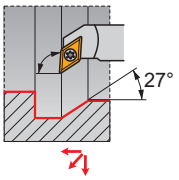
P M K N S H

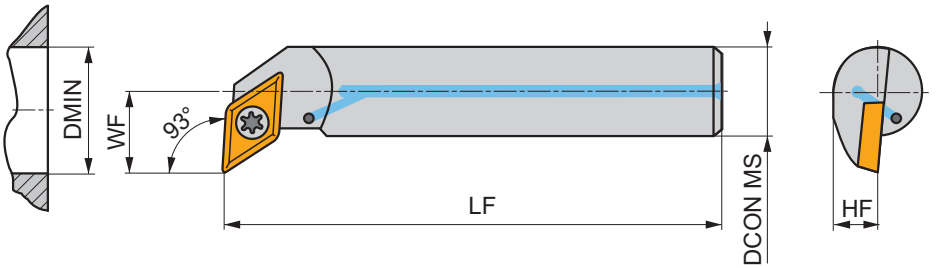
PRAMET

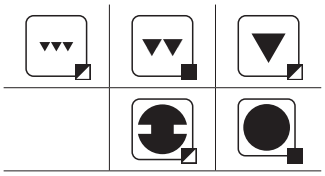
S

Internal Carbide Screw Lock Boring Bar with 93° Cutting Angle for DC.. Inserts

Internal Right/Left hand carbide boring bar, through coolant, 93° cutting angle for screw type positive DC.. inserts. For internal longitudinal turning with shoulder, taper, copying and chamfer turning. For tool overhang >3xD.







	Product	DCON MS (mm)	DMIN (mm)	WF (mm)	HF (mm)	LF (mm)	LAMS (°)	GAMO (°)		lbs			MID
R	E10M-SDUCR 07-ER	10	15	9	5.6	150	-5	0	✓	.31	GI052	SD21	6760499
	E12Q-SDUCR 07-ER	12	18	11	6.5	150	-5	0	✓	.57	GI052	SD21	6760503
	E16R-SDUCR 07-ER	16	22	13	8.5	150	-5	0	✓	1.08	GI052	SD21	6760507
L	E10M-SDUCL 07-ER	10	15	9	5.6	150	-5	0	✓	.34	GI052	SD21	6760498
	E12Q-SDUCL 07-ER	12	18	11	6.5	150	-5	0	✓	.57	GI052	SD21	6760502
	E16R-SDUCL 07-ER	16	22	13	8.5	150	-5	0	✓	1.10	GI052	SD21	6760506

GI052	DC.. 21.5.. (DC.. 0702..)

SD21	5513 020-03	0.8	M 2.5	0.256	PT-8001

ISDUC(RL)-E INT

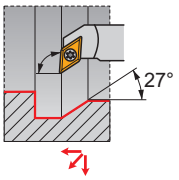
P M K N S H

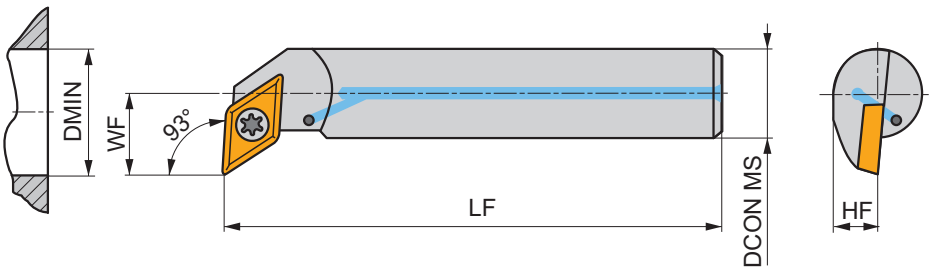
PRAMET

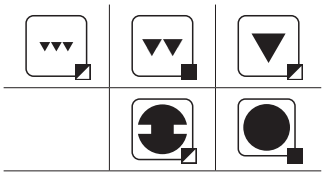
S

Internal Carbide Screw Lock Boring Bar with 93° Cutting Angle for DC.. Inserts

Internal Right/Left hand carbide boring bar, through coolant, 93° cutting angle for screw type positive DC.. inserts. For internal longitudinal turning with shoulder, taper, copying and chamfer turning. For tool overhang >3xD.







	Product	DCON MS (inch)	DMIN (inch)	WF (inch)	HF (inch)	LF (inch)	LAMS (°)	GAMO (°)		lbs			MID
R	E06M-SDUCR 2	.375	.598	.375	.168	6.000	-7	0	✓	1.20	GI052	SD07	6788515
	E08R-SDUCR 2	.500	.716	.438	.230	8.000	-5	0	✓	1.65	GI052	SD07	6788517
	E10R-SDUCR 2	.625	.850	.500	.281	8.000	-4	0	✓	2.35	GI052	SD07	6788519
L	E08R-SDUCL 2	.500	.716	.438	.230	8.000	-5	0	✓	1.65	GI052	SD07	6788516
	E10R-SDUCL 2	.625	.850	.500	.281	8.000	-4	0	✓	2.35	GI052	SD07	6788518

GI052	DC.. 21.5.. (DC.. 0702..)

SD07	US 2003-T07P	0.8	M 2.5	0.256	FLAG T07P

SDZC(RL) INT

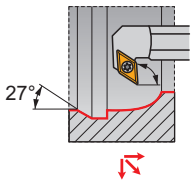
P M K N S H

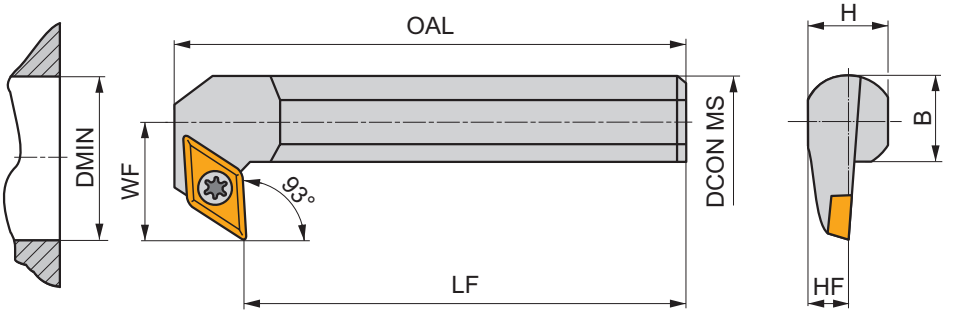
PRAMET

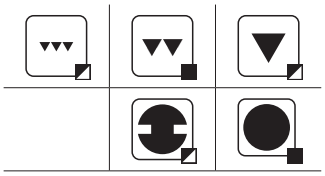
S

Internal Screw Lock Boring Bar with 93° Cutting Angle for DC.. Inserts

Internal Right/Left hand boring bar with 93° cutting angle for screw type DC.. inserts. Suited for internal longitudinal back turning with shoulder, taper, copying and chamfer turning. Body treated for longer tool life.







	Product	DCON MS (mm)	DMIN (mm)	WF (mm)	H (mm)	B (mm)	LF (mm)	OAL (mm)	LAMS (°)	GAMO (°)	lbs			MID
R	S16M-SDZCR 07-93	16	27	17	14.5	15	150	163	-4	0	.57	GI052	S01	6756832
	S20Q-SDZCR 11-93	20	35	22	18	18.5	180	198	-5	0	1.07	GI012	S08	6757156
	S25R-SDZCR 11-93	25	42	27	23	23	200	218	-3	0	1.75	GI012	S08	6756876
	S32S-SDZCR 11-93-A	32	53	35	30	30	250	268	-6	0	3.58	GI012	SD10	6756647
	S40T-SDZCR 11-93-A	40	65	43	38	38	300	322	-5	0	6.61	GI012	SD10	6756658
L	S16M-SDZCL 07-93	16	27	17	14.5	15	150	163	-4	0	.60	GI052	S01	6757004
	S20Q-SDZCL 11-93	20	35	22	18	18.5	180	198	-5	0	1.06	GI012	S08	6757003
	S25R-SDZCL 11-93	25	42	27	23	23	200	218	-3	0	1.76	GI012	S08	6756852
	S32S-SDZCL 11-93-A	32	53	35	30	30	250	268	-6	0	3.53	GI012	SD10	6756646
	S40T-SDZCL 11-93-A	40	65	43	38	38	300	322	-5	0	6.61	GI012	SD10	6756733

GI012	DC.. 32.5.. (DC.. 11T3..)
GI052	DC.. 21.5.. (DC.. 0702..)

		Nm						
SD10	US 3510-T15P	3.0	M 3.5	0.417	SDN 110304	MS 3510	FLAG T15P	HXK 3.5
S01	US 2506-T07P	0.9	M 2.5	0.248	–	–	FLAG T07P	–
S08	US 3510-T15P	3.0	M 3.5	0.417	–	–	FLAG T15P	–

ISDZC(RL) INT

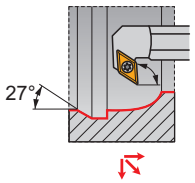
P M K N S H

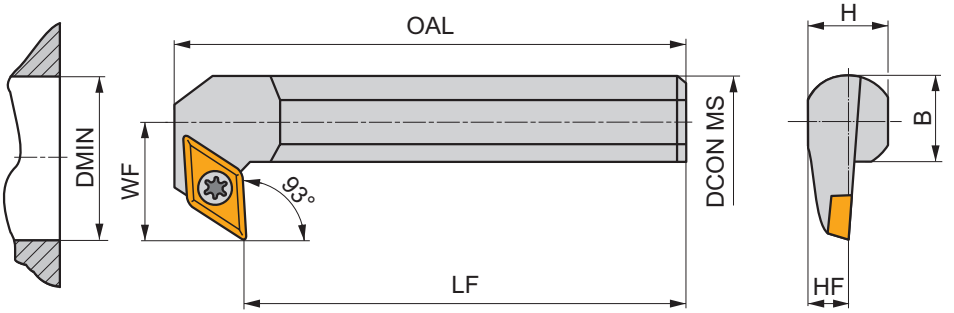
PRAMET

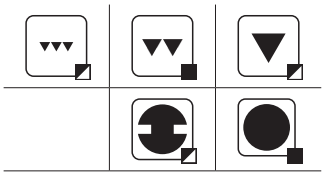
S

Internal Screw Lock Boring Bar with 93° Cutting Angle for DC.. Inserts

Internal Right/Left hand boring bar with 93° cutting angle for screw type DC.. inserts. Suited for internal longitudinal back turning with shoulder, taper, copying and chamfer turning. Body treated for longer tool life.







	Product	DCON MS (inch)	DMIN (inch)	WF (inch)	H (inch)	LF (inch)	OAL (inch)	LAMS (°)	GAMO (°)	lbs			MID
R	A20T-SDZCR 3-93	1.250	1.579	.875	1.181	12.000	12.658	-7	0	3.08	GI012	SD11V	6788640
L	A20T-SDZCL 3-93	1.250	1.579	.876	1.182	12.000	12.658	-7	0	3.08	GI012	SD11V	6788639

GI012	DC.. 32.5.. (DC.. 11T3..)

SD11V	US 2001-T15P	3.0 Nm	M 3.5	0.476	SDS 263-01	MS 9001	FLAG T15P/3,5

C.-SDUC(RL) INT

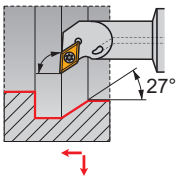
P M K N S H

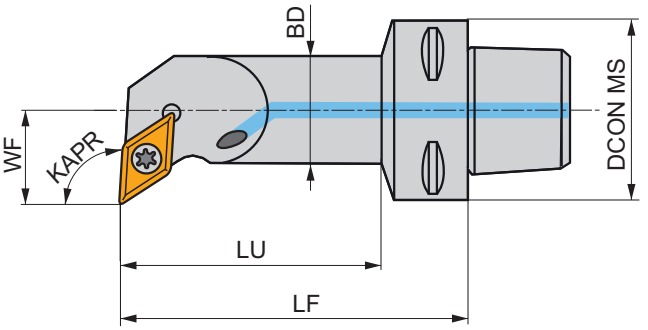
PRAMET

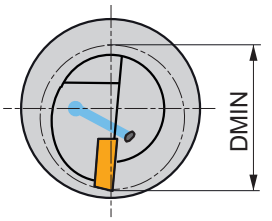
S

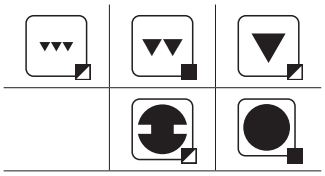
Internal PSC Quick Change Tool, Screw Lock, 93° Cutting Angle for DC.. Inserts

Internal Right/Left hand tool, through coolant, with 93° cutting angle for screw type DC.. inserts. Suited for a wide range of internal turning applications. Polygon Shank Coupling with choice of lengths. Body treated for longer tool life.









	Product	DCON MS (mm)	DMIN (mm)	WF (mm)	LF (mm)	LU (mm)	BD (mm)	KAPR (°)	LAMS (°)	GAMO (°)		lbs			MID
R	C3-SDUCR-11065-07	50	20	11	65	48	16	93	-4.3	0	✓	.44	GI052	SV11	7809886
	C4-SDUCR-11070-07	40	20	11	70	47	16	93	-4.3	0	✓	.77	GI052	SV11	7809888
	C4-SDUCR-13080-11	40	25	13	80	57	20	93	-5.8	0	✓	.90	GI012	SC09M	7809890
	C4-SDUCR-17090-11	40	32	17	90	68	25	93	-3.4	0	✓	1.09	GI012	SV16	7809892
	C5-SDUCR-13080-11	50	25	13	80	56	20	93	-5.8	0	✓	1.32	GI012	SC09M	7809894
	C5-SDUCR-17090-11	50	32	17	90	67	25	93	-3.4	0	✓	1.51	GI012	SV16	7809895
L	C4-SDUCL-11070-07	40	20	11	70	47	16	93	-4.3	0	✓	.77	GI052	SV11	7809887
	C4-SDUCL-13080-11	40	25	13	80	57	20	93	-5.8	0	✓	.90	GI012	SC09M	7809889
	C4-SDUCL-17090-11	40	32	17	90	68	25	93	-3.4	0	✓	1.09	GI012	SV16	7809891
	C5-SDUCL-13080-11	50	25	13	80	56	20	93	-5.8	0	✓	1.33	GI012	SC09M	7809893

GI012	DC.. 32.5.. (DC.. 11T3..)
GI052	DC.. 21.5.. (DC.. 0702..)

		Nm				
SC09M	US 2009-T15P	3.0	M 3.5	0.319	FLAG T15P/3,5	–
SV11	US 2003-T07P	0.8	M 2.5	0.256	–	FLAG T07P
SV16	US 2010-T15P	3.0	M 3.5	0.398	–	FLAG T15P/3,5

SEGC(RL) EXT

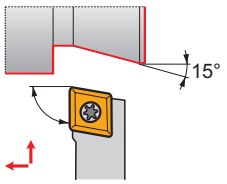
P M K N S H

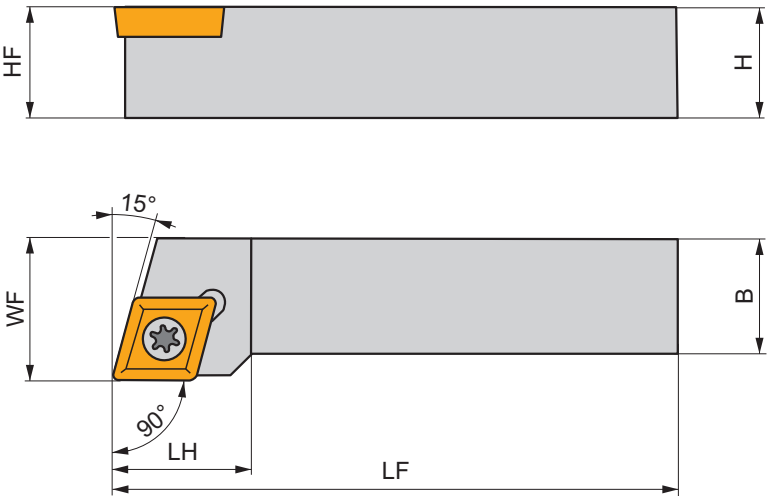
PRAMET

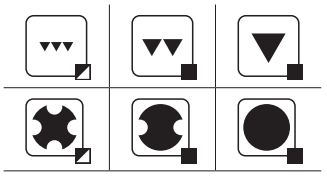
S

External Screw Lock Tool Holder with 90° Cutting Angle for EC.. Inserts

External Right/Left hand tool holder with 90° cutting angle for screw type positive EC.. inserts. Suited for external face and longitudinal turning with shoulder, taper, chamfer and face turning. Body treated for longer tool life.







	Product	H (mm)	B (mm)	HF (mm)	WF (mm)	LF (mm)	LH (mm)	LAMS (°)	GAMO (°)	lbs			MID
R	**SEGCR 1212 N 08**	12	12	12	16	160	12.0	0	0	.33	GI210	SE08	6760434
	SEGCR 1616 H 08	16	16	16	20	100	12.0	0	0	.48	GI210	SE08	6760435
L	**SEGCL 1212 N 08**	12	12	12	16	160	12.0	0	0	.49	GI210	SE08	6760432
	SEGCL 1616 H 08	16	16	16	20	100	12.0	0	0	4.72	GI210	SE08	6760433

GI210	EC.. 2.52.. (EC.. 0803..)

SE08	416.1-832	3.6	M 3	0.335	PT-8002

SEUC(RL) INT

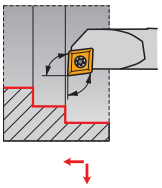
P M K N S H

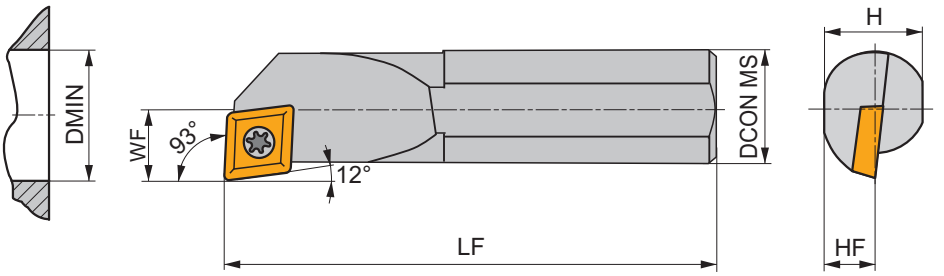
PRAMET

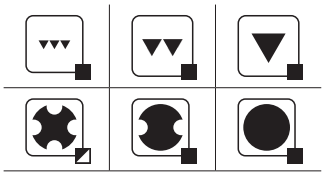
S

Internal Screw Lock Boring Bar with 93° Cutting Angle for EC.. Inserts

Internal Right/Left hand boring bar with 93° cutting angle for screw type EC.. inserts. Suited for internal taper and longitudinal turning with shoulder and chamfer turning. Body treated for longer tool life.







	Product	DCON MS (mm)	DMIN (mm)	WF (mm)	H (mm)	HF (mm)	LF (mm)	LAMS (°)	GAMO (°)	lbs			MID
R	S08K-SEUCR 06	8	11	7	7	3.5	125	-5	0	.14	GI213	SE23	6760453
	S10M-SEUCR 06	10	13	8	9	4.5	150	-5	0	.22	GI213	SE23	6760455
	S12M-SEUCR 08	12	15	9	11	5.5	150	-5	0	.31	GI210	SE24	6760457
	S16R-SEUCR 08	16	20	11	15	7.5	200	-5	0	.71	GI210	SE24	6760459
	S20S-SEUCR 08	20	25	13	18	9	250	-5	0	1.29	GI210	SE24	6760460
	S25T-SEUCR 08	25	32	17	23	11.5	300	-4	0	2.34	GI210	SE24	6760461
L	S08K-SEUCL 06	8	11	7	7	3.5	125	-5	0	.14	GI213	SE23	6760452
	S10M-SEUCL 06	10	13	8	9	4.5	150	-5	0	.23	GI213	SE23	6760454
	S12M-SEUCL 08	12	15	9	11	5.5	150	-5	0	.31	GI210	SE24	6760456
	S16R-SEUCL 08	16	20	11	15	7.5	200	-5	0	.71	GI210	SE24	6760458
	S20S-SEUCL 08	20	25	13	18	9	250	-5	0	1.28	GI210	SE24	6760770

GI210	EC.. 2.52.. (EC.. 0803..)
GI213	EC.. 21.5.. (EC.. 0602..)

		Nm			
SE23	5513 020-03	0.8	M 2.5	0.256	PT-8001
SE24	416.1-832	3.6	M 3	0.335	PT-8003

SELP(RL) INT

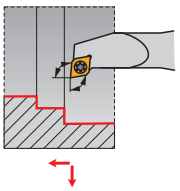
P M K N S H

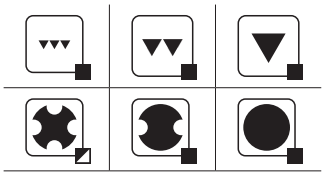
PRAMET

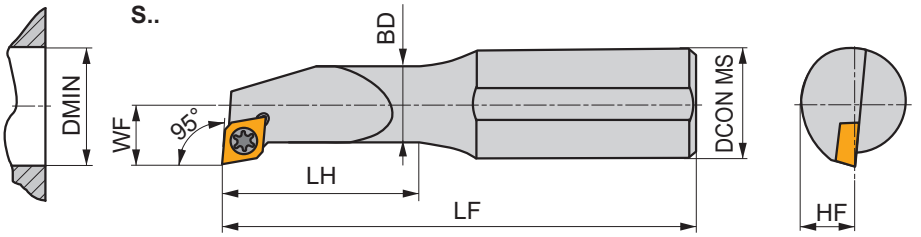
S

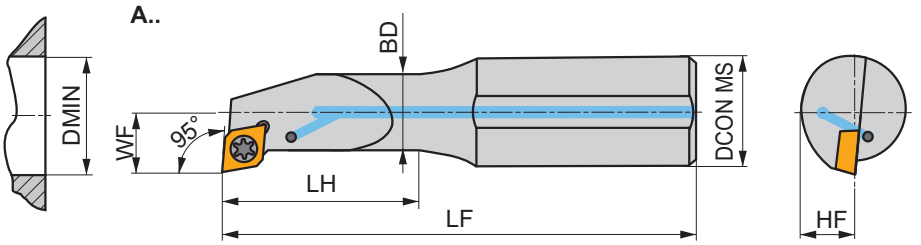
Internal Screw Lock Boring Bar with 95° Cutting Angle for EP.. Inserts

Internal Right/Left hand boring bar, through coolant available, with 95° cutting angle for screw type EP.. inserts. Suited for internal taper and longitudinal turning with shoulder and chamfer turning. Body treated for longer tool life.









	Product	DCON MS (mm)	DMIN (mm)	BD (mm)	WF (mm)	LF (mm)	LH (mm)	LAMS (°)	GAMO (°)		lbs			MID
R	S0608H-SELPR 05	8	8	6	4.5	100	20.0	-10	0	–	.09	GI212	SE21	6760463
	S0810J-SELPR 05	10	11	8	6	110	26.0	-5	0	–	.14	GI212	SE22	6760467
	S1012K-SELPR 05	12	13	10	7	125	32.0	-5	0	–	.24	GI212	SE22	6760470
	A1216M-SELPR 05	16	16	12	9	150	40.0	-2	0	✓	.40	GI212	SE22	6760745
	S1216M-SELPR 05	16	16	12	9	150	40.0	-2	0	–	.45	GI212	SE22	6760474
L	S0608H-SELPL 05	8	8	6	4.5	100	20.0	-10	0	–	.09	GI212	SE21	6760462
	S0810J-SELPL 05	10	11	8	6	110	26.0	-5	0	–	.14	GI212	SE22	6760466
	S1012K-SELPL 05	12	13	10	7	125	32.0	-5	0	–	.24	GI212	SE22	6760469
	S1216M-SELPL 05	16	16	12	9	150	40.0	-2	0	–	.45	GI212	SE22	6760473

GI212	EP.. 1.81.5.. (EP.. 0502..)

		Nm			
SE21	28992	0.8	M 2.2	0.165	MA2-8304
SE22	28588	0.8	M 2.2	0.22	MA2-8304

SELP(RL)-E INT

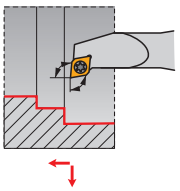
P M K N S H

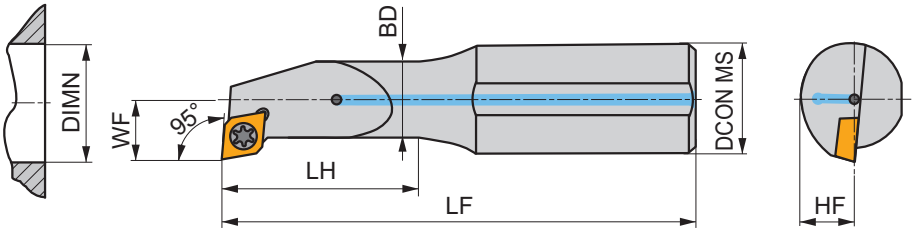
PRAMET

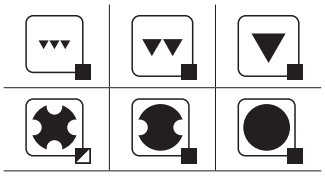
S

Internal Carbide Screw Lock Boring Bar with 95° Cutting Angle for EP.. Inserts

Internal Right/Left hand carbide boring bar, through coolant, with 95° cutting angle for screw type EP.. inserts. Suited for internal taper and longitudinal turning with shoulder and chamfer turning. For tool overhang >3xD.







	Product	DCON MS (mm)	DMIN (mm)	BD (mm)	WF (mm)	LF (mm)	LH (mm)	LAMS (°)	GAMO (°)		lbs			MID
R	E0608H-SELPR 05	8	8	6	4.5	100	28.0	-10	0	✓	.14	GI212	SE22	6760478
	E0810J-SELPR 05	10	11	8	6	110	36.0	-5	0	✓	.23	GI212	SE22	6760480
	E1012K-SELPR 05	12	13	10	7	125	44.0	-5	0	✓	.38	GI212	SE22	6760481
L	E0608H-SELPL 05	8	8	6	4.5	100	28.0	-10	0	✓	.14	GI212	SE22	6760477
	E0810J-SELPL 05	10	11	8	6	110	36.0	-5	0	✓	.23	GI212	SE22	6760479
	E1216M-SELPL 05	16	16	12	9	150	55.0	-2	0	✓	.72	GI212	SE22	6760776

GI212	EP.. 1.81.5.. (EP.. 0502..)

SE22	28588	0.8	M 2.2	0.22	MA2-8304

SEUP(RL) INT

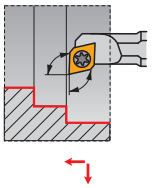
P M K N S H

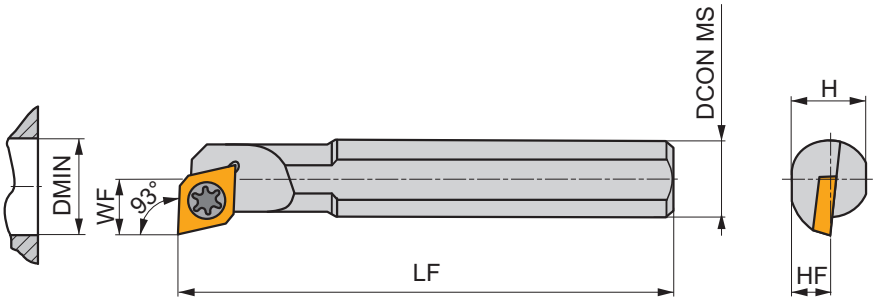
PRAMET

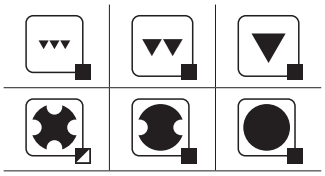
S

Internal Screw Lock Boring Bar with 93° Cutting Angle for EP.. Inserts

Internal Right/Left hand boring bar with 93° cutting angle for screw type EP..inserts. Suited for internal taper and longitudinal turning with shoulder and chamfer turning. Body treated for longer tool life.







	Product	DCON MS (mm)	DMIN (mm)	WF (mm)	H (mm)	HF (mm)	LF (mm)	LAMS (°)	GAMO (°)	lbs			MID
R	S06H-SEUPR 05	6	8.3	5	5.4	2.7	100	-7	0	.10	GI212	SE21	6760451
L	S06H-SEUPL 05	6	8.3	5	5.4	2.7	100	-7	0	.11	GI212	SE21	6760450

GI212	EP.. 1.81.5.. (EP.. 0502..)

SE21	28992	0.8	M 2.2	0.165	MA2-8304

SEXP(RL) INT

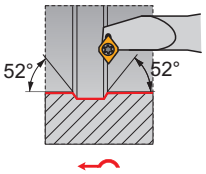
P M K N S H

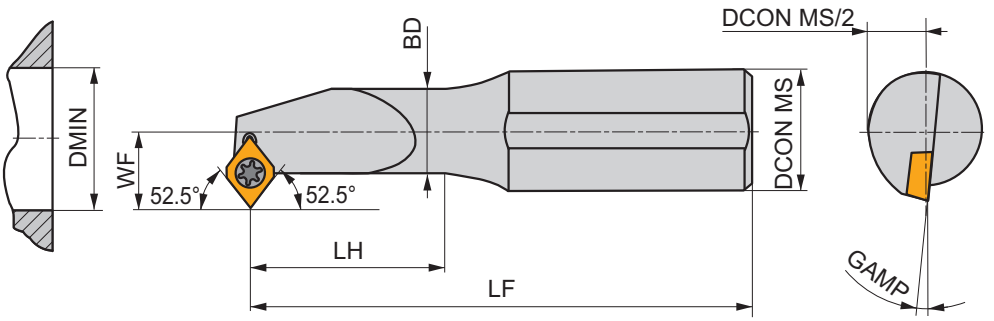
PRAMET

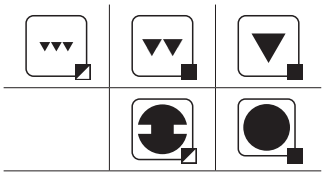
S

Internal Screw Lock Boring Bar with 52.5° Cutting Angle for EP.. Inserts

Internal Right/Left hand boring bar, 52.5° cutting angle for screw type EP.. inserts. For internal back chamfer, taper, multi-directional, chamfer and longitudinal turning without shoulder. Body treated for longer tool life.







	Product	DCON MS (mm)	DMIN (mm)	BD (mm)	WF (mm)	LF (mm)	LH (mm)	GAMP (°)	lbs			MID
R	S0608H-SEXPR 05	8	9.5	6	5.5	100	20.0	-7	.09	GI212	SE21	6760465
	S0810J-SEXPR 05	10	11	8	6	110	26.0	-5	.14	GI212	SE22	6760468
	S1012K-SEXPR 05	12	13	10	7	125	32.0	-5	.23	GI212	SE22	6760472
	S1216M-SEXPR 05	16	16	12	9	150	40.0	-2	.47	GI212	SE22	6760476
L	S0608H-SEXPL 05	8	9.5	6	5.5	100	20.0	-7	.09	GI212	SE21	6760464
	S0810J-SEXPL 05	10	11	8	6	110	26.0	-5	.14	GI212	SE22	6760771
	S1012K-SEXPL 05	12	13	10	7	125	32.0	-5	.24	GI212	SE22	6760471
	S1216M-SEXPL 05	16	16	12	9	150	40.0	-2	.46	GI212	SE22	6760475

GI212	EP.. 1.81.5.. (EP.. 0502..)

		Nm			
SE21	28992	0.8	M 2.2	0.165	MA2-8304
SE22	28588	0.8	M 2.2	0.22	MA2-8304

SEXP(RL)-E INT

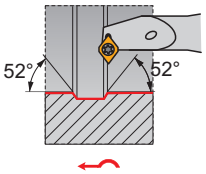
P M K N S H

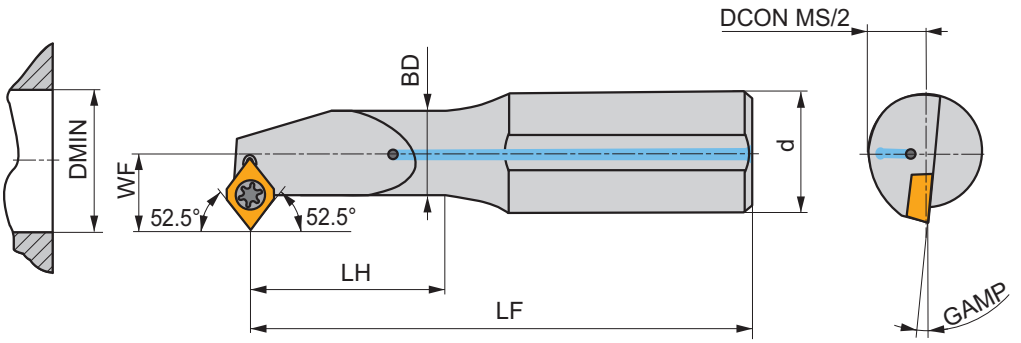
PRAMET

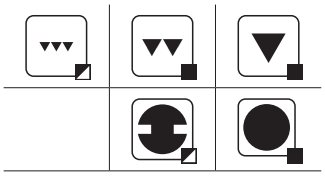
S

Internal Carbide Screw Lock Boring Bar, 52.5° Cutting Angle for EP.. Inserts

Internal Right/Left hand carbide boring bar, through coolant, 52.5° cutting angle for screw type EP.. inserts. For internal back chamfer, taper, multi-directional, chamfer and longitudinal turning without shoulder. For overhang > 3xD.







	Product	DCON MS (mm)	DMIN (mm)	BD (mm)	WF (mm)	LF (mm)	LH (mm)	GAMP (°)		lbs			MID
R	E0608H-SEXPR 05	8	9.5	6	5.5	100	28.0	-7	✓	.14	GI212	SE21	6760773
	E0810J-SEXPR 05	10	11	8	6	110	36.0	-5	✓	.22	GI212	SE22	6760774
	E1012K-SEXPR 05	12	13	10	7	125	44.0	-5	✓	.36	GI212	SE22	6760775
	E1216M-SEXPR 05	16	16	12	9	150	55.0	-2	✓	.71	GI212	SE22	6760777
L	E0608H-SEXPL 05	8	9.5	6	5.5	100	28.0	-7	✓	.14	GI212	SE21	6760772

GI212	EP.. 1.81.5.. (EP.. 0502..)

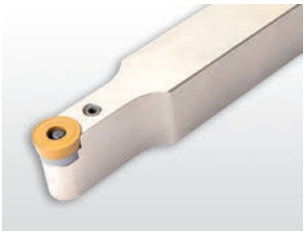
		Nm			
SE21	28992	0.8	M 2.2	0.165	MA2-8304
SE22	28588	0.8	M 2.2	0.22	MA2-8304

PRDCN EXT

P M K N S H

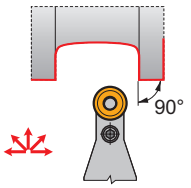
PRAMET

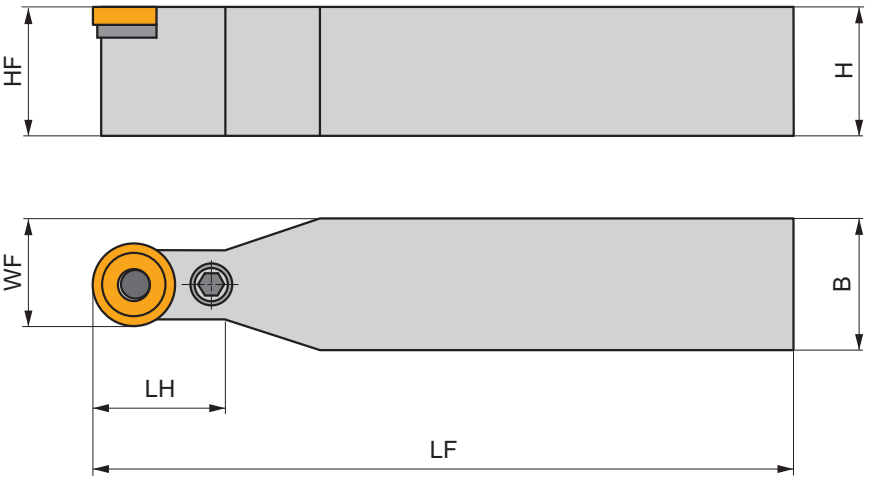
P

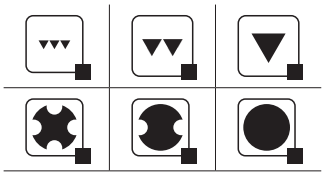


External Lever Lock Tool Holder for Round RC.. Inserts

External neutral lever lock tool holder for positive RC.. inserts. Suited for external face and longitudinal turning without shoulder, copy turning up to 90°, taper and chamfer turning. Body treated for longer tool life.







	Product	H (mm)	B (mm)	HF (mm)	WF (mm)	LF (mm)	LH (mm)	LAMS (°)	GAMO (°)	lbs			MID
N	**PRDCN 3225 P 16**	32	25	32	20.5	170	34.0	0	0	1.76	GI090	PR01	6757144
	PRDCN 3232 P 20	32	32	32	26	170	42.0	0	0	2.55	GI069	PR03	6756904
	PRDCN 4040 S 20	40	40	40	30	250	40.0	0	0	6.08	GI069	PR03	6757911
	PRDCN 4040 S 25	40	40	40	32.5	250	40.0	0	0	6.06	GI122	PR02	6758511
	PRDCN 5050 V 32	50	50	50	41	400	52.0	0	0	16.09	GI096	PR04	8281353

GI069	RCMX 2006M0
GI090	RCMX 1606M0
GI096	RCMX 3209M0
GI122	RCMX 2507M0

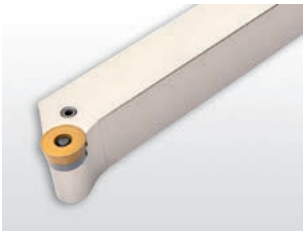
				Nm					
PR01	PRS 816	CL 116	CS 706	2.0	M 6x1	0.815	TR 16	MT 05	HXK 2.5
PR02	PRS 825	CL 125	CS 710	3.5	M 10x1	1.197	TR 19	MT 06	HXK 4
PR03	PRS 820	CL 120	CS 708	3.0	M 8x1	0.925	TR 15	MT 07	HXK 3
PR04	PRS 832	CL 132	CS 612	4.0	M 12x1	1.417	TR 25	MT 08	HXK 5

PRSC(RL) EXT

P M K N S H

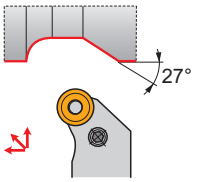
PRAMET

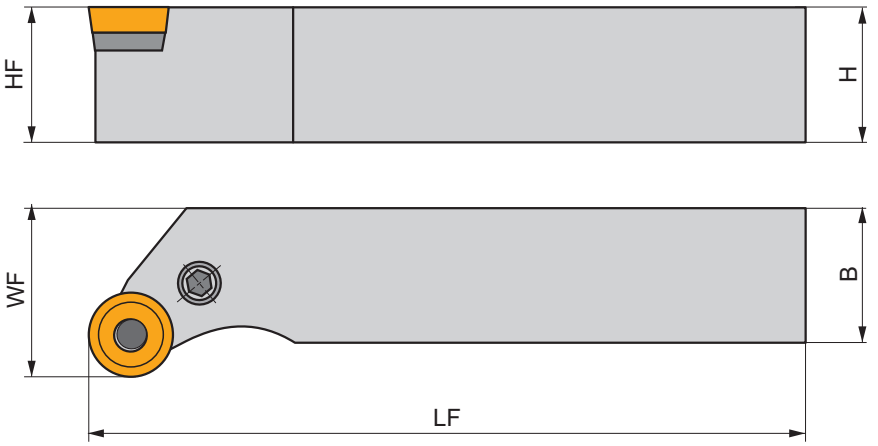
P

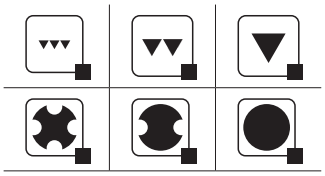


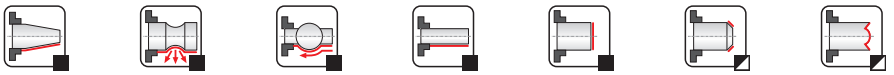
External Lever Lock Tool Holder for Round RC.. Inserts

External Right/Left hand lever lock tool holder for positive RC.. inserts. Suited for external face and longitudinal turning without shoulder, copy turning up to 27°, taper and chamfer turning, including face copy turning. Body treated for longer tool life.









	Product	H (mm)	B (mm)	HF (mm)	WF (mm)	LF (mm)	LAMS (°)	GAMO (°)	lbs			MID
R	PRSCR 3225 P 16	32	25	32	32	170	0	0	2.31	GI090	PR01	6757185
	PRSCR 4040 S 16	40	40	40	50	250	0	0	6.61	GI090	PR01	8281355
	PRSCR 3232 P 20	32	32	32	40	170	0	0	2.85	GI069	PR03	6757174
	PRSCR 4040 S 25	40	40	40	50	250	0	0	6.71	GI122	PR02	6758534
L	PRSCL 3225 P 16	32	25	32	32	170	0	0	1.98	GI090	PR01	6757179
	PRSCL 4040 S 16	40	40	40	50	250	0	0	5.25	GI090	PR01	8281354
	PRSCL 3232 P 20	32	32	32	40	170	0	0	2.91	GI069	PR03	6757180
	PRSCL 4040 S 25	40	40	40	50	250	0	0	6.76	GI122	PR02	6758533

GI069	RCMX 2006M0
GI090	RCMX 1606M0
GI122	RCMX 2507M0

				Nm					
PR01	PRS 816	CL 116	CS 706	2.0	M 6x1	0.815	TR 16	MT 05	HXK 2.5
PR02	PRS 825	CL 125	CS 710	3.5	M 10x1	1.197	TR 19	MT 06	HXK 4
PR03	PRS 820	CL 120	CS 708	3.0	M 8x1	0.925	TR 15	MT 07	HXK 3

SRDC(RL) EXT

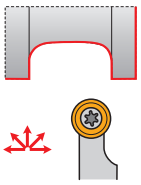
P M K N S H

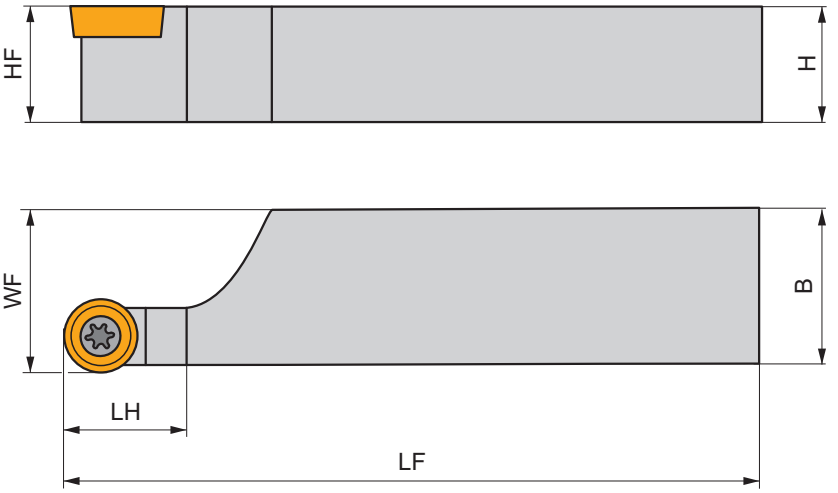
PRAMET

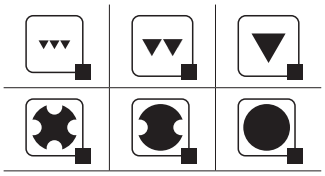
S

External Screw Lock Tool Holder for Round RC.. Inserts

External Right/Left hand tool holder for screw type positive RC.. inserts. Suited for external face and longitudinal turning without shoulder, taper and chamfer turning. Body treated for longer tool life.







	Product	H (mm)	B (mm)	HF (mm)	WF (mm)	LF (mm)	LH (mm)	LAMS (°)	GAMO (°)	lbs			MID
R	SRDCR 2020 K 08-A	20	20	20	20.5	125	20.0	0	0	.80	GI051	SR21	6760489
	SRDCR 2525 M 08-A	25	25	25	25.5	150	20.0	0	0	1.46	GI051	SR21	6760490
	SRDCR 3225 P 08-A	32	25	32	25.5	170	20.0	0	0	2.09	GI051	SR21	6760491
L	SRDCL 2020 K 08-A	20	20	20	20.5	125	20.0	0	0	.81	GI051	SR21	6760486
	SRDCL 2525 M 08-A	25	25	25	25.5	150	20.0	0	0	1.46	GI051	SR21	6760487
	SRDCL 3225 P 08-A	32	25	32	25.5	170	20.0	0	0	2.12	GI051	SR21	6760488

GI051	RC.. 0803M0

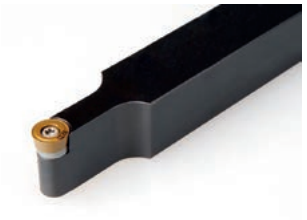
		Nm			
SR21	5513 020-04	1.5	M 3	0.283	PT-8002

SRDCN EXT

P M K N S H

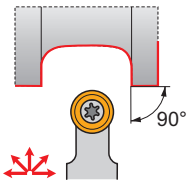
PRAMET

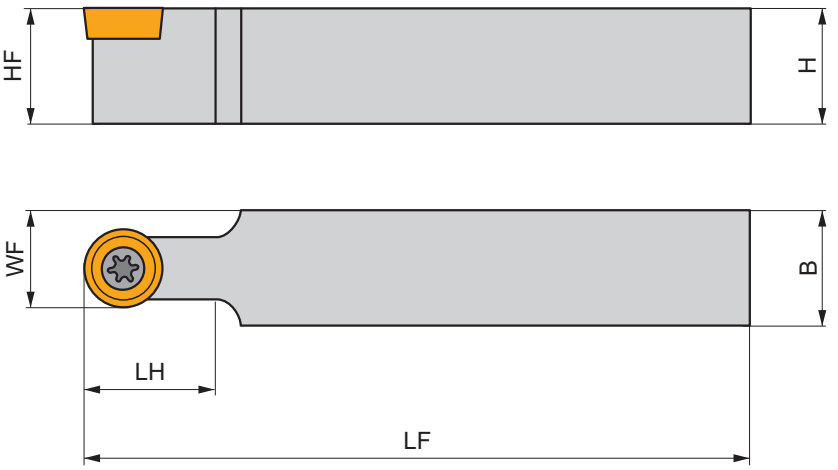
S

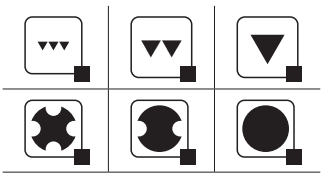


External Screw Lock Tool Holder for Round RC.. Inserts

External neutral tool holder for screw type positive RC.. inserts. Suited for external face and longitudinal turning without shoulder, copy, taper and chamfer turning. Body treated for longer tool life.







	Product	H (mm)	B (mm)	HF (mm)	WF (mm)	LF (mm)	LH (mm)	LAMS (°)	GAMO (°)	lbs			MID
N	**SRDCN 1212 F 06**	12	12	12	9	80	12.0	0	0	.22	GI054	S01	6757150
	SRDCN 1616 H 06	16	16	16	11	100	12.0	0	0	.43	GI054	S01	6756811
	SRDCN 2020 K 08	20	20	20	14	125	20.0	0	0	.82	GI051	S03	6757097
	SRDCN 2020 K 1003-M-A	20	20	20	15	125	25.0	0	0	.83	GI064	SR10	6756875
	SRDCN 2020 K 10-M-A	20	20	20	15	125	25.0	0	0	.81	GI013	SR10	6756588
	SRDCN 2525 M 10-M-A	25	25	25	17.5	150	25.0	0	0	1.47	GI013	SR10	6756589
	SRDCN 2525 M 12-M-A	25	25	25	18.5	150	30.0	0	0	1.48	GI014	SR12	6756590
	SRDCN 3225 P 10-M	32	25	32	17.5	170	25.0	0	0	1.98	GI013	SR10	6758436
	SRDCN 3225 P 12-M	32	25	32	18.5	170	30.0	0	0	1.98	GI014	SR12	6758437
	SRDCN 3225 P 16-M	32	25	32	20.5	170	32.0	0	0	2.21	GI161	SR16	6758444

GI013	RC.. 10T3M0
GI014	RC.. 1204M0
GI051	RC.. 0803M0
GI054	RC.. 0602M0
GI064	RC.. 1003M0
GI161	RC.. 1606M0

		Nm						
S01	US 2506-T07P	0.9	M 2.5	0.248	–	–	FLAG T07P	–
S03	US 3007-T09P	2.0	M 3	0.287	–	–	FLAG T09P	–
SR10	US 3510-T15P	3.0	M 3.5	0.417	SRN 100300	MS 3510	FLAG T15P	HXK 3.5
SR12	US 3510-T15P	3.0	M 3.5	0.417	SRN 120300	MS 3510	FLAG T15P	HXK 3.5
SR16	US 5018-T20P	5.0	M 5	0.717	SRN 16T3M0	MS 5015	FLAG T20P	HXK 5

SRSC(RL) EXT

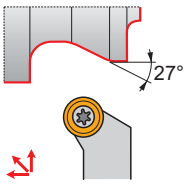
P M K N S H

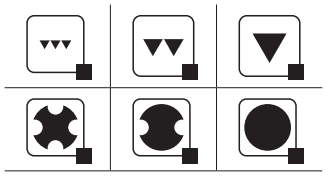
PRAMET

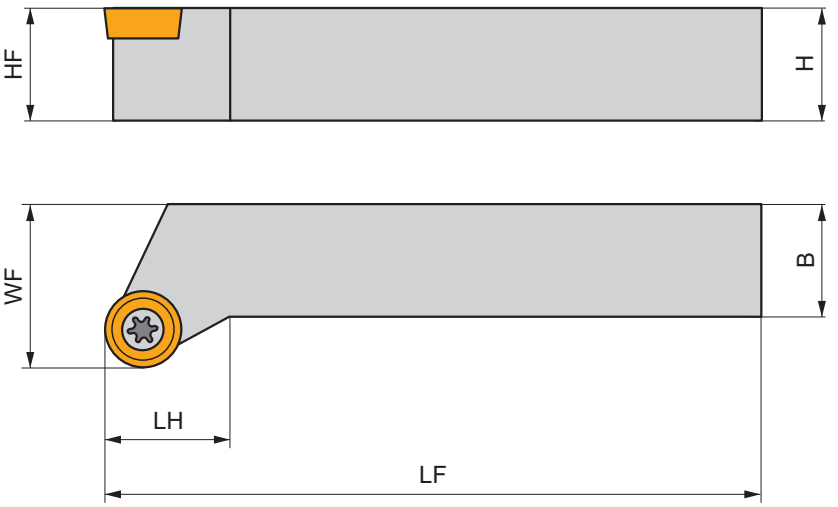
S

External Screw Lock Tool Holder for Round RC.. Inserts

External Right/Left hand tool holder for screw type positive RC.. inserts. Suited for external face and longitudinal turning without shoulder, copy, taper and chamfer turning. Body treated for longer tool life.







	Product	H (mm)	B (mm)	HF (mm)	WF (mm)	LF (mm)	LH (mm)	LAMS (°)	GAMO (°)	lbs			MID
R	SRSCR 1212 F 06	12	12	12	16	80	12.0	0	0	.20	GI054	S01	6756873
	SRSCR 1616 H 06	16	16	16	20	100	12.0	0	0	.47	GI054	S01	6756785
	SRSCR 2020 K 08	20	20	20	25	125	20.0	0	0	.88	GI051	S03	6756780
	SRSCR 2020 K 10-M-A	20	20	20	25	125	20.0	0	0	.90	GI013	SR10	6756594
	SRSCR 2525 M 10-M-A	25	25	25	32	150	20.0	0	0	1.65	GI013	SR10	6756595
	SRSCR 3225 P 10-M	32	25	32	32	170	20.0	0	0	2.34	GI013	SR10	6758438
	SRSCR 2525 M 12-M-A	25	25	25	32	150	20.0	0	0	1.65	GI014	SR12	6756596
	SRSCR 3225 P 16-M	32	25	32	32	170	20.0	0	0	2.39	GI161	SR16	6758442
L	SRSCL 1212 F 06	12	12	12	16	80	12.0	0	0	.22	GI054	S01	6756994
	SRSCL 1616 H 06	16	16	16	20	100	12.0	0	0	.49	GI054	S01	6757213
	SRSCL 2020 K 08	20	20	20	25	125	20.0	0	0	.99	GI051	S03	6756889
	SRSCL 2020 K 10-M-A	20	20	20	25	125	20.0	0	0	.92	GI013	SR10	6756591
	SRSCL 2525 M 10-M-A	25	25	25	32	150	20.0	0	0	1.64	GI013	SR10	6756592
	SRSCL 3225 P 10-M	32	25	32	32	170	20.0	0	0	2.34	GI013	SR10	6758439
	SRSCL 2525 M 12-M-A	25	25	25	32	150	20.0	0	0	1.65	GI014	SR12	6756593
	SRSCL 3225 P 16-M	32	25	32	32	170	20.0	0	0	2.38	GI161	SR16	6758443

GI013	RC.. 10T3M0
GI014	RC.. 1204M0
GI051	RC.. 0803M0
GI054	RC.. 0602M0

GI161	RC.. 1606M0

		Nm						
S01	US 2506-T07P	0.9	M 2.5	0.248	–	–	FLAG T07P	–
S03	US 3007-T09P	2.0	M 3	0.287	–	–	FLAG T09P	–
SR10	US 3510-T15P	3.0	M 3.5	0.417	SRN 100300	MS 3510	FLAG T15P	HXK 3.5
SR12	US 3510-T15P	3.0	M 3.5	0.417	SRN 120300	MS 3510	FLAG T15P	HXK 3.5
SR16	US 5018-T20P	5.0	M 5	0.717	SRN 16T3M0	MS 5015	FLAG T20P	HXK 5

C.-SRDCN EXT

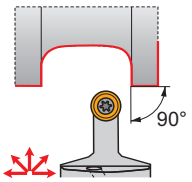
P M K N S H

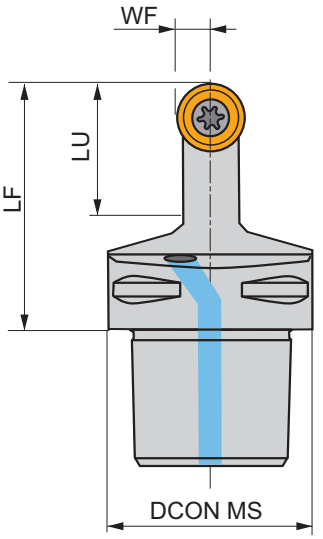
PRAMET

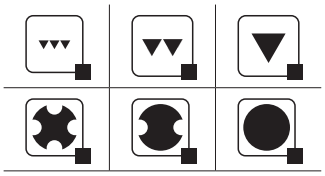
S

External PSC Quick Change Tool, Screw Lock for RC.. Inserts

External neutral tool, through coolant, for screw type positive RC.. inserts. Suited for external face and longitudinal turning without shoulder, copy, taper and chamfer turning. Polygon Shank Coupling. Body treated for longer tool life.







	Product	DCON MS (mm)	WF (mm)	LF (mm)	LU (mm)	LAMS (°)	GAMO (°)		lbs			MID
N	C4-SRDCN-00050-12A	40	6	50	28	0	0	✓	.70	GI014	C-SR12V-1	7809842
	C5-SRDCN-00060-10A	50	5	60	25	0	0	✓	1.24	GI013	C-SR10V	7809841
	C5-SRDCN-00060-12A	50	6	60	28	0	0	✓	1.24	GI014	C-SR12V-2	7809843

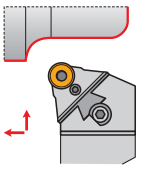
GI013	RC.. 10T3M0
GI014	RC.. 1204M0

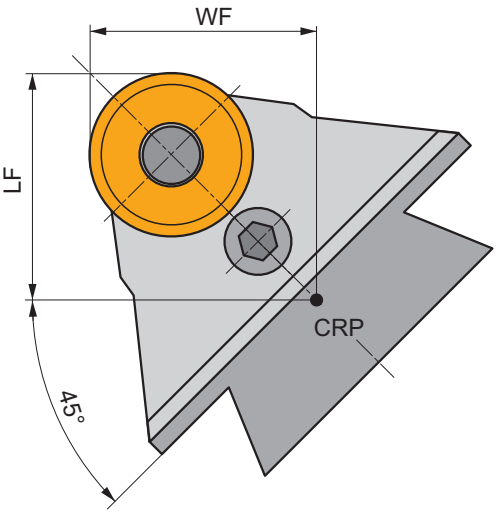
		Nm						
C-SR10V	US 2010-T15P	3.0	M 3.5	0.398	SRS 110-01	MS 9001	FLAG T15P/3,5	CN 034-02
C-SR12V-1	US 2001-T15P	3.0	M 3.5	0.476	SRS 110-02	MS 9001	FLAG T15P/3,5	CN 034-01
C-SR12V-2	US 2001-T15P	3.0	M 3.5	0.476	SRS 110-02	MS 9001	FLAG T15P/3,5	CN 034-02

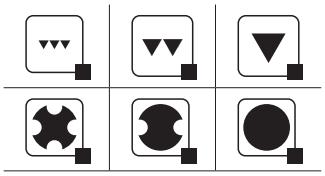
KHP-RSC(RL)

Modular KHP Lever Lock Turning Cartridge for RC.. Inserts

Dovetailed Right/Left hand lever lock turning cartridge for mounting on DKH tool holder shank. Suited for heavy longitudinal turning without shoulder, face turning, taper and chamfer turning with positive RC.. inserts. Tool holder treated for longer tool life.







	Product	WF (mm)	LF (mm)	LAMS (°)	GAMO (°)	lbs			MID
R	**KHP-RSCR 20**	35	45	0	0	2.76	GI069	PRP90	6757409
	KHP-RSCL 20	35	45	0	0	2.87	GI069	PRP90	6757403

GI069	RCMX 2006M0

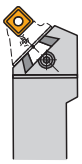
PRP90	RCU 200400	CL 120	US 36	6.0 Nm	M 8x1	1.024	NT 07	MT 07	HXK 4

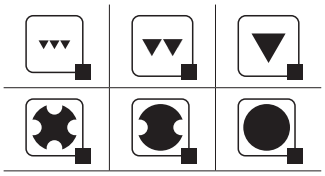
DKH(RL)

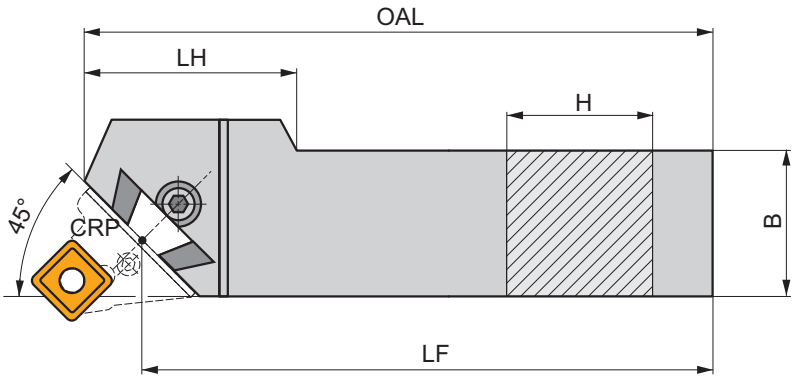
PRAMET

External Tool Holder Shank for KHP/KHS Heavy Turning Cartridges

Dovetailed Right/Left hand modular tool shank for KHP/KHS cartridges. Suited for heavy turning applications. Body treated for longer tool life.







	Product	H (mm)	B (mm)	LF (mm)	OAL (mm)	LH (mm)	lbs			MID
R	**DKHR 4050 V**	40	50	400	425	100.0	15.65	GI098	DKH10	6757384
	DKHR 5060 W	50	60	450	475	110.0	24.91	GI098	DKH10	6757219
	DKHR 6080 W-A	60	80	450	485	90.0	43.32	GI098	DKH10	6758501
L	**DKHL 4050 V**	40	50	400	425	100.0	15.65	GI098	DKH10	6757385
	DKHL 5060 W	50	60	450	475	110.0	24.91	GI098	DKH10	6757220
	DKHL 6080 W-A	60	80	450	485	90.0	42.51	GI098	DKH10	6758516

GI098	KHP	KHS

DKH10	SR 14	HXK 10

SSBC(RL) EXT

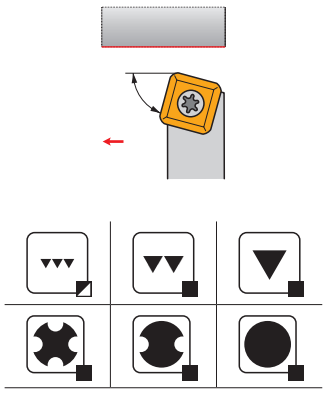
P M K N S H

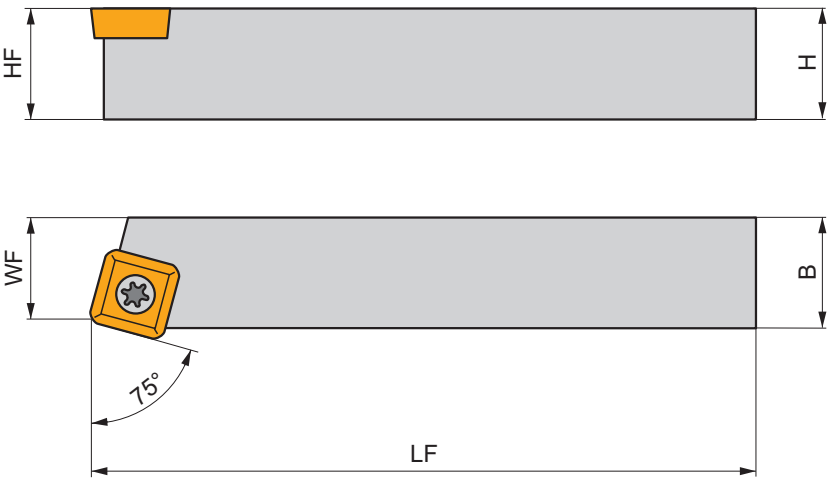
PRAMET

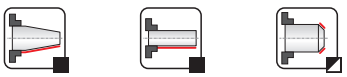
S

External Screw Lock Tool Holder with 75° Cutting Angle for SC.. Inserts

External Right/Left hand tool holder for screw type positive SC.. inserts. Suited for external longitudinal turning without shoulder, taper and chamfer turning. Body treated for longer tool life.







	Product	H (mm)	B (mm)	HF (mm)	WF (mm)	LF (mm)	LAMS (°)	GAMO (°)	lbs			MID
R	SSBCR 1212 F 09	12	12	12	11	80	0	0	.22	GI053	S08	6756887
	SSBCR 1616 H 09	16	16	16	13	100	0	0	.44	GI053	S08	6756784
	SSBCR 2020 K 12-M-A	20	20	20	17	125	0	0	.88	GI015	SS20	6756599
	SSBCR 2525 M 12-M-A	25	25	25	22	150	0	0	1.67	GI015	SS20	6756600
	SSBCR 4040 S 25	40	40	40	35	250	0	0	6.64	GI131	SS25	6757890
	SSBCR 5050 T 25	50	50	50	43	300	0	0	12.46	GI131	SS25	6757892
	SSBCR 5050 T 38-A	50	50	50	43	300	0	0	10.67	GI164	SS38A	6759703
	SSBCR 6060 V 38-A	60	60	60	53	400	0	0	24.47	GI164	SS38A	6759657
L	SSBCL 1212 F 09	12	12	12	11	80	0	0	.21	GI053	S08	6757214
	SSBCL 1616 H 09	16	16	16	13	100	0	0	.48	GI053	S08	6756993
	SSBCL 2020 K 12-M-A	20	20	20	17	125	0	0	.88	GI015	SS20	6756597
	SSBCL 2525 M 12-M-A	25	25	25	22	150	0	0	1.54	GI015	SS20	6756598
	SSBCL 4040 S 25	40	40	40	35	250	0	0	6.64	GI131	SS25	6757891
	SSBCL 5050 T 25	50	50	50	43	300	0	0	12.46	GI131	SS25	6757893
	SSBCL 5050 T 38-A	50	50	50	43	300	0	0	12.74	GI164	SS38A	6759704
	SSBCL 6060 V 38-A	60	60	60	53	400	0	0	24.60	GI164	SS38A	6759638

GI015	SC.. 43.. (SC.. 1204..)
GI053	SC.. 32.5.. (SC.. 09T3..)
GI131	SC.. 86.. (SC.. 2509..)
GI164	SC.. 126.. (SC.. 3809..)

		Nm							
S08	US 3510-T15P	3.0	M 3.5	0.417	–	–	FLAG T15P	–	–
SS20	US 5012-T15P	5.0	M 5	0.48	SSN 120304	MS 5008	FLAG T15P	HXK 5	–
SS25	US 8025-T30P	13.0	M 8	0.953	SSN 250620	MS 8020	–	HXK 5	SDR T30P
SS38A	US 8025-T30P	13.0	M 8	0.953	SSN 380920	MS 8020	–	HXK 5	SDR T30P

SSDCN EXT

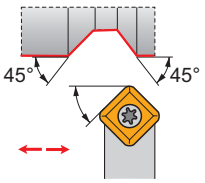
P M K N S H

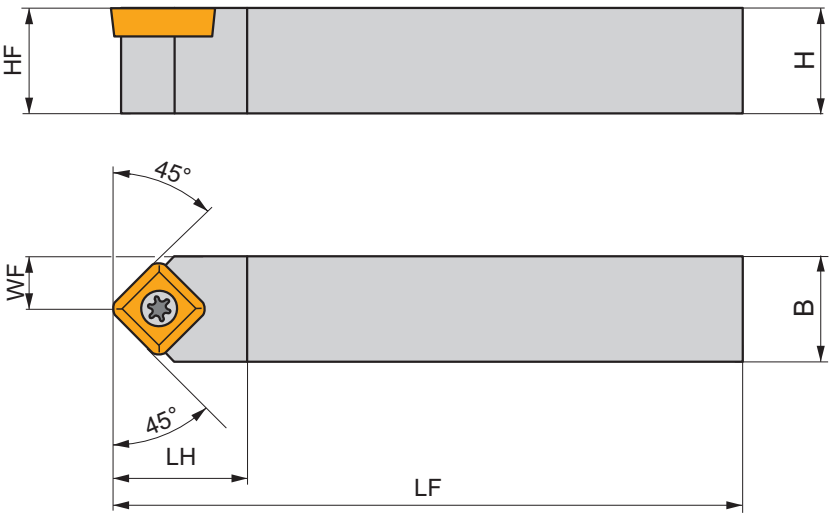
PRAMET

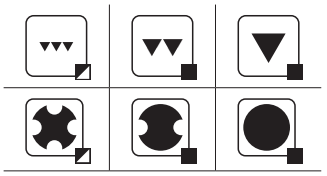
S

External Screw Lock Tool Holder with 45° Cutting Angle for SC.. Inserts

External neutral tool holder for screw type positive SC.. inserts. Suited for external longitudinal turning without shoulder, copy, taper and chamfer turning. Body treated for longer tool life.







	Product	H (mm)	B (mm)	HF (mm)	WF (mm)	LF (mm)	LH (mm)	LAMS (°)	GAMO (°)	lbs			MID
N	SSDCN 1212 F 09	12	12	12	6	80	–	0	0	.24	GI053	S08	6756823
	SSDCN 1616 H 09	16	16	16	8	100	–	0	0	.44	GI053	S08	6756802
	SSDCN 2020 K 12-M-A	20	20	20	10	125	–	0	0	.91	GI015	SS20	6756601
	SSDCN 2525 M 12-M-A	25	25	25	12.5	150	–	0	0	1.63	GI015	SS20	6756602

GI015	SC.. 43.. (SC.. 1204..)
GI053	SC.. 32.5.. (SC.. 09T3..)

		Nm						
S08	US 3510-T15P	3.0	M 3.5	0.417	–	–	FLAG T15P	–
SS20	US 5012-T15P	5.0	M 5	0.48	SSN 120304	MS 5008	FLAG T15P	HXK 5

ISSDCN EXT

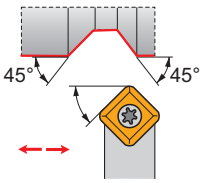
P M K N S H

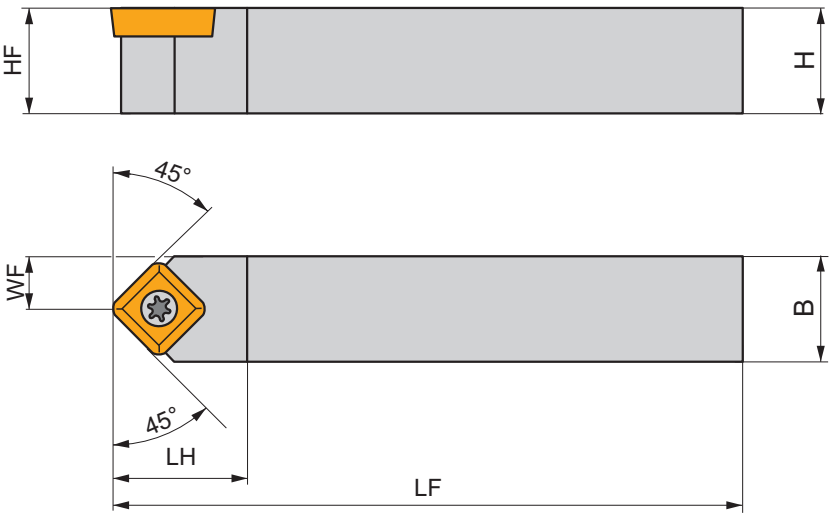
PRAMET

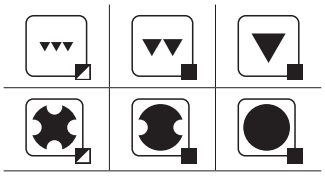
S

External Screw Lock Tool Holder with 45° Cutting Angle for SC.. Inserts

External neutral tool holder for screw type positive SC.. inserts. Suited for external longitudinal turning without shoulder, copy, taper and chamfer turning. Body treated for longer tool life.







	Product	H (inch)	B (inch)	HF (inch)	WF (inch)	LF (inch)	LH (inch)	LAMS (°)	GAMO (°)	lbs			MID
N	SSDCN 08 3	.500	.500	.500	.261	3.500	.594	0	0	.33	GI053	SS09	6788674

GI053	SC.. 32.5.. (SC.. 09T3..)

SS09	US 2010-T15P	3.0	M 3.5	0.398	FLAG T15P/3,5

SSKC(RL) EXT

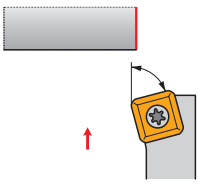
P M K N S H

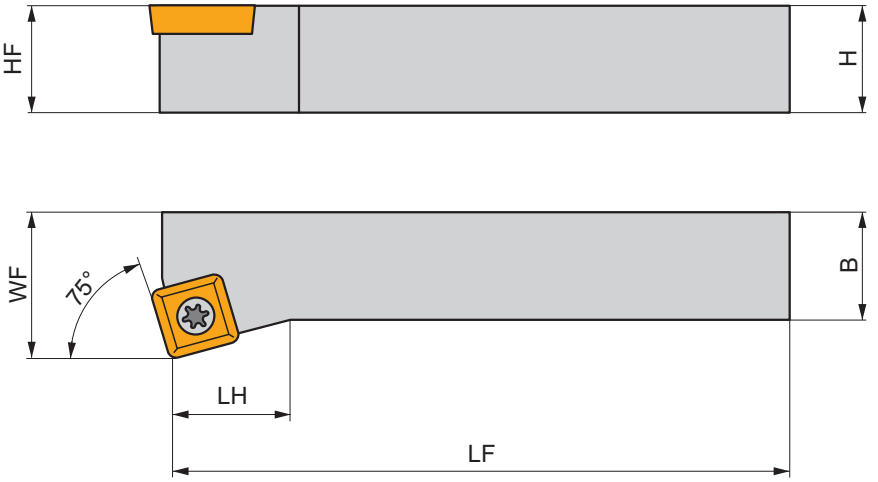
PRAMET

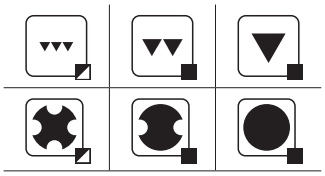
S

Ext. Screw Lock Tool Holder, 75° (Face Turning) Cutting Angle for SC.. Insert

External Right/Left hand tool holder for screw type positive SC.. inserts. Suited for external face turning without shoulder and chamfer turning. Body treated for longer tool life.







	Product	H (mm)	B (mm)	HF (mm)	WF (mm)	LF (mm)	LH (mm)	LAMS (°)	GAMO (°)	lbs			MID
R	**SSKCR 1212 F 09**	12	12	12	16	80	32.0	0	0	.22	GI053	S08	6756888
	SSKCR 1616 H 09	16	16	16	20	100	32.0	0	0	.55	GI053	S08	6756840
	SSKCR 2020 K 12-M-A	20	20	20	25	125	36.0	0	0	1.65	GI015	SS20	6756605
	SSKCR 2525 M 12-M-A	25	25	25	32	150	36.0	0	0	1.65	GI015	SS20	6756606

GI015	SC.. 43.. (SC.. 1204..)
GI053	SC.. 32.5.. (SC.. 09T3..)

		Nm						
S08	US 3510-T15P	3.0	M 3.5	0.417	–	–	FLAG T15P	–
SS20	US 5012-T15P	5.0	M 5	0.48	SSN 120304	MS 5008	FLAG T15P	HXK 5

SSSC(RL) INT

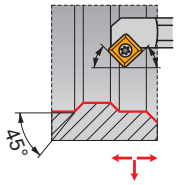
P M K N S H

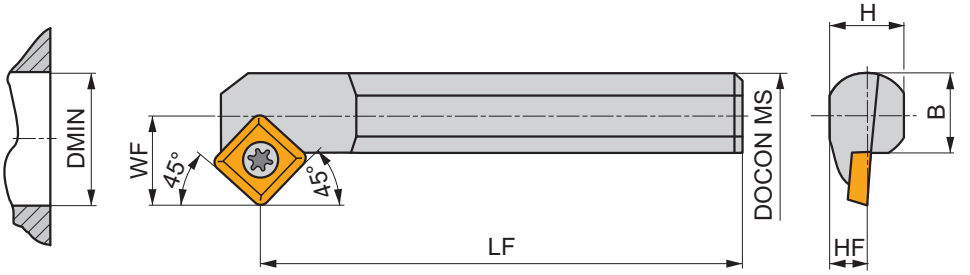
PRAMET

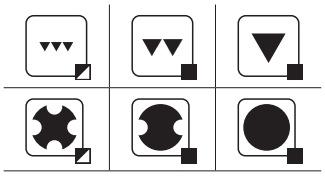
S

Internal Screw Lock Boring Bar with 45° Cutting Angle for SC.. Inserts

Internal Right/Left hand boring bar with 45° cutting angle for screw type SC.. inserts. For internal back chamfer, taper, multi-directional, chamfer and longitudinal turning without shoulder. Body treated for longer tool life.







	Product	DCON MS (mm)	DMIN (mm)	WF (mm)	H (mm)	B (mm)	LF (mm)	LAMS (°)	GAMO (°)	lbs			MID
R	**S20S-SSSCR 09**	20	25	13	18	18.5	250	-5	0	1.32	GI053	S04	6757069
	S25T-SSSCR 09	25	32	17	23	23	300	-3	0	2.43	GI053	S04	6757095
L	**S20S-SSSCL 09**	20	25	13	18	18.5	250	-5	0	1.35	GI053	S04	6756854
	S25T-SSSCL 09	25	32	17	23	23	300	-3	0	2.43	GI053	S04	6757094

GI053	SC.. 32.5.. (SC.. 09T3..)

S04	US 3510-T15P	3.0 Nm	M 3.5	0.417	FLAG T15P

KHS-SBC(RL)

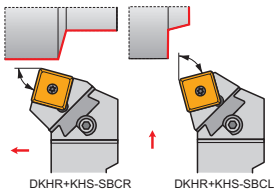
P M K

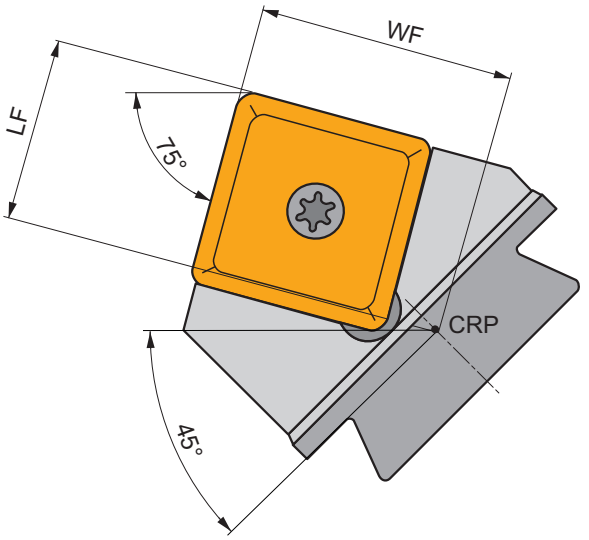
PRAMET

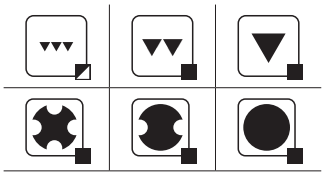
S

Modular KHS Screw Clamp Turning Cartridge 75° Cutting Angle for SC.. Inserts

Dovetailed Right/Left hand screw lock turning cartridge, 75° cutting angle, for mounting on DKH tool holder shank. Suited for heavy longitudinal turning without shoulder, face turning, taper and chamfer turning with positive SC.. inserts Tool holder treated for longer tool life.







	Product	WF (mm)	LF (mm)	LAMS (°)	GAMO (°)	lbs			MID
R	KHS-SBCR 25	47	36	0	0	3.31	GI131	SS26	6758301
	KHS-SBCR 38-A	47	36	0	0	3.25	GI164	SS38	6758503
L	KHS-SBCL 25	47	36	0	0	3.20	GI131	SS26	6758300
	KHS-SBCL 38-A	47	36	0	0	3.26	GI164	SS38	6758514

GI131	SC.. 86.. (SC.. 2509..)
GI164	SC.. 126.. (SC.. 3809..)

		Nm						
SS26	US 8025-T30P	13.0	M 8	0.953	SSN 250620	MS 8020	SDR T30P	HXK 5
SS38	US 8025-T30P	13.0	M 8	0.953	SSN 380620	MS 8020	SDR T30P	HXK 5

STAC(RL) EXT

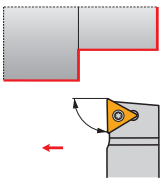
P M K N S H

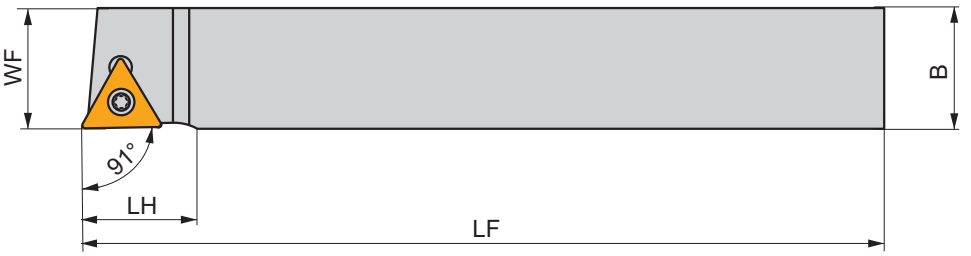
PRAMET

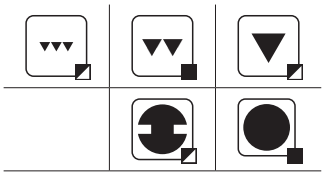
S

External Screw Lock Tool Holder with 91° Cutting Angle for TC.. Inserts

External Right/Left hand tool holder for screw type positive TC.. inserts. Suited for external longitudinal shoulder, taper and chamfer turning and usable for sliding head machines. Body treated for longer tool life.







	Product	H (mm)	B (mm)	HF (mm)	WF (mm)	LF (mm)	LH (mm)	LAMS (°)	GAMO (°)	lbs	GI056	S01	MID
R	STACR 1212 K 11-S	12	12	12	12	125	15.2	0	0	.30	GI056	S01	8181055
	STACR 1616 K 11-S	16	16	16	16	125	15.2	0	0	.54	GI056	S01	8181056
L	STACL 1212 K 11-S	12	12	12	12	125	15.2	0	0	.30	GI056	S01	8181053
	STACL 1616 K 11-S	16	16	16	16	125	15.2	0	0	.54	GI056	S01	8181054

GI056	TC.. 21.5.. (TC.. 1102..)

S01	US 2506-T07P	0.9	M 2.5	0.248	FLAG T07P

STFC(RL) EXT

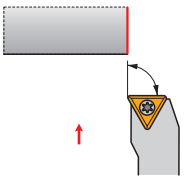
P M K N S H

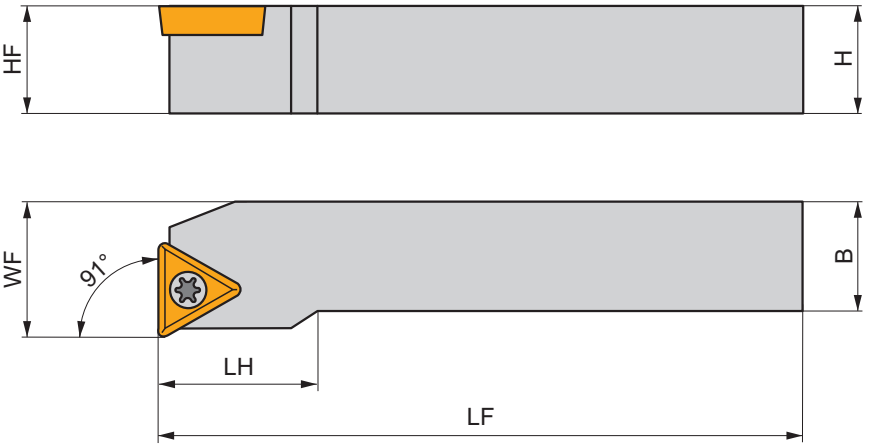
PRAMET

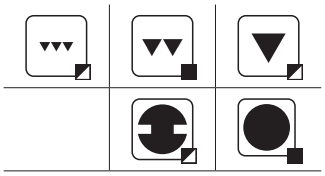
S

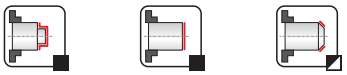
Ext. Screw Lock Tool Holder, 91° (Face Turning) Cutting Angle for TC.. Inserts

External Right/Left hand tool holder for screw type positive TC.. inserts. Suited for external face turning with shoulder and chamfer turning. Body treated for longer tool life.









	Product	H (mm)	B (mm)	HF (mm)	WF (mm)	LF (mm)	LH (mm)	LAMS (°)	GAMO (°)	lbs			MID
R	STFCR 1616 H 11	16	16	16	20	100	18.0	0	0	.45	GI056	S01	6756805
	STFCR 2020 K 16-M-A	20	20	20	25	125	25.0	0	0	.88	GI016	ST10	6756609
	STFCR 2525 M 16-M-A	25	25	25	32	150	25.0	0	0	1.66	GI016	ST10	6756610
L	STFCL 1616 H 11	16	16	16	20	100	18.0	0	0	.49	GI056	S01	6756788
	STFCL 2020 K 16-M-A	20	20	20	25	125	25.0	0	0	.88	GI016	ST10	6756607
	STFCL 2525 M 16-M-A	25	25	25	32	150	25.0	0	0	1.65	GI016	ST10	6756608

GI016	TC.. 32.5.. (TC.. 16T3..)
GI056	TC.. 21.5.. (TC.. 1102..)

		Nm						
S01	US 2506-T07P	0.9	M 2.5	0.248	–	–	FLAG T07P	–
ST10	US 3510-T15P	3.0	M 3.5	0.417	STN 160308	MS 3510	FLAG T15P	HXK 3.5

STFC(RL)-A EXT

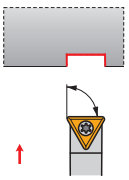
P M K N S H

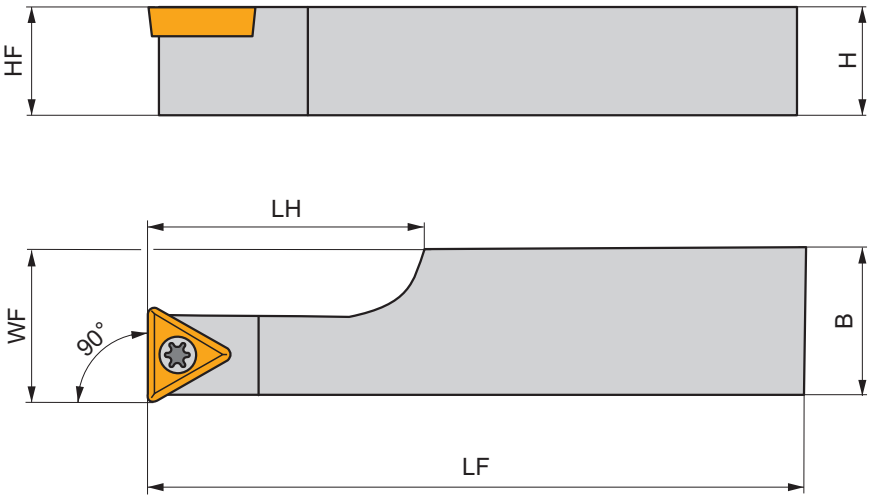
PRAMET

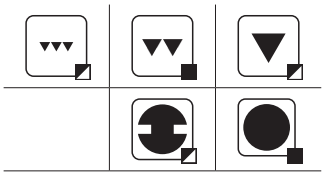
S

Ext. Screw Lock Tool Holder, 90° (Face Turning) Cutting Angle for TC.. Inserts

External Right/Left hand tool holder for screw type positive TC.. inserts. Suited for left and right-sided external face turning with shoulder and chamfer turning. Body treated for longer tool life.







	Product	H (mm)	B (mm)	HF (mm)	WF (mm)	LF (mm)	LH (mm)	LAMS (°)	GAMO (°)	lbs			MID
R	STFCR 2020 K 11-A	20	20	20	25	125	21.3	0	0	.82	GI056	ST21	6760493
L	STFCL 2020 K 11-A	20	20	20	25	125	21.3	0	0	.80	GI056	ST21	6760492

GI056	TC.. 21.5.. (TC.. 1102..)

ST21	5513 020-03	0.8	M 2.5	0.256	PT-8001

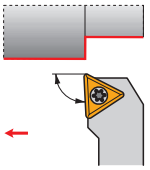
ISTGC(RL) EXT

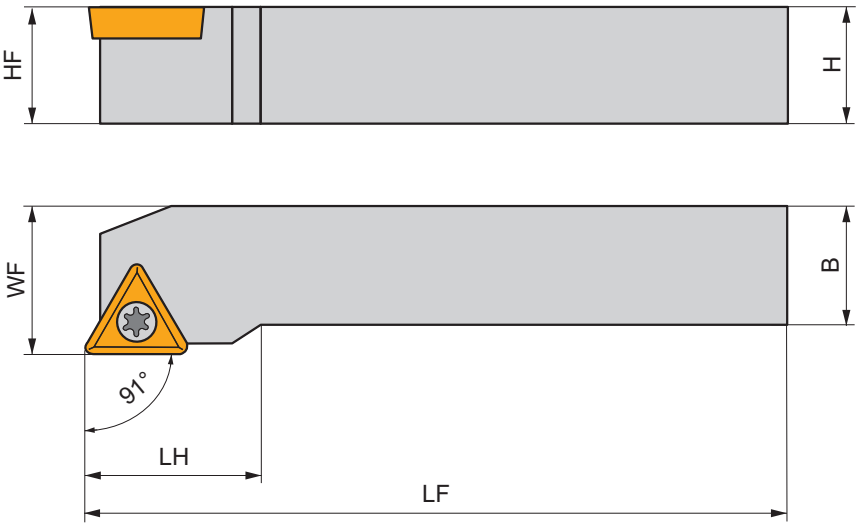
P M K N S H

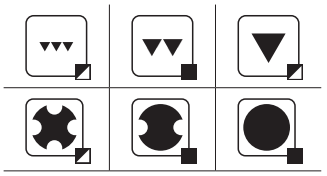
PRAMET

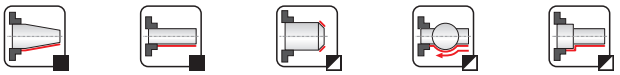
External Screw Lock Tool Holder with 91° Cutting Angle for TC.. Inserts

External Right/Left hand tool holder for screw type positive TC.. inserts. Suited for external longitudinal turning with shoulder, taper, copy and chamfer turning. Body treated for longer tool life.









	Product	H (inch)	B (inch)	HF (inch)	WF (inch)	LF (inch)	LH (inch)	LAMS (°)	GAMO (°)	lbs			MID
R	**STGCR 08 2**	.500	.500	.500	.625	3.500	.543	0	0	.33	GI056	ST11	6788679
	STGCR 12 3B	.750	.750	.750	1.000	4.500	.815	0	0	.88	GI016	ST16	6788680
	STGCR 16 3D	1.000	1.000	1.000	1.250	6.000	.815	0	0	1.54	GI016	ST16	6788681
L	**STGCL 08 2**	.500	.500	.500	.625	3.500	.543	0	0	.33	GI056	ST11	6788676
	STGCL 12 3B	.750	.750	.750	1.000	4.500	.815	0	0	.88	GI016	ST16	6788677
	STGCL 16 3D	1.000	1.000	1.000	1.250	6.000	.815	0	0	1.54	GI016	ST16	6788678

GI016	TC.. 32.5.. (TC.. 16T3..)
GI056	TC.. 21.5.. (TC.. 1102..)

		Nm					
ST11	US 2003-T07P	0.8	M 2.5	0.256	–	–	FLAG T07P
ST16	US 2001-T15P	3.0	M 3.5	0.476	STS 320-01	MS 9001	FLAG T15P/3,5

STJC(RL) EXT

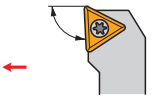
P M K N S H

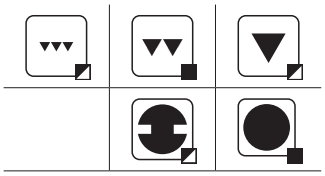
PRAMET

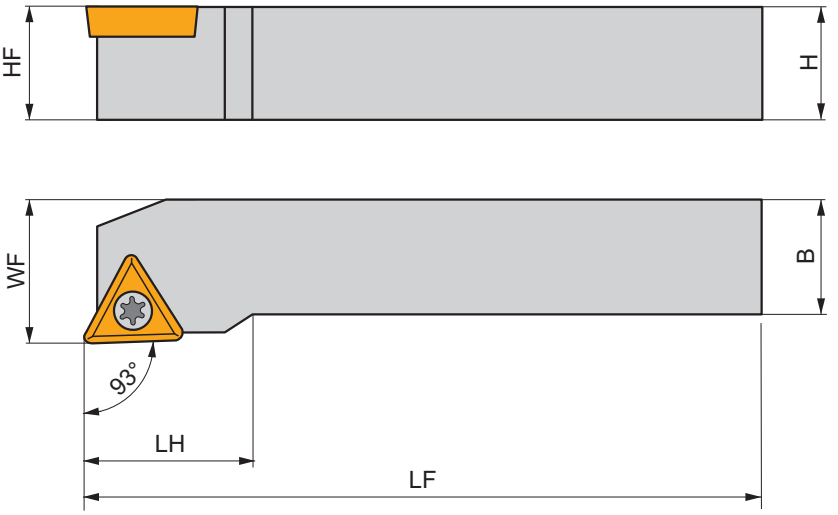
S

External Screw Lock Tool Holder with 93° Cutting Angle for TC.. Inserts

External Right/Left hand tool holder for screw type positive TC.. inserts. Suited for external longitudinal turning with shoulder, taper and chamfer turning. Body treated for longer tool life.







	Product	H (mm)	B (mm)	HF (mm)	WF (mm)	LF (mm)	LH (mm)	LAMS (°)	GAMO (°)	lbs			MID
R	STJCR 1616 H 11	16	16	16	20	100	18.0	0	0	.48	GI056	S01	6756806
	STJCR 2020 K 16-M-A	20	20	20	25	125	25.0	0	0	.95	GI016	ST10	6756613
	STJCR 2525 M 16-M-A	25	25	25	32	150	25.0	0	0	1.68	GI016	ST10	6756614
L	STJCL 1616 H 11	16	16	16	20	100	18.0	0	0	.49	GI056	S01	6756791
	STJCL 2020 K 16-M-A	20	20	20	25	125	25.0	0	0	.95	GI016	ST10	6756611
	STJCL 2525 M 16-M-A	25	25	25	32	150	25.0	0	0	1.65	GI016	ST10	6756612

GI016	TC.. 32.5.. (TC.. 16T3..)
GI056	TC.. 21.5.. (TC.. 1102..)

		Nm						
S01	US 2506-T07P	0.9	M 2.5	0.248	–	–	FLAG T07P	–
ST10	US 3510-T15P	3.0	M 3.5	0.417	STN 160308	MS 3510	FLAG T15P	HXK 3.5

STFC(RL) INT

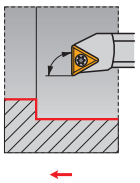
P M K N S H

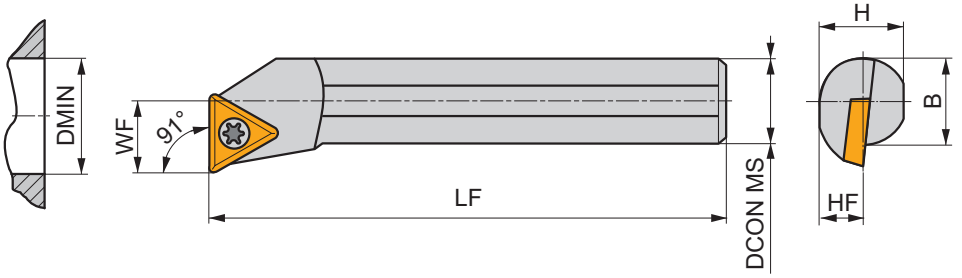
PRAMET

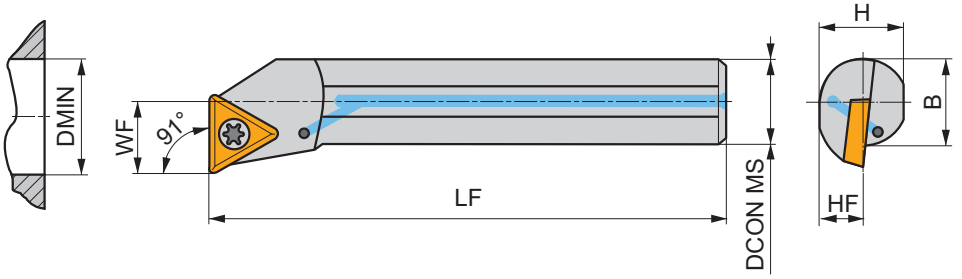
S

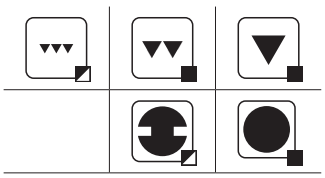
Internal Screw Lock Boring Bar with 91° Cutting Angle for TC.. Inserts

Internal Right/Left hand boring bar, through coolant available, 91° cutting angle for screw type TC.. inserts. Suited for internal taper and longitudinal turning with shoulder and chamfer turning. Body treated for longer tool life.









	Product	DCON MS (mm)	DMIN (mm)	WF (mm)	H (mm)	B (mm)	LF (mm)	LAMS (°)	GAMO (°)		lbs			MID
R	A06F-STFCR 06	6	8.5	4.5	5	–	80	-12	0	✓	.04	GI217	ST12	6760912
	A08H-STFCR 06	8	11	5.9	7	–	100	-10	0	✓	.12	GI217	ST13	6760914
	A10K-STFCR 09	10	13	7	9	–	125	-9	0	✓	.13	GI218	ST14	6760916
	A12M-STFCR 09	12	16	9	11	–	150	-6.5	0	✓	.26	GI218	ST14	6760918
	S10H-STFCR 11	10	13	7	9	9.5	100	-10	0	–	.17	GI056	S02	6756911
	A12M-STFCR 11	12	16	9	11	11.5	150	-10	0	✓	.30	GI056	S01	6761011
	S12K-STFCR 11	12	16	9	11	11.5	125	-7	0	–	.28	GI056	S01	6757052
	A16R-STFCR 11	16	20	11	14.5	15	200	-7	0	✓	.67	GI056	S01	6761013
	S16M-STFCR 11	16	20	11	14.5	15	150	-7	0	–	.53	GI056	S01	6756913
	A20S-STFCR 11	20	25	13	18	18.5	250	-7	0	✓	1.17	GI056	S01	6761015
	S20Q-STFCR 11	20	25	13	18	18.5	180	-7	0	–	.88	GI056	S01	6756894
	A25R-STFCR 16	25	32	17	23	23	200	-3	0	✓	1.43	GI016	S08	6761017
	S25T-STFCR 16	25	32	17	23	23	300	-3	0	–	2.38	GI016	S08	6757110
	A32S-STFCR 16	32	40	22	30	30	250	-10	0	✓	2.97	GI016	ST10	6761019
	S32U-STFCR 16-A	32	40	22	30	30	350	-10	0	–	4.63	GI016	ST10	6756657
L	A06F-STFCL 06	6	8.5	4.5	5	–	80	-12	0	✓	.06	GI217	ST12	6760911
	A08H-STFCL 06	8	11	5.9	7	–	100	-10	0	✓	.11	GI217	ST13	6760913
	A10K-STFCL 09	10	13	7	9	–	125	-9	0	✓	.13	GI218	ST14	6760915
	A12M-STFCL 09	12	16	9	11	–	150	-6.5	0	✓	.07	GI218	ST14	6760917
	S10H-STFCL 11	10	13	7	9	9.5	100	-10	0	–	.13	GI056	S02	6756858
	A12M-STFCL 11	12	16	9	11	11.5	150	-10	0	✓	.26	GI056	S01	6761010
	S12K-STFCL 11	12	16	9	11	11.5	125	-7	0	–	.26	GI056	S01	6757091
	A16R-STFCL 11	16	20	11	14.5	15	200	-7	0	✓	.56	GI056	S01	6761012

	Product	DCON MS (mm)	DMIN (mm)	WF (mm)	H (mm)	B (mm)	LF (mm)	LAMS (°)	GAMO (°)		lbs			MID
L	**S16M-STFCL 11**	16	20	11	14.5	15	150	-7	0	–	.54	GI056	S01	6757227
	A20S-STFCL 11	20	25	13	18	18.5	250	-7	0	✓	1.12	GI056	S01	6761014
	A25R-STFCL 16	25	32	17	23	23	200	-3	0	✓	1.45	GI016	S08	6761016
	S25T-STFCL 16	25	32	17	23	23	300	-3	0	–	2.38	GI016	S08	6757011
	A32S-STFCL 16	32	40	22	30	30	250	-10	0	✓	2.99	GI016	ST10	6761018
	S32U-STFCL 16-A	32	40	22	30	30	350	-10	0	–	4.54	GI016	ST10	6756656

GI016	TC.. 32.5.. (TC.. 16T3..)
GI056	TC.. 21.5.. (TC.. 1102..)
GI217	TC.. 1.21.2.. (TC.. 06T1..)
GI218	TC.. 1.81.5.. (TC.. 0902..)

		Nm							
S01	US 2506-T07P	0.9	M 2.5	0.248	–	–	FLAG T07P	–	–
S02	US 2505-T07P	0.9	M 2.5	0.205	–	–	FLAG T07P	–	–
S08	US 3510-T15P	3.0	M 3.5	0.417	–	–	FLAG T15P	–	–
ST10	US 3510-T15P	3.0	M 3.5	0.417	STN 160308	MS 3510	FLAG T15P	HXK 3.5	–
ST12	5513 020-28	0.6	M 2	0.165	–	–	–	–	PT-8000
ST13	5513 020-27	0.6	M 2	0.193	–	–	–	–	PT-8000
ST14	5513 020-05	0.8	M 2.2	0.252	–	–	–	–	PT-8001

ISTFC(RL) INT

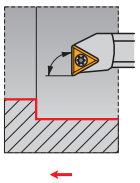
P M K N S H

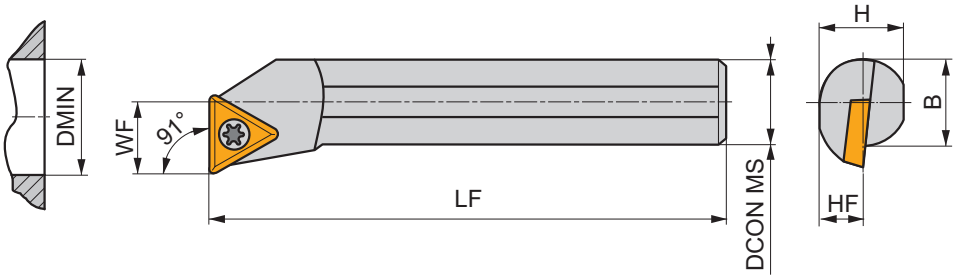
PRAMET

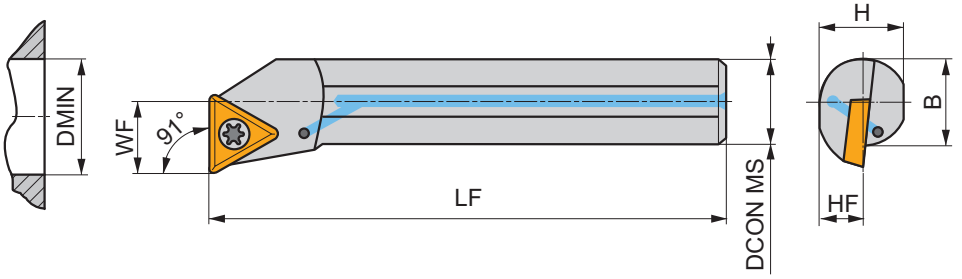
S

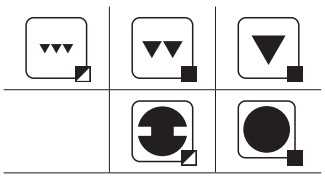
Internal Screw Lock Boring Bar with 91° Cutting Angle for TC.. Inserts

Internal Right/Left hand boring bar, through coolant available, 91° cutting angle for screw type TC.. inserts. Suited for internal taper and longitudinal turning with shoulder and chamfer turning. Body treated for longer tool life.









	Product	DCON MS (inch)	DMIN (inch)	WF (inch)	H (inch)	LF (inch)	LAMS (°)	GAMO (°)		lbs			MID
R	A08M-STFCR 2	.500	.598	.312	.460	6.000	-7	0	✓	.33	GI056	ST11	6788454
	A10R-STFCR 2	.625	.772	.406	.562	8.000	-5	0	✓	.66	GI056	ST11	6788462
	A12S-STFCR 2	.750	.929	.500	.709	10.000	-3	0	✓	1.21	GI056	ST11	6788475
	A16T-STFCR 3	1.000	1.201	.640	.906	12.000	-4	0	✓	1.54	GI016	ST16I	6788491
L	A08M-STFCL 2	.500	.598	.312	.460	6.000	-7	0	✓	.33	GI056	ST11	6788453
	A16T-STFCL 3	1.000	1.201	.640	.906	12.000	-4	0	✓	1.54	GI016	ST16I	6788490

GI016	TC.. 32.5.. (TC.. 16T3..)
GI056	TC.. 21.5.. (TC.. 1102..)

		Nm			
ST11	US 2003-T07P	0.8	M 2.5	0.256	FLAG T07P
ST16I	US 2010-T15P	3.0	M 3.5	0.398	FLAG T15P/3,5

STFC(RL)-E INT

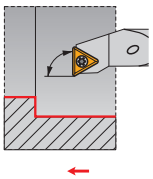
P M K N S H

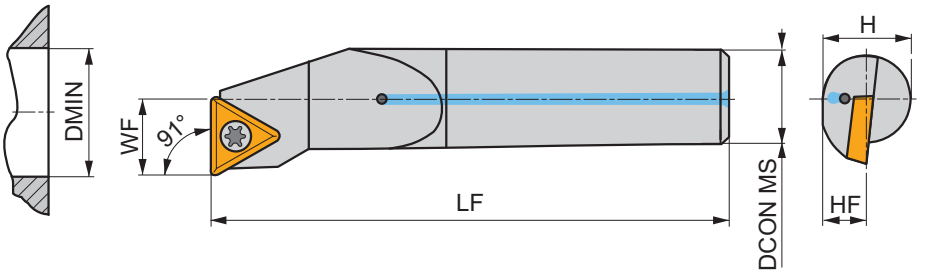
PRAMET

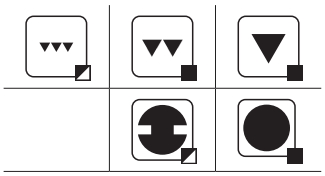
S

Internal Carbide Screw Lock Boring Bar with 91° Cutting Angle for TC.. Inserts

Internal Right/Left hand carbide boring bar, through coolant, with 91° cutting angle for screw type TC.. inserts. For internal taper and longitudinal turning with shoulder and chamfer turning. For tool overhang >3xD.







	Product	DCON MS (mm)	DMIN (mm)	WF (mm)	H (mm)	HF (mm)	LF (mm)	LAMS (°)	GAMO (°)		lbs			MID
R	E06H-STFCR 06-R	6	8.5	4.5	6	3	100	-10	0	✓	.12	GI217	ST22	6760495
	E08K-STFCR 06-R	8	11	5.9	8	4	125	-10	0	✓	.20	GI217	ST23	6760497
	E10M-STFCR 09-R	10	13	7	10	5	150	-8	0	✓	.33	GI218	ST24	6760501
	E12Q-STFCR 09-R	12	16	9	12	6	180	-6	0	✓	.56	GI218	ST24	6760505
	E16R-STFCR 11-R	16	20	11	16	8	200	-5	0	✓	1.05	GI056	ST21	6760509
L	E06H-STFCL 06-R	6	8.5	4.5	6	3	100	-10	0	✓	.12	GI217	ST22	6760494
	E08K-STFCL 06-R	8	11	5.9	8	4	125	-10	0	✓	.20	GI217	ST23	6760496
	E10M-STFCL 09-R	10	13	7	10	5	150	-8	0	✓	.34	GI218	ST24	6760500
	E12Q-STFCL 09-R	12	16	9	12	6	180	-6	0	✓	.57	GI218	ST24	6760504
	E16R-STFCL 11-R	16	20	11	16	8	200	-5	0	✓	1.06	GI056	ST21	6760508

GI056	TC.. 21.5.. (TC.. 1102..)
GI217	TC.. 1.21.2.. (TC.. 06T1..)
GI218	TC.. 1.81.5.. (TC.. 0902..)

		Nm			
ST21	5513 020-03	0.8	M 2.5	0.256	PT-8001
ST22	5513 020-28	0.6	M 2	0.165	PT-8000
ST23	5513 020-27	0.6	M 2	0.193	PT-8000
ST24	5513 020-05	0.8	M 2.2	0.252	PT-8001

SVHB(C)(RL) EXT

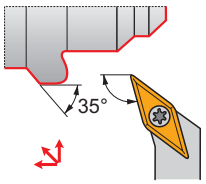
P M K N S H

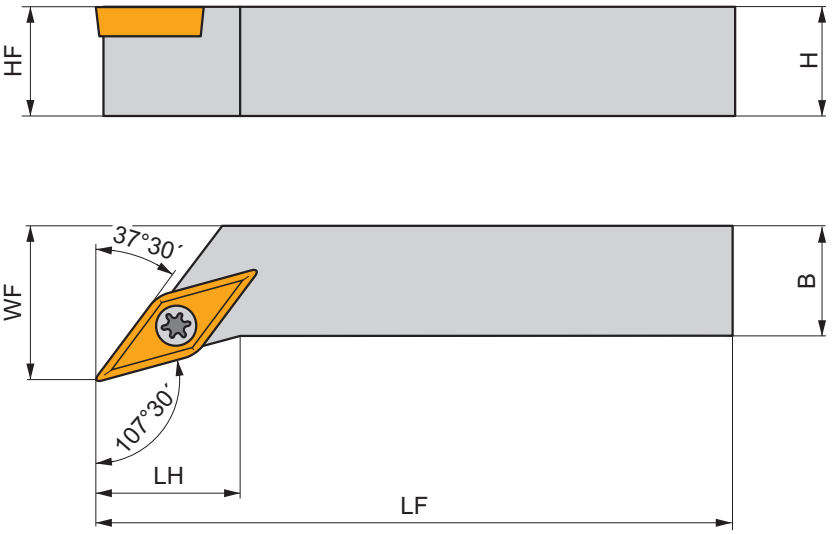
PRAMET

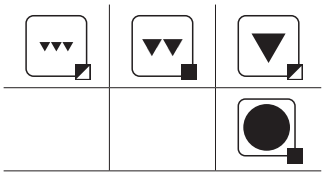
S

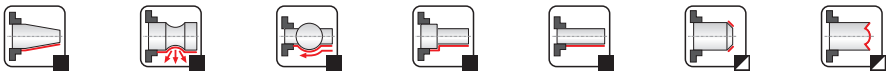
Ext. Screw Lock Tool Holder with 107.5° Cutting Angle for VB/VC.. Inserts

External Right/Left hand tool holder for screw type positive VB.. and VC.. inserts. Suited for external face and longitudinal turning with shoulder, taper, face and longitudinal copy turning up to 35° and chamfer turning. Body treated for longer tool life.









	Product	H (mm)	B (mm)	HF (mm)	WF (mm)	LF (mm)	LH (mm)	LAMS (°)	GAMO (°)	lbs			MID
R	SVHBR 1616 H 11	16	16	16	20	100	14.0	0	0	.45	GI194	S01	6760328
	SVHCR 2020 K 16-M-A	20	20	20	25	125	20.0	0	0	.86	GI017	SV10	6756617
	SVHCR 2525 M 16-M-A	25	25	25	32	150	20.0	0	0	1.56	GI017	SV10	6756618
L	SVHBL 1616 H 11	16	16	16	20	100	14.0	0	0	.42	GI194	S01	6760327
	SVHCL 2020 K 16-M-A	20	20	20	25	125	20.0	0	0	.88	GI017	SV10	6756615
	SVHCL 2525 M 16-M-A	25	25	25	32	150	20.0	0	0	1.52	GI017	SV10	6756616

GI017	VB.. 33.. (VB.. 1604..)	VC.. 33.. (VC.. 1604..)
GI194	VB.. 22.. (VB.. 1103..)	VC.. 22.. (VC.. 1103..)

		Nm						
S01	US 2506-T07P	0.9	M 2.5	0.248	–	–	FLAG T07P	–
SV10	US 3512-T15P	3.0	M 3.5	0.496	SVN 160304	MS 3510	FLAG T15P	HXK 3.5

SVJB(C)(RL) EXT

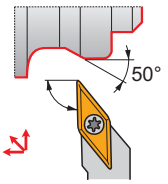
P M K N S H

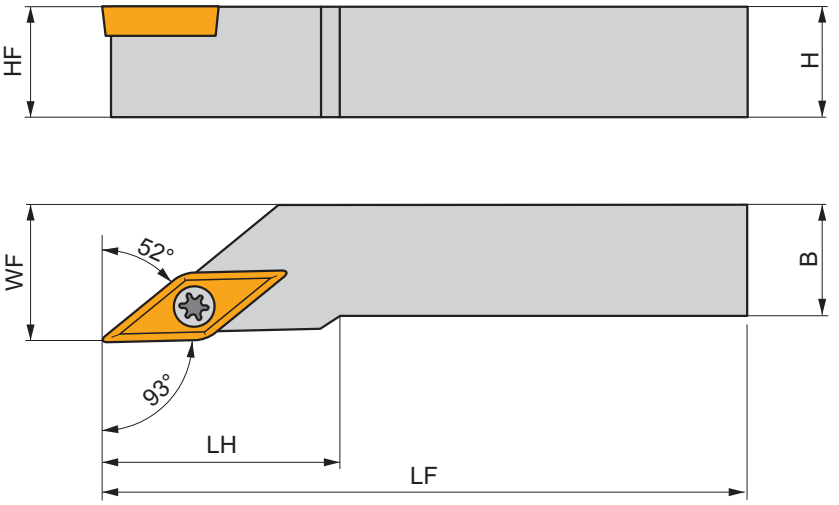
PRAMET

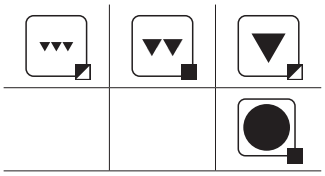
S

External Screw Lock Tool Holder with 93° Cutting Angle for VB/VC.. Inserts

External Right/Left hand tool holder for screw type positive VB.. and VC.. inserts. Suited for external longitudinal shoulder, taper, chamfer and copy turning up to 50° with some usable for sliding head machines. Body treated for longer tool life.







	Product	H (mm)	B (mm)	HF (mm)	WF (mm)	LF (mm)	LH (mm)	LAMS (°)	GAMO (°)	lbs			MID
R	SVJBR 1212 F 11	12	12	12	16	80	20.0	0	0	.20	GI194	S01	6760331
	SVJBR 1212 K 11-S	12	12	12	12	125	25.6	0	0	.28	GI194	S01	8181059
	SVJBR 1616 H 11	16	16	16	20	100	20.0	0	0	.41	GI194	S01	6760332
	SVJBR 1616 K 11-S	16	16	16	16	125	25.6	0	0	.49	GI194	S01	8181060
	SVJCR 1212 N 13	12	12	12	16	160	27.0	0	0	.42	GI211	SV21	6760440
	SVJCR 1616 H 13	16	16	16	20	100	30.0	0	0	.44	GI211	SV21	6760441
	SVJCR 2020 K 13	20	20	20	25	125	30.0	0	0	.82	GI211	SV22	6760442
	SVJCR 2020 K 16-M-A	20	20	20	25	125	28.0	0	0	.77	GI017	SV10	6756622
	SVJCR 2525 M 13	25	25	25	32	150	30.0	0	0	1.48	GI211	SV22	6760443
	SVJCR 2525 M 16-M-A	25	25	25	32	150	32.0	0	0	1.45	GI017	SV10	6756623
	SVJCR 3225 P 16-M-A	32	25	32	32	170	32.0	0	0	2.18	GI017	SV10	6756624
L	SVJBL 1212 F 11	12	12	12	16	80	20.0	0	0	.20	GI194	S01	6760329
	SVJBL 1212 K 11-S	12	12	12	12	125	25.6	0	0	.28	GI194	S01	8181057
	SVJBL 1616 H 11	16	16	16	20	100	20.0	0	0	.42	GI194	S01	6760330
	SVJBL 1616 K 11-S	16	16	16	16	125	25.6	0	0	.49	GI194	S01	8181058
	SVJCL 1212 N 13	12	12	12	16	160	27.0	0	0	.42	GI211	SV21	6760436
	SVJCL 1616 H 13	16	16	16	20	100	30.0	0	0	.44	GI211	SV21	6760437
	SVJCL 2020 K 13	20	20	20	25	125	30.0	0	0	.82	GI211	SV22	6760438
	SVJCL 2020 K 16-M-A	20	20	20	25	125	28.0	0	0	.83	GI017	SV10	6756619
	SVJCL 2525 M 13	25	25	25	32	150	30.0	0	0	1.47	GI211	SV22	6760439
	SVJCL 2525 M 16-M-A	25	25	25	32	150	32.0	0	0	1.50	GI017	SV10	6756620
	SVJCL 3225 P 16-M-A	32	25	32	32	170	32.0	0	0	2.18	GI017	SV10	6756621

GI017	VB.. 33.. (VB.. 1604..)	VC.. 33.. (VC.. 1604..)
GI194	VB.. 22.. (VB.. 1103..)	VC.. 22.. (VC.. 1103..)
GI211	–	VC.. 2.52.. (VC.. 1303..)

S01	US 2506-T07P	0.9	M 2.5	0.248	–	–	FLAG T07P	–
SV10	US 3512-T15P	3.0	M 3.5	0.496	SVN 160304	MS 3510	FLAG T15P	HXK 3.5
SV21	5513 020-24	1.5	M 3	0.335	–	–	PT-8002	–
SV22	DVF 0573	1.5	M 3	0.406	DAP 0331	DVT 0332	PT-8002	174.1-870

ISVJB(C)(RL) EXT

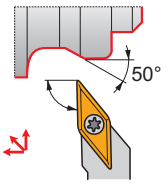
P M K N S H

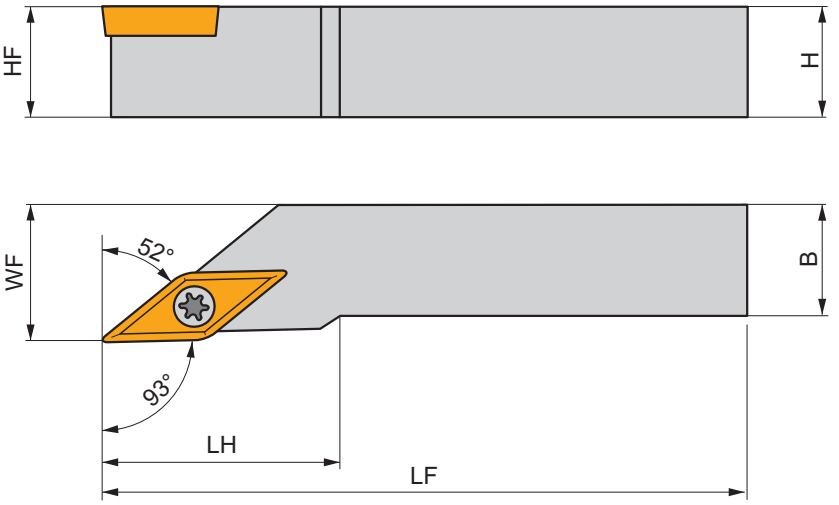
PRAMET

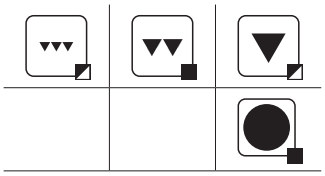
S

External Screw Lock Tool Holder with 93° Cutting Angle for VB/VC.. Inserts

External Right/Left hand tool holder for screw type positive VB.. and VC.. inserts. Suited for external longitudinal shoulder, taper, chamfer and copy turning up to 50° with some usable for sliding head machines. Body treated for longer tool life.







	Product	H (inch)	B (inch)	HF (inch)	WF (inch)	LF (inch)	LH (inch)	LAMS (°)	GAMO (°)	lbs			MID
R	SVJBR 12 2B	.750	.750	.750	1.000	4.500	.835	0	0	.88	GI194	SV11	6788688
	SVJBR 12 3B	.750	.750	.750	1.000	4.500	1.228	0	0	.88	GI017	SV16S	6788693
	SVJBR 16 3D	1.000	1.000	1.000	1.250	6.000	1.240	0	0	1.54	GI017	SV16S	6788694
L	SVJBL 12 2B	.750	.750	.750	1.000	4.500	.835	0	0	.88	GI194	SV11	6788686
	SVJBL 12 3B	.750	.750	.750	1.000	4.500	1.228	0	0	.88	GI017	SV16S	6788690
	SVJBL 16 3D	1.000	1.000	1.000	1.250	6.000	1.240	0	0	1.54	GI017	SV16S	6789414

GI017	VB.. 33.. (VB.. 1604..)	VC.. 33.. (VC.. 1604..)
GI194	VB.. 22.. (VB.. 1103..)	VC.. 22.. (VC.. 1103..)

		Nm					
SV11	US 2003-T07P	0.8	M 2.5	0.256	–	–	FLAG T07P
SV16S	US 2001-T15P	3.0	M 3.5	0.476	SVS 270-01	MS 9001	FLAG T15P/3,5

SVPB(C)(RL) EXT

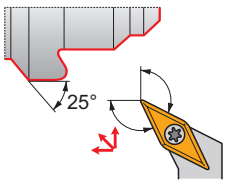
P M K N S H

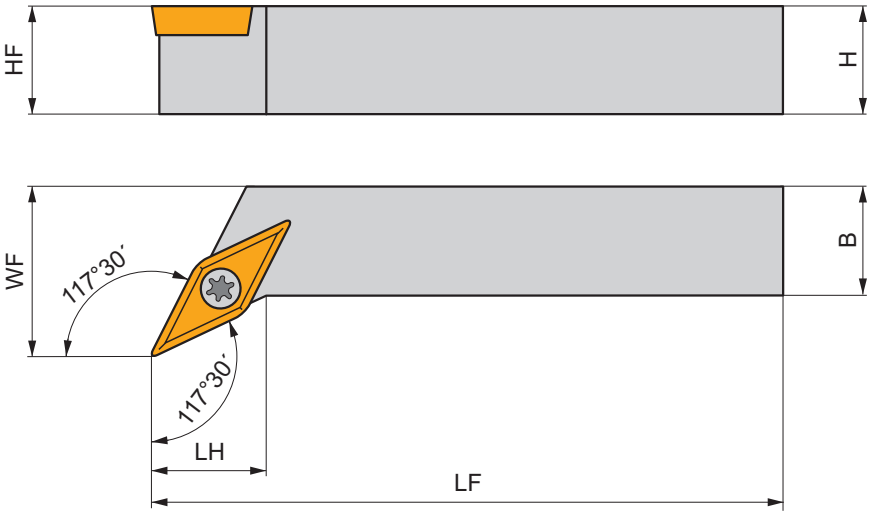
PRAMET

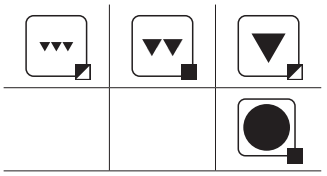
S

External Screw Lock Tool Holder, 117.5° Cutting Angle for VB/VC.. Inserts

External Right/Left hand tool holder for screw type positive VB.. and VC.. inserts. Suited for external face and longitudinal turning with shoulder, taper, face copy turning up to 25° and chamfer turning. Body treated for longer tool life.







	Product	H (mm)	B (mm)	HF (mm)	WF (mm)	LF (mm)	LH (mm)	LAMS (°)	GAMO (°)	lbs			MID
R	SVPBR 1616 H 11	16	16	16	20	100	12.0	0	0	.44	GI194	S01	6760335
	SVPBR 2020 K 11	20	20	20	25	125	12.0	0	0	.87	GI194	S01	6760336
	SVPCR 2020 K 16-M-A	20	20	20	25	125	20.0	0	0	.88	GI017	SV10	6756628
	SVPCR 2525 M 16-M-A	25	25	25	32	150	25.0	0	0	1.60	GI017	SV10	6756629
	SVPCR 3225 P 16-M-A	32	25	32	32	170	25.0	0	0	2.27	GI017	SV10	6756630
L	SVPBL 1616 H 11	16	16	16	20	100	12.0	0	0	.44	GI194	S01	6760333
	SVPBL 2020 K 11	20	20	20	25	125	12.0	0	0	.85	GI194	S01	6760334
	SVPCL 2020 K 16-M-A	20	20	20	25	125	20.0	0	0	.89	GI017	SV10	6756625
	SVPCL 2525 M 16-M-A	25	25	25	32	150	25.0	0	0	1.53	GI017	SV10	6756626
	SVPCL 3225 P 16-M-A	32	25	32	32	170	25.0	0	0	2.20	GI017	SV10	6756627

GI017	VB.. 33.. (VB.. 1604..)	VC.. 33.. (VC.. 1604..)
GI194	VB.. 22.. (VB.. 1103..)	VC.. 22.. (VC.. 1103..)

		Nm						
S01	US 2506-T07P	0.9	M 2.5	0.248	–	–	FLAG T07P	–
SV10	US 3512-T15P	3.0	M 3.5	0.496	SVN 160304	MS 3510	FLAG T15P	HXK 3.5

SVVB(C)N EXT

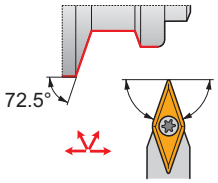
P M K N S H

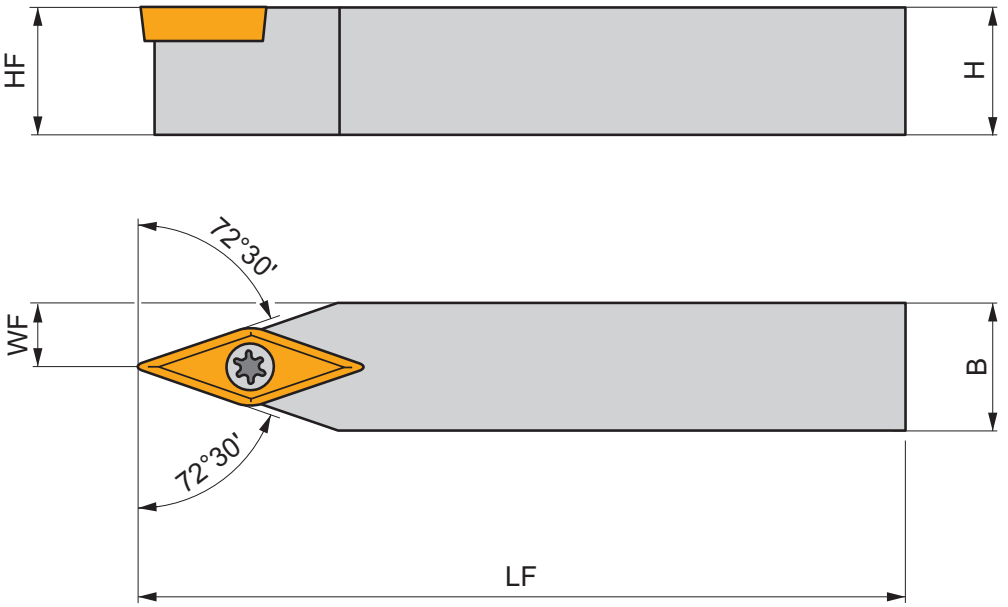
PRAMET

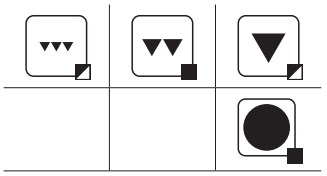
S

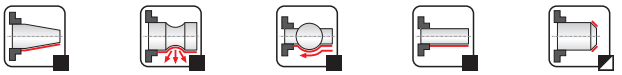
External Screw Lock Tool Holder, 72.5° Cutting Angle for VB/VC.. Inserts

External neutral tool holder for screw type positive VB.. and VC.. inserts. Suited for external longitudinal turning without shoulder, taper, copy turning up to 72.5° and chamfer turning. Body treated for longer tool life.









	Product	H (mm)	B (mm)	HF (mm)	WF (mm)	LF (mm)	LH (mm)	LAMS (°)	GAMO (°)	lbs			MID
N	**SVVBN 1212 F 11**	12	12	12	6	80	–	0	0	.22	GI194	S01	6760337
	SVVBN 1616 H 11	16	16	16	8	100	–	0	0	.43	GI194	S01	6760338
	SVVBN 2020 K 11	20	20	20	10	125	–	0	0	.79	GI194	S01	6760339
	SVVCN 1212 N 13	12	12	12	6	160	–	0	0	.41	GI211	SV21	6760444
	SVVCN 1616 H 13	16	16	16	8	100	–	0	0	.43	GI211	SV21	6760445
	SVVCN 2020 K 13	20	20	20	10	125	–	0	0	.80	GI211	SV22	6760446
	SVVCN 2525 M 13	25	25	25	12.5	150	–	0	0	1.45	GI211	SV22	6760447
	SVVCN 2020 K 16-M-A	20	20	20	10	125	–	0	0	.75	GI017	SV10	6756631
	SVVCN 2525 M 16-M-A	25	25	25	12.5	150	–	0	0	1.48	GI017	SV10	6756632
	SVVCN 3225 P 16-M-A	32	25	32	12.5	170	–	0	0	2.15	GI017	SV10	6756633

GI017	VB.. 33.. (VB.. 1604..)	VC.. 33.. (VC.. 1604..)
GI194	VB.. 22.. (VB.. 1103..)	VC.. 22.. (VC.. 1103..)
GI211	–	VC.. 2.52.. (VC.. 1303..)

		Nm						
S01	US 2506-T07P	0.9	M 2.5	0.248	–	–	FLAG T07P	–
SV10	US 3512-T15P	3.0	M 3.5	0.496	SVN 160304	MS 3510	FLAG T15P	HXK 3.5
SV21	5513 020-24	1.5	M 3	0.335	–	–	PT-8002	–
SV22	DVF 0573	1.5	M 3	0.406	DAP 0331	DVT 0332	PT-8002	174.1-870

ISVVB(C)N EXT

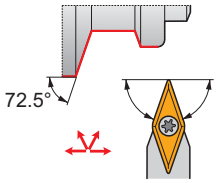
P M K N S H

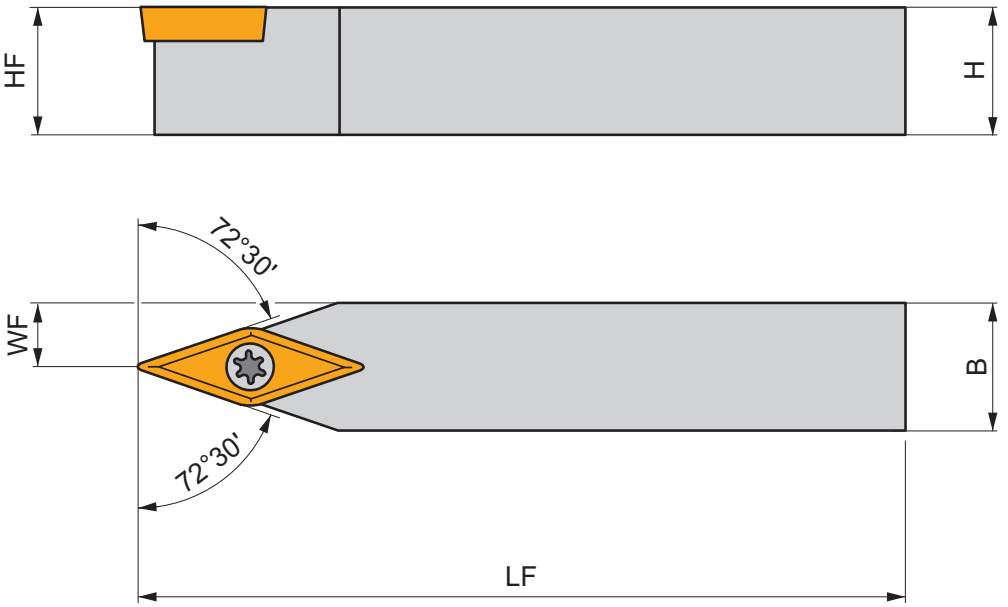
PRAMET

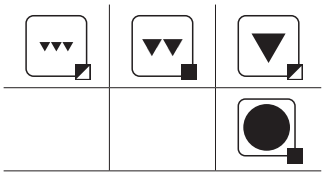
S

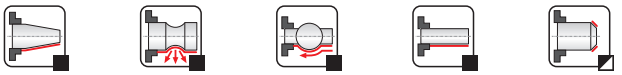
External Screw Lock Tool Holder, 72.5° Cutting Angle for VB/VC.. Inserts

External neutral tool holder for screw type positive VB.. and VC.. inserts. Suited for external longitudinal turning without shoulder, taper, copy turning up to 72.5° and chamfer turning. Body treated for longer tool life.









	Product	H (inch)	B (inch)	HF (inch)	WF (inch)	LF (inch)	LH (inch)	LAMS (°)	GAMO (°)	lbs			MID
N	**SVVBN 08 2**	.500	.500	.500	.260	3.500	.831	0	0	.22	GI194	SV11	6788696
	SVVBN 12 2B	.750	.750	.750	.384	4.500	.831	0	0	.88	GI194	SV11	6788697
	SVVBN 12 3B	.750	.750	.750	.395	4.500	1.240	0	0	.88	GI017	SV16S	6788698
	SVVBN 16 3D	1.000	1.000	1.000	.520	6.000	1.240	0	0	1.54	GI017	SV16S	6788699
	SVVBN 20 3D	1.250	1.250	1.250	.645	6.000	1.240	0	0	2.76	GI017	SV16S	6788700

GI017	VB.. 33.. (VB.. 1604..)	VC.. 33.. (VC.. 1604..)
GI194	VB.. 22.. (VB.. 1103..)	VC.. 22.. (VC.. 1103..)

		Nm					
SV11	US 2003-T07P	0.8	M 2.5	0.256	–	–	FLAG T07P
SV16S	US 2001-T15P	3.0	M 3.5	0.476	SVS 270-01	MS 9001	FLAG T15P/3,5

SVXB(C)(RL) EXT

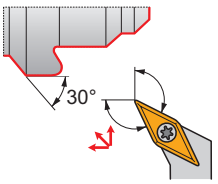
P M K N S H

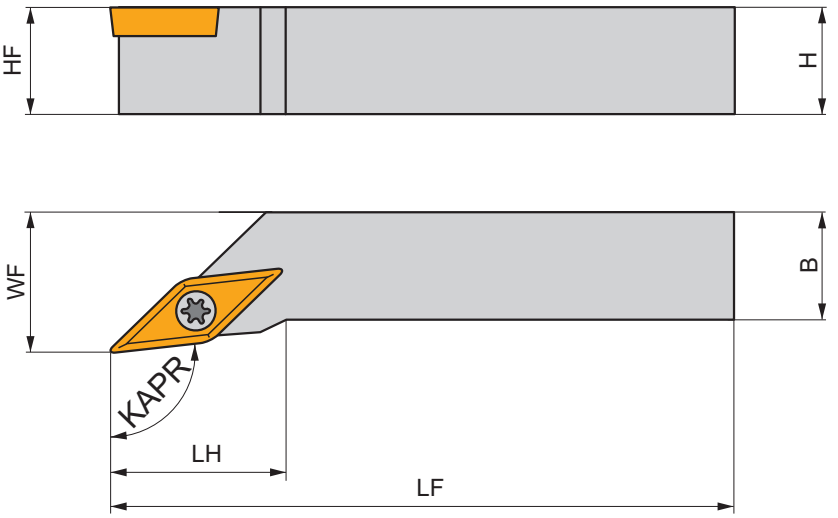
PRAMET

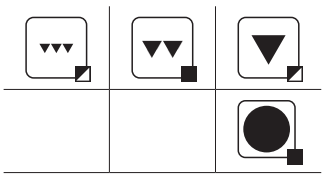
S

External Screw Lock Tool Holder 98/113° Cutting Angle for VB/VC.. Inserts

External Right/Left hand tool holder for screw type positive VB.. and VC.. inserts. Suited for external longitudinal turning with shoulder, taper, copy turning up to 30° and chamfer turning. Body treated for longer tool life.







	Product	H (mm)	B (mm)	HF (mm)	WF (mm)	LF (mm)	LH (mm)	KAPR (°)	LAMS (°)	GAMO (°)	lbs			MID
R	SVXBR 1212 F 11	12	12	12	16	80	20.0	98	0	0	.20	GI194	S01	6760342
	SVXBR 1616 H 11	16	16	16	20	100	14.0	98	0	0	.42	GI194	S01	6760343
	SVXCR 2020 K 13	20	20	20	25	125	12.0	113	0	0	.90	GI211	SV22	6760449
	SVXCR 2020 K 16-M-A	20	20	20	25	125	28.0	98	0	0	.84	GI017	SV10	6756637
	SVXCR 2525 M 16-M-A	25	25	25	32	150	32.0	98	0	0	1.50	GI017	SV10	6756638
	SVXCR 3225 P 16-M-A	32	25	32	32	170	32.0	98	0	0	2.20	GI017	SV10	6756639
L	SVXBL 1212 F 11	12	12	12	16	80	20.0	98	0	0	.20	GI194	S01	6760340
	SVXBL 1616 H 11	16	16	16	20	100	14.0	98	0	0	.42	GI194	S01	6760341
	SVXCL 2020 K 13	20	20	20	25	125	12.0	113	0	0	.85	GI211	SV22	6760448
	SVXCL 2020 K 16-M-A	20	20	20	25	125	28.0	98	0	0	.84	GI017	SV10	6756634
	SVXCL 2525 M 16-M-A	25	25	25	32	150	32.0	98	0	0	1.53	GI017	SV10	6756635
	SVXCL 3225 P 16-M-A	32	25	32	32	170	32.0	98	0	0	2.18	GI017	SV10	6756636

GI017	VB.. 33.. (VB.. 1604..)	VC.. 33.. (VC.. 1604..)
GI194	VB.. 22.. (VB.. 1103..)	VC.. 22.. (VC.. 1103..)
GI211	–	VC.. 2.52.. (VC.. 1303..)

		Nm						
S01	US 2506-T07P	0.9	M 2.5	0.248	–	–	FLAG T07P	–
SV10	US 3512-T15P	3.0	M 3.5	0.496	SVN 160304	MS 3510	FLAG T15P	HXK 3.5
SV22	DVF 0573	1.5	M 3	0.406	DAP 0331	DVT 0332	PT-8002	174.1-870

C.-SVHB(RL) EXT

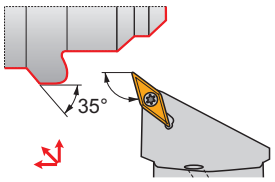
P M K N S H

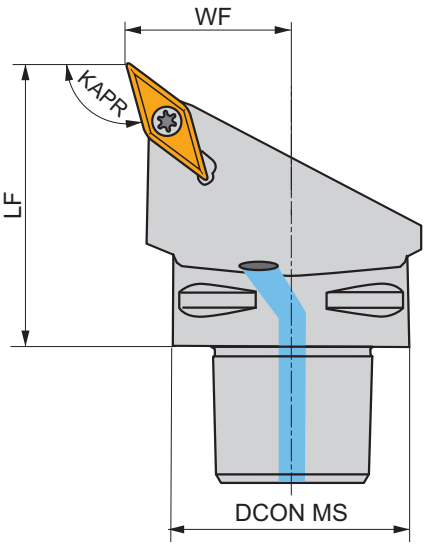
PRAMET

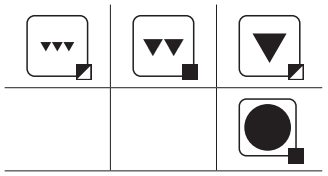
S

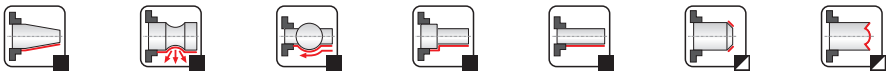
Ext. PSC Quick Change Tool, Screw Lock, 107.5° Cutting Angle, VB/VC.. Inserts

External Right/Left hand tool, through coolant, for screw type positive VB.. and VC.. inserts. Suited for external longitudinal turning with shoulder, taper, copy turning up to 35° and chamfer turning. Polygon Shank Coupling. Body treated for longer tool life.









	Product	DCON MS (mm)	WF (mm)	LF (mm)	KAPR (°)	LAMS (°)	GAMO (°)		lbs			MID
R	C4-SVHBR-27050-16	40	27	50	107.5	0	0	✓	.77	GI017	C-SV16S-1	7809845
	C5-SVHBR-35060-16	50	35	60	107.5	0	0	✓	1.40	GI017	C-SV16S-2	7809847
	C6-SVHBR-45065-16	63	45	65	107.5	0	0	✓	2.49	GI017	C-SV16S-2	7809849
L	C4-SVHBL-27050-16	40	27	50	107.5	0	0	✓	.77	GI017	C-SV16S-1	7809844
	C5-SVHBL-35060-16	50	35	60	107.5	0	0	✓	1.40	GI017	C-SV16S-2	7809846
	C6-SVHBL-45065-16	63	45	65	107.5	0	0	✓	2.48	GI017	C-SV16S-2	7809848

GI017	VB.. 33.. (VB.. 1604..)	VC.. 33.. (VC.. 1604..)

		Nm						
C-SV16S-1	US 2001-T15P	3.0	M 3.5	0.476	SVS 270-01	MS 9001	FLAG T15P/3,5	CN 034-01
C-SV16S-2	US 2001-T15P	3.0	M 3.5	0.476	SVS 270-01	MS 9001	FLAG T15P/3,5	CN 034-02

C.-SVJB(RL) EXT

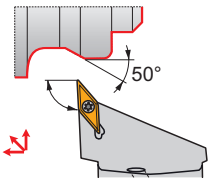
P M K N S H

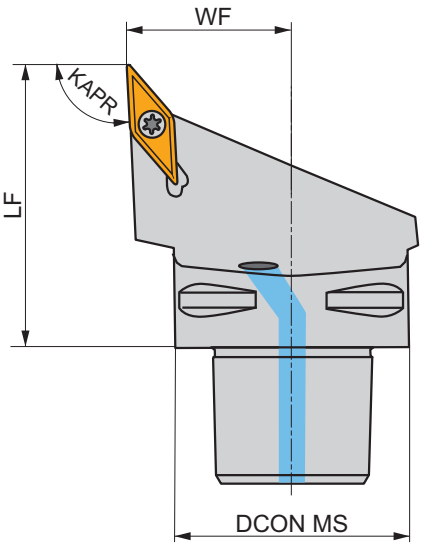
PRAMET

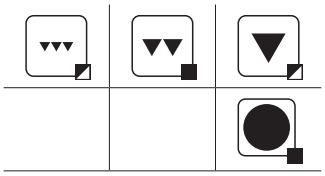
S

Ext. PSC Quick Change Tool, Screw Lock, 93° Cutting Angle for VB/VC.. Inserts

External Right/Left hand tool, through coolant, for screw type positive VB.. and VC.. inserts. Suited for external longitudinal turning with shoulder, taper, copy turning up to 50° and chamfer turning. Polygon Shank Coupling. Body treated for longer tool life.







	Product	DCON MS (mm)	WF (mm)	LF (mm)	KAPR (°)	LAMS (°)	GAMO (°)		lbs			MID
R	C3-SVJBR-22040-11-B1	32	22	40	93	0	0	✓	.38	GI194	C-SV11	7809850
	C4-SVJBR-27050-11-B1	40	27	50	93	0	0	✓	.76	GI194	C-SV11	7809851
	C4-SVJBR-27050-16	40	27	50	93	0	0	✓	.76	GI017	C-SV16S-1	7809853
	C5-SVJBR-35060-16	50	35	60	93	0	0	✓	1.40	GI017	C-SV16S-2	7809855
	C6-SVJBR-45065-16	63	45	65	93	0	0	✓	2.45	GI017	C-SV16S-2	7809857
L	C4-SVJBL-27050-16	40	27	50	93	0	0	✓	.76	GI017	C-SV16S-1	7809852
	C5-SVJBL-35060-16	50	35	60	93	0	0	✓	1.40	GI017	C-SV16S-2	7809854
	C6-SVJBL-45065-16	63	45	65	93	0	0	✓	2.45	GI017	C-SV16S-2	7809856

GI017	VB.. 33.. (VB.. 1604..)	VC.. 33.. (VC.. 1604..)
GI194	VB.. 22.. (VB.. 1103..)	VC.. 22.. (VC.. 1103..)

		Nm						
C-SV11	US 2003-T07P	0.8	M 2.5	0.256	–	–	FLAG T07P	CN 034-01
C-SV16S-1	US 2001-T15P	3.0	M 3.5	0.476	SVS 270-01	MS 9001	FLAG T15P/3,5	CN 034-01
C-SV16S-2	US 2001-T15P	3.0	M 3.5	0.476	SVS 270-01	MS 9001	FLAG T15P/3,5	CN 034-02

C.-SVVBN EXT

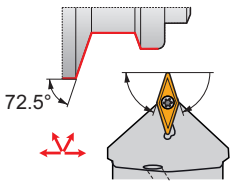
P M K N S H

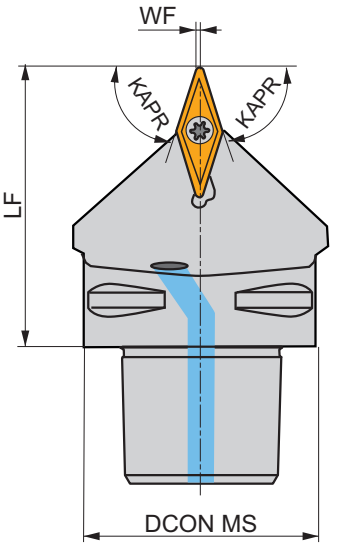
PRAMET

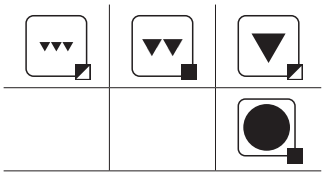
S

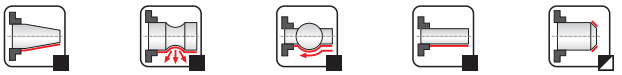
Ext. PSC Quick Change Tool, Screw Lock, 72.5° Cutting Angle, VB/VC.. Inserts

External neutral tool, through coolant, for screw type positive VB.. and VC.. inserts. Suited for external longitudinal turning without shoulder, taper, copy turning up to 72.5° and chamfer turning. Polygon Shank Coupling. Body treated for longer tool life.









	Product	DCON MS (mm)	WF (mm)	LF (mm)	KAPR (°)	LAMS (°)	GAMO (°)		lbs			MID
N	C4-SVVBN-00050-16	40	0.6	50	72.5	0	0	✓	.72	GI017	C-SV16S-1	7809858
	C5-SVVBN-00060-16	50	0.6	60	72.5	0	0	✓	1.24	GI017	C-SV16S-2	7809859
	C6-SVVBN-00065-16	63	0.6	65	72.5	0	0	✓	2.19	GI017	C-SV16S-2	7809860

GI017	VB.. 33.. (VB.. 1604..)	VC.. 33.. (VC.. 1604..)

		Nm						
C-SV16S-1	US 2001-T15P	3.0	M 3.5	0.476	SVS 270-01	MS 9001	FLAG T15P/3,5	CN 034-01
C-SV16S-2	US 2001-T15P	3.0	M 3.5	0.476	SVS 270-01	MS 9001	FLAG T15P/3,5	CN 034-02

SVJB(RL) INT

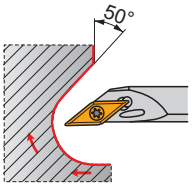
P M K N S H

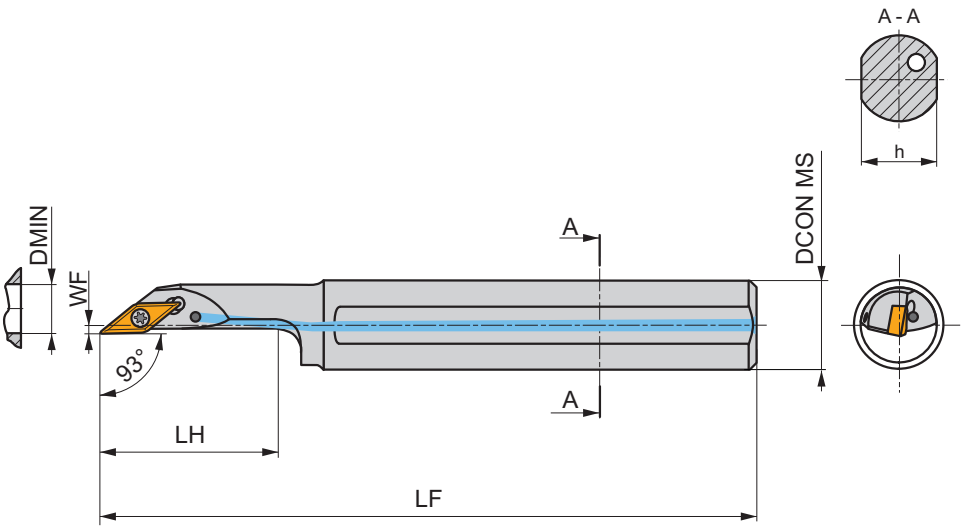
PRAMET

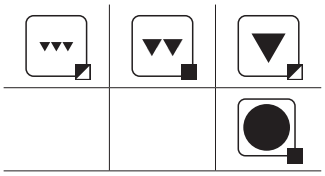
S

Internal Screw Lock Boring Bar with 93° Cutting Angle for VB/VC.. Inserts

Internal Right/Left hand boring bar, through coolant, with 93° cutting angle for screw type VB.. VC.. inserts. Suited for face copy turning under 50°. Body treated for longer tool life.







	Product	DCON MS (mm)	DMIN (mm)	WF (mm)	H (mm)	LF (mm)	LH (mm)	LAMS (°)	GAMO (°)		lbs			MID
R	**A20R-SVJBR 11**	20	25	2	18	200	40.0	-5	-5	✓	.89	GI194	S07	6759718
	A25S-SVJBR 11	25	32	3.5	23	250	50.0	-5	-5	✓	1.78	GI194	S07	6759720
L	**A20R-SVJBL 11**	20	25	2	18	200	40.0	-5	-5	✓	.90	GI194	S07	6759717
	A25S-SVJBL 11	25	32	3.5	23	250	50.0	-5	-5	✓	1.79	GI194	S07	6759719

GI194	VB.. 22.. (VB.. 1103..)	VC.. 22.. (VC.. 1103..)

S07	US 2506-T07P	0.9	M 2.5	0.248	FLAG T07P

SVQB(C)(RL) INT

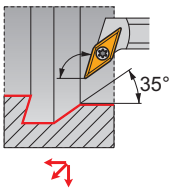
P M K N S H

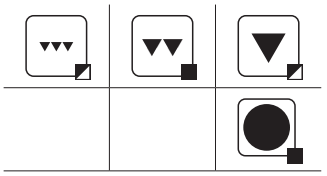
PRAMET

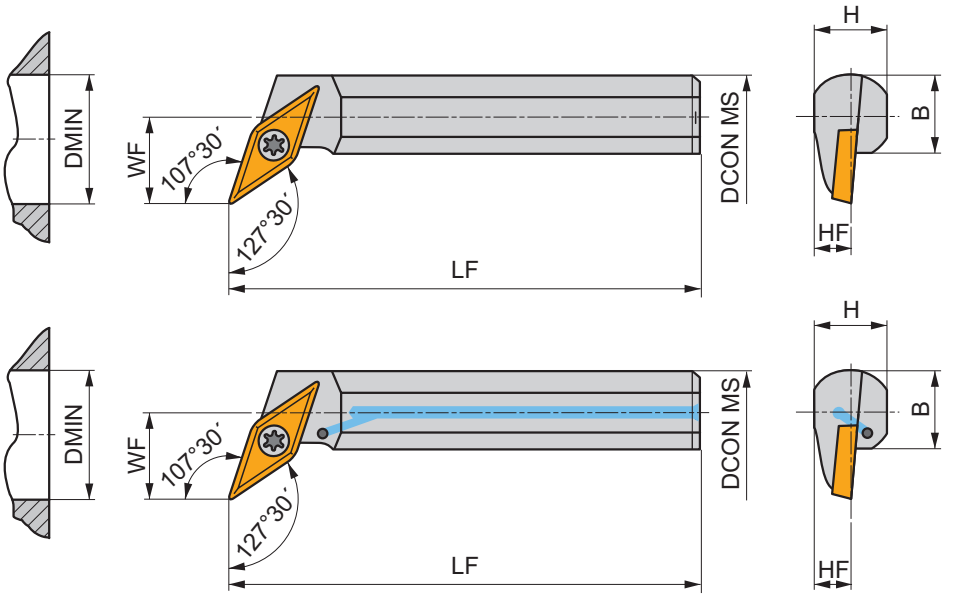
S

Internal Screw Lock Boring Bar with 107.5° Cutting Angle for VB/VC.. Inserts

Internal Right/Left hand boring bar, through coolant available, with 107.5° cutting angle for screw type VB../VC.. inserts. Suited for a wide range of internal turning operations.







	Product	DCON MS (mm)	DMIN (mm)	WF (mm)	H (mm)	B (mm)	LF (mm)	LAMS (°)	GAMO (°)		lbs			MID
R	A16R-SVQBR 11	16	20	11	14.5	15	200	-5	0	✓	.73	GI194	S01	6760320
	A20S-SVQBR 11	20	25	13	18	18.5	250	-4	0	✓	1.25	GI194	S01	6760322
	A16R-SVQCR 13	16	21	11	15	15	200	-6	0	✓	.64	GI211	SV21	6760920
	A20S-SVQCR 13	20	25	13	18	18.5	250	-4	0	✓	1.18	GI211	SV21	6760902
	S25T-SVQCR 16	25	32	17	23	23	300	-7	0	–	2.39	GI017	S08	6756834
	S32U-SVQCR 16	32	40	22	30	30	350	-5	0	–	4.56	GI017	S08	6756835
	S40V-SVQCR 16-A	40	50	27	38	38	400	-5	0	–	8.38	GI017	SV10	6756660
L	A16R-SVQBL 11	16	20	11	14.5	15	200	-5	0	✓	.70	GI194	S01	6760319
	A20S-SVQBL 11	20	25	13	18	18.5	250	-4	0	✓	1.25	GI194	S01	6760321
	A16R-SVQCL 13	16	21	11	15	15	200	-6	0	✓	.64	GI211	SV21	6760919
	A20S-SVQCL 13	20	25	13	18	18.5	250	-4	0	✓	1.19	GI211	SV21	6760901
	S25T-SVQCL 16	25	32	17	23	23	300	-7	0	–	2.31	GI017	S08	6757300
	S32U-SVQCL 16	32	40	22	30	30	350	-5	0	–	4.56	GI017	S08	6757010
	S40V-SVQCL 16-A	40	50	27	38	38	400	-5	0	–	9.04	GI017	SV10	6756659

GI017	VB.. 33.. (VB.. 1604..)	VC.. 33.. (VC.. 1604..)
GI194	VB.. 22.. (VB.. 1103..)	VC.. 22.. (VC.. 1103..)
GI211	–	VC.. 2.52.. (VC.. 1303..)

		Nm						
S01	US 2506-T07P	0.9	M 2.5	0.248	–	–	FLAG T07P	–
S08	US 3510-T15P	3.0	M 3.5	0.417	–	–	FLAG T15P	–
SV10	US 3512-T15P	3.0	M 3.5	0.496	SVN 160304	MS 3510	FLAG T15P	HXK 3.5
SV21	5513 020-24	1.5	M 3	0.335	–	–	PT-8002	–

ISVQB(C)(RL) INT

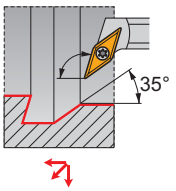
P M K N S H

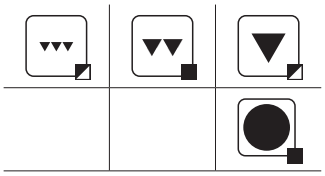
PRAMET

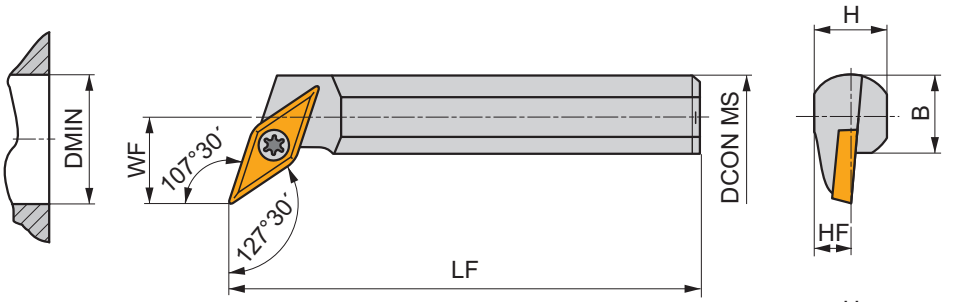
S

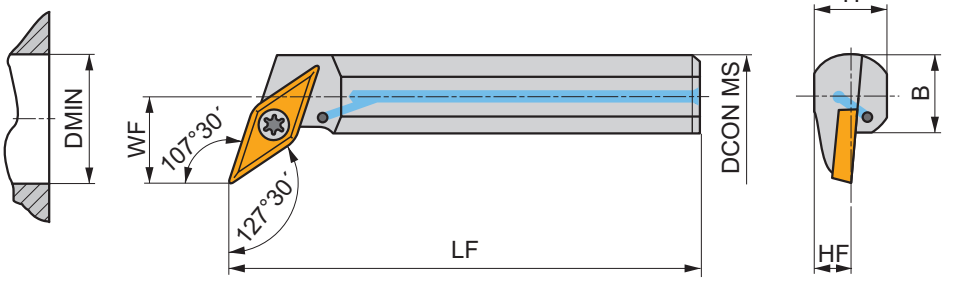
Internal Screw Lock Boring Bar with 107.5° Cutting Angle for VB/VC.. Inserts

Internal Right/Left hand boring bar, through coolant available, with 107.5° cutting angle for screw type VB../VC.. inserts. Suited for a wide range of internal turning operations.









	Product	DCON MS (inch)	DMIN (inch)	WF (inch)	H (inch)	B (inch)	LF (inch)	LAMS (°)	GAMO (°)		lbs			MID
R	**A16T-SVQBR 3**	1.000	1.299	.750	.906	–	12.000	-7	0	✓	1.54	GI017	SV16	6788638
	A24T-SVQBR 3	1.500	1.841	1.063	1.374	–	12.000	-5	0	✓	8.25	GI017	SV16S	6788648
L	**A16T-SVQBL 3**	1.000	1.299	.750	.906	–	12.000	-7	0	✓	1.54	GI017	SV16	6788637
	A20T-SVQBL 3	1.250	1.579	.875	1.181	–	12.000	-7	0	✓	4.51	GI017	SV16S	6788643

GI017	VB.. 33.. (VB.. 1604..)	VC.. 33.. (VC.. 1604..)

		Nm					
SV16	US 2010-T15P	3.0	M 3.5	0.398	–	–	FLAG T15P/3,5
SV16S	US 2001-T15P	3.0	M 3.5	0.476	SVS 270-01	MS 9001	FLAG T15P/3,5

SVUB(C)(RL) INT

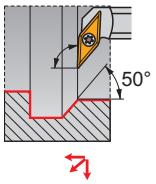
P M K N S H

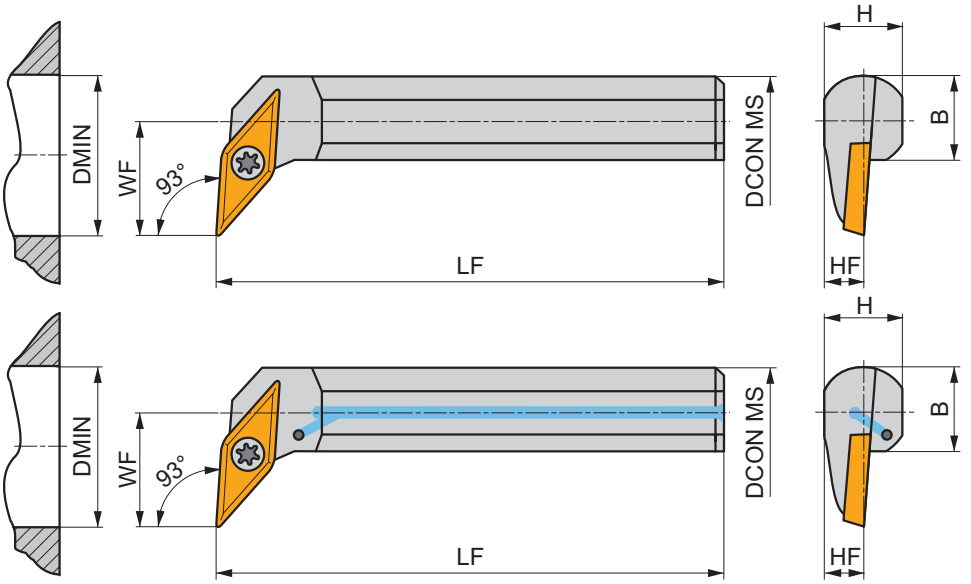
PRAMET

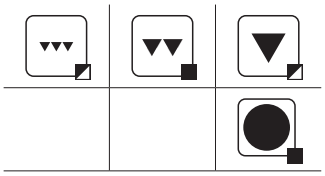
S

Internal Screw Lock Boring Bar with 93° Cutting Angle for VB/VC.. Inserts

Internal Right/Left hand boring bar, through coolant available, with 93° cutting angle for screw type VB../VC.. inserts. For a wide range of internal turning operations and copying under 50°. Body treated for longer tool life.







	Product	DCON MS (mm)	DMIN (mm)	WF (mm)	H (mm)	B (mm)	LF (mm)	LAMS (°)	GAMO (°)		lbs			MID
R	A16R-SVUBR 11	16	20	11	14.5	15	200	-5	0	✓	.71	GI194	S01	6760324
	A20S-SVUBR 11	20	25	13	18	18.8	250	-4	0	✓	1.26	GI194	S01	6760326
	A20S-SVUCR 13	20	25	13	19	18.5	250	-4	2	✓	1.19	GI211	SV21	6760922
	A25T-SVUCR 13	25	32	17	24	23	300	-2	2	✓	2.12	GI211	SV22	6760909
	A32T-SVUCR 13	32	40	22	30	30	300	-1	2	✓	3.66	GI211	SV22	6760742
	S25T-SVUCR 16	25	32	17	23	23	300	-7	0	–	2.38	GI017	S08	6756833
	S32U-SVUCR 16	32	40	22	30	30	350	-5	0	–	4.63	GI017	S08	6756849
	S40V-SVUCR 16-A	40	50	27	38	38	400	-5	0	–	9.04	GI017	SV10	6756662
L	A16R-SVUBL 11	16	20	11	14.5	15	200	-5	0	✓	.71	GI194	S01	6760323
	A20S-SVUBL 11	20	25	13	18	18.5	250	-4	0	✓	1.23	GI194	S01	6760325
	A20S-SVUCL 13	20	25	13	19	18.5	250	-4	2	✓	.71	GI211	SV21	6760921
	A25T-SVUCL 13	25	32	17	24	23	300	-2	2	✓	2.12	GI211	SV22	6760910
	A32T-SVUCL 13	32	40	22	30	30	300	-1	2	✓	3.66	GI211	SV22	6760743
	S25T-SVUCL 16	25	32	17	23	23	300	-7	0	–	2.39	GI017	S08	6757187
	S32U-SVUCL 16	32	40	22	30	30	350	-5	0	–	4.63	GI017	S08	6757296
	S40V-SVUCL 16-A	40	50	27	38	38	400	-5	0	–	9.04	GI017	SV10	6756661

GI017	VB.. 33.. (VB.. 1604..)	VC.. 33.. (VC.. 1604..)
GI194	VB.. 22.. (VB.. 1103..)	VC.. 22.. (VC.. 1103..)
GI211	–	VC.. 2.52.. (VC.. 1303..)

		Nm						
S01	US 2506-T07P	0.9	M 2.5	0.248	–	–	FLAG T07P	–
S08	US 3510-T15P	3.0	M 3.5	0.417	–	–	FLAG T15P	–
SV10	US 3512-T15P	3.0	M 3.5	0.496	SVN 160304	MS 3510	FLAG T15P	HXK 3.5
SV21	5513 020-24	1.5	M 3	0.335	–	–	PT-8002	–
SV22	DVF 0573	1.5	M 3	0.406	DAP 0331	DVT 0332	PT-8002	174.1-870

ISVUB(C)(RL) INT

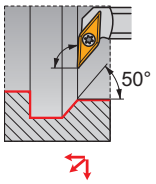
P M K N S H

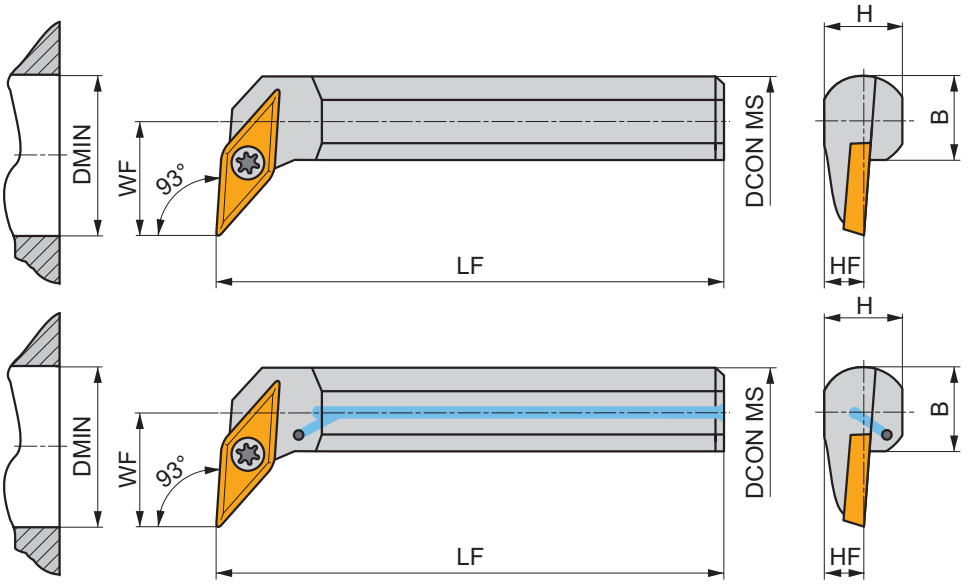
PRAMET

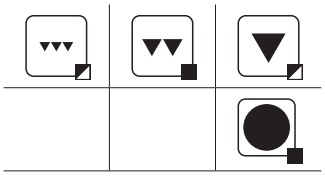
S

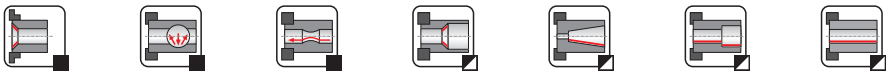
Internal Screw Lock Boring Bar with 93° Cutting Angle for VB/VC.. Inserts

Internal Right/Left hand boring bar, through coolant available, with 93° cutting angle for screw type VB../VC.. inserts. For a wide range of internal turning operations and copying under 50°. Body treated for longer tool life.









	Product	DCON MS (inch)	DMIN (inch)	WF (inch)	H (inch)	LF (inch)	LAMS (°)	GAMO (°)		lbs			MID
R	A10R-SVUBR 2	.625	.850	.486	.560	8.000	-7	0	✓	.66	GI194	SV11I	6788465
	A12S-SVUBR 2	.750	1.012	.580	.710	10.000	-5	0	✓	1.21	GI194	SV11I	6788477
	A20T-SVUBR 3	1.250	1.705	1.000	1.181	12.000	-5	0	✓	4.51	GI017	SV16S	6788646
	A24T-SVUBR 3	1.500	2.126	1.125	1.374	12.000	-3	0	✓	8.25	GI017	SV16S	6788650
L	A10R-SVUBL 2	.625	.850	.486	.560	8.000	-7	0	✓	.66	GI194	SV11I	6788463
	A12S-SVUBL 2	.750	1.012	.580	.710	10.000	-5	0	✓	1.21	GI194	SV11I	6788476
	A20T-SVUBL 3	1.250	1.705	1.000	1.181	12.000	-5	0	✓	4.51	GI017	SV16S	6788645
	A24T-SVUBL 3	1.500	2.126	1.125	1.374	12.000	-3	0	✓	8.25	GI017	SV16S	6788649

GI017	VB.. 33.. (VB.. 1604..)	VC.. 33.. (VC.. 1604..)
GI194	VB.. 22.. (VB.. 1103..)	VC.. 22.. (VC.. 1103..)

		Nm					
SV11I	US 2020-T07P	0.8	M 2.5	0.28	–	–	FLAG T07P
SV16S	US 2001-T15P	3.0	M 3.5	0.476	SVS 270-01	MS 9001	FLAG T15P/3,5

C.-SVQB(RL) INT

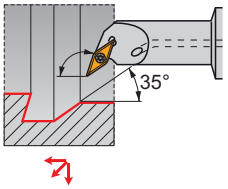
P M K N S H

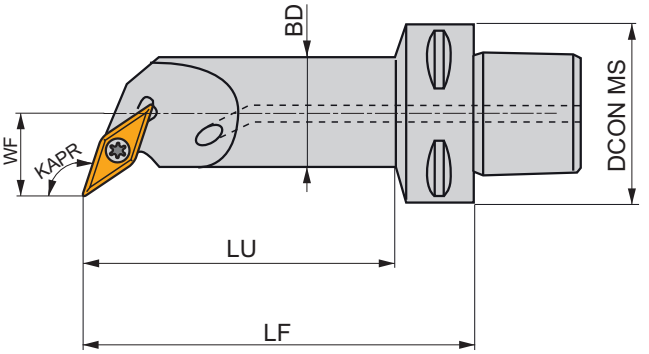
PRAMET

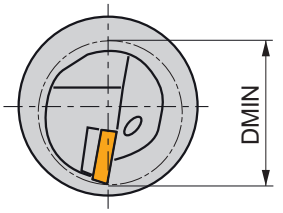
S

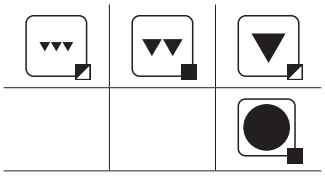
Int. PSC Quick Change Tool, Screw Lock, 107.5° Cutting Angle, VB/VC.. Inserts

Internal Right/Left hand tool, through coolant, with 107.5° cutting angle for screw type VB.. or VC.. inserts. Suited for a wide range of internal turning operations. Polygon Shank Coupling with choice of lengths. Body treated for longer tool life.









	Product	DCON MS (mm)	DMIN (mm)	WF (mm)	LF (mm)	LU (mm)	BD (mm)	KAPR (°)	LAMS (°)	GAMO (°)		lbs			MID
R	C4-SVQBR-18090-16	40	33	18	90	68	25	107.5	-7.2	0	✓	1.07	GI017	SV16	7809897
	C5-SVQBR-18090-16	50	33	18	90	67	25	107.5	-7.2	0	✓	1.49	GI017	SV16	7809899
L	C4-SVQBL-18090-16	40	33	18	90	68	25	107.5	-7.2	0	✓	1.07	GI017	SV16	7809896
	C5-SVQBL-18090-16	50	33	18	90	67	25	107.5	-7.2	0	✓	1.49	GI017	SV16	7809898

GI017	VB.. 33.. (VB.. 1604..)	VC.. 33.. (VC.. 1604..)

SV16	US 2010-T15P	3.0 Nm	M 3.5	0.398	FLAG T15P/3,5

SVAC(RL)-DC EXT

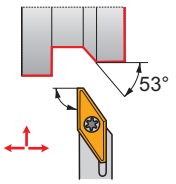
P M K N S H

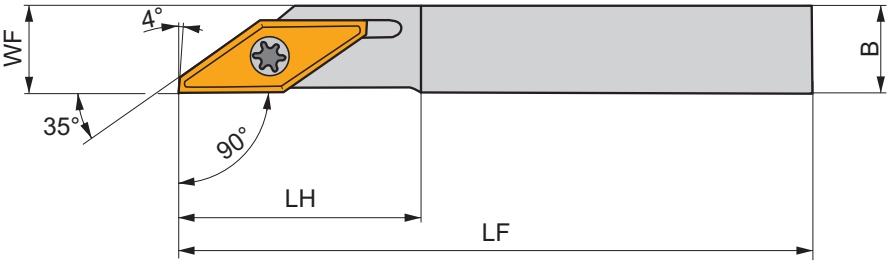
PRAMET

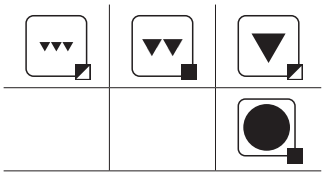
S

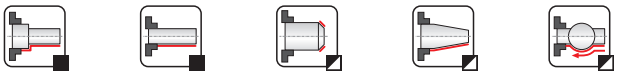
Ext. Screw Lock Swiss Style Tool Holder, 90° Cutting Angle for VCGX 13 Inserts

External Right/Left hand tool holder for screw type positive VCGX 13 Swiss style inserts. Suited for external face and longitudinal turning with shoulder, taper, copy turning up to 53° and chamfer turning. Body treated for longer tool life.









	Product	H (mm)	B (mm)	HF (mm)	WF (mm)	LF (mm)	LH (mm)	LAMS (°)	GAMO (°)	lbs			MID
R	SVACR 1010 L 13-DC	10	10	10	10	140	25.0	0	0	.27	GI222	SV20	6760607
	SVACR 1212 L 13-DC	12	12	12	12	140	25.0	0	0	.37	GI222	SV20	6760608
	SVACR 1616 M 13-DC	16	16	16	16	150	25.0	0	0	.65	GI222	SV20	6760610
	SVACR 2020 M 13-DC	20	20	20	20	150	25.0	0	0	1.01	GI222	SV20	6760834
L	SVACL 1212 L 13-DC	12	12	12	12	140	25.0	0	0	.42	GI222	SV20	6760609
	SVACL 1616 M 13-DC	16	16	16	16	150	25.0	0	0	.65	GI222	SV20	6760833
	SVACL 2020 M 13-DC	20	20	20	20	150	25.0	0	0	.95	GI222	SV20	6760835
	SVACL 2525 M 13-DC	25	25	25	25	150	25.0	0	0	1.49	GI222	SV20	6760611

GI222	VC.. 2.52.. (VCGX 1303..)

SV20	5513 020-24	1.5 Nm	M 3	0.335	PT-8002

SVJC(RL)-DC EXT

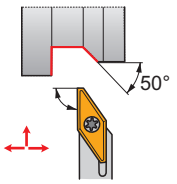
P M K N S H

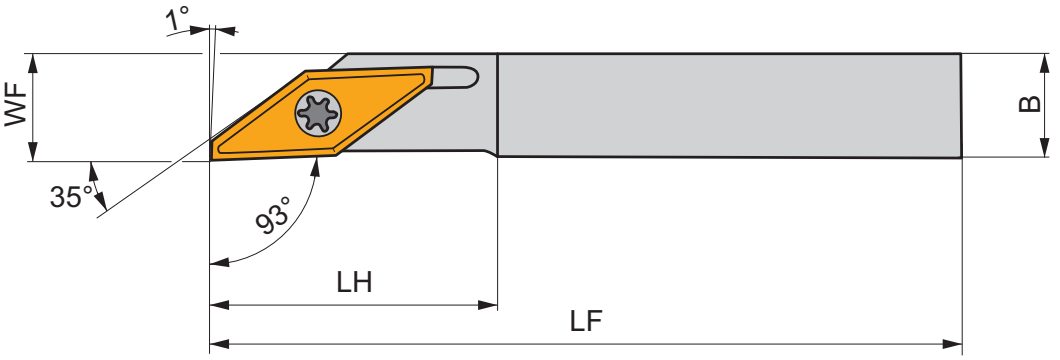
PRAMET

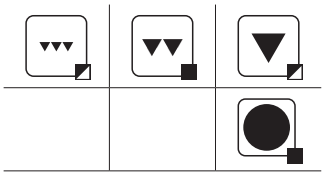
S

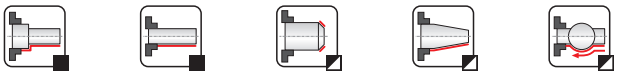
Ext. Screw Lock Swiss Style Tool Holder, 93° Cutting Angle for VCGX Insert

External Right/Left hand tool holder for screw type positive VCGX 13 Swiss style inserts. Suited for external face and longitudinal turning with shoulder, taper, copy turning up to 50° and chamfer turning. Body treated for longer tool life.









	Product	H (mm)	B (mm)	HF (mm)	WF (mm)	LF (mm)	LH (mm)	LAMS (°)	GAMO (°)	lbs			MID
R	SVJCR 1212 L 13-DC	12	12	12	–	140	25.0	0	0	.37	GI222	SV20	6760599
	SVJCR 1616 M 13-DC	16	16	16	–	150	25.0	0	0	.65	GI222	SV20	6760601
	SVJCR 2020 M 13-DC	20	20	20	–	150	25.0	0	0	1.00	GI222	SV20	6760603
	SVJCR 2525 M 13-DC	25	25	25	–	150	25.0	0	0	1.50	GI222	SV20	6760605
L	SVJCL 1212 L 13-DC	12	12	12	–	140	25.0	0	0	.37	GI222	SV20	6760600
	SVJCL 1616 M 13-DC	16	16	16	–	150	25.0	0	0	.65	GI222	SV20	6760602
	SVJCL 2020 M 13-DC	20	20	20	–	150	25.0	0	0	1.04	GI222	SV20	6760604
	SVJCL 2525 M 13-DC	25	25	25	–	150	25.0	0	0	1.52	GI222	SV20	6760830

GI222	VC.. 2.52.. (VCGX 1303..)

		Nm			
SV20	5513 020-24	1.5	M 3	0.335	PT-8002

SVLC(RL) INT

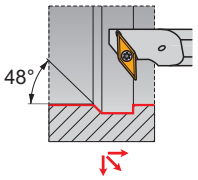
P M K N S H

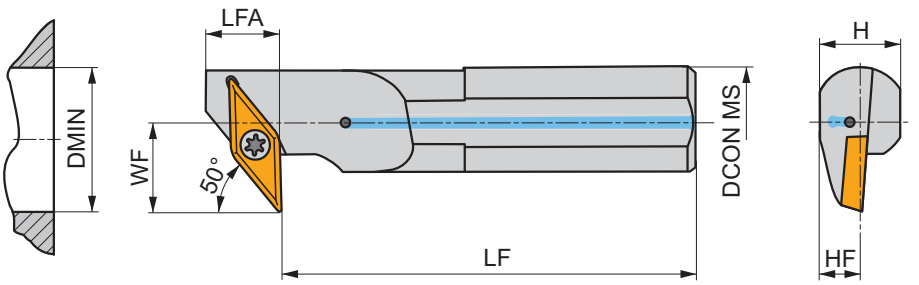
PRAMET

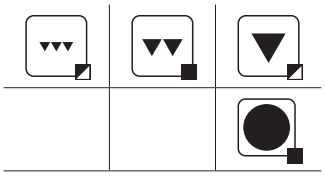
S

Internal Screw Lock Boring Bar with 50° Cutting Angle for VC.. Inserts

Internal Right/Left hand boring bar, through coolant, with 50° cutting angle for screw type VC.. inserts. Suited for a wide range of internal pulling turning operations and copying under 48°. Body treated for longer tool life.







	Product	DCON MS (mm)	DMIN (mm)	WF (mm)	H (mm)	LF (mm)	HF (mm)	LFA (mm)	LAMS (°)	GAMO (°)		lbs			MID
R	A20S-SVLCR 13-X	20	27	15	18	250	9	15	-4	-2	✓	1.26	GI211	SV21	6760904
	A25T-SVLCR 13-X	25	35	20	24	300	12	18	-2	-2	✓	2.23	GI211	SV22	6760906
	A32T-SVLCR 13-X	32	43	25	30	300	15	18	-1	-2	✓	3.85	GI211	SV22	6760905
L	A20S-SVLCL 13-X	20	27	15	18	250	9	15	-4	-2	✓	1.26	GI211	SV21	6760903
	A25T-SVLCL 13-X	25	35	20	24	300	12	18	-2	-2	✓	.11	GI211	SV22	6760907
	A32T-SVLCL 13-X	32	43	25	30	300	15	18	-1	-2	✓	3.86	GI211	SV22	6760908

GI211	VC.. 2.52.. (VC.. 1303..)

		Nm						
SV21	5513 020-24	1.5	M 3	0.335	–	–	PT-8002	–
SV22	DVF 0573	1.5	M 3	0.406	DAP 0331	DVT 0332	PT-8002	174.1-870

SVXC(RL) INT

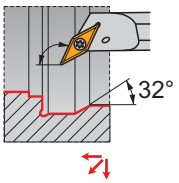
P M K N S H

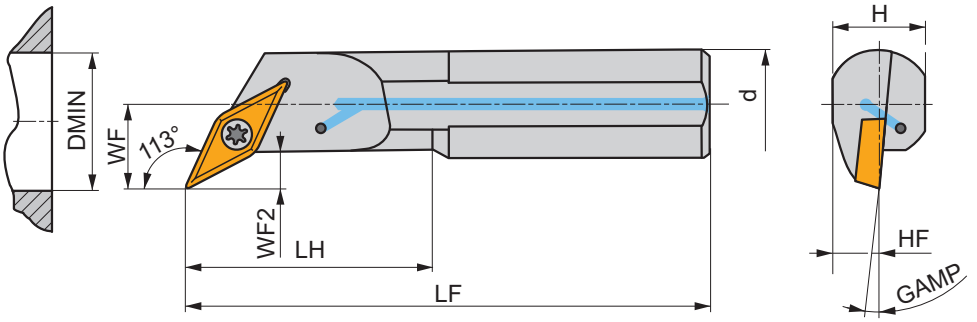
PRAMET

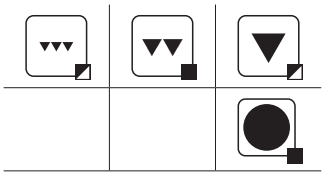
S

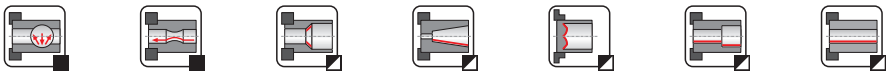
Internal Screw Lock Boring Bar with 113° Cutting Angle for VC.. Inserts

Internal Right/Left hand boring bar, through coolant, with 113° cutting angle for screw type VC.. inserts. Suited for a wide range of internal turning operations and copying under 32° . Body treated for longer tool life.









	Product	DCON MS (mm)	DMIN (mm)	WF (mm)	H (mm)	LF (mm)	HF (mm)	LH (mm)	WF2 (mm)	GAMP (°)		lbs			MID
R	A10H-SVXCR 07	10	12.5	7	9	100	4.5	22.0	3	-10	✓	.13	GI234	SV23	6760753
	A12K-SVXCR 07	12	15.5	9	11	125	5.5	28.0	3	-8	✓	.24	GI234	SV23	6760754
	A16M-SVXCR 07	16	17.5	11	15	150	7.5	36.0	3	-6	✓	.42	GI234	SV23	6760755
L	A10H-SVXCL 07	10	12.5	7	9	100	4.5	22.0	3	-10	✓	.13	GI234	SV23	6760756
	A12K-SVXCL 07	12	15.5	9	11	125	5.5	28.0	3	-8	✓	.24	GI234	SV23	6760757
	A16M-SVXCL 07	16	17.5	11	15	150	7.5	36.0	3	-6	✓	.44	GI234	SV23	6760758

GI234	VC.. 1.21.5.. (VC.. 0702..)

SV23	DVF 3584	0.6	M 2	0.217	DMD 1650

SVXC(RL)-E INT

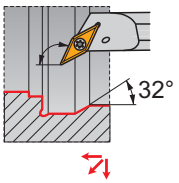
P M K N S H

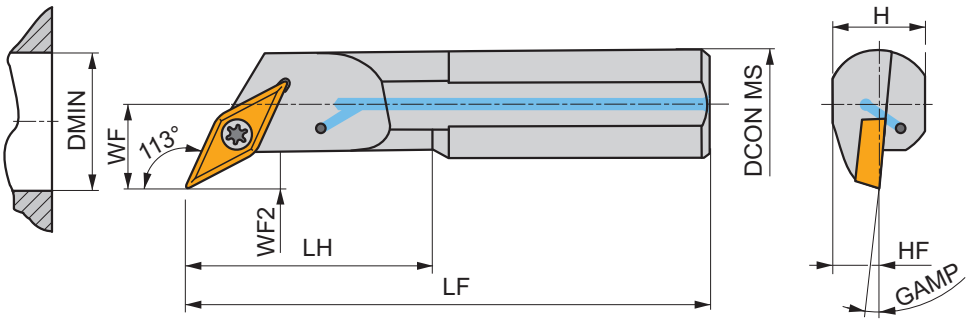
PRAMET

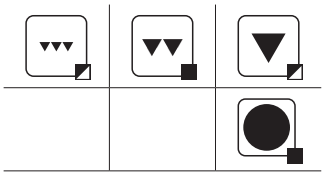
S

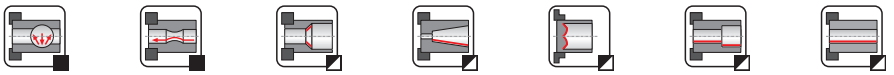
Internal Carbide Screw Lock Boring Bar, 113° Cutting Angle for VC.. Inserts

Internal Right/Left hand carbide boring bar, through coolant, with 113° cutting angle for screw type VC.. inserts. Suited for a wide range of internal turning operations and copying under 32° . For tool overhang >3xD.









	Product	DCON MS (mm)	DMIN (mm)	WF (mm)	H (mm)	HF (mm)	LF (mm)	LH (mm)	WF2 (mm)	GAMP (°)		lbs			MID
R	E10H-SVXCR 07	10	12.5	7	9	4.5	100	22.0	3	-10	✓	.21	GI234	SV23	6760760
	E12K-SVXCR 07	12	15.5	9	11	5.5	125	28.0	3	-8	✓	.41	GI234	SV23	6760761
	E16M-SVXCR 07	16	17.5	11	15	7.5	150	36.0	3	-6	✓	.73	GI234	SV23	6760759
L	E10H-SVXCL 07	10	12.5	7	9	4.5	100	22.0	3	-10	✓	.21	GI234	SV23	6760762
	E16M-SVXCL 07	16	17.5	11	15	7.5	150	36.0	3	-6	✓	.73	GI234	SV23	6760764

GI234	VC.. 1.21.5.. (VC.. 0702..)

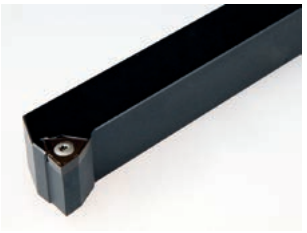
SV23	DVF 3584	0.6	M 2	0.217	DMD 1650

SWLC(RL) EXT

P M K N S H

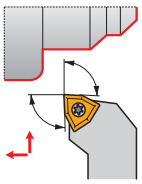
PRAMET

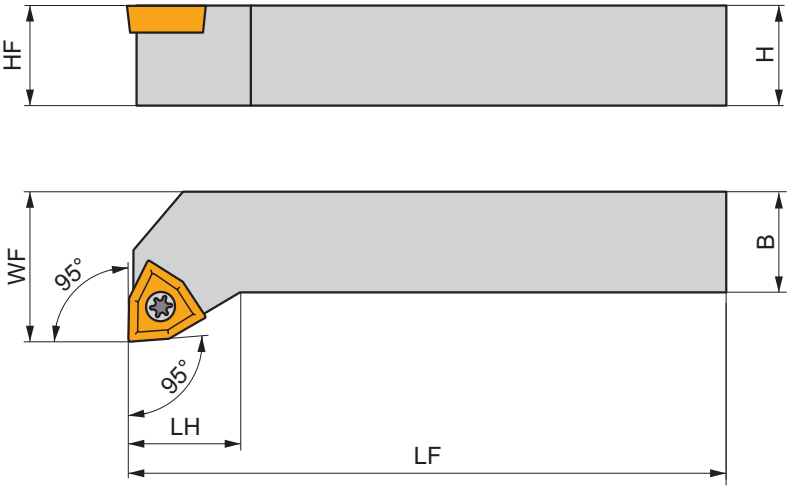
S

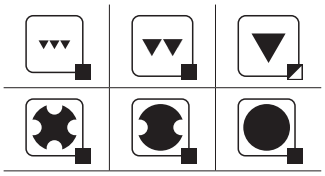


External Screw Lock Tool Holder with 95° Cutting Angle for WC.. Inserts

External Right/Left hand tool holder for screw type positive screw type WC.. inserts. Suited for face and longitudinal turning with shoulder, taper and chamfer turning. Body treated for longer tool life.







	Product	H (mm)	B (mm)	HF (mm)	WF (mm)	LF (mm)	LH (mm)	LAMS (°)	GAMO (°)	lbs			MID
R	**SWLCR 1616 H 06**	16	16	16	20	100	15.0	0	0	.50	GI055	S04	6756786
	SWLCR 2020 K 06	20	20	20	25	125	15.0	0	0	.93	GI055	S04	6756809
	SWLCR 2525 M 08	25	25	25	32	150	20.0	0	0	1.69	GI049	S09	6756766
L	**SWLCL 1616 H 06**	16	16	16	20	100	15.0	0	0	.51	GI055	S04	6756995
	SWLCL 2020 K 06	20	20	20	25	125	15.0	0	0	.88	GI055	S04	6756798
	SWLCL 2525 M 08	25	25	25	32	150	20.0	0	0	1.65	GI049	S09	6757190

GI049	WC.. 43.. (WC.. 0804..)
GI055	WC.. 32.5.. (WC.. 06T3..)

		Nm			
S04	US 3510-T15P	3.0	M 3.5	0.417	FLAG T15P
S09	US 4512-T15P	5.0	M 4.5	0.48	FLAG T15P

SWLC(RL) INT

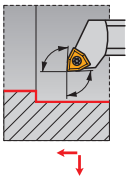
P M K N S H

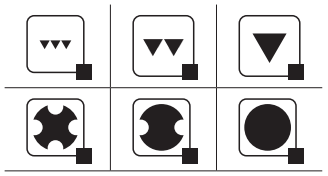
PRAMET

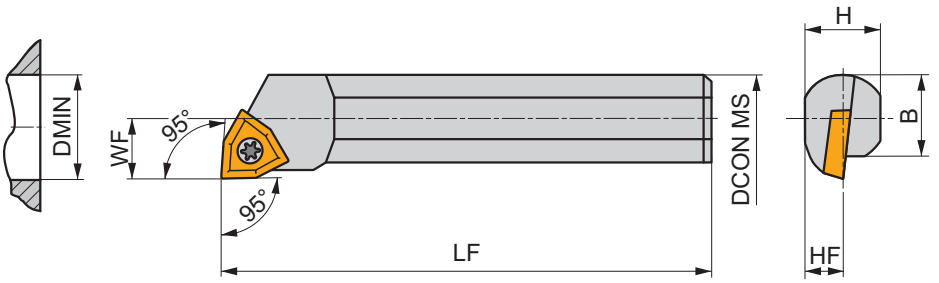
S

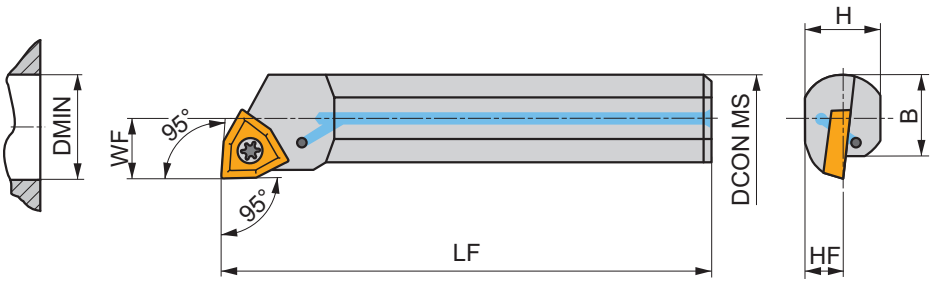
Internal Screw Lock Boring Bar with 95° Cutting Angle for WC.. Inserts

Internal Right/Left hand boring bar, through coolant available, 95° cutting angle for screw type WC.. inserts. For internal taper and longitudinal turning with shoulder and chamfer turning. Body treated for longer tool life.









	Product	DCON MS (mm)	DMIN (mm)	WF (mm)	H (mm)	B (mm)	LF (mm)	LAMS (°)	GAMO (°)		lbs			MID
R	A20Q-SWLCR 06	20	25	13	18	18.5	180	-7	0	✓	.81	GI055	S04	6761021
	S20S-SWLCR 06	20	25	13	18	18.5	250	-7	0	–	1.33	GI055	S04	6756825
	S25T-SWLCR 06	25	32	17	23	23	300	-7	0	–	2.47	GI055	S04	6756826
	A25R-SWLCR 08	25	32	17	23	23	200	-7	0	✓	1.54	GI049	S04	6761025
	A32S-SWLCR 08	32	40	22	30	30	250	-5	0	✓	2.91	GI049	S09	6761027
	S32U-SWLCR 08	32	40	22	30	30	350	-5	0	–	4.52	GI049	S09	6756850
L	A20Q-SWLCL 06	20	25	13	18	18.5	180	-7	0	✓	.81	GI055	S04	6761020
	S20S-SWLCL 06	20	25	13	18	18.5	250	-7	0	–	1.32	GI055	S04	6756877
	A25R-SWLCL 06	25	32	17	23	23	200	-7	0	✓	1.44	GI055	S04	6761022

GI049	WC.. 43.. (WC.. 0804..)
GI055	WC.. 32.5.. (WC.. 06T3..)

		Nm			
S04	US 3510-T15P	3.0	M 3.5	0.417	FLAG T15P
S09	US 4512-T15P	5.0	M 4.5	0.48	FLAG T15P

ISWLC(RL) INT

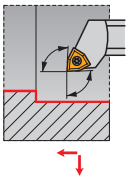
P M K N S H

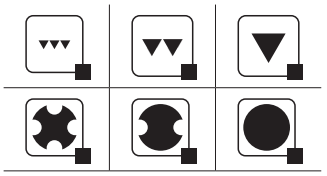
PRAMET

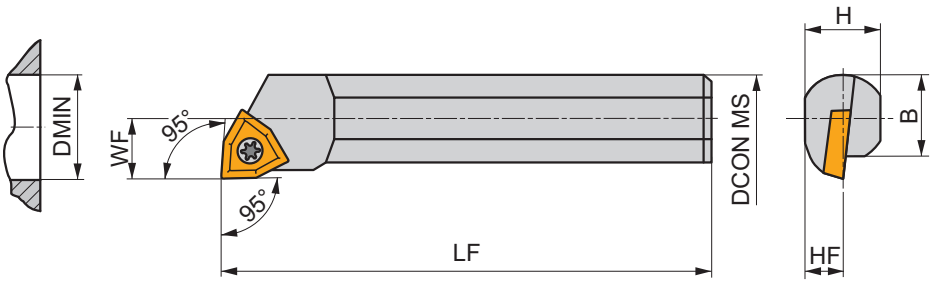
S

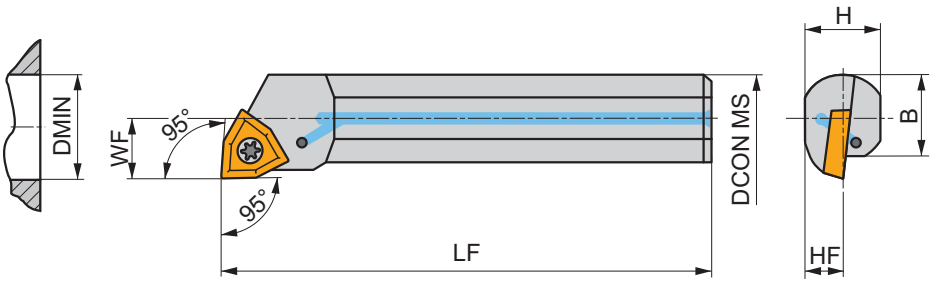
Internal Screw Lock Boring Bar with 95° Cutting Angle for WC.. Inserts

Internal Right/Left hand boring bar, through coolant available, 95° cutting angle for screw type WC.. inserts. For internal taper and longitudinal turning with shoulder and chamfer turning. Body treated for longer tool life.









	Product	DCON MS (inch)	DMIN (inch)	WF (inch)	H (inch)	LF (inch)	LAMS (°)	GAMO (°)		lbs			MID
R	A12S-SWLCR 3	.750	.929	.500	.709	10.000	-6	0	✓	1.32	GI055	S08	6820322

GI055	WC.. 32.5.. (WC.. 06T3..)

		Nm			
S08	US 3510-T15P	3.0	M 3.5	0.417	FLAG T15P

SWUC(RL) INT

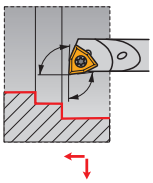
P M K N S H

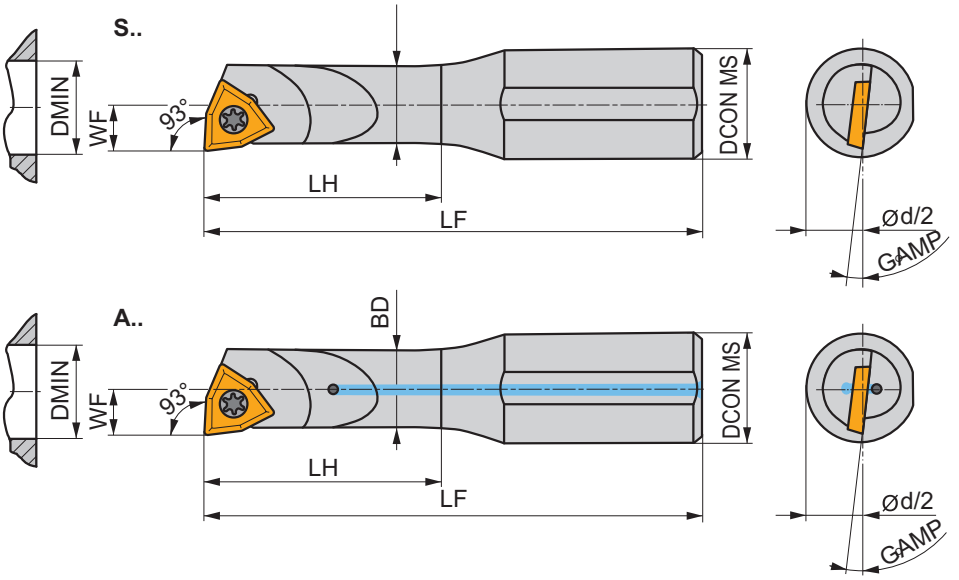
PRAMET

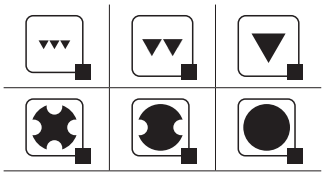
S

Internal Screw Lock Boring Bar with 93° Cutting Angle for WC.. Inserts

Internal Right/Left hand boring bar, through coolant available, 93° cutting angle for screw type WC.. inserts. Suited for internal taper and longitudinal turning with shoulder and chamfer turning. Body treated for longer tool life.







	Product	DCON MS (mm)	DMIN (mm)	BD (mm)	WF (mm)	LF (mm)	LH (mm)	GAMP (°)		lbs			MID
R	A0508H-SWUCR 02	8	5.8	5	2.9	100	18.0	-17	✓	.08	GI221	SW21	6760579
	S0508H-SWUCR 02	8	5.8	5	2.9	100	18.0	-17	–	.07	GI221	SW21	6760583
	A0608H-SWUCR 02	8	7.8	6	3.9	100	24.0	-12	✓	.08	GI221	SW21	6760581
	S0608H-SWUCR 02	8	7.8	6	3.9	100	24.0	-12	–	.09	GI221	SW21	6760585
L	A0508H-SWUCL 02	8	5.8	5	2.9	100	18.0	-17	✓	.08	GI221	SW21	6760580
	S0508H-SWUCL 02	8	5.8	5	2.9	100	18.0	-17	–	.09	GI221	SW21	6760584
	A0608H-SWUCL 02	8	7.8	6	3.9	100	24.0	-12	✓	.08	GI221	SW21	6760582
	S0608H-SWUCL 02	8	7.8	6	3.9	100	24.0	-12	–	.09	GI221	SW21	6760586

GI221	WC.. 1.21.. (WC.. 0201..)

		Nm			
SW21	T20.037	0.6	M 2	0.146	DMD 1650

SWUC(RL)-E INT

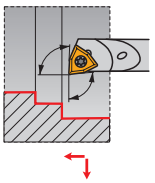
P M K N S H

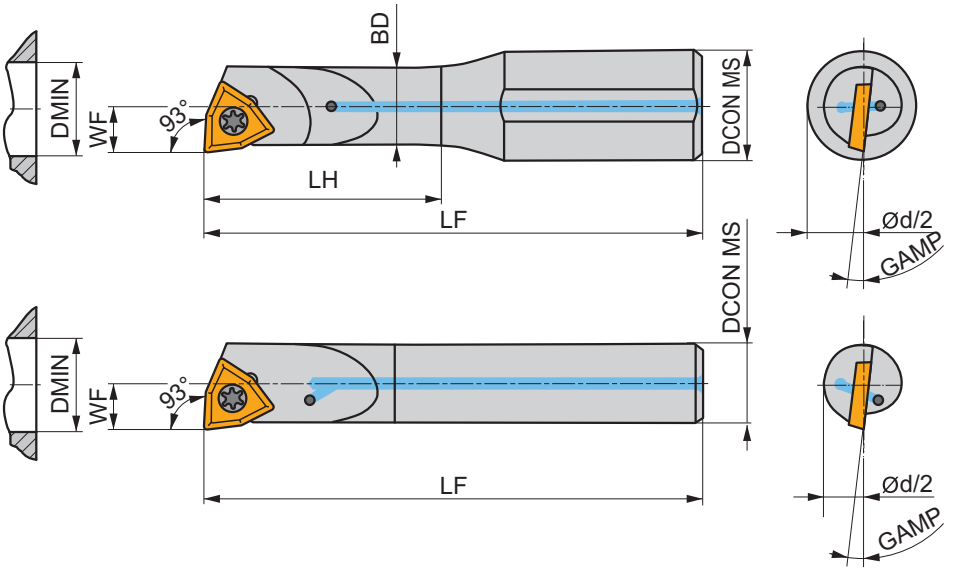
PRAMET

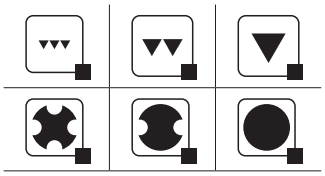
S

Internal carbide Screw Lock Boring Bar with 93° Cutting Angle for WC.. Inserts

Internal Right/Left hand carbide boring bar, through coolant, with 93° cutting angle for screw type WC.. inserts. Suited for internal taper and longitudinal turning with shoulder and chamfer turning. For tool overhang >3xD.







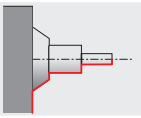
	Product	DCON MS (mm)	DMIN (mm)	BD (mm)	WF (mm)	LF (mm)	LH (mm)	GAMP (°)		lbs			MID
R	E0508H-SWUCR 02	8	5.8	5	2.9	100	24.0	-17	✓	.13	GI221	SW21	6760587
	E05F-SWUCR 02	5	5.8	–	2.9	85	–	-17	✓	.06	GI221	SW21	6760591
	E0608H-SWUCR 02	8	7.8	6	3.9	100	32.0	-12	✓	.14	GI221	SW21	6760589
	E06G-SWUCR 02	6	7.8	–	3.9	95	–	-12	✓	.09	GI221	SW21	6760593
L	E0508H-SWUCL 02	8	5.8	5	2.9	100	24.0	-17	✓	.13	GI221	SW21	6760588
	E05F-SWUCL 02	5	5.8	–	2.9	85	–	-17	✓	.06	GI221	SW21	6760592
	E0608H-SWUCL 02	8	7.8	6	3.9	100	32.0	-12	✓	.14	GI221	SW21	6760590
	E06G-SWUCL 02	6	7.8	–	3.9	95	–	-12	✓	.09	GI221	SW21	6760594

GI221	WC.. 1.21.. (WC.. 0201..)

SW21	T20.037	0.6	M 2	0.146	DMD 1650

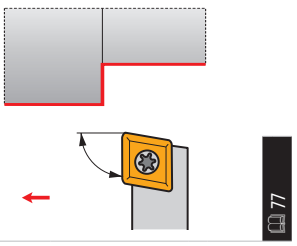
ISO TURNING – EXTERNAL

LONG AND UNSTABLE COMPONENTS (positive inserts)



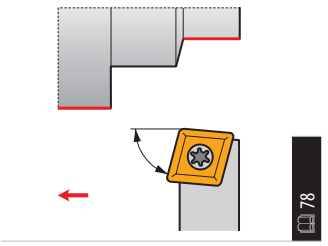
SCAC(RL) EXT 90°

CC..



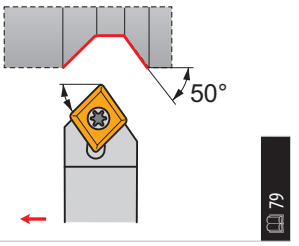
SCBC(RL) EXT 75°

CC..



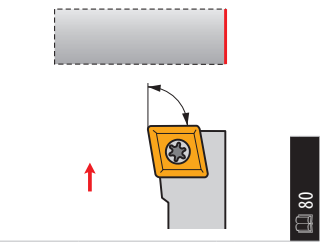
SCDCR EXT 45°

CC..



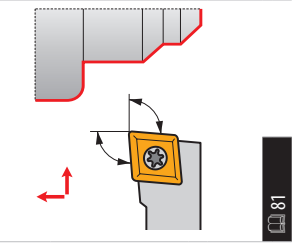
SCFC(RL) EXT 90°

CC..



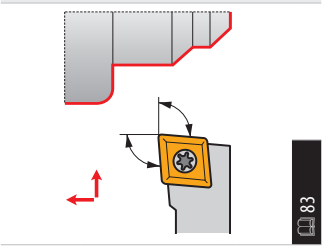
SCLC(RL) EXT 95°

CC..



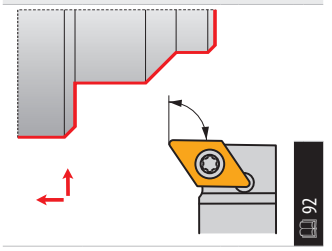
ISCLC(RL) EXT 95°

CC..



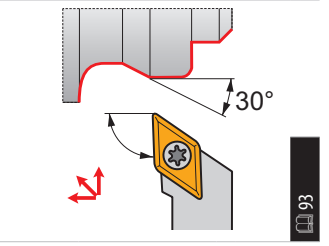
SDFC(RL) EXT 91°

DC..



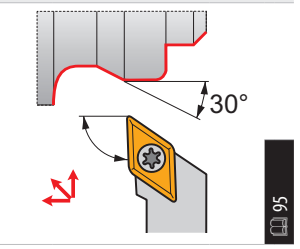
SDJC(RL) EXT 93°

DC..



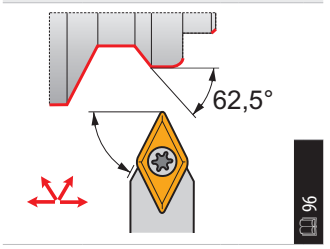
ISDJC(RL) EXT 93°

DC..



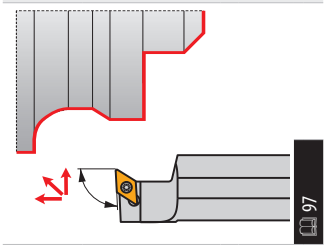
SDNCN EXT 62°30´

DC..



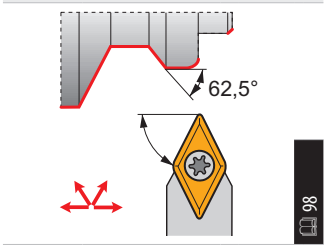
SDUCL EXT 93°

DC..



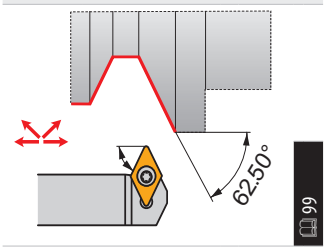
ISDPCN EXT

DC..



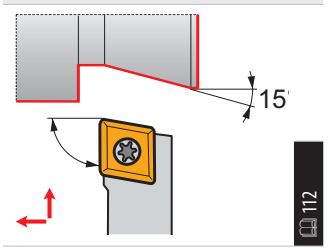
SDXC(RL) EXT 62°30´

DC..



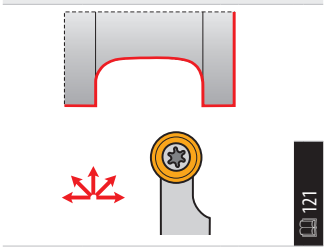
SEGC(RL) EXT 90°

EC..



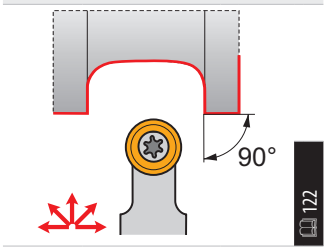
SRDC(RL) EXT

RC..



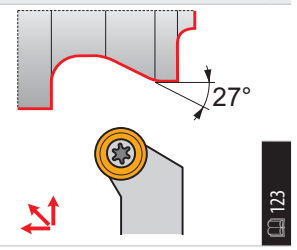
SRDCN EXT

RC..



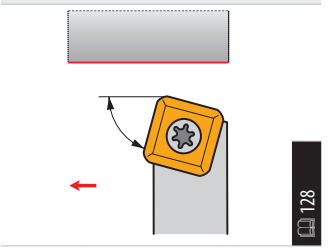
SRSC (RL) EXT

RC..



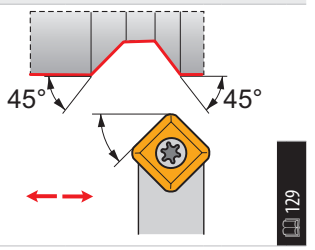
SSBC(RL) EXT 75°

SC..



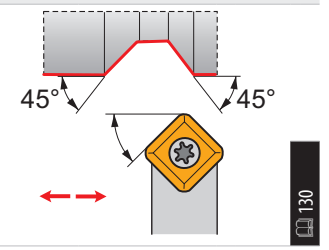
SSDCN EXT 45°

SC..



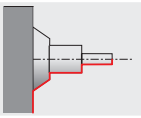
ISSDCN EXT 45°

SC..



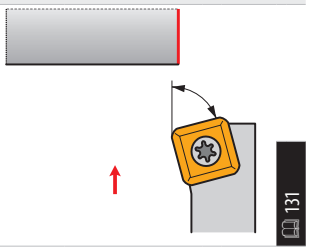
ISO TURNING – EXTERNAL

LONG AND UNSTABLE COMPONENTS (positive inserts)



SSKC(RL) EXT 75°

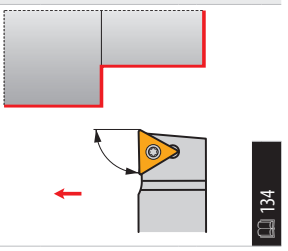
SC..



131

STAC(RL) EXT 90°

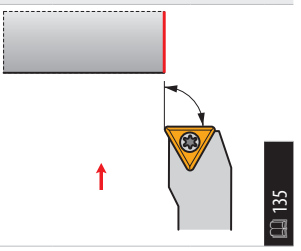
TC..



134

STFC(RL) EXT 90°

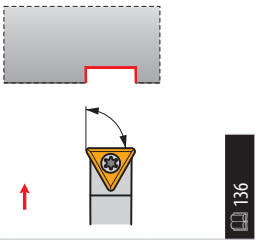
TC..



135

STFC(RL)-A EXT 90°

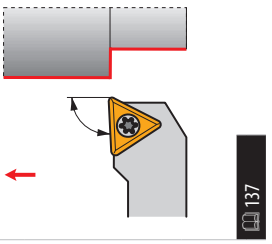
TC..



136

ISTGC(RL) EXT

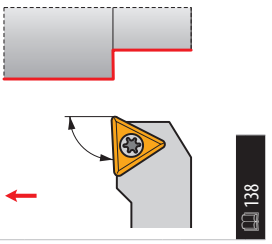
TC..



137

STJC(RL) EXT 93°

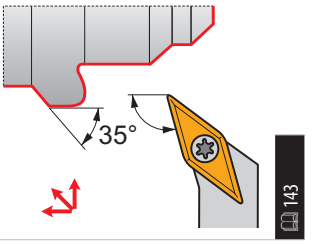
TC..



138

SVHB(C)(RL) EXT 107°30´

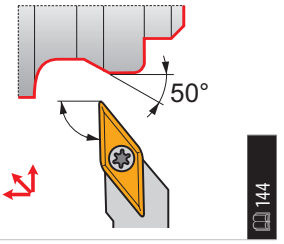
VB, VC..



143

SVJB(C)(RL) EXT 93°

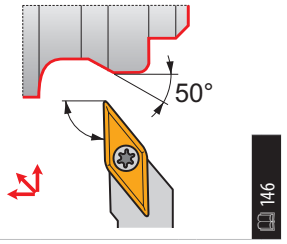
VB, VC..



144

ISVJB(C)(RL) EXT 93°

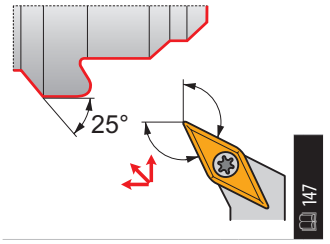
VB, VC..



146

SVPB(C)(RL) EXT 117°30´

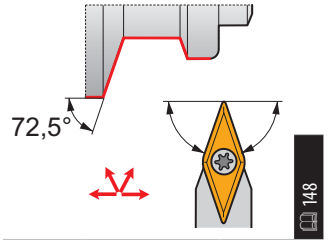
VB, VC..



147

SVVB(C)N EXT 72°30´

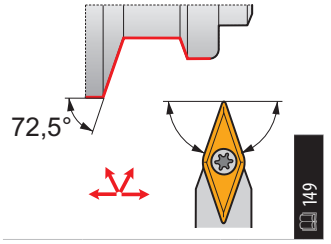
VB, VC..



148

ISVVB(C)N EXT 72°30´

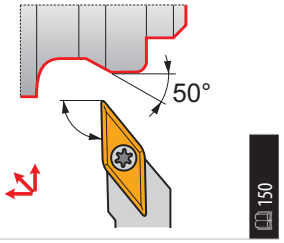
VB, VC..



149

SVXB(C)(RL) EXT 98°

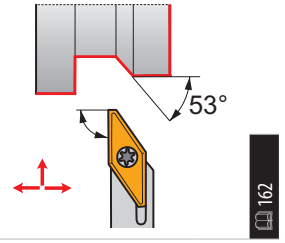
VB, VC..



150

SVAC(RL)-DC EXT 90°

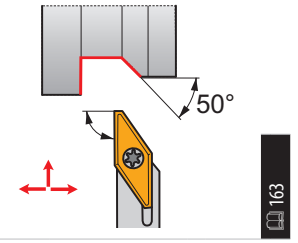
VC..



162

SVJC(RL)-DC EXT 93°

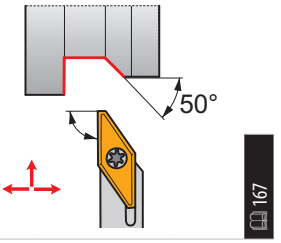
VC..



163

SWLC(RL) EXT 95°

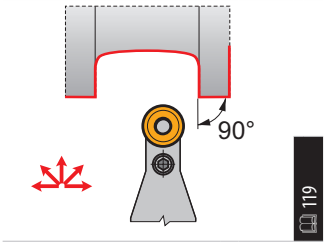
WC..



167

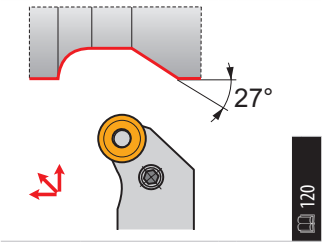
PRDCN EXT

RC..



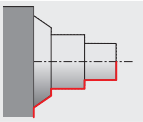
PRSC(RL) EXT

RC..



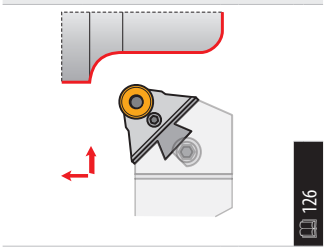
ISO TURNING – HEAVY ROUGHING – EXTERNAL

HEAD (KH)



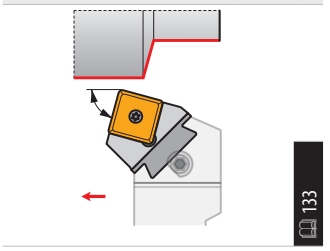
KHP-RSCR/L

RC..



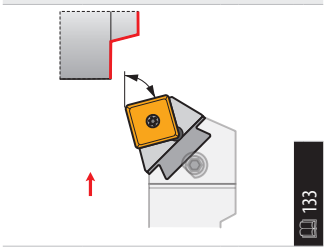
KHS-SBCR 75°

SC..

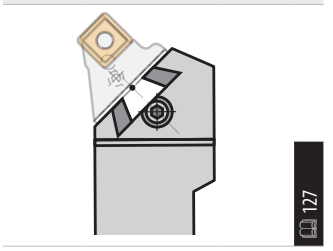


KHS-SBCL 75°

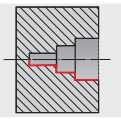
SC..



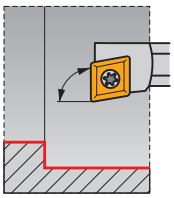
DKH(RL)



ISO TURNING – INTERNAL
LONG AND UNSTABLE COMPONENTS (positive inserts)

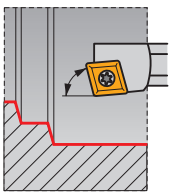


SCFC(RL) INT 90°
CC..



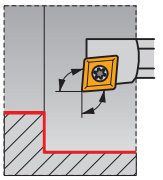
85

SCKC(RL) INT 75°
CC..



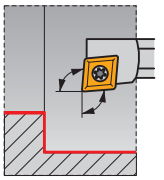
86

SCLC(RL) INT 45°
CC..



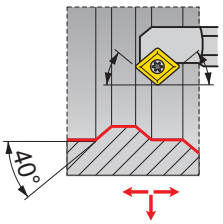
87

ISCLC(RL) INT 45°
CC..



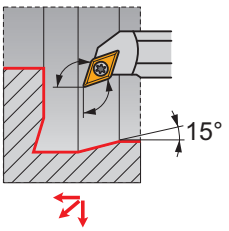
89

SCXC(RL) INT 90°
CC..



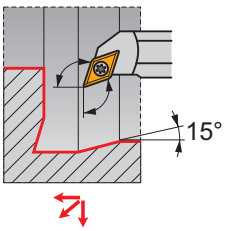
90

SDQC(RL) INT 95°
DC..



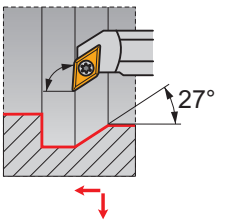
102

ISDQC(RL) INT 95°
DC..



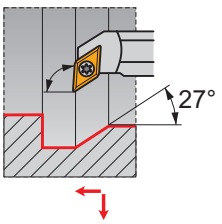
104

SDUC(RL) INT 93°
DC..



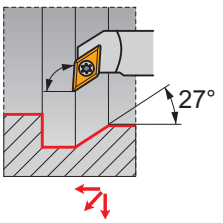
105

ISDUC(RL) INT 93°
DC..



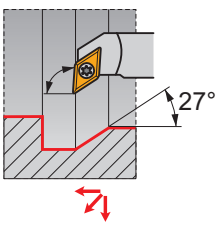
106

SDUC(RL)-E INT 62°30´
DC..



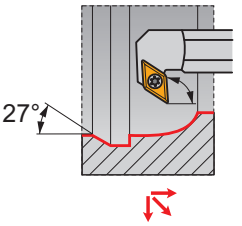
107

ISDUC(RL)-E INT 62°30´
DC..



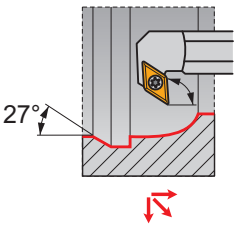
108

SDZC(RL) INT 90°
DC..



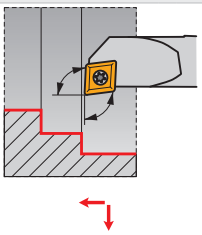
109

ISDZC(RL) INT 90°
DC..



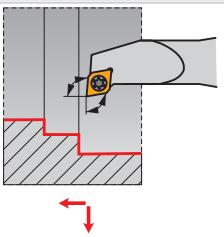
110

SEUC(RL) INT 93°
EC..



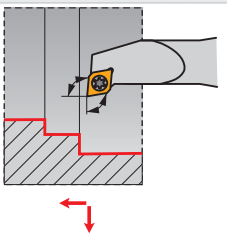
113

SELP(RL) INT 95°
EP..



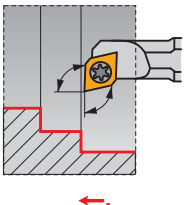
114

SELP(RL)-E INT 95°
EP..



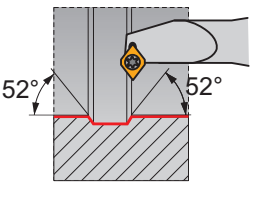
115

SEUP(RL) INT 93°
EP..



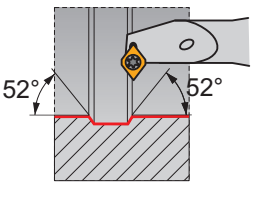
116

SEXP(RL) INT 52°30´
EP..



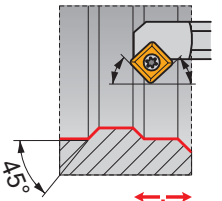
117

SEXP(RL)-E INT 52°30´
EP..



118

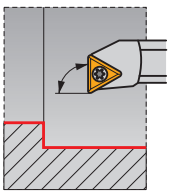
SSSC(RL) INT 45°
SC..



132

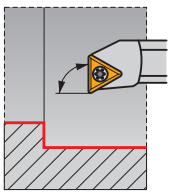
ISO TURNING – INTERNAL
LONG AND UNSTABLE COMPONENTS (positive inserts)

STFC(RL) INT 90°
TC..



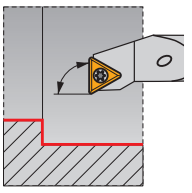
139

ISTFC(RL) INT 90°
TC..



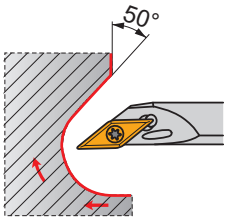
141

STFC(RL)-E INT 90°
TC..



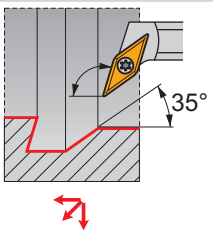
142

SVJB(RL) INT 93°
VB, VC..



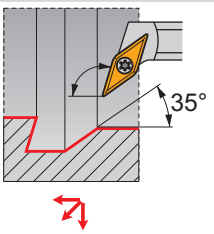
154

SVQB(C)(RL) INT 107°30´
VB, VC..



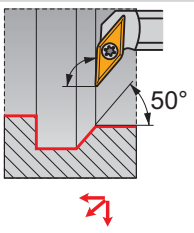
155

ISVQB(C)(RL) INT 107°30´
VB, VC..



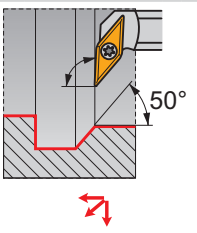
157

SVUB(C)(RL) INT 93°
VB, VC..



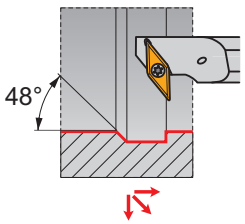
158

ISVUB(C)(RL) INT 93°
VB, VC..



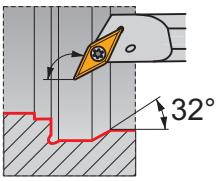
160

SVLC(RL) INT 95°
VC..



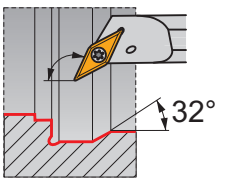
164

SVXC(RL) INT 113°
VC..



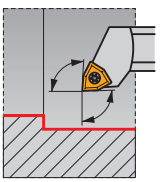
165

SVXC(RL)-E INT 113°
VC..



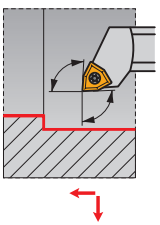
166

SWLC(RL) INT 95°
WC..



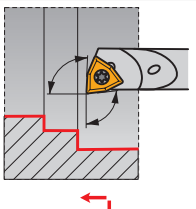
168

ISWLC(RL) INT 95°
WC..



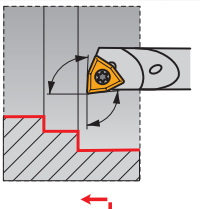
169

SWUC(RL) INT 93°
WC..



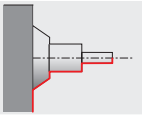
170

SWUC(RL)-E INT 93°
WC..

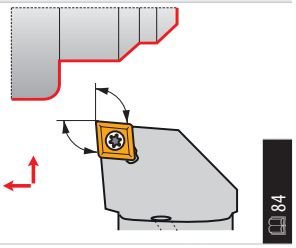


171

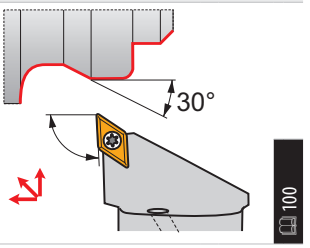
ISO TURNING – EXTERNAL PSC
LONG AND UNSTABLE COMPONENTS (positive inserts)



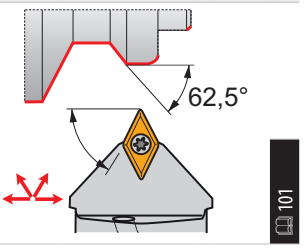
C.-SCLC(RL) EXT 95°
CC..



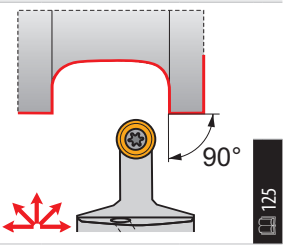
C.-SDJC(RL) EXT 93°
DC..



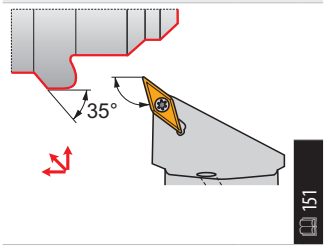
C.-SDNCN EXT 62°30´
DC..



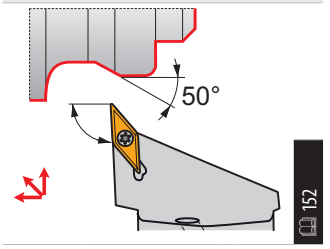
C.-SRDCN EXT
RC..



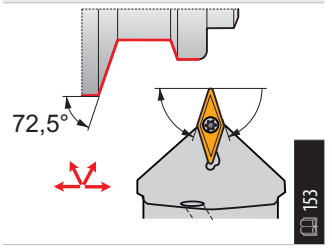
C.-SVHB(RL) EXT 107°30´
VB, VC..



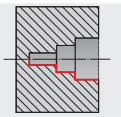
C.-SVJB(RL) EXT 93°
VB, VC..



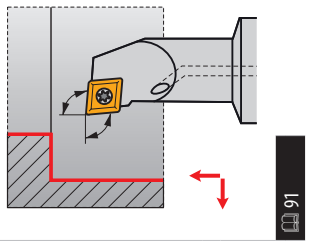
C.-SVVBN EXT 72°30´
VB, VC..



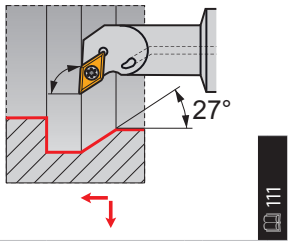
ISO TURNING – INTERNAL PSC
LONG AND UNSTABLE COMPONENTS (positive inserts)



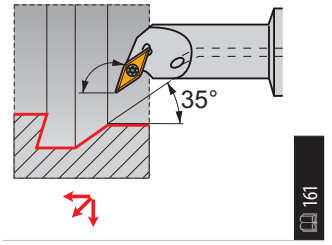
C.-SCLC(RL) INT 95°
CC..

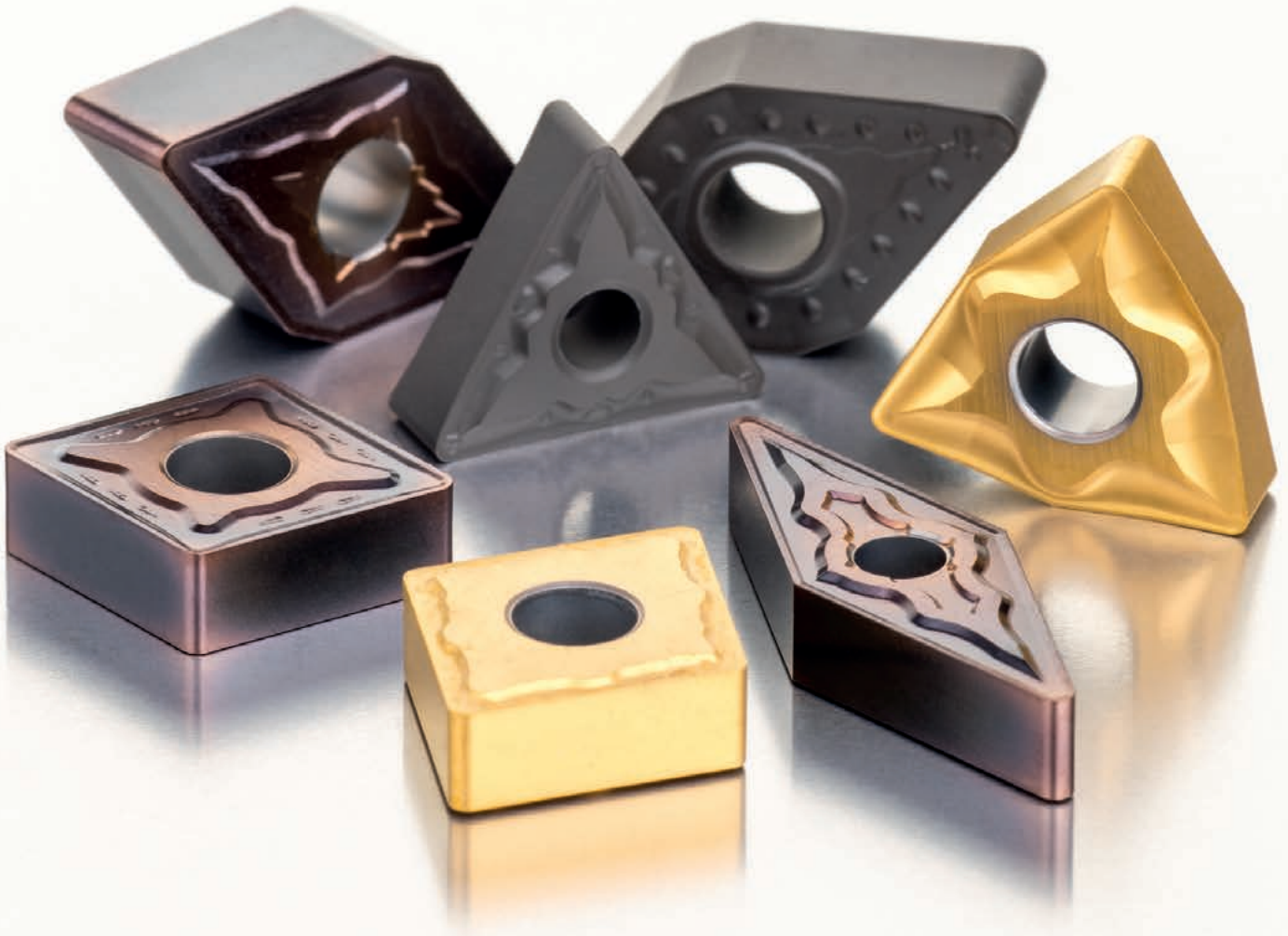


C.-SDUC(RL) INT 93°
DC..



C.-SVQB(C)(RL) INT 108°
VB, VC..





NEGATIVE INSERTS

P

Very unstable working conditions

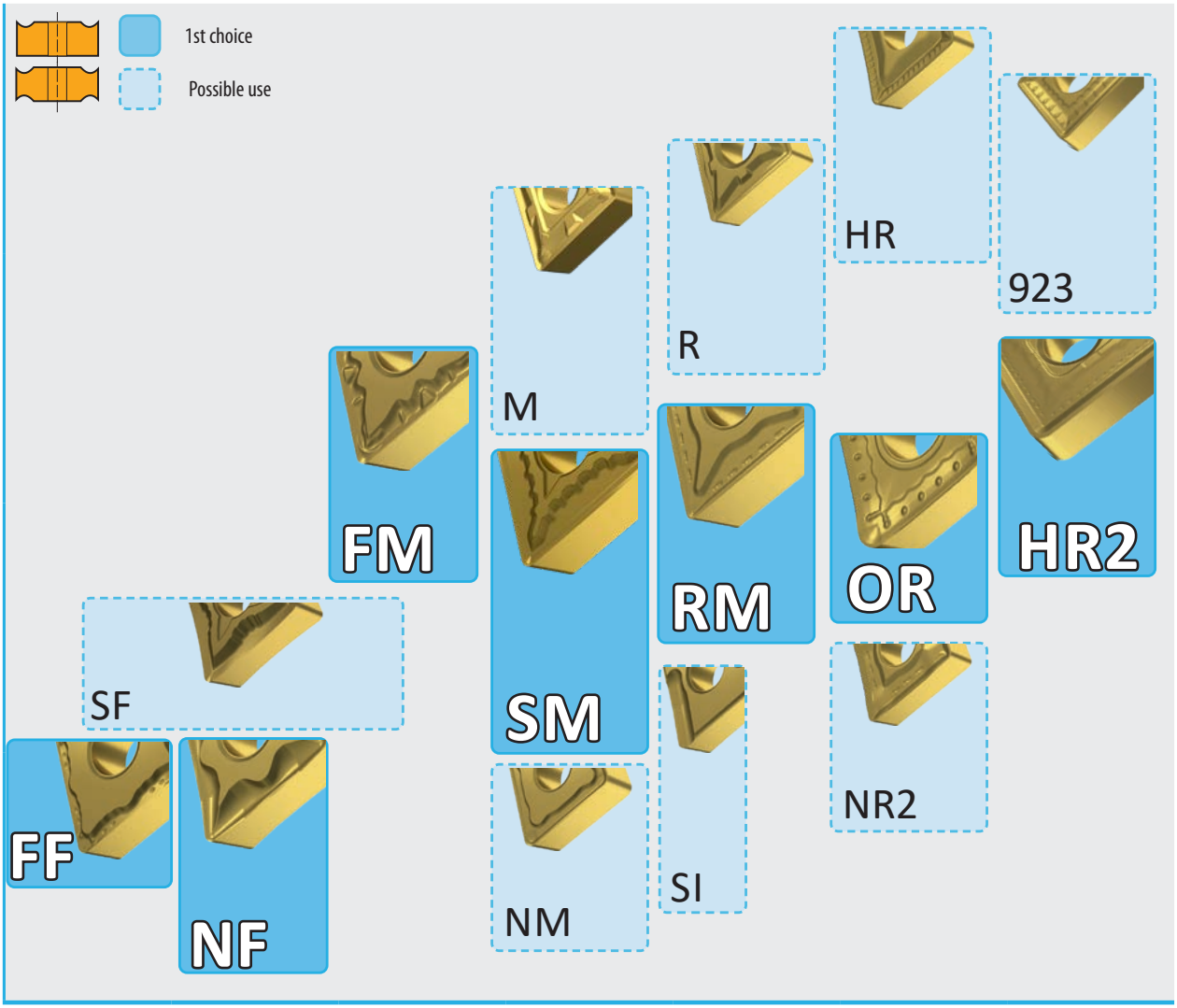
Unstable working conditions

Stable working conditions

Thin -walled and slim workpieces

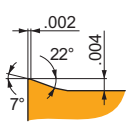
1st choice

Possible use



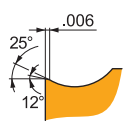
	FF	F	M	R	HR
f ⇨	.001 – .007 in/rev	.001 – .007 in/rev	.007 – .015 in/rev	.015 – .039 in/rev	> .039 in/rev
a_p	.001 – .078 in	.001 – .078 in	.078 – .157 in	.157– .393 in	> .393in

FF



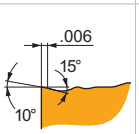
Highly positive geometry designed for fine finish machining, stainless steel and steel, potentially cast irons, continuous cuts

NF



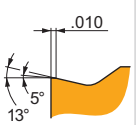
Highly positive design for fine finish and medium machining, stainless steels. steel, potentially cast irons, non ferrous materials and super alloys, continuous cuts

FM



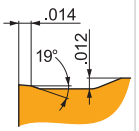
Positive geometry designed for finish to semi-rough machining, steel and cast irons, potentially and super alloys, continuous and moderately interrupted cuts

SM



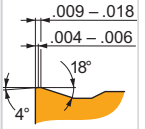
Positive geometry designed for medium machining, stainless steels, super alloys, steels and cast irons, potentially non ferrous and hard materials and for machining thin walls, continuous and interrupted cuts

RM



Designed for semi-rough and rough machining, steels, stainless steels and cast irons, potentailly super alloys, continuous and interrupted cuts

OR



Designed for finish to heavy rough machining, steels and cast irons, potentially stainless steel and super alloys, continuous and interrupted cuts

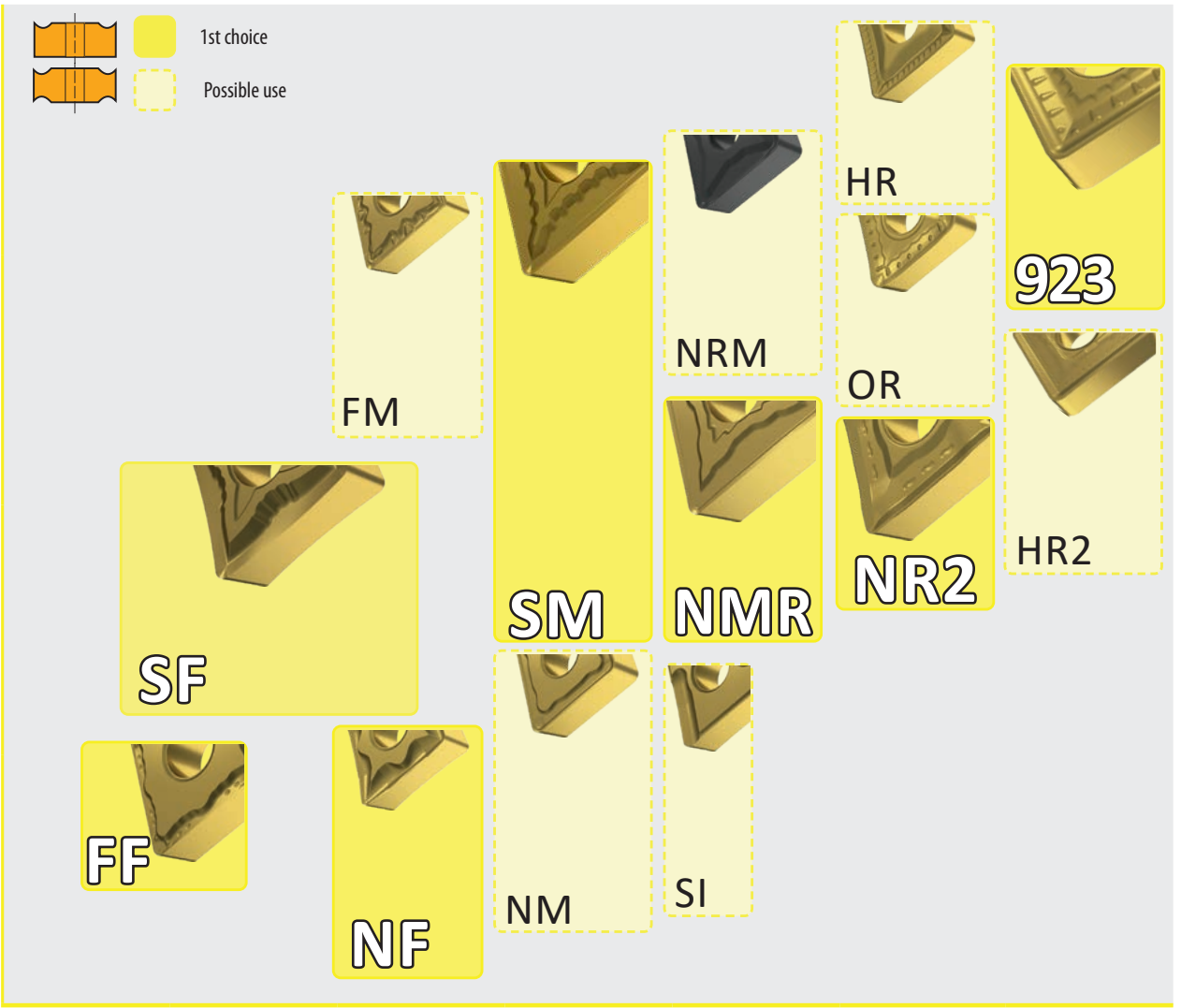
M

Very unstable working conditions

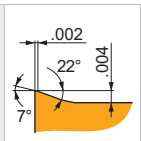
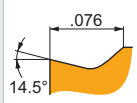
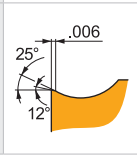
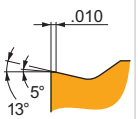
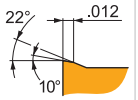
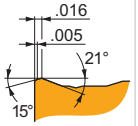
Unstable working conditions

Stable working conditions

Thin -walled and slim workpieces



	FF	F	M	R	HR
f	.001 – .007 in/rev	.001 – .007 in/rev	.007 – .015 in/rev	.015 – .039 in/rev	> .039 in/rev
a_p	.001 – .078 in	.001 – .078 in	.078 – .157 in	.157– .393 in	> .393in

FF		Highly positive geometry designed for fine finish machining, stainless steel and steel, potentially cast irons, continuous cuts
SF		Versatile positive geometry designed for fine finish machining, steels, stainless steels, cast irons and super alloys and hard materials, potentially non ferous materials and for machining thin walls, with continuous cuts
NF		Highly positive design for fine finish and medium machining, stainless steels. steel, potentially cast irons, non ferrous materials and super alloys, continuous cuts
SM		Positive geometry designed for medium machining, stainless steels, super alloys, steels and cast irons, potentially non ferrous and hard materials and for machining thin walls, continuous and interrupted cuts
NMR		Positive design for medium to rough machining, stainless steels as well as soft steels and super alloys, continuous cuts
NR2		Designed for finish to rough machining, stainless steels and steels, potentially cast irons and super alloys, continuous and interrupted cuts

K

Very unstable working conditions

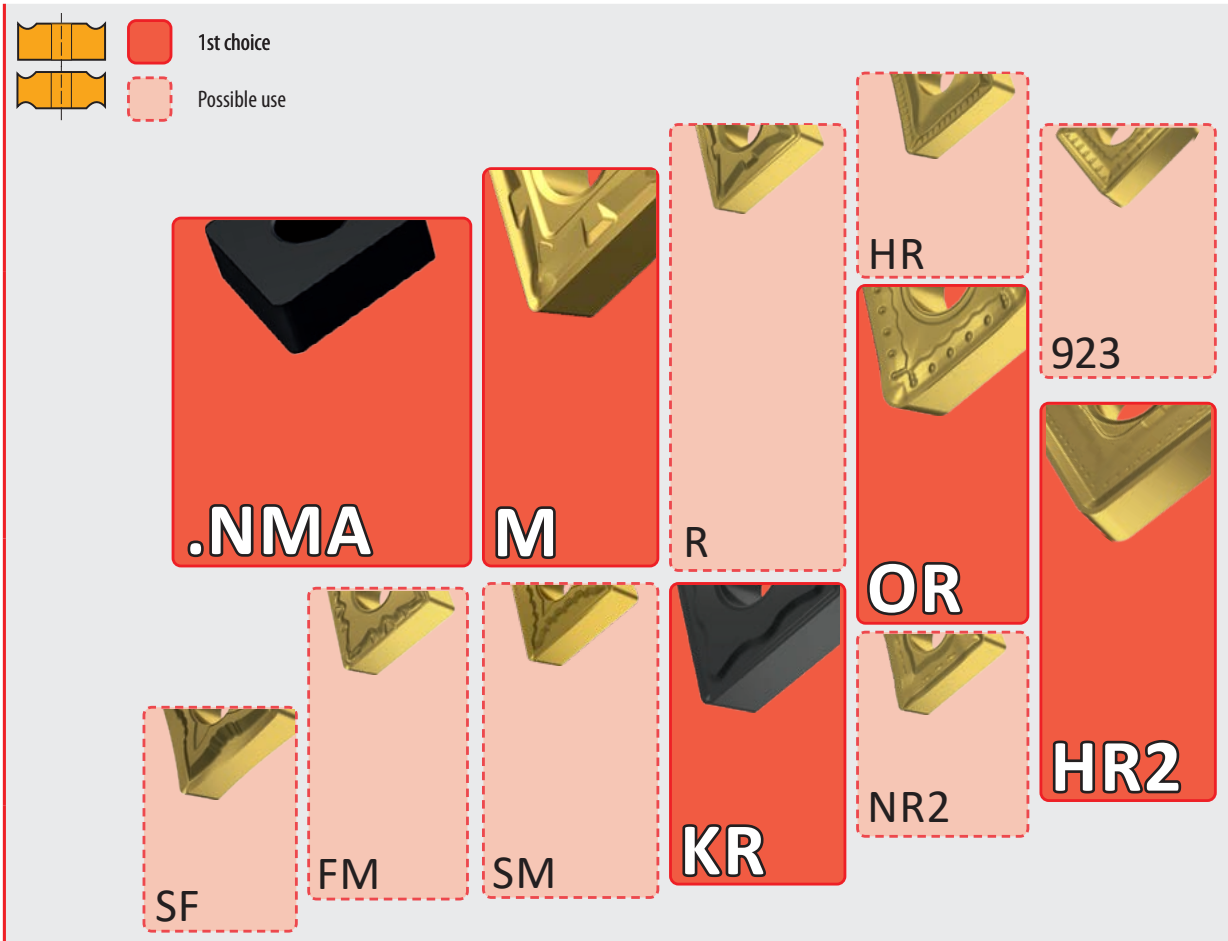
Unstable working conditions

Stable working conditions

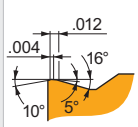
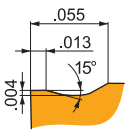
Thin -walled and slim workpieces

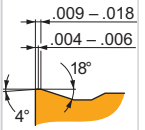
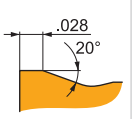
1st choice

Possible use



	FF	F	M	R	HR
f	.001 – .007 in/rev	.001 – .007 in/rev	.007 – .015 in/rev	.015 – .039 in/rev	> .039 in/rev
a_p	.001 – .078 in	.001 – .078 in	.078 – .157 in	.157– .393 in	> .393in

.NMA		Designed for fine finish to semi rough machining, cast irons, potentially hard materials, continuous and slightly interrupted cuts
M		Designed for finish and semi-rough machining, cast irons, potentially steels and hard materials, continuous and interrupted cuts
KR		Designed for semi-rough and rough machining, cast irons, potentially steel and hard materials, continuous and interrupted cuts

OR		Designed for finish to heavy rough machining, steels and cast irons, potentially stainless steel and super alloys, continuous and interrupted cuts
HR2		Designed for rough to heavy rough machining with high feeds, steels and cast irons, potentially stainless steels, continuous and interrupted cuts

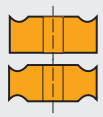
N

Very unstable working conditions

Unstable working conditions

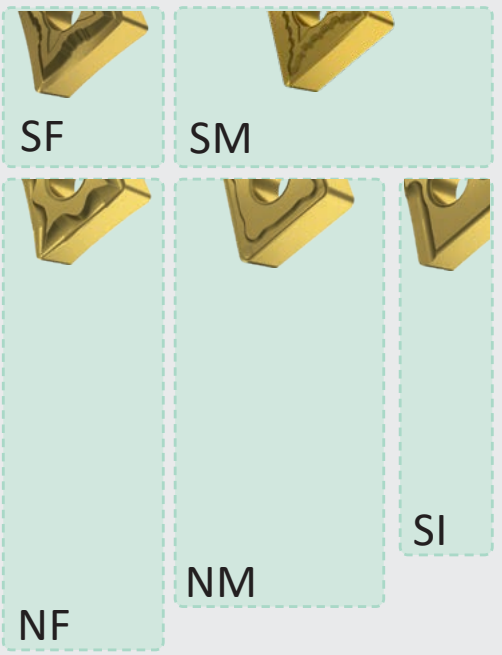
Stable working conditions

Thin -walled and slim workpieces

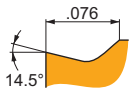
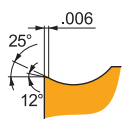
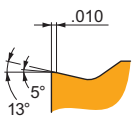
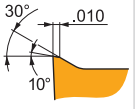
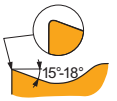


1st choice

Possible use



	FF	F	M	R	HR
f	.001 – .007 in/rev	.001 – .007 in/rev	.007 – .015 in/rev	.015 – .039 in/rev	> .039 in/rev
a_p	.001 – .078 in	.001 – .078 in	.078 – .157 in	.157– .393 in	> .393in

SF		Versatile positive geometry designed for fine finish machining, steels, stainless steels, cast irons and super alloys and hard materials, potentially non ferous materials and for machining thin walls, with continuous cuts
NF		Highly positive design for fine finish and medium machining, stainless steels. steel, potentially cast irons, non ferrous materials and super alloys, continuous cuts
SM		Positive geometry designed for medium machining, stainless steels, super alloys, steels and cast irons, potentially non ferrous and hard materials and for machining thin walls, continuous and interrupted cuts
NM		Highly positive design for fine finish, medium and rough machining, stainless steels, steels, potentially non ferrrous materials and super alloys, continuous cuts
SI		Positive geometry for fine finish to semi-rough machining, steels, stainless steels and cast irons and potentially non ferrous materials, continuous cuts

S

Very unstable working conditions

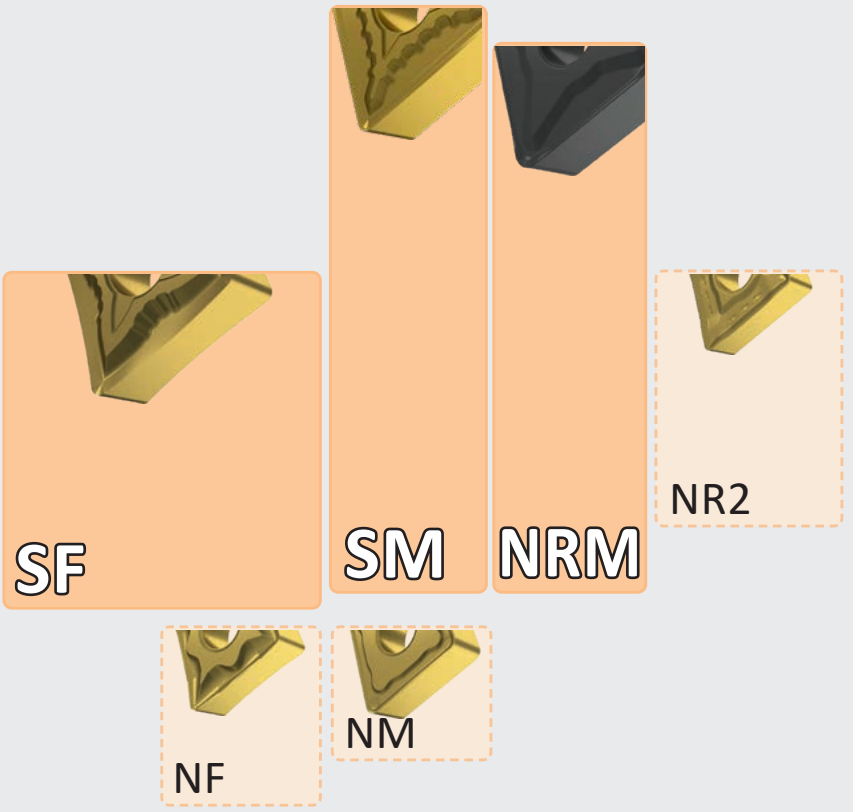
Unstable working conditions

Stable working conditions

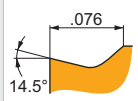
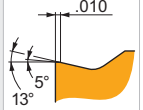
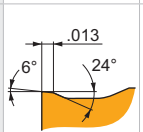
Thin -walled and slim workpieces

1st choice

Possible use



	FF	F	M	R	HR
f ⇨	.001 – .007 in/rev	.001 – .007 in/rev	.007 – .015 in/rev	.015 – .039 in/rev	> .039 in/rev
a_p	.001 – .078 in	.001 – .078 in	.078 – .157 in	.157– .393 in	> .393in

SF		Versatile positive geometry designed for fine finish machining, steels, stainless steels, cast irons and super alloys and hard materials, potentially non ferous materials and for machining thin walls, with continuous cuts
SM		Positive geometry designed for medium machining, stainless steels, super alloys, steels and cast irons, potentially non ferrous and hard materials and for machining thin walls, continuous and interrupted cuts
NRM		Positive design for semi-rough and rough machining, stainless steel, soft steels and super alloys, continuous cuts

H

Very unstable working conditions

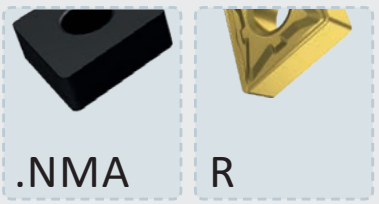
Unstable working conditions

Stable working conditions

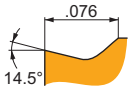
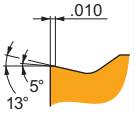
Thin -walled and slim workpieces

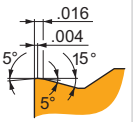
1st choice

Possible use

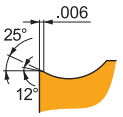
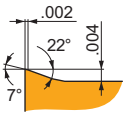


	FF	F	M	R	HR
f	.001 – .007 in/rev	.001 – .007 in/rev	.007 – .015 in/rev	.015 – .039 in/rev	> .039 in/rev
a_p	.001 – .078 in	.001 – .078 in	.078 – .157 in	.157– .393 in	> .393in

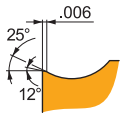
SF		Versatile positive geometry designed for fine finish machining, steels, stainless steels, cast irons and super alloys and hard materials, potentially non ferous materials and for machining thin walls, with continuous cuts
SM		Positive geometry designed for medium machining, stainless steels, super alloys, steels and cast irons, potentially non ferrous and hard materials and for machining thin walls, continuous and interrupted cuts
.NMA		Designed for fine finish to semi rough machining, cast irons, potentially hard materials, continuous and slightly interrupted cuts

R		Designed for semi-rough and rough machining, cast irons, potentially steel and hard materials, continuous and interrupted cuts

FINE-FINISHING – NAVIGATOR

NF			**NF** chip breaker is sharp and the first choice for fine-finishing of Steels, Stainless steels. It features highly positive rake angle and highly positive, narrow T-land. It's also conditionally suitable for Cast irons and Non-ferrous alloys and Super-alloy
FF			**FF** chip breaker is sharp and designed for fine-finishing of Steels, Stainless steels. It features positive rake angle and positive, thin T-land. It's also conditionally suitable for Cast irons.

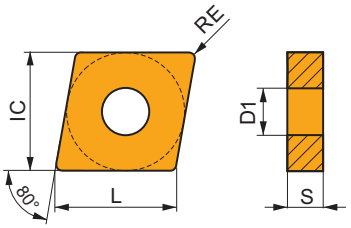
NF



NF chip breaker is sharp and the first choice for fine-finishing of Steels, Stainless steels. It features highly positive rake angle and highly positive, narrow T-land. It's also conditionally suitable for Cast irons and Non-ferrous alloys and Super-alloy

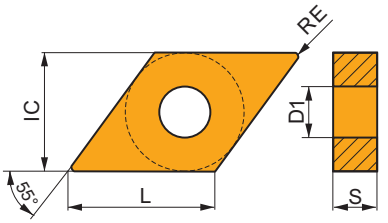
CNMG

	IC (inch)	D1 (inch)	L (inch)	S (inch)
32	.375	.150	.382	.125
43	.500	.203	.508	.187



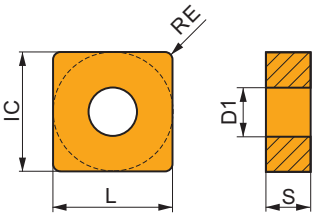
DNMG

	IC (inch)	D1 (inch)	L (inch)	S (inch)
33	.375	.150	.457	.187
43	.500	.203	.610	.187
44	.500	.203	.610	.250



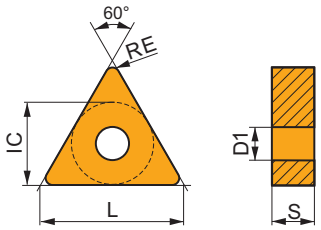
SNMG

	IC (inch)	D1 (inch)	L (inch)	S (inch)
43	.500	.203	.500	.187



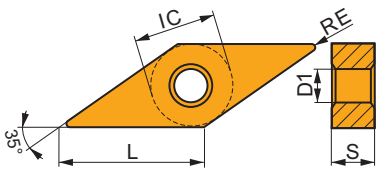
TNMG

	IC (inch)	D1 (inch)	L (inch)	S (inch)
33	.375	.150	.650	.187



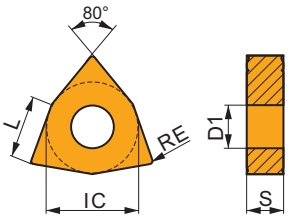
VNMG

	IC (inch)	D1 (inch)	L (inch)	S (inch)
33	.375	.150	.654	.187

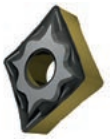
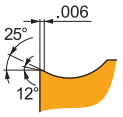


WNMG

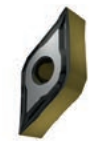
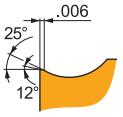
	IC (inch)	D1 (inch)	L (inch)	S (inch)
33	.375	.150	.256	.187
43	.500	.203	.343	.187



Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our cutting conditions app for further options.

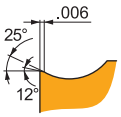
Product		RE	P			M			K			N			S			H			MID
			vc (ft/min)	f (in/rev)	ap (inch)	vc (ft/min)	f (in/rev)	ap (inch)	vc (ft/min)	f (in/rev)	ap (inch)	vc (ft/min)	f (in/rev)	ap (inch)	vc (ft/min)	f (in/rev)	ap (inch)	vc (ft/min)	f (in/rev)	ap (inch)	
																					
CNMG 321-NF	**T6310**	.016	623	.0067	.031	443	.0059	.031	492	.0067	.031	1870	.0079	.031	180	.0047	.024	–	–	–	6922831
	T7335	.016	689	.0071	.031	525	.0063	.031	–	–	–	–	–	–	213	.0063	.024	–	–	–	6834619
	T8430	.016	738	.0067	.031	394	.0059	.031	607	.0067	.031	2018	.0079	.031	148	.0047	.024	–	–	–	7977311
	T9325	.016	869	.0071	.031	509	.0063	.031	820	.0071	.031	–	–	–	180	.0063	.024	–	–	–	6834642
CNMG 322-NF	**T8430**	.031	804	.0075	.039	443	.0067	.039	656	.0075	.039	2215	.0091	.039	164	.0059	.031	–	–	–	7977313
	T9325	.031	984	.0075	.039	591	.0067	.039	935	.0075	.039	–	–	–	213	.0059	.031	–	–	–	6834646
CNMG 431-NF	**HF7**	.016	–	–	–	312	.0059	.067	509	.0067	.067	1624	.0079	.067	–	–	–	–	–	–	6834647
	T6310	.016	591	.0067	.067	410	.0059	.067	476	.0067	.067	1772	.0079	.067	164	.0055	.055	–	–	–	6922833
	T7325	.016	656	.0071	.067	509	.0063	.067	–	–	–	–	–	–	213	.0063	.055	–	–	–	7156187
	T7335	.016	640	.0071	.067	492	.0063	.067	–	–	–	–	–	–	197	.0063	.055	–	–	–	6834648
	T8430	.016	656	.0067	.067	361	.0059	.067	541	.0067	.067	1821	.0079	.067	131	.0055	.055	–	–	–	7977059
	T9325	.016	820	.0071	.067	492	.0063	.067	771	.0071	.067	–	–	–	180	.0063	.055	–	–	–	6834652
	T9415	.016	1033	.0067	.067	–	–	–	968	.0067	.067	–	–	–	–	–	–	–	–	–	8345269
CNMG 432-NF	**HF7**	.031	–	–	–	361	.0067	.067	591	.0075	.067	1870	.0091	.067	–	–	–	–	–	–	6834653
	T6310	.031	656	.0075	.067	459	.0067	.067	525	.0075	.067	1969	.0091	.067	197	.0059	.055	–	–	–	6922834
	T7325	.031	771	.0075	.067	591	.0067	.067	–	–	–	–	–	–	246	.0059	.055	–	–	–	7156196
	T7335	.031	738	.0075	.067	574	.0067	.067	–	–	–	–	–	–	230	.0059	.055	–	–	–	6834654
	T8315	.031	705	.0075	.067	410	.0067	.067	656	.0075	.067	2116	.0091	.067	164	.0059	.055	–	–	–	6834655
	T8430	.031	771	.0075	.067	410	.0067	.067	623	.0075	.067	2116	.0091	.067	164	.0059	.055	–	–	–	7977106
	T9325	.031	935	.0075	.067	558	.0067	.067	886	.0075	.067	–	–	–	197	.0059	.055	–	–	–	6834658
	T9415	.031	1181	.0075	.067	–	–	–	1115	.0075	.067	–	–	–	–	–	–	–	–	–	8345515
CNMG 433-NF	**T6310**	.047	607	.0118	.083	427	.0106	.083	476	.0118	.083	1821	.0142	.083	180	.0083	.067	–	–	–	6922835
	T7325	.047	673	.0118	.083	509	.0106	.083	–	–	–	–	–	–	213	.0083	.067	–	–	–	7156205
	T7335	.047	656	.0118	.083	509	.0106	.083	–	–	–	–	–	–	213	.0083	.067	–	–	–	6834659
	T8430	.047	656	.0118	.083	361	.0106	.083	541	.0118	.083	1821	.0142	.083	131	.0083	.067	–	–	–	7977317
	T9415	.047	1033	.0118	.083	–	–	–	968	.0118	.083	–	–	–	–	–	–	–	–	–	8345518

NF chip breaker is sharp and the first choice for fine-finishing of Steels, Stainless steels. It features highly positive rake angle and highly positive, narrow T-land. It's also conditionally suitable for Cast irons and Non-ferrous alloys and Super-alloys.

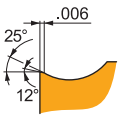
Product		RE	P			M			K			N			S			H			MID
			vc (ft/min)	f (in/rev)	ap (inch)	vc (ft/min)	f (in/rev)	ap (inch)	vc (ft/min)	f (in/rev)	ap (inch)	vc (ft/min)	f (in/rev)	ap (inch)	vc (ft/min)	f (in/rev)	ap (inch)	vc (ft/min)	f (in/rev)	ap (inch)	
																					
DNMG 331-NF	**T6310**	.016	509	.0059	.031	361	.0055	.031	410	.0059	.031	1526	.0071	.031	148	.0047	.024	–	–	–	6922836
	T7325	.016	558	.0071	.031	427	.0063	.031	–	–	–	–	–	–	180	.0063	.024	–	–	–	7156259
	T7335	.016	541	.0071	.031	410	.0063	.031	–	–	–	–	–	–	164	.0063	.024	–	–	–	6834663
	T8430	.016	623	.0059	.031	344	.0055	.031	509	.0059	.031	1722	.0071	.031	131	.0047	.024	–	–	–	7977347
	T9325	.016	689	.0071	.031	410	.0063	.031	640	.0071	.031	–	–	–	148	.0063	.024	–	–	–	6834666
DNMG 332-NF	**T6310**	.031	574	.0067	.039	410	.0059	.039	459	.0067	.039	1722	.0079	.039	164	.0055	.031	–	–	–	6922837
	T7325	.031	656	.0071	.039	509	.0063	.039	–	–	–	–	–	–	213	.0063	.031	–	–	–	7156267
	T7335	.031	640	.0071	.039	492	.0063	.039	–	–	–	–	–	–	197	.0063	.031	–	–	–	6834667
	T8430	.031	673	.0067	.039	361	.0059	.039	558	.0067	.039	1870	.0079	.039	148	.0055	.031	–	–	–	7977353
	T9325	.031	820	.0071	.039	492	.0063	.039	771	.0071	.039	–	–	–	180	.0063	.031	–	–	–	6834670
	T9415	.031	1033	.0067	.039	–	–	–	968	.0067	.039	–	–	–	–	–	–	–	–	–	8345545
DNMG 431-NF	**T6310**	.016	459	.0067	.067	328	.0059	.067	361	.0067	.067	1378	.0079	.067	131	.0059	.055	–	–	–	6922838
	T7325	.016	525	.0071	.067	394	.0063	.067	–	–	–	–	–	–	164	.0063	.055	–	–	–	7156277
	T7335	.016	509	.0071	.067	394	.0063	.067	–	–	–	–	–	–	164	.0063	.055	–	–	–	6834671
	T8430	.016	541	.0067	.067	295	.0059	.067	443	.0067	.067	1476	.0079	.067	115	.0059	.055	–	–	–	7977360
	T9325	.016	656	.0071	.067	394	.0063	.067	623	.0071	.067	–	–	–	148	.0063	.055	–	–	–	6834674
	T9415	.016	853	.0059	.067	–	–	–	804	.0059	.067	–	–	–	–	–	–	–	–	–	8345549
DNMG 432-NF	**T6310**	.031	541	.0071	.067	377	.0063	.067	427	.0071	.067	1624	.0087	.067	148	.0063	.055	–	–	–	6922839
	T7325	.031	623	.0071	.067	476	.0063	.067	–	–	–	–	–	–	197	.0063	.055	–	–	–	7156281
	T8430	.031	623	.0071	.067	344	.0063	.067	509	.0071	.067	1722	.0087	.067	131	.0063	.055	–	–	–	7977365
	T9415	.031	984	.0067	.067	–	–	–	935	.0067	.067	–	–	–	–	–	–	–	–	–	8345550

NF chip breaker is sharp and the first choice for fine-finishing of Steels, Stainless steels. It features highly positive rake angle and highly positive, narrow T-land. It's also conditionally suitable for Cast irons and Non-ferrous alloys and Super-alloys.

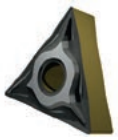
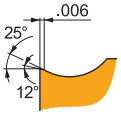
Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our cutting conditions app for further options.

Product		RE	P			M			K			N			S			H			MID
		(inch)	vc (ft/min)	f (in/rev)	ap (inch)	vc (ft/min)	f (in/rev)	ap (inch)	vc (ft/min)	f (in/rev)	ap (inch)	vc (ft/min)	f (in/rev)	ap (inch)	vc (ft/min)	f (in/rev)	ap (inch)	vc (ft/min)	f (in/rev)	ap (inch)	
																					
DNMG 441-NF	**HF7**	.016	–	–	–	262	.0055	.075	427	.0059	.075	1378	.0071	.075	–	–	–	–	–	–	6834679
	T6310	.016	459	.0067	.075	328	.0059	.075	361	.0067	.075	1378	.0079	.075	131	.0059	.059	–	–	–	6922840
	T7325	.016	509	.0071	.075	394	.0063	.075	–	–	–	–	–	–	164	.0063	.059	–	–	–	7156287
	T7335	.016	492	.0071	.075	377	.0063	.075	–	–	–	–	–	–	148	.0063	.059	–	–	–	6834680
	T8315	.016	476	.0067	.075	279	.0059	.075	443	.0067	.075	1427	.0079	.075	115	.0059	.059	–	–	–	6834681
	T8430	.016	541	.0067	.075	295	.0059	.075	443	.0067	.075	1476	.0079	.075	115	.0059	.059	–	–	–	7977121
	T9325	.016	640	.0071	.075	377	.0063	.075	607	.0071	.075	–	–	–	131	.0063	.059	–	–	–	6834684
	T9415	.016	853	.0059	.075	–	–	–	804	.0059	.075	–	–	–	–	–	–	–	–	–	8345552
DNMG 442-NF	**HF7**	.031	–	–	–	295	.0059	.075	476	.0067	.075	1526	.0079	.075	–	–	–	–	–	–	6834685
	T6310	.031	541	.0071	.075	377	.0063	.075	427	.0071	.075	1624	.0087	.075	148	.0063	.059	–	–	–	6922841
	T7325	.031	607	.0071	.075	459	.0063	.075	–	–	–	–	–	–	197	.0063	.059	–	–	–	7156295
	T7335	.031	591	.0071	.075	459	.0063	.075	–	–	–	–	–	–	180	.0063	.059	–	–	–	6834686
	T8315	.031	574	.0071	.075	344	.0063	.075	541	.0071	.075	1722	.0087	.075	131	.0063	.059	–	–	–	6834687
	T8430	.031	623	.0071	.075	344	.0063	.075	509	.0071	.075	1722	.0087	.075	131	.0063	.059	–	–	–	7977125
	T9325	.031	755	.0071	.075	443	.0063	.075	705	.0071	.075	–	–	–	164	.0063	.059	–	–	–	6834690
	T9415	.031	968	.0067	.075	–	–	–	919	.0067	.075	–	–	–	–	–	–	–	–	–	8345555
DNMG 443-NF	**T6310**	.047	492	.0118	.059	344	.0106	.059	394	.0118	.059	1476	.0142	.059	148	.0083	.047	–	–	–	6922842
	T8430	.047	541	.0118	.059	295	.0106	.059	443	.0118	.059	1476	.0142	.059	115	.0083	.047	–	–	–	7977378

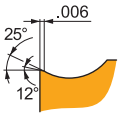
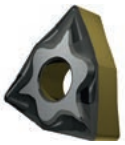
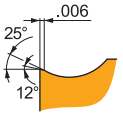
NF chip breaker is sharp and the first choice for fine-finishing of Steels, Stainless steels. It features highly positive rake angle and highly positive, narrow T-land. It's also conditionally suitable for Cast irons and Non-ferrous alloys and Super-alloys.

																					
SNMG 431-NF	**T6310**	.016	607	.0067	.067	427	.0059	.067	476	.0067	.067	1821	.0079	.067	180	.0055	.055	–	–	–	6922843
	T7335	.016	673	.0071	.067	509	.0063	.067	–	–	–	–	–	–	213	.0063	.055	–	–	–	6834694
	T8430	.016	689	.0067	.067	377	.0059	.067	574	.0067	.067	1919	.0079	.067	148	.0055	.055	–	–	–	7977130
	T9325	.016	853	.0071	.067	509	.0063	.067	804	.0071	.067	–	–	–	180	.0063	.055	–	–	–	6834697
SNMG 432-NF	**HF7**	.031	–	–	–	394	.0067	.067	623	.0075	.067	1969	.0091	.067	–	–	–	–	–	–	6834698
	T6310	.031	689	.0075	.067	492	.0067	.067	541	.0075	.067	2067	.0091	.067	197	.0059	.055	–	–	–	6922844
	T7325	.031	804	.0075	.067	623	.0067	.067	–	–	–	–	–	–	246	.0059	.055	–	–	–	7156335
	T7335	.031	787	.0075	.067	607	.0067	.067	–	–	–	–	–	–	246	.0059	.055	–	–	–	6834699
	T8315	.031	755	.0075	.067	443	.0067	.067	705	.0075	.067	2264	.0091	.067	180	.0059	.055	–	–	–	6834700
	T8430	.031	820	.0075	.067	443	.0067	.067	673	.0075	.067	2264	.0091	.067	164	.0059	.055	–	–	–	7977383
	T9325	.031	984	.0075	.067	591	.0067	.067	935	.0075	.067	–	–	–	213	.0059	.055	–	–	–	6834703

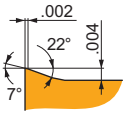
NF chip breaker is sharp and the first choice for fine-finishing of Steels, Stainless steels. It features highly positive rake angle and highly positive, narrow T-land. It's also conditionally suitable for Cast irons and Non-ferrous alloys and Super-alloys.

																					
TNMG 331-NF	**HF7**	.016	–	–	–	295	.0055	.055	459	.0059	.055	1476	.0071	.055	–	–	–	–	–	–	6834704
	T6310	.016	492	.0067	.055	344	.0059	.055	394	.0067	.055	1476	.0079	.055	148	.0059	.043	–	–	–	6922845
	T7325	.016	558	.0071	.055	427	.0063	.055	–	–	–	–	–	–	180	.0063	.043	–	–	–	7156378
	T7335	.016	541	.0071	.055	410	.0063	.055	–	–	–	–	–	–	164	.0063	.043	–	–	–	6834705
	T8315	.016	525	.0067	.055	312	.0059	.055	492	.0067	.055	1575	.0079	.055	131	.0059	.043	–	–	–	6834706
	T8430	.016	574	.0067	.055	312	.0059	.055	459	.0067	.055	1575	.0079	.055	115	.0059	.043	–	–	–	7977138
	T9325	.016	705	.0071	.055	410	.0063	.055	656	.0071	.055	–	–	–	148	.0063	.043	–	–	–	6834709
	T9415	.016	935	.0059	.055	–	–	–	886	.0059	.055	–	–	–	–	–	–	–	–	–	8345592
TNMG 332-NF	**HF7**	.031	–	–	–	328	.0059	.055	525	.0067	.055	1673	.0079	.055	–	–	–	–	–	–	6834710
	T6310	.031	591	.0071	.055	410	.0063	.055	476	.0071	.055	1772	.0087	.055	164	.0063	.043	–	–	–	6922846
	T7325	.031	656	.0071	.055	509	.0063	.055	–	–	–	–	–	–	213	.0063	.043	–	–	–	7156386
	T7335	.031	640	.0071	.055	492	.0063	.055	–	–	–	–	–	–	197	.0063	.043	–	–	–	6834711
	T8315	.031	623	.0071	.055	361	.0063	.055	591	.0071	.055	1870	.0087	.055	148	.0063	.043	–	–	–	6834712
	T8430	.031	673	.0071	.055	361	.0063	.055	558	.0071	.055	1870	.0087	.055	148	.0063	.043	–	–	–	7977142
	T9325	.031	837	.0071	.055	492	.0063	.055	787	.0071	.055	–	–	–	180	.0063	.043	–	–	–	6834715

Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our cutting conditions app for further options.

Product		RE	P				M				K				N				S				H				MID
			vc (ft/min)	f (in/rev)	ap (inch)		vc (ft/min)	f (in/rev)	ap (inch)		vc (ft/min)	f (in/rev)	ap (inch)		vc (ft/min)	f (in/rev)	ap (inch)		vc (ft/min)	f (in/rev)	ap (inch)		vc (ft/min)	f (in/rev)	ap (inch)		
																											
			NF chip breaker is sharp and the first choice for fine-finishing of Steels, Stainless steels. It features highly positive rake angle and highly positive, narrow T-land. It's also conditionally suitable for Cast irons and Non-ferrous alloys and Super-alloys.																							
VNMG 331-NF	**T6310**	.016	■	459	.0047	.047	■	328	.0043	.047	◪	361	.0047	.047	◪	1378	.0055	.047	◪	131	.0043	.039		–	–	–	6922852
	T7325	.016	◪	459	.0071	.047	■	344	.0063	.047		–	–	–		–	–	–	◪	148	.0063	.039		–	–	–	7156433
	T7335	.016	◪	459	.0071	.047	■	344	.0063	.047		–	–	–		–	–	–	◪	148	.0063	.039		–	–	–	6834716
	T8315	.016	◪	492	.0047	.047	■	295	.0043	.047	◪	459	.0047	.047	◪	1476	.0055	.047	◪	115	.0043	.039		–	–	–	6834717
	T8430	.016	■	574	.0047	.047	■	312	.0043	.047	◪	459	.0047	.047	◪	1575	.0055	.047	◪	115	.0043	.039		–	–	–	7977413
	T9325	.016	■	591	.0071	.047	■	344	.0063	.047	◪	558	.0071	.047		–	–	–	◪	131	.0063	.039		–	–	–	6834720
	T9415	.016	■	837	.0047	.047		–	–	–	◪	787	.0047	.047		–	–	–		–	–	–		–	–	–	8345602
VNMG 332-NF	**T6310**	.031	■	476	.0067	.055	■	328	.0059	.055	◪	377	.0067	.055	◪	1427	.0079	.055	◪	131	.0055	.043		–	–	–	6922853
	T7325	.031	◪	541	.0071	.055	■	410	.0063	.055		–	–	–		–	–	–	◪	164	.0063	.043		–	–	–	7156439
	T7335	.031	◪	525	.0071	.055	■	394	.0063	.055		–	–	–		–	–	–	◪	164	.0063	.043		–	–	–	6834721
	T8315	.031	◪	525	.0067	.055	■	312	.0059	.055	◪	492	.0067	.055	◪	1575	.0079	.055	◪	131	.0055	.043		–	–	–	6834722
	T8430	.031	■	574	.0067	.055	■	312	.0059	.055	◪	459	.0067	.055	◪	1575	.0079	.055	◪	115	.0055	.043		–	–	–	7977156
	T9325	.031	■	689	.0071	.055	■	410	.0063	.055	◪	640	.0071	.055		–	–	–	◪	148	.0063	.043		–	–	–	6834725
	T9415	.031	■	886	.0067	.055		–	–	–	◪	837	.0067	.055		–	–	–		–	–	–		–	–	–	8244317
																											
			NF chip breaker is sharp and the first choice for fine-finishing of Steels, Stainless steels. It features highly positive rake angle and highly positive, narrow T-land. It's also conditionally suitable for Cast irons and Non-ferrous alloys and Super-alloys.																							
WNMG 331-NF	**T6310**	.016	■	623	.0067	.031	■	443	.0059	.031	◪	492	.0067	.031	◪	1870	.0079	.031	◪	180	.0047	.024		–	–	–	6922847
	T7325	.016	◪	705	.0071	.031	■	541	.0063	.031		–	–	–		–	–	–	◪	213	.0063	.024		–	–	–	7156454
	T7335	.016	◪	689	.0071	.031	■	525	.0063	.031		–	–	–		–	–	–	◪	213	.0063	.024		–	–	–	6834726
	T8315	.016	◪	656	.0067	.031	■	394	.0059	.031	◪	623	.0067	.031	◪	1969	.0079	.031	◪	164	.0047	.024		–	–	–	6834727
	T8430	.016	■	738	.0067	.031	■	394	.0059	.031	◪	607	.0067	.031	◪	2018	.0079	.031	◪	148	.0047	.024		–	–	–	7977424
	T9325	.016	■	869	.0071	.031	■	509	.0063	.031	◪	820	.0071	.031		–	–	–	◪	180	.0063	.024		–	–	–	6834730
	T9415	.016	■	1115	.0067	.031		–	–	–	◪	1050	.0067	.031		–	–	–		–	–	–		–	–	–	8345607
WNMG 332-NF	**T6310**	.031	■	705	.0075	.039	■	492	.0067	.039	◪	558	.0075	.039	◪	2116	.0091	.039	◪	197	.0059	.031		–	–	–	6922848
	T7325	.031	◪	804	.0075	.039	■	623	.0067	.039		–	–	–		–	–	–	◪	246	.0059	.031		–	–	–	7156461
	T8430	.031	■	804	.0075	.039	■	443	.0067	.039	◪	656	.0075	.039	◪	2215	.0091	.039	◪	164	.0059	.031		–	–	–	7977158
	T9325	.031	■	984	.0075	.039	■	591	.0067	.039	◪	935	.0075	.039		–	–	–	◪	213	.0059	.031		–	–	–	6834733
	T9415	.031	■	1247	.0075	.039		–	–	–	◪	1181	.0075	.039		–	–	–		–	–	–		–	–	–	8345609
WNMG 431-NF	**HF7**	.016		–	–	–	◪	312	.0059	.067	◪	509	.0067	.067	◪	1624	.0079	.067		–	–	–		–	–	–	6834734
	T6310	.016	■	591	.0067	.067	■	410	.0059	.067	◪	476	.0067	.067	◪	1772	.0079	.067	◪	164	.0055	.055		–	–	–	6922849
	T7325	.016	◪	656	.0071	.067	■	509	.0063	.067		–	–	–		–	–	–	◪	213	.0063	.055		–	–	–	7156473
	T7335	.016	◪	640	.0071	.067	■	492	.0063	.067		–	–	–		–	–	–	◪	197	.0063	.055		–	–	–	6834735
	T8315	.016	◪	607	.0067	.067	■	361	.0059	.067	◪	574	.0067	.067	◪	1821	.0079	.067	◪	148	.0055	.055		–	–	–	6834736
	T8430	.016	■	656	.0067	.067	■	361	.0059	.067	◪	541	.0067	.067	◪	1821	.0079	.067	◪	131	.0055	.055		–	–	–	7977162
	T9325	.016	■	820	.0071	.067	■	492	.0063	.067	◪	771	.0071	.067		–	–	–	◪	180	.0063	.055		–	–	–	6834739
WNMG 432-NF	**HF7**	.031		–	–	–	◪	361	.0067	.067	◪	591	.0075	.067	◪	1870	.0091	.067		–	–	–		–	–	–	6834740
	T6310	.031	■	656	.0075	.067	■	459	.0067	.067	◪	525	.0075	.067	◪	1969	.0091	.067	◪	197	.0059	.055		–	–	–	6922850
	T7325	.031	◪	771	.0075	.067	■	591	.0067	.067		–	–	–		–	–	–	◪	246	.0059	.055		–	–	–	7156482
	T7335	.031	◪	738	.0075	.067	■	574	.0067	.067		–	–	–		–	–	–	◪	230	.0059	.055		–	–	–	6834741
	T8315	.031	◪	705	.0075	.067	■	410	.0067	.067	◪	656	.0075	.067	◪	2116	.0091	.067	◪	164	.0059	.055		–	–	–	6834742
	T8430	.031	■	771	.0075	.067	■	410	.0067	.067	◪	623	.0075	.067	◪	2116	.0091	.067	◪	164	.0059	.055		–	–	–	7977168
	T9325	.031	■	935	.0075	.067	■	558	.0067	.067	◪	886	.0075	.067		–	–	–	◪	197	.0059	.055		–	–	–	6834745
	T9415	.031	■	1181	.0075	.067		–	–	–	◪	1115	.0075	.067		–	–	–		–	–	–		–	–	–	8345617
WNMG 433-NF	**T6310**	.047	■	607	.0118	.083	■	427	.0106	.083	◪	476	.0118	.083	◪	1821	.0142	.083	◪	180	.0083	.067		–	–	–	6922851
	T7325	.047	◪	673	.0118	.083	■	509	.0106	.083		–	–	–		–	–	–	◪	213	.0083	.067		–	–	–	7156491
	T8430	.047	■	656	.0118	.083	■	361	.0106	.083	◪	541	.0118	.083	◪	1821	.0142	.083	◪	131	.0083	.067		–	–	–	7977441
	T9415	.047	■	1033	.0118	.083		–	–	–	◪	968	.0118	.083		–	–	–		–	–	–		–	–	–	8345621

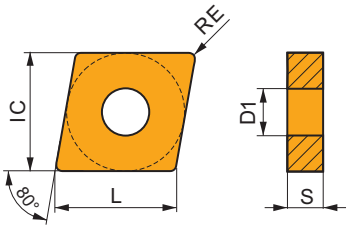
FF



FF chip breaker is sharp and designed for fine-finishing of Steels, Stainless steels. It features positive rake angle and positive, thin T-land. It's also conditionally suitable for Cast irons.

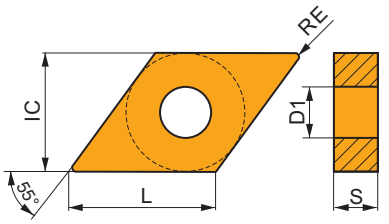
CNMG

	IC (inch)	D1 (inch)	L (inch)	S (inch)
43	.500	.203	.508	.187



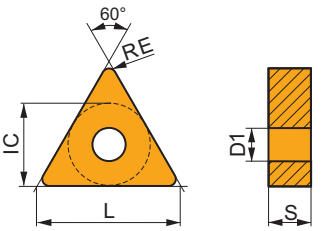
DNMG

	IC (inch)	D1 (inch)	L (inch)	S (inch)
33	.375	.150	.457	.187
43	.500	.203	.610	.187
44	.500	.203	.610	.250



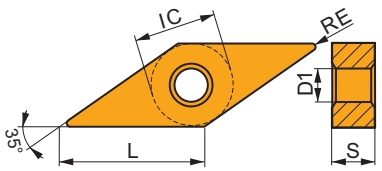
TNMG

	IC (inch)	D1 (inch)	L (inch)	S (inch)
33	.375	.150	.650	.187



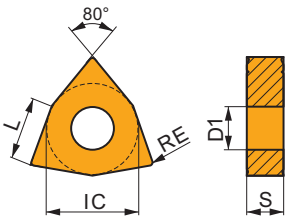
VNMG

	IC (inch)	D1 (inch)	L (inch)	S (inch)
33	.375	.150	.654	.187

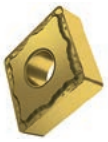
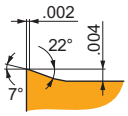
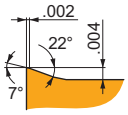
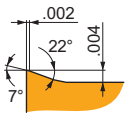
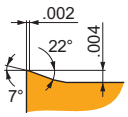
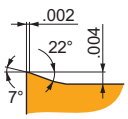


WNMG

	IC (inch)	D1 (inch)	L (inch)	S (inch)
33	.375	.150	.256	.187
43	.500	.203	.343	.187

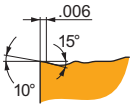
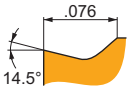
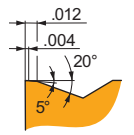
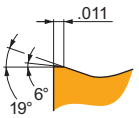


Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our cutting conditions app for further options.

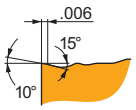
Product		RE (inch)	P vc (ft/min)	P f (in/rev)	P ap (inch)	M vc (ft/min)	M f (in/rev)	M ap (inch)	K vc (ft/min)	K f (in/rev)	K ap (inch)	N vc (ft/min)	N f (in/rev)	N ap (inch)	S vc (ft/min)	S f (in/rev)	S ap (inch)	H vc (ft/min)	H f (in/rev)	H ap (inch)	MID
																					
CNMG 431-FF	**T7325**	.016	771	.0047	.039	591	.0043	.039	–	–	–	–	–	–	–	–	–	–	–	–	7156501
	T8415	.016	853	.0047	.039	443	.0043	.039	787	.0047	.039	–	–	–	–	–	–	–	–	–	8552988
CNMG 432-FF	**T7325**	.031	869	.0059	.039	673	.0055	.039	–	–	–	–	–	–	–	–	–	–	–	–	7156502
	T8415	.031	984	.0059	.039	509	.0053	.039	886	.0059	.039	–	–	–	–	–	–	–	–	–	8553062
																					
DNMG 330.5-FF	**T8315**	.008	574	.0039	.031	344	.0035	.031	541	.0039	.031	–	–	–	–	–	–	–	–	–	6753601
	T8415	.016	705	.0039	.031	361	.0035	.031	640	.0039	.031	–	–	–	–	–	–	–	–	–	8553078
DNMG 331-FF	**T8315**	.016	574	.0047	.031	344	.0043	.031	541	.0047	.031	–	–	–	–	–	–	–	–	–	6753602
	T8415	.016	705	.0047	.031	361	.0043	.031	640	.0047	.031	–	–	–	–	–	–	–	–	–	8553079
	T8430	.016	673	.0047	.031	361	.0043	.031	558	.0047	.031	–	–	–	–	–	–	–	–	–	7977345
DNMG 332-FF	**T8415**	.016	787	.0059	.031	410	.0053	.031	705	.0059	.031	–	–	–	–	–	–	–	–	–	8553083
DNMG 431-FF	**T8315**	.016	574	.0047	.039	344	.0043	.039	541	.0047	.039	–	–	–	–	–	–	–	–	–	6753606
DNMG 441-FF	**T8415**	.031	689	.0047	.039	361	.0043	.039	623	.0047	.039	–	–	–	–	–	–	–	–	–	8553092
DNMG 442-FF	**T7325**	.031	689	.0059	.039	525	.0055	.039	–	–	–	–	–	–	–	–	–	–	–	–	7156504
	T8415	.031	787	.0059	.039	410	.0053	.039	705	.0059	.039	–	–	–	–	–	–	–	–	–	8553097
																					
TNMG 331-FF	**T7325**	.016	656	.0047	.039	509	.0043	.039	–	–	–	–	–	–	–	–	–	–	–	–	7156505
	T8415	.016	738	.0047	.039	377	.0043	.039	673	.0047	.039	–	–	–	–	–	–	–	–	–	8553119
	T8430	.016	689	.0047	.039	377	.0043	.039	574	.0047	.039	–	–	–	–	–	–	–	–	–	7977402
TNMG 332-FF	**T8415**	.031	820	.0059	.039	427	.0053	.039	738	.0059	.039	–	–	–	–	–	–	–	–	–	8553125
																					
VNMG 331-FF	**T7325**	.016	541	.0047	.039	410	.0043	.039	–	–	–	–	–	–	–	–	–	–	–	–	7156507
	T8415	.016	607	.0047	.039	312	.0043	.039	541	.0047	.039	–	–	–	–	–	–	–	–	–	8553141
	T8430	.016	574	.0047	.039	312	.0043	.039	459	.0047	.039	–	–	–	–	–	–	–	–	–	7977152
																					
WNMG 330.5-FF	**T8415**	.008	853	.0039	.039	443	.0035	.039	787	.0039	.039	–	–	–	–	–	–	–	–	–	8553150
WNMG 331-FF	**T8415**	.016	853	.0047	.039	443	.0043	.039	787	.0047	.039	–	–	–	–	–	–	–	–	–	8553151
WNMG 431-FF	**T7325**	.016	771	.0047	.039	591	.0043	.039	–	–	–	–	–	–	–	–	–	–	–	–	7156508
	T8415	.016	853	.0047	.039	443	.0043	.039	787	.0047	.039	–	–	–	–	–	–	–	–	–	8553156
WNMG 432-FF	**T7325**	.031	869	.0059	.039	673	.0055	.039	–	–	–	–	–	–	–	–	–	–	–	–	7156509
	T8415	.031	984	.0059	.039	509	.0053	.039	886	.0059	.039	–	–	–	–	–	–	–	–	–	8553162

FF chip breaker is sharp and designed for fine-finishing of Steels, Stainless steels. It features positive rake angle and positive, thin T-land. It's also conditionally suitable for Cast irons.

FINISHING – NAVIGATOR

FM			**FM** chip breaker is versatile and the first choice for finishing of Steels and Cast irons. It features slightly positive rake angle and positive, narrow T-land. It's also conditionally suitable for Stainless steels and Super-alloys.
SF			**SF** chip breaker is sharp and the first choice for finishing of Stainless steels and Super-alloys. It features slightly positive rake angle without T-land. It's also suitable for Steels, Cast irons and Hard materials, and conditionally for Non-ferrous alloys.
W-M			**W-M** chip breaker has wiper edge and is designed for finishing of Steels. It features positive rake angle and positive, moderate T-land. It's also conditionally suitable for Cast irons.
W-MR			**W-MR** chip breaker has wiper edge and is designed for finishing of Steels. It features positive rake angle and stable, wide T-land. It's also conditionally suitable for Stainless steels and Cast irons.

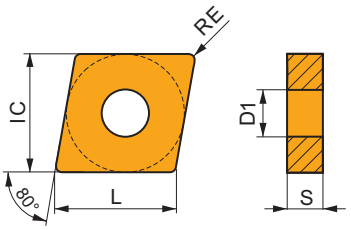
FM



FM chip breaker is versatile and the first choice for finishing of Steels and Cast irons. It features slightly positive rake angle and positive, narrow T-land. It's also conditionally suitable for Stainless steels and Super-alloys.

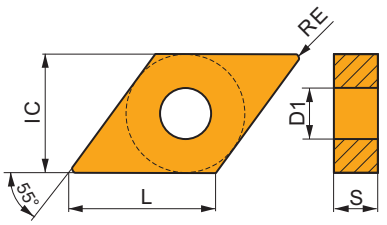
CNMG

	IC (inch)	D1 (inch)	L (inch)	S (inch)
32	.375	.150	.382	.125
43	.500	.203	.508	.187



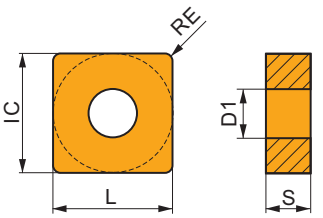
DNMG

	IC (inch)	D1 (inch)	L (inch)	S (inch)
33	.375	.150	.457	.187
43	.500	.203	.610	.187
44	.500	.203	.610	.250



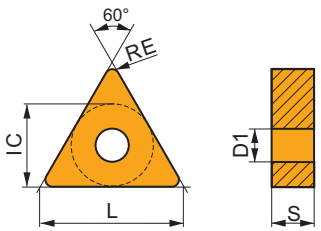
SNMG

	IC (inch)	D1 (inch)	L (inch)	S (inch)
43	.500	.203	.500	.187



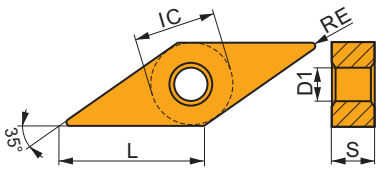
TNMG

	IC (inch)	D1 (inch)	L (inch)	S (inch)
33	.375	.150	.650	.187
43	.500	.203	.866	.187



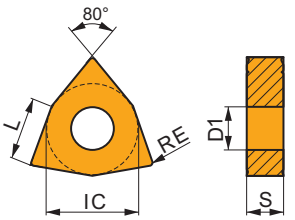
VNMG

	IC (inch)	D1 (inch)	L (inch)	S (inch)
33	.375	.150	.654	.187

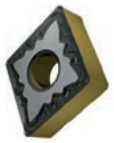
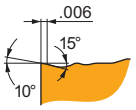
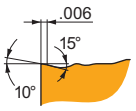


WNMG

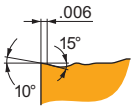
	IC (inch)	D1 (inch)	L (inch)	S (inch)
32.5	.375	.150	.256	.156
33	.375	.150	.256	.187
43	.500	.203	.343	.187



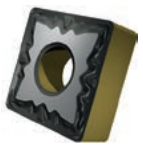
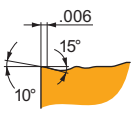
Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our cutting conditions app for further options.

Product		RE	P						M						K						N						S						H						MID
			vc (ft/min)		f (in/rev)		ap (inch)		vc (ft/min)		f (in/rev)		ap (inch)		vc (ft/min)		f (in/rev)		ap (inch)		vc (ft/min)		f (in/rev)		ap (inch)		vc (ft/min)		f (in/rev)		ap (inch)		vc (ft/min)		f (in/rev)		ap (inch)	
			**FM** chip breaker is versatile and the first choice for finishing of Steels and Cast irons. It features slightly positive rake angle and positive, narrow T-land. It's also conditionally suitable for Stainless steels and Super-alloys.																																			
CNMG 321-FM	**T8430**	.016	■ 640	.0079	.055	◪ 344	.0071	.055	◪ 525	.0079	.055	–	–	–	◪ 131	.0055	.043	–	–	–	7977310
	T9325	.016	■ 787	.0079	.055	◪ 459	.0071	.055	◪ 738	.0079	.055	–	–	–	◪ 164	.0063	.043	–	–	–	6753875
	T9415	.016	■ 1001	.0079	.055	–	–	–	◪ 935	.0079	.055	–	–	–	–	–	–	–	–	–	8244146
CNMG 322-FM	**T8430**	.031	■ 771	.0079	.055	◪ 410	.0071	.055	◪ 623	.0079	.055	–	–	–	◪ 164	.0055	.043	–	–	–	7977312
	T9325	.031	■ 935	.0079	.055	◪ 558	.0071	.055	◪ 886	.0079	.055	–	–	–	◪ 197	.0063	.043	–	–	–	6753876
	T9415	.031	■ 1198	.0079	.055	–	–	–	◪ 1132	.0079	.055	–	–	–	–	–	–	–	–	–	8244147
CNMG 431-FM	**T7325**	.016	◪ 607	.0079	.083	◪ 459	.0071	.083	–	–	–	–	–	–	◪ 197	.0063	.067	–	–	–	7156185
	T7335	.016	◪ 591	.0079	.083	◪ 459	.0071	.083	–	–	–	–	–	–	◪ 180	.0063	.067	–	–	–	6754747
	T8415	.016	■ 705	.0079	.083	◪ 361	.0071	.083	■ 640	.0079	.083	–	–	–	◪ 148	.0055	.066	–	–	–	8552989
	T8430	.016	■ 623	.0079	.083	◪ 344	.0071	.083	◪ 509	.0079	.083	–	–	–	◪ 131	.0055	.067	–	–	–	7977057
	T9325	.016	■ 755	.0079	.083	◪ 443	.0071	.083	◪ 705	.0079	.083	–	–	–	◪ 164	.0063	.067	–	–	–	6753878
	T9415	.016	■ 951	.0079	.083	–	–	–	◪ 902	.0079	.083	–	–	–	–	–	–	–	–	–	8244148
	TT310	.016	■ 853	.0079	.083	◪ 509	.0071	.083	–	–	–	–	–	–	–	–	–	–	–	–	6798556
CNMG 432-FM	**T7325**	.031	◪ 722	.0079	.083	◪ 558	.0071	.083	–	–	–	–	–	–	◪ 230	.0063	.067	–	–	–	7156194
	T7335	.031	◪ 705	.0079	.083	◪ 541	.0071	.083	–	–	–	–	–	–	◪ 213	.0063	.067	–	–	–	6754751
	T8415	.031	■ 820	.0079	.083	◪ 427	.0071	.083	■ 738	.0079	.083	–	–	–	◪ 180	.0063	.066	–	–	–	8553063
	T8430	.031	■ 738	.0079	.083	◪ 394	.0071	.083	◪ 607	.0079	.083	–	–	–	◪ 148	.0063	.067	–	–	–	7977103
	T9325	.031	■ 902	.0079	.083	◪ 541	.0071	.083	◪ 853	.0079	.083	–	–	–	◪ 197	.0063	.067	–	–	–	6753899
	T9415	.031	■ 1148	.0079	.083	–	–	–	◪ 1083	.0079	.083	–	–	–	–	–	–	–	–	–	8183351
	TT310	.031	■ 1017	.0079	.083	◪ 607	.0071	.083	–	–	–	–	–	–	–	–	–	–	–	–	6798557
CNMG 433-FM	**T7325**	.047	◪ 689	.0106	.083	◪ 525	.0094	.083	–	–	–	–	–	–	◪ 213	.0075	.067	–	–	–	7156204
	T9325	.047	■ 837	.0106	.083	◪ 492	.0094	.083	◪ 787	.0106	.083	–	–	–	◪ 180	.0075	.067	–	–	–	6753889
	T9415	.047	■ 1083	.0106	.083	–	–	–	◪ 1017	.0106	.083	–	–	–	–	–	–	–	–	–	8244244
			**FM** chip breaker is versatile and the first choice for finishing of Steels and Cast irons. It features slightly positive rake angle and positive, narrow T-land. It's also conditionally suitable for Stainless steels and Super-alloys.																																			
DNMG 331-FM	**T8415**	.016	■ 607	.0079	.031	◪ 312	.0071	.031	■ 541	.0079	.031	–	–	–	◪ 131	.0055	.025	–	–	–	8553080
	T8430	.016	■ 541	.0079	.031	◪ 295	.0071	.031	◪ 443	.0079	.031	–	–	–	◪ 115	.0055	.024	–	–	–	7977117
	T9325	.016	■ 656	.0079	.031	◪ 394	.0071	.031	◪ 623	.0079	.031	–	–	–	◪ 148	.0079	.024	–	–	–	6753939
	T9415	.016	■ 853	.0079	.031	–	–	–	◪ 804	.0079	.031	–	–	–	–	–	–	–	–	–	8244263
DNMG 332-FM	**T7325**	.031	◪ 656	.0079	.031	◪ 509	.0071	.031	–	–	–	–	–	–	◪ 213	.0063	.024	–	–	–	7156265
	T8315	.031	◪ 591	.0079	.031	◪ 344	.0071	.031	■ 558	.0079	.031	–	–	–	◪ 148	.0055	.024	–	–	–	6753605
	T8415	.031	■ 722	.0079	.031	◪ 377	.0071	.031	■ 656	.0079	.031	–	–	–	◪ 164	.0055	.025	–	–	–	8553084
	T8430	.031	■ 640	.0079	.031	◪ 344	.0071	.031	◪ 525	.0079	.031	–	–	–	◪ 131	.0055	.024	–	–	–	7977351
	T9325	.031	■ 787	.0079	.031	◪ 459	.0071	.031	◪ 738	.0079	.031	–	–	–	◪ 164	.0063	.024	–	–	–	6753944
	T9415	.031	■ 1001	.0079	.031	–	–	–	◪ 935	.0079	.031	–	–	–	–	–	–	–	–	–	8244264
DNMG 431-FM	**T7325**	.016	◪ 492	.0079	.067	◪ 377	.0071	.067	–	–	–	–	–	–	◪ 148	.0079	.055	–	–	–	7156276
	T8430	.016	■ 492	.0079	.067	◪ 262	.0071	.067	◪ 410	.0079	.067	–	–	–	◪ 98	.0055	.055	–	–	–	7977358
	T9325	.016	■ 623	.0079	.067	◪ 361	.0071	.067	◪ 591	.0079	.067	–	–	–	◪ 131	.0079	.055	–	–	–	6753952
	T9415	.016	■ 771	.0079	.067	–	–	–	◪ 722	.0079	.067	–	–	–	–	–	–	–	–	–	8244268
DNMG 432-FM	**T7325**	.031	◪ 591	.0079	.067	◪ 459	.0071	.067	–	–	–	–	–	–	◪ 180	.0063	.055	–	–	–	7156279
	T8430	.031	■ 607	.0079	.067	◪ 328	.0071	.067	◪ 492	.0079	.067	–	–	–	◪ 131	.0063	.055	–	–	–	7977363
	T9325	.031	■ 738	.0079	.067	◪ 443	.0071	.067	◪ 689	.0079	.067	–	–	–	◪ 164	.0063	.055	–	–	–	6753954
	T9415	.031	■ 919	.0079	.067	–	–	–	◪ 869	.0079	.067	–	–	–	–	–	–	–	–	–	8244269
DNMG 441-FM	**T7325**	.016	◪ 492	.0079	.067	◪ 377	.0071	.067	–	–	–	–	–	–	◪ 148	.0079	.055	–	–	–	7156285
	T7335	.016	◪ 492	.0079	.067	◪ 377	.0071	.067	–	–	–	–	–	–	◪ 148	.0079	.055	–	–	–	6754786
	T8415	.016	■ 558	.0079	.067	◪ 295	.0071	.067	■ 509	.0079	.067	–	–	–	◪ 115	.0055	.054	–	–	–	8553093
	T8430	.016	■ 492	.0079	.067	◪ 262	.0071	.067	◪ 410	.0079	.067	–	–	–	◪ 98	.0055	.055	–	–	–	7977119
	T9325	.016	■ 623	.0079	.067	◪ 361	.0071	.067	◪ 591	.0079	.067	–	–	–	◪ 131	.0079	.055	–	–	–	6753960
	T9415	.016	■ 771	.0079	.067	–	–	–	◪ 722	.0079	.067	–	–	–	–	–	–	–	–	–	8183395

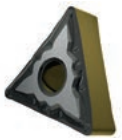
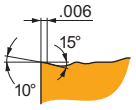
Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our cutting conditions app for further options.

Product		RE	P				M				K				N				S				H				MID
				vc (ft/min)	f (in/rev)	ap (inch)		vc (ft/min)	f (in/rev)	ap (inch)		vc (ft/min)	f (in/rev)	ap (inch)		vc (ft/min)	f (in/rev)	ap (inch)		vc (ft/min)	f (in/rev)	ap (inch)		vc (ft/min)	f (in/rev)	ap (inch)	
																											
DNMG 442-FM	**T7325**	.031	◪	591	.0079	.067	◪	459	.0071	.067		–	–	–		–	–	–	◪	180	.0063	.055		–	–	–	7156293
	T7335	.031	◪	574	.0079	.067	◪	443	.0071	.067		–	–	–		–	–	–	◪	180	.0063	.055		–	–	–	6754790
	T8315	.031	◪	558	.0079	.067	◪	328	.0071	.067	■	525	.0079	.067		–	–	–	◪	131	.0063	.055		–	–	–	6753610
	T8415	.031	■	689	.0079	.067	◪	361	.0071	.067	■	623	.0079	.067		–	–	–	◪	148	.0063	.054		–	–	–	8553098
	T8430	.031	■	607	.0079	.067	◪	328	.0071	.067	◪	492	.0079	.067		–	–	–	◪	131	.0063	.055		–	–	–	7977123
	T9315	.031	■	820	.0079	.067		–	–	–	◪	771	.0079	.067		–	–	–		–	–	–		–	–	–	6753739
	T9325	.031	■	738	.0079	.067	◪	443	.0071	.067	◪	689	.0079	.067		–	–	–	◪	164	.0063	.055		–	–	–	6753964
	T9415	.031	■	919	.0079	.067		–	–	–	◪	869	.0079	.067		–	–	–		–	–	–		–	–	–	8183396
DNMG 443-FM	**T8430**	.047	■	574	.0098	.067	◪	312	.0091	.067	◪	459	.0098	.067		–	–	–	◪	115	.0071	.055		–	–	–	7977377
	T9325	.047	■	705	.0098	.067	◪	410	.0091	.067	◪	656	.0098	.067		–	–	–	◪	148	.0071	.055		–	–	–	6753967
	T9415	.047	■	902	.0098	.067		–	–	–	◪	853	.0098	.067		–	–	–		–	–	–		–	–	–	8244276
DNMG 444-FM	**T9325**	.063	■	689	.0118	.067	◪	410	.0106	.067	◪	640	.0118	.067		–	–	–	◪	148	.0083	.055		–	–	–	6922830
	T9415	.063	■	886	.0118	.067		–	–	–	◪	837	.0118	.067		–	–	–		–	–	–		–	–	–	8244280

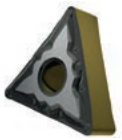
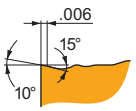
FM chip breaker is versatile and the first choice for finishing of Steels and Cast irons. It features slightly positive rake angle and positive, narrow T-land. It's also conditionally suitable for Stainless steels and Super-alloys.

																											
SNMG 431-FM	**T7325**	.016	◪	640	.0079	.083	◪	492	.0071	.083		–	–	–		–	–	–	◪	197	.0063	.067		–	–	–	7156332
	T8415	.016	■	722	.0079	.083	◪	377	.0071	.083	■	656	.0079	.083		–	–	–	◪	164	.0055	.066		–	–	–	8553107
	T8430	.016	■	640	.0079	.083	◪	344	.0071	.083	◪	525	.0079	.083		–	–	–	◪	131	.0055	.067		–	–	–	7977129
	T9325	.016	■	787	.0079	.083	◪	459	.0071	.083	◪	738	.0079	.083		–	–	–	◪	164	.0063	.067		–	–	–	6754004
	T9415	.016	■	1001	.0079	.083		–	–	–	◪	935	.0079	.083		–	–	–		–	–	–		–	–	–	8244282
SNMG 432-FM	**T8415**	.031	■	853	.0079	.083	◪	443	.0071	.083	■	787	.0079	.083		–	–	–	◪	197	.0063	.066		–	–	–	8553108
	T8430	.031	■	771	.0079	.083	◪	410	.0071	.083	◪	623	.0079	.083		–	–	–	◪	164	.0063	.067		–	–	–	7977131
	T9325	.031	■	951	.0079	.083	◪	558	.0071	.083	◪	902	.0079	.083		–	–	–	◪	213	.0063	.067		–	–	–	6754005
	T9415	.031	■	1198	.0079	.083		–	–	–	◪	1132	.0079	.083		–	–	–		–	–	–		–	–	–	8244283
SNMG 433-FM	**T8430**	.047	■	722	.0106	.083	◪	394	.0094	.083	◪	591	.0106	.083		–	–	–	◪	148	.0075	.067		–	–	–	7977387
	T9325	.047	■	886	.0106	.083	◪	525	.0094	.083	◪	837	.0106	.083		–	–	–	◪	197	.0075	.067		–	–	–	6754008
	T9415	.047	■	1132	.0106	.083		–	–	–	◪	1066	.0106	.083		–	–	–		–	–	–		–	–	–	8244286
SNMG 434-FM	**T8430**	.063	■	722	.0126	.083	◪	394	.0114	.083	◪	591	.0126	.083		–	–	–	◪	148	.0087	.067		–	–	–	7977389

FM chip breaker is versatile and the first choice for finishing of Steels and Cast irons. It features slightly positive rake angle and positive, narrow T-land. It's also conditionally suitable for Stainless steels and Super-alloys.

																											
TNMG 331-FM	**T7325**	.016	◪	525	.0079	.067	◪	394	.0071	.067		–	–	–		–	–	–	◪	164	.0079	.055		–	–	–	7156376
	T7335	.016	◪	525	.0079	.067	◪	394	.0071	.067		–	–	–		–	–	–	◪	164	.0079	.055		–	–	–	6754820
	T8315	.016	◪	492	.0079	.067	◪	295	.0071	.067	■	459	.0079	.067		–	–	–	◪	115	.0055	.055		–	–	–	6753625
	T8415	.016	■	607	.0079	.067	◪	312	.0071	.067	■	541	.0079	.067		–	–	–	◪	131	.0055	.054		–	–	–	8553120
	T8430	.016	■	541	.0079	.067	◪	295	.0071	.067	◪	443	.0079	.067		–	–	–	◪	115	.0055	.055		–	–	–	7977136
	T9325	.016	■	656	.0079	.067	◪	394	.0071	.067	◪	623	.0079	.067		–	–	–	◪	148	.0079	.055		–	–	–	6754105
	T9415	.016	■	820	.0079	.067		–	–	–	◪	771	.0079	.067		–	–	–		–	–	–		–	–	–	8183404
	TT310	.016	■	738	.0079	.067	◪	443	.0071	.067		–	–	–		–	–	–		–	–	–		–	–	–	6798571
TNMG 332-FM	**T7325**	.031	◪	640	.0079	.067	◪	492	.0071	.067		–	–	–		–	–	–	◪	197	.0063	.055		–	–	–	7156384
	T7335	.031	◪	623	.0079	.067	◪	476	.0071	.067		–	–	–		–	–	–	◪	197	.0063	.055		–	–	–	6754824
	T8315	.031	◪	591	.0079	.067	◪	344	.0071	.067	■	558	.0079	.067		–	–	–	◪	148	.0063	.055		–	–	–	6753627
	T8415	.031	■	722	.0079	.067	◪	377	.0071	.067	■	656	.0079	.067		–	–	–	◪	164	.0063	.054		–	–	–	8553126
	T8430	.031	■	640	.0079	.067	◪	344	.0071	.067	◪	525	.0079	.067		–	–	–	◪	131	.0063	.055		–	–	–	7977140
	T9310	.031	■	951	.0079	.067		–	–	–	◪	902	.0079	.067		–	–	–		–	–	–		–	–	–	6755057
	T9325	.031	■	771	.0079	.067	◪	459	.0071	.067	◪	722	.0079	.067		–	–	–	◪	164	.0063	.055		–	–	–	6754111
	T9415	.031	■	984	.0079	.067		–	–	–	◪	935	.0079	.067		–	–	–		–	–	–		–	–	–	8183405
	TT310	.031	■	886	.0079	.067	◪	525	.0071	.067		–	–	–		–	–	–		–	–	–		–	–	–	6798572
TNMG 333-FM	**T8430**	.047	■	607	.0098	.067	◪	328	.0091	.067	◪	492	.0098	.067		–	–	–	◪	131	.0071	.055		–	–	–	7977408
	T9325	.047	■	738	.0098	.067	◪	443	.0091	.067	◪	689	.0098	.067		–	–	–	◪	164	.0071	.055		–	–	–	6754116
	T9415	.047	■	951	.0098	.067		–	–	–	◪	902	.0098	.067		–	–	–		–	–	–		–	–	–	8244302

Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our cutting conditions app for further options.

Product		RE	P				M				K				N				S				H				MID
			vc (ft/min)	f (in/rev)	ap (inch)		vc (ft/min)	f (in/rev)	ap (inch)		vc (ft/min)	f (in/rev)	ap (inch)		vc (ft/min)	f (in/rev)	ap (inch)		vc (ft/min)	f (in/rev)	ap (inch)		vc (ft/min)	f (in/rev)	ap (inch)		
																											
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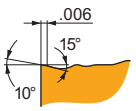
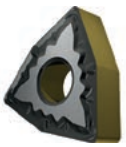
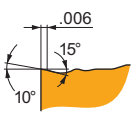
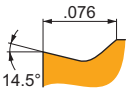
TNMG 431-FM	**T8430**	.016	541	.0079	.067		295	.0071	.067		443	.0079	.067		–	–	–		115	.0071	.055		–	–	–		7977410
	T9325	.016	656	.0079	.067		394	.0071	.067		623	.0079	.067		–	–	–		148	.0071	.055		–	–	–		6926950
	T9415	.016	820	.0079	.067		–	–	–		771	.0079	.067		–	–	–		–	–	–		–	–	–		8244305
TNMG 432-FM	**T8430**	.031	640	.0079	.067		344	.0071	.067		525	.0079	.067		–	–	–		131	.0063	.055		–	–	–		7977147
	T9325	.031	771	.0079	.067		459	.0071	.067		722	.0079	.067		–	–	–		164	.0063	.055		–	–	–		6926953
	T9415	.031	984	.0079	.067		–	–	–		935	.0079	.067		–	–	–		–	–	–		–	–	–		8244306
																											
FM chip breaker is versatile and the first choice for finishing of Steels and Cast irons. It features slightly positive rake angle and positive, narrow T-land. It's also conditionally suitable for Stainless steels and Super-alloys.																											
VNMG 331-FM	**T7325**	.016	459	.0079	.047		344	.0071	.047		–	–	–		–	–	–		148	.0079	.039		–	–	–		7156432
	T8430	.016	443	.0079	.047		246	.0071	.047		361	.0079	.047		–	–	–		82	.0055	.039		–	–	–		7977153
	T9325	.016	558	.0079	.047		328	.0071	.047		525	.0079	.047		–	–	–		115	.0079	.039		–	–	–		6754434
	T9415	.016	705	.0079	.047		–	–	–		656	.0079	.047		–	–	–		–	–	–		–	–	–		8183406
VNMG 332-FM	**T7325**	.031	525	.0079	.055		394	.0071	.055		–	–	–		–	–	–		164	.0063	.043		–	–	–		7156438
	T8430	.031	541	.0079	.055		295	.0071	.055		443	.0079	.055		–	–	–		115	.0063	.043		–	–	–		7977155
	T9325	.031	656	.0079	.055		394	.0071	.055		623	.0079	.055		–	–	–		148	.0063	.043		–	–	–		6754437
	T9415	.031	837	.0079	.055		–	–	–		787	.0079	.055		–	–	–		–	–	–		–	–	–		8183407
VNMG 333-FM	**T8430**	.047	541	.0087	.055		295	.0079	.055		443	.0087	.055		–	–	–		115	.0071	.043		–	–	–		7977420
	T9325	.047	656	.0087	.055		394	.0079	.055		623	.0087	.055		–	–	–		148	.0071	.043		–	–	–		6754440
	T9415	.047	837	.0087	.055		–	–	–		787	.0087	.055		–	–	–		–	–	–		–	–	–		8183408
																											
FM chip breaker is versatile and the first choice for finishing of Steels and Cast irons. It features slightly positive rake angle and positive, narrow T-land. It's also conditionally suitable for Stainless steels and Super-alloys.																											
WNMG 32.51-FM	**T8430**	.016	640	.0079	.055		344	.0071	.055		525	.0079	.055		–	–	–		131	.0055	.043		–	–	–		7977433
	T9325	.016	787	.0079	.055		459	.0071	.055		738	.0079	.055		–	–	–		164	.0063	.043		–	–	–		6755157
WNMG 32.52-FM	**T8430**	.031	771	.0079	.055		410	.0071	.055		623	.0079	.055		–	–	–		164	.0055	.043		–	–	–		7977434
	T9325	.031	935	.0079	.055		558	.0071	.055		886	.0079	.055		–	–	–		197	.0063	.043		–	–	–		6755159
WNMG 331-FM	**T7325**	.016	640	.0079	.055		492	.0071	.055		–	–	–		–	–	–		197	.0063	.043		–	–	–		7156452
	T8415	.016	722	.0079	.055		377	.0071	.055		656	.0079	.055		–	–	–		164	.0055	.044		–	–	–		8553152
	T8430	.016	640	.0079	.055		344	.0071	.055		525	.0079	.055		–	–	–		131	.0055	.043		–	–	–		7977422
	T9325	.016	787	.0079	.055		459	.0071	.055		738	.0079	.055		–	–	–		164	.0063	.043		–	–	–		6754448
	T9415	.016	1001	.0079	.055		–	–	–		935	.0079	.055		–	–	–		–	–	–		–	–	–		8244318
WNMG 332-FM	**T7325**	.031	771	.0079	.055		591	.0071	.055		–	–	–		–	–	–		246	.0063	.043		–	–	–		7156460
	T8430	.031	771	.0079	.055		410	.0071	.055		623	.0079	.055		–	–	–		164	.0055	.043		–	–	–		7977157
	T9325	.031	935	.0079	.055		558	.0071	.055		886	.0079	.055		–	–	–		197	.0063	.043		–	–	–		6754453
	T9415	.031	1198	.0079	.055		–	–	–		1132	.0079	.055		–	–	–		–	–	–		–	–	–		8244319
WNMG 333-FM	**T9415**	.047	1148	.0106	.047		–	–	–		1083	.0106	.047		–	–	–		–	–	–		–	–	–		8244321
WNMG 431-FM	**T7325**	.016	623	.0079	.075		476	.0071	.075		–	–	–		–	–	–		197	.0063	.059		–	–	–		7156471
	T7335	.016	591	.0079	.075		459	.0071	.075		–	–	–		–	–	–		180	.0063	.059		–	–	–		6754845
	T8415	.016	705	.0079	.075		361	.0071	.075		640	.0079	.075		–	–	–		148	.0055	.060		–	–	–		8553157
	T8430	.016	623	.0079	.075		344	.0071	.075		509	.0079	.075		–	–	–		131	.0055	.059		–	–	–		7977160
	T9325	.016	804	.0079	.047		476	.0071	.047		755	.0079	.047		–	–	–		180	.0063	.039		–	–	–		6754460
	T9415	.016	1017	.0079	.047		–	–	–		951	.0079	.047		–	–	–		–	–	–		–	–	–		8244322
WNMG 432-FM	**T7325**	.031	738	.0079	.075		574	.0071	.075		–	–	–		–	–	–		230	.0063	.059		–	–	–		7156480
	T7335	.031	705	.0079	.075		541	.0071	.075		–	–	–		–	–	–		213	.0063	.059		–	–	–		6754847
	T8415	.031	820	.0079	.075		427	.0071	.075		738	.0079	.075		–	–	–		180	.0063	.060		–	–	–		8553163
	T8430	.031	738	.0079	.075		394	.0071	.075		607	.0079	.075		–	–	–		148	.0063	.059		–	–	–		7977165
	T9325	.031	919	.0079	.075		541	.0071	.075		869	.0079	.075		–	–	–		197	.0063	.059		–	–	–		6754466
	T9415	.031	1148	.0079	.075		–	–	–		1083	.0079	.075		–	–	–		–	–	–		–	–	–		8244324
WNMG 433-FM	**T7325**	.047	722	.0106	.075		558	.0094	.075		–	–	–		–	–	–		230	.0075	.059		–	–	–		7156490
	T8430	.047	689	.0106	.075		377	.0094	.075		574	.0106	.075		–	–	–		148	.0075	.059		–	–	–		7977439
	T9310	.047	1017	.0106	.075		–	–	–		951	.0106	.075		–	–	–		–	–	–		–	–	–		6755072
	T9325	.047	837	.0106	.075		492	.0094	.075		787	.0106	.075		–	–	–		180	.0075	.059		–	–	–		6754472
	T9415	.047	1099	.0106	.075		–	–	–		1033	.0106	.075		–	–	–		–	–	–		–	–	–		8244330

SF



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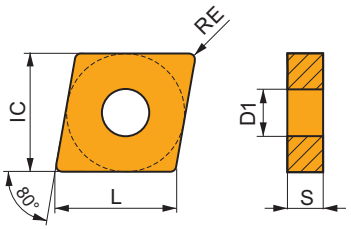
PRAMET

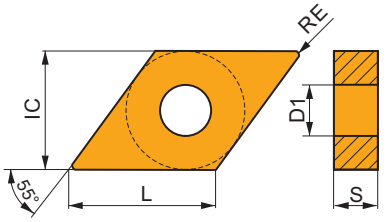
CNGG / CNMG

	IC (inch)	D1 (inch)	L (inch)	S (inch)
43	.500	.203	.508	.187



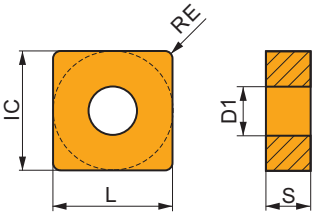
DNMG

	IC (inch)	D1 (inch)	L (inch)	S (inch)
33	.375	.150	.457	.187
43	.500	.203	.610	.187
44	.500	.203	.610	.250



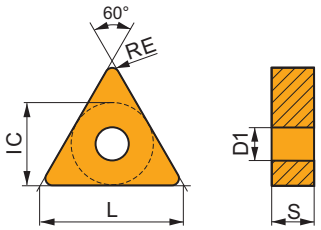
SNMG

	IC (inch)	D1 (inch)	L (inch)	S (inch)
43	.500	.203	.500	.187



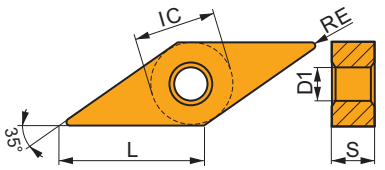
TNMG

	IC (inch)	D1 (inch)	L (inch)	S (inch)
33	.375	.150	.650	.187
43	.500	.203	.866	.187



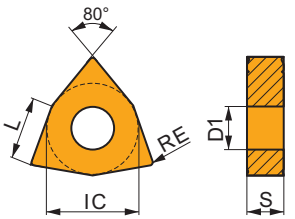
VNMG

	IC (inch)	D1 (inch)	L (inch)	S (inch)
33	.375	.150	.654	.187

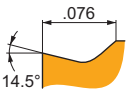
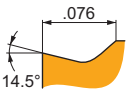


WNMG

	IC (inch)	D1 (inch)	L (inch)	S (inch)
33	.375	.150	.256	.187
43	.500	.203	.343	.187



Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our cutting conditions app for further options.

Product		RE	P			M			K			N			S			H			MID
			vc (ft/min)	f (in/rev)	ap (inch)	vc (ft/min)	f (in/rev)	ap (inch)	vc (ft/min)	f (in/rev)	ap (inch)	vc (ft/min)	f (in/rev)	ap (inch)	vc (ft/min)	f (in/rev)	ap (inch)	vc (ft/min)	f (in/rev)	ap (inch)	
																					
SF chip breaker is sharp and the first choice for finishing of Stainless steels and Super-alloys. It features slightly positive rake angle without T-land. It's also suitable for Steels, Cast irons and Hard materials, and conditionally for Non-ferrous alloys.																					
CNGG 430.5-SF	**H07**	.008	–	–	–	◪	344	.0035	.039	■	541	.0039	.039	◪	1722	.0047	.039	■	164	.0031	.031		–	–	–	6921011
	T6310	.008	■	640	.0039	.039	■	459	.0035	.039	■	509	.0039	.039	◪	1919	.0047	.039	■	180	.0031	.031	■	115	.0039	.008	6919707
	T8415	.008	■	820	.0039	.039	■	427	.0035	.039	■	738	.0039	.039	◪	2067	.0047	.039	■	180	.0031	.031	■	131	.0039	.006	8552985
	T8430	.008	■	787	.0039	.039	■	427	.0035	.039	◪	640	.0039	.039	◪	2165	.0047	.039	◪	164	.0031	.031	◪	131	.0039	.008	7977289
																					
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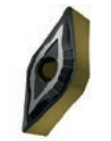
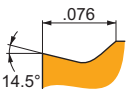
CNMG 431-SF	**H07**	.016	–	–	–	◪	295	.0055	.039	■	476	.0059	.039	◪	1542	.0071	.039	■	148	.0047	.031		–	–	–	6921012
	T6310	.016	■	591	.0059	.039	■	410	.0055	.039	■	476	.0059	.039	◪	1772	.0071	.039	■	164	.0047	.031	■	115	.0043	.012	6919751
	T7325	.016	◪	673	.0067	.039	■	509	.0059	.039		–	–	–		–	–	–	■	213	.0059	.031		–	–	–	7156191
	T8315	.016	◪	640	.0059	.039	■	377	.0055	.039	■	607	.0059	.039	◪	1919	.0071	.039	◪	148	.0047	.031	■	115	.0043	.012	6919753
	T8415	.016	■	787	.0059	.039	■	410	.0053	.039	■	705	.0059	.039	◪	1969	.0071	.039	■	180	.0047	.031	■	131	.0041	.013	8553060
	T8430	.016	■	722	.0059	.039	■	394	.0055	.039	◪	591	.0059	.039	◪	1969	.0071	.039	◪	148	.0047	.031	◪	115	.0043	.012	7977315
	T9325	.016	■	837	.0067	.039	■	492	.0059	.039	◪	787	.0067	.039		–	–	–	◪	180	.0059	.031		–	–	–	7035049
	T9415	.016	■	1033	.0067	.039		–	–	–	◪	968	.0067	.039		–	–	–		–	–	–	◪	197	.0051	.012	8345512
CNMG 432-SF	**H07**	.031	–	–	–	◪	312	.0071	.039	■	509	.0079	.039	◪	1624	.0094	.039	■	164	.0059	.031		–	–	–	6921013
	T6310	.031	■	656	.0079	.039	■	459	.0071	.039	■	525	.0079	.039	◪	1969	.0094	.039	■	197	.0055	.031	■	131	.0039	.028	6919756
	T7325	.031	◪	755	.0079	.039	■	574	.0071	.039		–	–	–		–	–	–	■	230	.0063	.031		–	–	–	7156201
	T7335	.031	◪	722	.0079	.039	■	558	.0071	.039		–	–	–		–	–	–	■	230	.0063	.031		–	–	–	6919757
	T8315	.031	◪	689	.0079	.039	■	410	.0071	.039	■	640	.0079	.039	◪	2067	.0094	.039	◪	164	.0055	.031	■	131	.0039	.028	6919758
	T8415	.031	■	837	.0079	.039	■	443	.0071	.039	■	755	.0079	.039	◪	2116	.0094	.039	■	180	.0055	.031	■	148	.0039	.026	8553066
	T8430	.031	■	755	.0079	.039	■	410	.0071	.039	◪	607	.0079	.039	◪	2067	.0094	.039	◪	148	.0055	.031	◪	115	.0039	.028	7977111
	T9325	.031	■	919	.0079	.039	■	541	.0071	.039	◪	869	.0079	.039		–	–	–	◪	197	.0063	.031		–	–	–	7035051
CNMG 433-SF	**T6310**	.047	■	623	.0098	.059	■	443	.0091	.059	■	492	.0098	.059	◪	1870	.0118	.059	■	180	.0071	.047	■	115	.0051	.039	6919760
	T8415	.047	■	820	.0098	.059	■	427	.0089	.059	■	738	.0098	.059	◪	2067	.0118	.059	■	180	.0069	.047	■	131	.0049	.039	8553069
	T8430	.047	■	689	.0098	.059	■	377	.0091	.059	◪	574	.0098	.059	◪	1919	.0118	.059	◪	148	.0071	.047	◪	115	.0051	.039	7977320
																					
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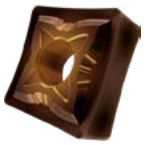
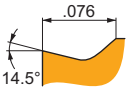
DNMG 331-SF	**T8415**	.016	■	623	.0059	.031	■	328	.0053	.031	■	558	.0059	.031	◪	1575	.0071	.031	■	131	.0047	.025	■	98	.0041	.013	8553081
	T8430	.016	■	591	.0059	.031	■	312	.0055	.031	◪	476	.0059	.031	◪	1624	.0071	.031	◪	115	.0047	.024	◪	98	.0043	.012	7977349
DNMG 332-SF	**T8415**	.031	■	722	.0067	.031	■	377	.006	.031	■	656	.0067	.031	◪	1821	.008	.031	■	164	.0054	.025	■	115	.0044	.026	8553086
	T8430	.031	■	656	.0067	.031	■	361	.0059	.031	◪	541	.0067	.031	◪	1821	.0079	.031	◪	131	.0055	.024	◪	115	.0043	.028	7977356
DNMG 431-SF	**T6310**	.016	■	459	.0059	.059	■	328	.0055	.059	■	361	.0059	.059	◪	1378	.0071	.059	■	131	.0047	.047	■	82	.0043	.012	6919771
	T8415	.016	■	591	.0059	.059	■	295	.0053	.059	■	525	.0059	.059	◪	1476	.0071	.059	■	131	.0047	.047	■	98	.0041	.013	8553088
	T8430	.016	■	541	.0059	.059	■	295	.0055	.059	◪	443	.0059	.059	◪	1476	.0071	.059	◪	115	.0047	.047	◪	82	.0043	.012	7977362
DNMG 432-SF	**T6310**	.031	■	525	.0067	.059	■	377	.0059	.059	■	410	.0067	.059	◪	1575	.0079	.059	■	148	.0055	.047	■	98	.0043	.028	6919774
	T8415	.031	■	689	.0067	.059	■	361	.006	.059	■	623	.0067	.059	◪	1722	.008	.059	■	148	.0054	.047	■	115	.0044	.026	8553090
	T8430	.031	■	623	.0067	.059	■	344	.0059	.059	◪	509	.0067	.059	◪	1722	.0079	.059	◪	131	.0055	.047	◪	98	.0043	.028	7977369
DNMG 441-SF	**H07**	.016	–	–	–	◪	230	.0055	.059	■	377	.0059	.059	◪	1181	.0071	.059	■	115	.0047	.047		–	–	–	6921014
	T6310	.016	■	459	.0059	.059	■	328	.0055	.059	■	361	.0059	.059	◪	1378	.0071	.059	■	131	.0047	.047	■	82	.0043	.012	6919778
	T7325	.016	◪	509	.0067	.059	■	394	.0059	.059		–	–	–		–	–	–	■	164	.0059	.047		–	–	–	7156291
	T8415	.016	■	591	.0059	.059	■	295	.0053	.059	■	525	.0059	.059	◪	1476	.0071	.059	■	131	.0047	.047	■	98	.0041	.013	8553095
	T8430	.016	■	541	.0059	.059	■	295	.0055	.059	◪	443	.0059	.059	◪	1476	.0071	.059	◪	115	.0047	.047	◪	82	.0043	.012	7977372
DNMG 442-SF	**H07**	.031	–	–	–	◪	262	.0059	.059	■	427	.0067	.059	◪	1362	.0079	.059	■	131	.0055	.047		–	–	–	6921015
	T6310	.031	■	525	.0067	.059	■	377	.0059	.059	■	410	.0067	.059	◪	1575	.0079	.059	■	148	.0055	.047	■	98	.0043	.028	6919783
	T7325	.031	◪	607	.0067	.059	■	459	.0059	.059		–	–	–		–	–	–	■	197	.0059	.047		–	–	–	7156300
	T8415	.031	■	689	.0067	.059	■	361	.006	.059	■	623	.0067	.059	◪	1722	.008	.059	■	148	.0054	.047	■	115	.0044	.026	8553102
	T8430	.031	■	623	.0067	.059	■	344	.0059	.059	◪	509	.0067	.059	◪	1722	.0079	.059	◪	131	.0055	.047	◪	98	.0043	.028	7977375
	T9325	.031	■	771	.0067	.059	■	459	.0059	.059	◪	722	.0067	.059		–	–	–	◪	164	.0059	.047		–	–	–	7035061
	T9415	.031	■	951	.0067	.059		–	–	–	◪	902	.0067	.059		–	–	–		–	–	–	◪	180	.0047	.028	8345559
DNMG 443-SF	**T8415**	.047	■	640	.0098	.059	■	328	.0089	.059	■	591	.0098	.059	◪	1624	.0118	.059	■	148	.0069	.047	■	98	.0049	.035	8553104

Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our cutting conditions app for further options.

Product		RE	P			M			K			N			S			H			MID
			vc (ft/min)	f (in/rev)	ap (inch)	vc (ft/min)	f (in/rev)	ap (inch)	vc (ft/min)	f (in/rev)	ap (inch)	vc (ft/min)	f (in/rev)	ap (inch)	vc (ft/min)	f (in/rev)	ap (inch)	vc (ft/min)	f (in/rev)	ap (inch)	
																					

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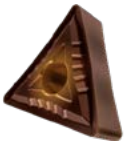
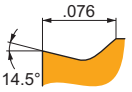
SNMG 432-SF	**H07**	.031		–	–	–		344	.0071	.039		541	.0079	.039		1722	.0094	.039		164	.0055	.031		–	–	–	6921016
	T6310	.031		689	.0079	.039		492	.0071	.039		541	.0079	.039		2067	.0094	.039		197	.0055	.031		131	.0039	.028	6919790
	T8415	.031		902	.0079	.039		459	.0071	.039		820	.0079	.039		2264	.0094	.039		197	.0055	.031		148	.0039	.026	8553110
	T8430	.031		804	.0079	.039		443	.0071	.039		656	.0079	.039		2215	.0094	.039		164	.0055	.031		131	.0039	.028	7977385
	T9325	.031		968	.0079	.039		574	.0071	.039		919	.0079	.039		–	–	–		213	.0063	.031		–	–	–	7035065
SNMG 433-SF	**T8415**	.047		853	.0098	.059		443	.0089	.059		787	.0098	.059		2165	.0118	.059		197	.0069	.047		148	.0049	.039	8553113
	T8430	.047		738	.0098	.059		394	.0091	.059		607	.0098	.059		2018	.0118	.059		148	.0071	.047		115	.0051	.039	7977388





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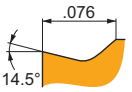
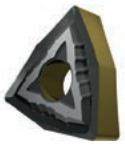
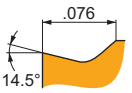
TNMG 331-SF	**T6310**	.016		492	.0059	.051		344	.0055	.051		394	.0059	.051		1476	.0071	.051		148	.0047	.039		98	.0043	.012	6919798
	T7325	.016		558	.0067	.051		427	.0059	.051		–	–	–		–	–	–		180	.0059	.039		–	–	–	7156382
	T8315	.016		525	.0059	.051		312	.0055	.051		492	.0059	.051		1575	.0071	.051		131	.0047	.039		98	.0043	.012	6919800
	T8415	.016		640	.0059	.051		328	.0053	.051		591	.0059	.051		1624	.0071	.051		148	.0047	.041		98	.0041	.013	8553123
	T8430	.016		591	.0059	.051		312	.0055	.051		476	.0059	.051		1624	.0071	.051		115	.0047	.039		98	.0043	.012	7977405
TNMG 332-SF	**T6310**	.031		574	.0067	.051		410	.0059	.051		459	.0067	.051		1722	.0079	.051		164	.0055	.039		115	.0043	.028	6919803
	T8415	.031		738	.0067	.051		377	.006	.051		673	.0067	.051		1870	.008	.051		164	.0054	.041		115	.0044	.026	8553130
	T8430	.031		673	.0067	.051		361	.0059	.051		558	.0067	.051		1870	.0079	.051		148	.0055	.039		115	.0043	.028	7977407
TNMG 333-SF	**T8415**	.047		689	.0098	.059		361	.0089	.059		623	.0098	.059		1722	.0118	.059		148	.0069	.047		115	.0049	.035	8553132
TNMG 431-SF	**T6310**	.016		476	.0067	.067		328	.0059	.067		377	.0067	.067		1427	.0079	.067		131	.0059	.055		82	.0047	.012	7763107
	T8415	.016		607	.0067	.067		312	.006	.067		541	.0067	.067		1526	.008	.067		131	.006	.054		98	.0047	.013	8553134
TNMG 432-SF	**T6310**	.031		558	.0067	.067		394	.0059	.067		443	.0067	.067		1673	.0079	.067		164	.0059	.055		98	.0047	.028	6919807
	T8415	.031		722	.0067	.067		377	.006	.067		656	.0067	.067		1821	.008	.067		164	.006	.054		115	.0047	.026	8553137
	T8430	.031		640	.0067	.067		344	.0059	.067		525	.0067	.067		1772	.0079	.067		131	.0059	.055		98	.0047	.028	7977412
TNMG 433-SF	**T8415**	.047		640	.0118	.067		328	.0106	.067		591	.0118	.067		1624	.0142	.067		148	.0083	.054		98	.0059	.035	8553139



SF chip breaker is sharp and the first choice for finishing of Stainless steels and Super-alloys. It features slightly positive rake angle without T-land. It's also suitable for Steels, Cast irons and Hard materials, and conditionally for Non-ferrous alloys.

VNMG 331-SF	**T6310**	.016		410	.0059	.047		295	.0055	.047		328	.0059	.047		1230	.0071	.047		115	.0055	.039		82	.0059	.012	6919810
	T7325	.016		476	.0059	.047		361	.0055	.047		–	–	–		–	–	–		148	.0055	.039		–	–	–	7156436
	T8415	.016		525	.0059	.047		279	.0053	.047		476	.0059	.047		1329	.0071	.047		115	.0053	.038		82	.0059	.013	8553143
	T8430	.016		476	.0059	.047		262	.0055	.047		394	.0059	.047		1329	.0071	.047		98	.0055	.039		82	.0059	.012	7977414
VNMG 332-SF	**T6310**	.031		459	.0067	.055		328	.0059	.055		361	.0067	.055		1378	.0079	.055		131	.0055	.043		82	.0043	.028	6919813
	T8415	.031		607	.0067	.055		312	.006	.055		541	.0067	.055		1526	.008	.055		131	.0054	.044		98	.0044	.026	8553146
	T8430	.031		541	.0067	.055		295	.0059	.055		443	.0067	.055		1476	.0079	.055		115	.0055	.043		82	.0043	.028	7977418
	T9415	.031		837	.0067	.055		–	–	–		787	.0067	.055		–	–	–		–	–	–		164	.0047	.028	8345605

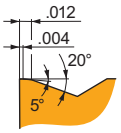
Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our cutting conditions app for further options.

Product		RE	P			M			K			N			S			H			MID
			vc (ft/min)	f (in/rev)	ap (inch)	vc (ft/min)	f (in/rev)	ap (inch)	vc (ft/min)	f (in/rev)	ap (inch)	vc (ft/min)	f (in/rev)	ap (inch)	vc (ft/min)	f (in/rev)	ap (inch)	vc (ft/min)	f (in/rev)	ap (inch)	
																					

SF chip breaker is sharp and the first choice for finishing of Stainless steels and Super-alloys. It features slightly positive rake angle without T-land. It's also suitable for Steels, Cast irons and Hard materials, and conditionally for Non-ferrous alloys.

WNMG 331-SF	**T6310**	.016	■	591	.0059	.039	■	410	.0055	.039	■	476	.0059	.039	◪	1772	.0071	.039	■	164	.0047	.031	■	115	.0043	.012	6919819
	T8415	.016	■	787	.0059	.039	■	410	.0053	.039	■	705	.0059	.039	◪	1969	.0071	.039	■	180	.0047	.031	■	131	.0041	.013	8553153
	T8430	.016	■	722	.0059	.039	■	394	.0055	.039	◪	591	.0059	.039	◪	1969	.0071	.039	◪	148	.0047	.031	◪	115	.0043	.012	7977428
WNMG 332-SF	**T6310**	.031	■	656	.0079	.039	■	459	.0071	.039	■	525	.0079	.039	◪	1969	.0094	.039	■	197	.0055	.031	■	131	.0039	.028	6919824
	T8415	.031	■	837	.0079	.039	■	443	.0071	.039	■	755	.0079	.039	◪	2116	.0094	.039	■	180	.0055	.031	■	148	.0039	.026	8553154
	T8430	.031	■	755	.0079	.039	■	410	.0071	.039	◪	607	.0079	.039	◪	2067	.0094	.039	◪	148	.0055	.031	◪	115	.0039	.028	7977430
WNMG 431-SF	**H07**	.016		–	–	–	◪	295	.0055	.039	■	476	.0059	.039	◪	1542	.0071	.039	■	148	.0047	.031		–	–	–	6921021
	T6310	.016	■	591	.0059	.039	■	410	.0055	.039	■	476	.0059	.039	◪	1772	.0071	.039	■	164	.0047	.031	■	115	.0043	.012	6919829
	T7325	.016	◪	673	.0067	.039	■	509	.0059	.039		–	–	–		–	–	–	■	213	.0059	.031		–	–	–	7156477
	T8415	.016	■	787	.0059	.039	■	410	.0053	.039	■	705	.0059	.039	◪	1969	.0071	.039	■	180	.0047	.031	■	131	.0041	.013	8553160
	T8430	.016	■	722	.0059	.039	■	394	.0055	.039	◪	591	.0059	.039	◪	1969	.0071	.039	◪	148	.0047	.031	◪	115	.0043	.012	7977164
WNMG 432-SF	**H07**	.031		–	–	–	◪	312	.0071	.039	■	509	.0079	.039	◪	1624	.0094	.039	■	164	.0055	.031		–	–	–	6921022
	T6310	.031	■	656	.0079	.039	■	459	.0071	.039	■	525	.0079	.039	◪	1969	.0094	.039	■	197	.0055	.031	■	131	.0039	.028	6919834
	T7325	.031	◪	755	.0079	.039	■	574	.0071	.039		–	–	–		–	–	–	■	230	.0063	.031		–	–	–	7156487
	T7335	.031	◪	722	.0079	.039	■	558	.0071	.039		–	–	–		–	–	–	■	230	.0063	.031		–	–	–	6919835
	T8415	.031	■	837	.0079	.039	■	443	.0071	.039	■	755	.0079	.039	◪	2116	.0094	.039	■	180	.0055	.031	■	148	.0039	.026	8553165
	T8430	.031	■	755	.0079	.039	■	410	.0071	.039	◪	607	.0079	.039	◪	2067	.0094	.039	◪	148	.0055	.031	◪	115	.0039	.028	7977438
	T9325	.031	■	919	.0079	.039	■	541	.0071	.039	◪	869	.0079	.039		–	–	–	◪	197	.0063	.031		–	–	–	7035079
	T9415	.031	■	1165	.0079	.039		–	–	–	◪	1099	.0079	.039		–	–	–		–	–	–	◪	230	.0051	.028	8345619

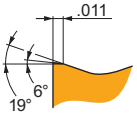
W-M



W-M chip breaker has wiper edge and is designed for finishing of Steels. It features positive rake angle and positive, moderate T-land. It's also conditionally suitable for Cast irons.

PRAMET

W-MR

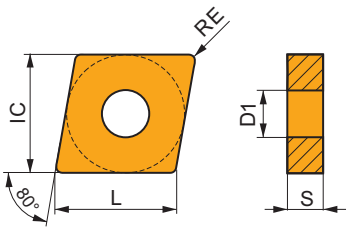


W-MR chip breaker has wiper edge and is designed for finishing of Steels. It features positive rake angle and stable, wide T-land. It's also conditionally suitable for Stainless steels and Cast irons.

PRAMET

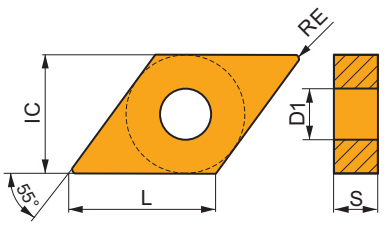
CNMG

	IC (inch)	D1 (inch)	L (inch)	S (inch)
43	.500	.203	.508	.187



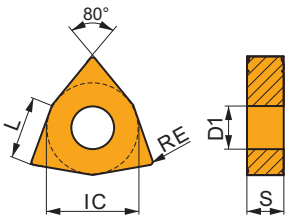
DNMG

	IC (inch)	D1 (inch)	L (inch)	S (inch)
44	.500	.203	.610	.250

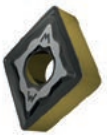
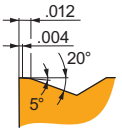
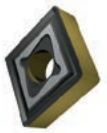
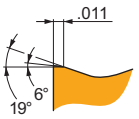
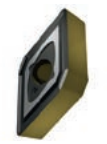
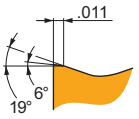
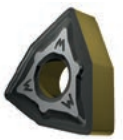
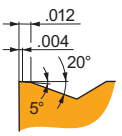
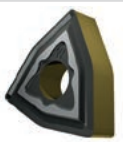
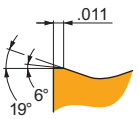


WNMG

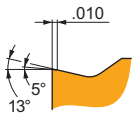
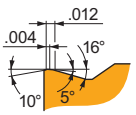
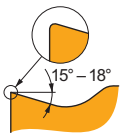
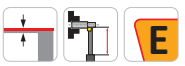
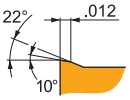
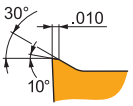
	IC (inch)	D1 (inch)	L (inch)	S (inch)
33	.375	.150	.256	.187
43	.500	.203	.343	.187



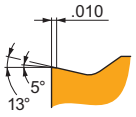
Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our cutting conditions app for further options.

Product		RE	P				M				K				N				S				H				MID
			vc (ft/min)	f (in/rev)	ap (inch)		vc (ft/min)	f (in/rev)	ap (inch)		vc (ft/min)	f (in/rev)	ap (inch)		vc (ft/min)	f (in/rev)	ap (inch)		vc (ft/min)	f (in/rev)	ap (inch)		vc (ft/min)	f (in/rev)	ap (inch)		
																											
			W-M chip breaker has wiper edge and is designed for finishing of Steels. It features positive rake angle and positive, moderate T-land. It's also conditionally suitable for Cast irons.																								
CNMG 432W-M	**T5315**	.031	755	.0177	.059		–	–	–		705	.0177	.059		–	–	–		–	–	–		–	–	–		6755796
	T9325	.031	607	.0177	.059		–	–	–		574	.0177	.059		–	–	–		–	–	–		–	–	–		6753888
	T9415	.031	804	.0177	.059		–	–	–		755	.0177	.059		–	–	–		–	–	–		–	–	–		8244242
																											
			W-MR chip breaker has wiper edge and is designed for finishing of Steels. It features positive rake angle and stable, wide T-land. It's also conditionally suitable for Stainless steels and Cast irons.																								
CNMG 431W-MR	**T9415**	.016	787	.0118	.059		–	–	–		738	.0118	.059		–	–	–		–	–	–		–	–	–		8345513
CNMG 432W-MR	**T9325**	.031	607	.0177	.059		361	.0161	.059		574	.0177	.059		–	–	–		–	–	–		–	–	–		6850881
	T9415	.031	804	.0177	.059		–	–	–		755	.0177	.059		–	–	–		–	–	–		–	–	–		8244243
CNMG 433W-MR	**T5315**	.047	755	.0217	.059		–	–	–		705	.0217	.059		–	–	–		–	–	–		–	–	–		6850882
	T9325	.047	591	.0217	.059		344	.0197	.059		558	.0217	.059		–	–	–		–	–	–		–	–	–		6850884
	T9415	.047	804	.0217	.059		–	–	–		755	.0217	.059		–	–	–		–	–	–		–	–	–		8194906
																											
			W-MR chip breaker has wiper edge and is designed for finishing of Steels. It features positive rake angle and stable, wide T-land. It's also conditionally suitable for Stainless steels and Cast irons.																								
DNMG 442W-MR	**T9325**	.031	509	.0157	.059		295	.0142	.059		476	.0157	.059		–	–	–		–	–	–		–	–	–		6850886
	T9415	.031	673	.0157	.059		–	–	–		623	.0157	.059		–	–	–		–	–	–		–	–	–		8345560
DNMG 443W-MR	**T9315**	.047	525	.0197	.059		–	–	–		492	.0197	.059		–	–	–		–	–	–		–	–	–		6850887
	T9325	.047	476	.0197	.059		279	.0177	.059		443	.0197	.059		–	–	–		–	–	–		–	–	–		6850888
	T9415	.047	656	.0197	.059		–	–	–		623	.0197	.059		–	–	–		–	–	–		–	–	–		8244279
																											
			W-M chip breaker has wiper edge and is designed for finishing of Steels. It features positive rake angle and positive, moderate T-land. It's also conditionally suitable for Cast irons.																								
WNMG 332W-M	**T9325**	.031	623	.0177	.047		–	–	–		591	.0177	.047		–	–	–		–	–	–		–	–	–		6754457
	T9415	.031	837	.0177	.047		–	–	–		787	.0177	.047		–	–	–		–	–	–		–	–	–		8244320
WNMG 333W-M	**T5315**	.047	771	.0217	.047		–	–	–		722	.0217	.047		–	–	–		–	–	–		–	–	–		6755737
	T9415	.047	820	.0217	.047		–	–	–		771	.0217	.047		–	–	–		–	–	–		–	–	–		8345611
WNMG 432W-M	**T9325**	.031	607	.0177	.059		–	–	–		574	.0177	.059		–	–	–		–	–	–		–	–	–		6754471
	T9415	.031	804	.0177	.059		–	–	–		755	.0177	.059		–	–	–		–	–	–		–	–	–		8244328
WNMG 433W-M	**T9325**	.047	591	.0217	.059		–	–	–		558	.0217	.059		–	–	–		–	–	–		–	–	–		6754492
																											
			W-MR chip breaker has wiper edge and is designed for finishing of Steels. It features positive rake angle and stable, wide T-land. It's also conditionally suitable for Stainless steels and Cast irons.																								
WNMG 332W-MR	**T9415**	.031	837	.0177	.047		–	–	–		787	.0177	.047		–	–	–		–	–	–		–	–	–		8345610
WNMG 431W-MR	**T9415**	.016	787	.0118	.059		–	–	–		738	.0118	.059		–	–	–		–	–	–		–	–	–		8345615
WNMG 432W-MR	**T9325**	.031	607	.0177	.059		361	.0161	.059		574	.0177	.059		–	–	–		–	–	–		–	–	–		6850895
	T9415	.031	804	.0177	.059		–	–	–		755	.0177	.059		–	–	–		–	–	–		–	–	–		8244329
WNMG 433W-MR	**T5315**	.047	755	.0217	.059		–	–	–		705	.0217	.059		–	–	–		–	–	–		–	–	–		6850896
	T9415	.047	804	.0217	.059		–	–	–		755	.0217	.059		–	–	–		–	–	–		–	–	–		8244332

MEDIUM – NAVIGATOR

SM			**SM** chip breaker is versatile and the first choice for medium machining of Steels and Super-alloys. It features slightly positive rake angle and stable, moderate T-land. It's also suitable for Stainless steels, Cast irons, and conditionally for Non-ferrous alloys and Hard materials.
M			**M** chip breaker is versatile and the first choice for medium machining of Cast irons. It features positive rake angle and negative/stable, moderate T-land. It's also suitable for Steels, and conditionally for Hard materials.
SI			**SI** chip breaker is sharp and designed for medium machining of Steels, Stainless steels. It features positive rake angle without T-land. It's also conditionally suitable for Non-ferrous alloys and Super-alloys.
NMR			**NMR** chip breaker is versatile and the first choice for medium machining of Stainless steels. It features positive rake angle and positive, wide T-land. It's also suitable for Steels and Super-alloys.
NM			**NM** chip breaker is sharp and designed for medium machining of Steels, Stainless steels and Super-alloys. It features highly positive rake angle and positive, moderate T-land. It's also conditionally suitable for Non-ferrous alloys.
.NMA			**.NMA** flat insert is designed for medium machining of Cast irons. It features neutral rake angle without T-land. It's also conditionally suitable for Hard materials.
.NMA ..S			**.NMA..S** flat insert is designed for medium machining of Cast irons. It features neutral rake angle and negative, moderate T-land. It's also conditionally suitable for Hard materials.

SM

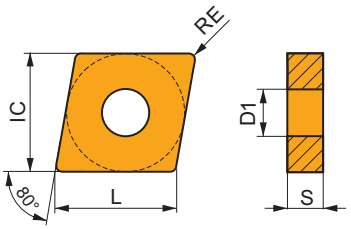


SM chip breaker is versatile and the first choice for medium machining of Steels and Super-alloys. It features slightly positive rake angle and stable, moderate T-land. It's also suitable for Stainless steels, Cast irons, and conditionally for Non-ferrous alloys and Hard materials.

PRAMET

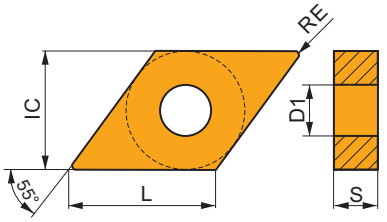
CNMG

	IC (inch)	D1 (inch)	L (inch)	S (inch)
43	.500	.203	.508	.187
54	.625	.250	.634	.250
64	.750	.313	.760	.250



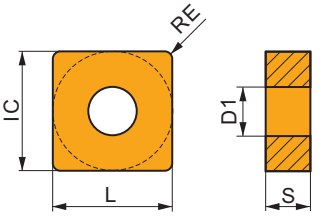
DNMG

	IC (inch)	D1 (inch)	L (inch)	S (inch)
33	.375	.150	.457	.187
43	.500	.203	.610	.187
44	.500	.203	.610	.250



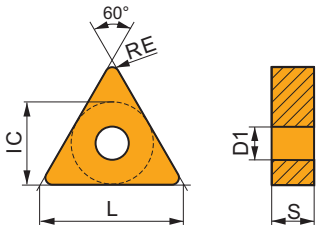
SNMG

	IC (inch)	D1 (inch)	L (inch)	S (inch)
43	.500	.203	.500	.187
64	.750	.313	.750	.250



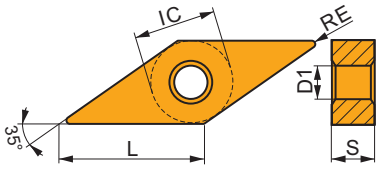
TNMG

	IC (inch)	D1 (inch)	L (inch)	S (inch)
33	.375	.150	.650	.187
43	.500	.203	.866	.187



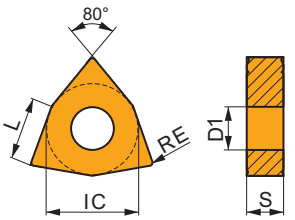
VNMG

	IC (inch)	D1 (inch)	L (inch)	S (inch)
33	.375	.150	.654	.187

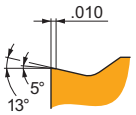
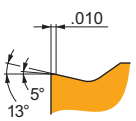


WNMG

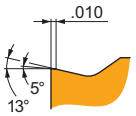
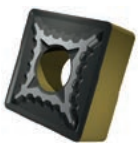
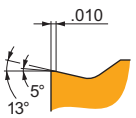
	IC (inch)	D1 (inch)	L (inch)	S (inch)
33	.375	.150	.256	.187
43	.500	.203	.343	.187



Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our cutting conditions app for further options.

Product		RE	P				M				K				N				S				H				MID
			vc (ft/min)	f (in/rev)	ap (inch)		vc (ft/min)	f (in/rev)	ap (inch)		vc (ft/min)	f (in/rev)	ap (inch)		vc (ft/min)	f (in/rev)	ap (inch)		vc (ft/min)	f (in/rev)	ap (inch)		vc (ft/min)	f (in/rev)	ap (inch)		
		(inch)																									
																											
SM chip breaker is versatile and the first choice for medium machining of Steels and Super-alloys. It features slightly positive rake angle and stable, moderate T-land. It's also suitable for Stainless steels, Cast irons, and conditionally for Non-ferrous alloys and Hard materials.																											
CNMG 431-SM	**T6310**	.016	509	.0079	.079		361	.0071	.079		410	.0079	.079		1526	.0094	.079		148	.0071	.063		98	.0051	.012	6915781
	T7325	.016	591	.0079	.079		459	.0071	.079		–	–	–		–	–	–		180	.0071	.063		–	–	–	7156192
	T7335	.016	574	.0079	.079		443	.0071	.079		–	–	–		–	–	–		180	.0071	.063		–	–	–	6915782
	T8415	.016	656	.0079	.079		344	.0071	.079		607	.0079	.079		1673	.0094	.079		148	.0071	.063		115	.0051	.013	8553061
	T8430	.016	591	.0079	.079		312	.0071	.079		476	.0079	.079		1624	.0094	.079		115	.0071	.063		98	.0051	.012	7977102
	T9325	.016	722	.0079	.079		427	.0071	.079		673	.0079	.079		–	–	–		148	.0071	.063		–	–	–	6915785
	T9415	.016	919	.0079	.079		–	–	–		869	.0079	.079		–	–	–		–	–	–		180	.0051	.012	8244240
CNMG 432-SM	**T6310**	.031	574	.0098	.079		410	.0091	.079		459	.0098	.079		1722	.0118	.079		164	.0079	.063		115	.0051	.028	6915786
	T7325	.031	656	.0098	.079		509	.0091	.079		–	–	–		–	–	–		213	.0079	.063		–	–	–	7156202
	T7335	.031	623	.0098	.079		476	.0091	.079		–	–	–		–	–	–		197	.0079	.063		–	–	–	6915787
	T8415	.031	738	.0098	.079		377	.0089	.079		673	.0098	.079		1870	.0118	.079		164	.0079	.063		115	.0049	.026	8553067
	T8430	.031	640	.0098	.079		344	.0091	.079		525	.0098	.079		1772	.0118	.079		131	.0079	.063		98	.0051	.028	7977112
	T9325	.031	771	.0098	.079		459	.0091	.079		722	.0098	.079		–	–	–		164	.0079	.063		–	–	–	6915800
	T9415	.031	1001	.0098	.079		–	–	–		935	.0098	.079		–	–	–		–	–	–		197	.0051	.028	8183355
CNMG 433-SM	**T6310**	.047	574	.0118	.079		410	.0106	.079		459	.0118	.079		1722	.0142	.079		164	.0094	.063		115	.0059	.039	6915801
	T7325	.047	640	.0118	.079		492	.0106	.079		–	–	–		–	–	–		197	.0094	.063		–	–	–	7156209
	T7335	.047	623	.0118	.079		476	.0106	.079		–	–	–		–	–	–		197	.0094	.063		–	–	–	6915802
	T8415	.047	738	.0118	.079		377	.0106	.079		673	.0118	.079		1870	.0142	.079		164	.0094	.063		115	.0059	.039	8553070
	T8430	.047	623	.0118	.079		344	.0106	.079		509	.0118	.079		1722	.0142	.079		131	.0094	.063		98	.0059	.039	7977115
	T9325	.047	771	.0118	.079		459	.0106	.079		722	.0118	.079		–	–	–		164	.0094	.063		–	–	–	6915805
	T9415	.047	984	.0118	.079		–	–	–		935	.0118	.079		–	–	–		–	–	–		197	.0059	.039	8183358
CNMG 542-SM	**T7325**	.031	607	.0102	.118		459	.0091	.118		–	–	–		–	–	–		197	.0091	.094		–	–	–	7156216
	T8430	.031	591	.0102	.118		312	.0091	.118		476	.0102	.118		1624	.0122	.118		115	.0091	.094		98	.0051	.028	7977324
	T9325	.031	738	.0102	.118		443	.0091	.118		689	.0102	.118		–	–	–		164	.0091	.094		–	–	–	6915808
CNMG 543-SM	**T6310**	.047	558	.0118	.118		394	.0106	.118		443	.0118	.118		1673	.0142	.118		164	.0106	.094		98	.0059	.039	6915809
	T7325	.047	623	.0118	.118		476	.0106	.118		–	–	–		–	–	–		197	.0106	.094		–	–	–	7156220
	T7335	.047	591	.0118	.118		459	.0106	.118		–	–	–		–	–	–		180	.0106	.094		–	–	–	6915810
	T8415	.047	705	.0118	.118		361	.0106	.118		640	.0118	.118		1772	.0142	.118		148	.0106	.094		115	.0059	.039	8553072
	T9325	.047	738	.0118	.118		443	.0106	.118		689	.0118	.118		–	–	–		164	.0106	.094		–	–	–	6915812
	T9415	.047	951	.0118	.118		–	–	–		902	.0118	.118		–	–	–		–	–	–		180	.0059	.039	8244251
CNMG 643-SM	**T6310**	.047	541	.0118	.157		377	.0106	.157		427	.0118	.157		1624	.0142	.157		148	.0106	.126		98	.0059	.039	6915813
	T7325	.047	607	.0118	.157		459	.0106	.157		–	–	–		–	–	–		197	.0106	.126		–	–	–	7156228
	T7335	.047	574	.0118	.157		443	.0106	.157		–	–	–		–	–	–		180	.0106	.126		–	–	–	6915814
	T8415	.047	689	.0118	.157		361	.0106	.157		623	.0118	.157		1722	.0142	.157		148	.0106	.126		115	.0059	.039	8553074
	T9415	.047	919	.0118	.157		–	–	–		869	.0118	.157		–	–	–		–	–	–		180	.0059	.039	8244256
																											
SM chip breaker is versatile and the first choice for medium machining of Steels and Super-alloys. It features slightly positive rake angle and stable, moderate T-land. It's also suitable for Stainless steels, Cast irons, and conditionally for Non-ferrous alloys and Hard materials.																											
DNMG 331-SM	**T7325**	.016	525	.0079	.031		394	.0071	.031		–	–	–		–	–	–		164	.0071	.024		–	–	–	7156264
	T8415	.016	591	.0079	.031		295	.0071	.031		525	.0079	.031		1476	.0094	.031		131	.0071	.025		98	.0055	.013	8553082
	T8430	.016	509	.0079	.031		279	.0071	.031		427	.0079	.031		1427	.0094	.031		98	.0071	.024		82	.0055	.012	7977350
	T9325	.016	623	.0079	.031		361	.0071	.031		591	.0079	.031		–	–	–		131	.0071	.024		–	–	–	6915820
DNMG 332-SM	**T7325**	.031	558	.0098	.047		427	.0091	.047		–	–	–		–	–	–		180	.0079	.039		–	–	–	7156273
	T7335	.031	525	.0098	.047		394	.0091	.047		–	–	–		–	–	–		164	.0079	.039		–	–	–	6915822
	T8415	.031	623	.0098	.047		328	.0089	.047		558	.0098	.047		1575	.0118	.047		131	.0079	.038		98	.0049	.026	8553087
	T8430	.031	558	.0098	.047		295	.0091	.047		443	.0098	.047		1526	.0118	.047		115	.0079	.039		82	.0051	.028	7977357
	T9325	.031	656	.0098	.047		394	.0091	.047		623	.0098	.047		–	–	–		148	.0079	.039		–	–	–	6915825
DNMG 431-SM	**T8415**	.016	541	.0079	.067		279	.0071	.067		492	.0079	.067		1378	.0094	.067		115	.0071	.054		82	.0055	.013	8553089

Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our cutting conditions app for further options.

Product		RE	P			M			K			N			S			H			MID
			vc (ft/min)	f (in/rev)	ap (inch)	vc (ft/min)	f (in/rev)	ap (inch)	vc (ft/min)	f (in/rev)	ap (inch)	vc (ft/min)	f (in/rev)	ap (inch)	vc (ft/min)	f (in/rev)	ap (inch)	vc (ft/min)	f (in/rev)	ap (inch)	
																					
			SM chip breaker is versatile and the first choice for medium machining of Steels and Super-alloys. It features slightly positive rake angle and stable, moderate T-land. It's also suitable for Stainless steels, Cast irons, and conditionally for Non-ferrous alloys and Hard materials.																	
DNMG 432-SM	**T6310**	.031	■ 459	.0098	.067	■ 328	.0091	.067	■ 361	.0098	.067	◪ 1378	.0118	.067	■ 131	.0079	.055	◪ 82	.0051	.028	7168667
	T8415	.031	■ 607	.0098	.067	■ 312	.0089	.067	■ 541	.0098	.067	◪ 1526	.0118	.067	■ 131	.0079	.054	◪ 98	.0049	.026	8553091
DNMG 441-SM	**T6310**	.016	■ 427	.0079	.067	■ 295	.0071	.067	■ 328	.0079	.067	◪ 1280	.0094	.067	■ 115	.0071	.055	◪ 82	.0055	.012	6915826
	T7325	.016	◪ 476	.0079	.067	■ 361	.0071	.067	–	–	–	–	–	–	■ 148	.0071	.055	–	–	–	7156292
	T7335	.016	◪ 459	.0079	.067	■ 344	.0071	.067	–	–	–	–	–	–	■ 148	.0071	.055	–	–	–	6915827
	T8415	.016	■ 541	.0079	.067	■ 279	.0071	.067	■ 492	.0079	.067	◪ 1378	.0094	.067	■ 115	.0071	.054	◪ 82	.0055	.013	8553096
	T8430	.016	■ 476	.0079	.067	■ 262	.0071	.067	◪ 394	.0079	.067	◪ 1329	.0094	.067	◪ 98	.0071	.055	◪ 82	.0055	.012	7977373
	T9325	.016	■ 591	.0079	.067	■ 344	.0071	.067	◪ 558	.0079	.067	–	–	–	◪ 131	.0071	.055	–	–	–	6915830
	T9415	.016	■ 738	.0079	.067	–	–	–	◪ 689	.0079	.067	–	–	–	–	–	–	◪ 148	.0055	.012	8244273
DNMG 442-SM	**T6310**	.031	■ 459	.0098	.067	■ 328	.0091	.067	■ 361	.0098	.067	◪ 1378	.0118	.067	■ 131	.0079	.055	◪ 82	.0051	.028	6915831
	T7325	.031	◪ 525	.0098	.067	■ 394	.0091	.067	–	–	–	–	–	–	■ 164	.0079	.055	–	–	–	7156301
	T7335	.031	◪ 509	.0098	.067	■ 394	.0091	.067	–	–	–	–	–	–	■ 164	.0079	.055	–	–	–	6915832
	T8415	.031	■ 607	.0098	.067	■ 312	.0089	.067	■ 541	.0098	.067	◪ 1526	.0118	.067	■ 131	.0079	.054	◪ 98	.0049	.026	8553103
	T8430	.031	■ 509	.0098	.067	■ 279	.0091	.067	◪ 427	.0098	.067	◪ 1427	.0118	.067	◪ 98	.0079	.055	◪ 82	.0051	.028	7977376
	T9325	.031	■ 640	.0098	.067	■ 377	.0091	.067	◪ 607	.0098	.067	–	–	–	◪ 131	.0079	.055	–	–	–	6915835
	T9415	.031	■ 820	.0098	.067	–	–	–	◪ 771	.0098	.067	–	–	–	–	–	–	◪ 164	.0051	.028	8244275
DNMG 443-SM	**T6310**	.047	■ 476	.0118	.067	■ 328	.0106	.067	■ 377	.0118	.067	◪ 1427	.0142	.067	■ 131	.0094	.055	◪ 82	.0059	.035	6915836
	T7325	.047	◪ 525	.0118	.067	■ 394	.0106	.067	–	–	–	–	–	–	■ 164	.0094	.055	–	–	–	7156307
	T8415	.047	■ 607	.0118	.067	■ 312	.0106	.067	■ 541	.0118	.067	◪ 1526	.0142	.067	■ 131	.0094	.054	◪ 98	.0059	.035	8553105
	T8430	.047	■ 509	.0118	.067	■ 279	.0106	.067	◪ 427	.0118	.067	◪ 1427	.0142	.067	◪ 98	.0094	.055	◪ 82	.0059	.035	7977381
	T9415	.047	■ 804	.0118	.067	–	–	–	◪ 755	.0118	.067	–	–	–	–	–	–	◪ 148	.0059	.035	8244278
																					
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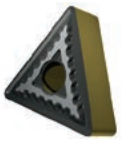
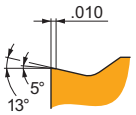
SNMG 432-SM	**T6310**	.031	■ 607	.0098	.071	■ 427	.0091	.071	■ 476	.0098	.071	◪ 1821	.0118	.071	■ 180	.0079	.055	◪ 115	.0051	.028	6915841
	T7325	.031	◪ 689	.0098	.071	■ 525	.0091	.071	–	–	–	–	–	–	■ 213	.0079	.055	–	–	–	7156339
	T7335	.031	◪ 673	.0098	.071	■ 509	.0091	.071	–	–	–	–	–	–	■ 213	.0079	.055	–	–	–	6915842
	T8415	.031	■ 787	.0098	.071	■ 410	.0089	.071	■ 705	.0098	.071	◪ 1969	.0118	.071	■ 180	.0079	.057	◪ 131	.0049	.026	8553111
	T8430	.031	■ 673	.0098	.071	■ 361	.0091	.071	◪ 558	.0098	.071	◪ 1870	.0118	.071	◪ 148	.0079	.055	◪ 115	.0051	.028	7977386
	T9325	.031	■ 837	.0098	.071	■ 492	.0091	.071	◪ 787	.0098	.071	–	–	–	◪ 180	.0079	.055	–	–	–	6915845
	T9415	.031	■ 1066	.0098	.071	–	–	–	◪ 1001	.0098	.071	–	–	–	–	–	–	◪ 213	.0051	.028	8244285
SNMG 433-SM	**T7325**	.047	◪ 689	.0118	.071	■ 525	.0106	.071	–	–	–	–	–	–	■ 213	.0094	.055	–	–	–	7156344
	T9415	.047	■ 1066	.0118	.071	–	–	–	◪ 1001	.0118	.071	–	–	–	–	–	–	◪ 213	.0059	.039	8244288
SNMG 643-SM	**T6310**	.047	■ 574	.0118	.157	■ 410	.0106	.157	■ 459	.0118	.157	◪ 1722	.0142	.157	■ 164	.0106	.126	◪ 115	.0059	.039	6915849
	T7325	.047	◪ 640	.0118	.157	■ 492	.0106	.157	–	–	–	–	–	–	■ 197	.0106	.126	–	–	–	7156353
	T7335	.047	◪ 607	.0118	.157	■ 459	.0106	.157	–	–	–	–	–	–	■ 197	.0106	.126	–	–	–	6915850
	T8415	.047	■ 722	.0118	.157	■ 377	.0106	.157	■ 656	.0118	.157	◪ 1821	.0142	.157	■ 164	.0106	.126	◪ 115	.0059	.039	8553115
	T9325	.047	■ 755	.0118	.157	■ 443	.0106	.157	◪ 705	.0118	.157	–	–	–	◪ 164	.0106	.126	–	–	–	6915851
SNMG 644-SM	**T7335**	.063	◪ 574	.0157	.157	■ 443	.0142	.157	–	–	–	–	–	–	■ 180	.0126	.126	–	–	–	6915852
	T9325	.063	■ 689	.0157	.157	■ 410	.0142	.157	◪ 640	.0157	.157	–	–	–	◪ 148	.0126	.126	–	–	–	6915853

Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our cutting conditions app for further options.

Product		RE	P				M				K				N				S				H				MID
			vc (ft/min)	f (in/rev)	ap (inch)		vc (ft/min)	f (in/rev)	ap (inch)		vc (ft/min)	f (in/rev)	ap (inch)		vc (ft/min)	f (in/rev)	ap (inch)		vc (ft/min)	f (in/rev)	ap (inch)		vc (ft/min)	f (in/rev)	ap (inch)		
		(inch)																									
																											
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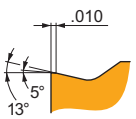
TNMG 331-SM	**T6310**	.016	■	443	.0079	.067	■	312	.0071	.067	■	344	.0079	.067	◪	1329	.0094	.067	■	131	.0071	.055	◪	82	.0055	.012	6915854
	T7325	.016	◪	509	.0079	.067	■	394	.0071	.067		–	–	–		–	–	–	■	164	.0071	.055		–	–	–	7156383
	T7335	.016	◪	492	.0079	.067	■	377	.0071	.067		–	–	–		–	–	–	■	148	.0071	.055		–	–	–	6915855
	T8415	.016	■	558	.0079	.067	■	295	.0071	.067	■	509	.0079	.067	◪	1427	.0094	.067	■	115	.0071	.054	◪	98	.0055	.013	8553124
	T8430	.016	■	509	.0079	.067	■	279	.0071	.067	◪	427	.0079	.067	◪	1427	.0094	.067	◪	98	.0071	.055	◪	82	.0055	.012	7977406
	T9325	.016	■	623	.0079	.067	■	361	.0071	.067	◪	591	.0079	.067		–	–	–	◪	131	.0071	.055		–	–	–	6915858
	T9415	.016	■	787	.0079	.067		–	–	–	◪	738	.0079	.067		–	–	–		–	–	–	◪	148	.0055	.012	8244298
TNMG 332-SM	**T6310**	.031	■	492	.0098	.067	■	344	.0091	.067	■	394	.0098	.067	◪	1476	.0118	.067	■	148	.0079	.055	◪	98	.0051	.028	6915859
	T7325	.031	◪	558	.0098	.067	■	427	.0091	.067		–	–	–		–	–	–	■	180	.0079	.055		–	–	–	7156392
	T7335	.031	◪	541	.0098	.067	■	410	.0091	.067		–	–	–		–	–	–	■	164	.0079	.055		–	–	–	6915860
	T8415	.031	■	640	.0098	.067	■	328	.0089	.067	■	591	.0098	.067	◪	1624	.0118	.067	■	148	.0079	.054	◪	98	.0049	.026	8553131
	T8430	.031	■	558	.0098	.067	■	295	.0091	.067	◪	443	.0098	.067	◪	1526	.0118	.067	◪	115	.0079	.055	◪	82	.0051	.028	7977146
	T9325	.031	■	673	.0098	.067	■	394	.0091	.067	◪	623	.0098	.067		–	–	–	◪	148	.0079	.055		–	–	–	6915863
	T9415	.031	■	869	.0098	.067		–	–	–	◪	820	.0098	.067		–	–	–		–	–	–	◪	164	.0051	.028	8244301
TNMG 333-SM	**T6310**	.047	■	509	.0118	.067	■	361	.0106	.067	■	410	.0118	.067	◪	1526	.0142	.067	■	148	.0094	.055	◪	98	.0059	.035	7763106
	T7325	.047	◪	558	.0118	.067	■	427	.0106	.067		–	–	–		–	–	–	■	180	.0094	.055		–	–	–	7156396
	T7335	.047	◪	541	.0118	.067	■	410	.0106	.067		–	–	–		–	–	–	■	164	.0094	.055		–	–	–	6915864
	T8415	.047	■	640	.0118	.067	■	328	.0106	.067	■	591	.0118	.067	◪	1624	.0142	.067	■	148	.0094	.054	◪	98	.0059	.035	8553133
	T9325	.047	■	673	.0118	.067	■	394	.0106	.067	◪	623	.0118	.067		–	–	–	◪	148	.0094	.055		–	–	–	6915865
TNMG 431-SM	**T6310**	.016	■	443	.0079	.067	■	312	.0071	.067	■	344	.0079	.067	◪	1329	.0094	.067	■	131	.0071	.055	◪	82	.0055	.012	6915866
	T7325	.016	◪	509	.0079	.067	■	394	.0071	.067		–	–	–		–	–	–	■	164	.0071	.055		–	–	–	7156397
	T8415	.016	■	558	.0079	.067	■	295	.0071	.067	■	509	.0079	.067	◪	1427	.0094	.067	■	115	.0071	.054	◪	98	.0055	.013	8553135
	T8430	.016	■	509	.0079	.067	■	279	.0071	.067	◪	427	.0079	.067	◪	1427	.0094	.067	◪	98	.0071	.055	◪	82	.0055	.012	7977411
	T9325	.016	■	623	.0079	.067	■	361	.0071	.067	◪	591	.0079	.067		–	–	–	◪	131	.0071	.055		–	–	–	6915868
TNMG 432-SM	**T6310**	.031	■	492	.0098	.067	■	344	.0091	.067	■	394	.0098	.067	◪	1476	.0118	.067	■	148	.0079	.055	◪	98	.0051	.028	6915869
	T7325	.031	◪	558	.0098	.067	■	427	.0091	.067		–	–	–		–	–	–	■	180	.0079	.055		–	–	–	7156401
	T7335	.031	◪	541	.0098	.067	■	410	.0091	.067		–	–	–		–	–	–	■	164	.0079	.055		–	–	–	6915870
	T8415	.031	■	640	.0098	.067	■	328	.0089	.067	■	591	.0098	.067	◪	1624	.0118	.067	■	148	.0079	.054	◪	98	.0049	.026	8553138
	T8430	.031	■	558	.0098	.067	■	295	.0091	.067	◪	443	.0098	.067	◪	1526	.0118	.067	◪	115	.0079	.055	◪	82	.0051	.028	7977150
	T9325	.031	■	673	.0098	.067	■	394	.0091	.067	◪	623	.0098	.067		–	–	–	◪	148	.0079	.055		–	–	–	6915873
	T9415	.031	■	869	.0098	.067		–	–	–	◪	820	.0098	.067		–	–	–		–	–	–	◪	164	.0051	.028	8244309
TNMG 433-SM	**T7325**	.047	◪	558	.0118	.067	■	427	.0106	.067		–	–	–		–	–	–	■	180	.0094	.055		–	–	–	7156405
	T7335	.047	◪	541	.0118	.067	■	410	.0106	.067		–	–	–		–	–	–	■	164	.0094	.055		–	–	–	6915874
	T8415	.047	■	640	.0118	.067	■	328	.0106	.067	■	591	.0118	.067	◪	1624	.0142	.067	■	148	.0094	.054	◪	98	.0059	.035	8553140
	T9325	.047	■	673	.0118	.067	■	394	.0106	.067	◪	623	.0118	.067		–	–	–	◪	148	.0094	.055		–	–	–	6915876
	T9415	.047	■	853	.0118	.067		–	–	–	◪	804	.0118	.067		–	–	–		–	–	–	◪	164	.0059	.035	8244313
																											
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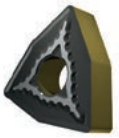
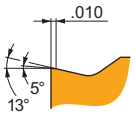
VNMG 331-SM	**T7325**	.016	◪	443	.0071	.047	■	344	.0063	.047		–	–	–		–	–	–	■	131	.0063	.039		–	–	–	7156437
	T8415	.016	■	509	.0071	.047	■	262	.0064	.047	■	459	.0071	.047	◪	1280	.0085	.047	■	115	.0064	.038	◪	82	.005	.013	8553144
	T8430	.016	■	443	.0071	.047	■	246	.0063	.047	◪	361	.0071	.047	◪	1230	.0087	.047	◪	82	.0063	.039	◪	66	.0051	.012	7977415
	T9325	.016	■	558	.0071	.047	■	328	.0063	.047	◪	525	.0071	.047		–	–	–	◪	115	.0063	.039		–	–	–	6915881
	T9415	.016	■	689	.0071	.047		–	–	–	◪	640	.0071	.047		–	–	–		–	–	–	◪	131	.0051	.012	8345603
VNMG 332-SM	**T6310**	.031	■	410	.0098	.055	■	295	.0091	.055	■	328	.0098	.055	◪	1230	.0118	.055	■	115	.0079	.043	◪	82	.0051	.028	6915882
	T7325	.031	◪	476	.0098	.055	■	361	.0091	.055		–	–	–		–	–	–	■	148	.0079	.043		–	–	–	7156442
	T8415	.031	■	525	.0098	.055	■	279	.0089	.055	■	476	.0098	.055	◪	1329	.0118	.055	■	115	.0079	.044	◪	82	.0049	.026	8553147
	T8430	.031	■	459	.0098	.055	■	246	.0091	.055	◪	377	.0098	.055	◪	1280	.0118	.055	◪	98	.0079	.043	◪	66	.0051	.028	7977419
	T9325	.031	■	558	.0098	.055	■	328	.0091	.055	◪	525	.0098	.055		–	–	–	◪	115	.0079	.043		–	–	–	6915886

Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our cutting conditions app for further options.

Product		RE	P				M				K				N				S				H				MID
				vc (ft/min)	f (in/rev)	ap (inch)		vc (ft/min)	f (in/rev)	ap (inch)		vc (ft/min)	f (in/rev)	ap (inch)		vc (ft/min)	f (in/rev)	ap (inch)		vc (ft/min)	f (in/rev)	ap (inch)		vc (ft/min)	f (in/rev)	ap (inch)	





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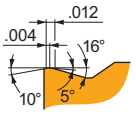
WNMG 331-SM	**T7335**	.016	◪	591	.0079	.067	■	459	.0071	.067		–	–	–		–	–	–	■	180	.0071	.055		–	–	–	6915889
	T8430	.016	■	607	.0079	.067	■	328	.0071	.067	◪	492	.0079	.067	◪	1673	.0094	.067	◪	131	.0071	.055	◪	98	.0051	.012	7977429
	T9325	.016	■	738	.0079	.067	■	443	.0071	.067	◪	689	.0079	.067		–	–	–	◪	164	.0071	.055		–	–	–	6915892
WNMG 332-SM	**T6310**	.031	■	574	.0098	.067	■	410	.0091	.067	■	459	.0098	.067	◪	1722	.0118	.067	■	164	.0079	.055	◪	115	.0051	.028	6915893
	T7325	.031	◪	656	.0098	.067	■	509	.0091	.067		–	–	–		–	–	–	■	213	.0079	.055		–	–	–	7156464
	T7335	.031	◪	640	.0098	.067	■	492	.0091	.067		–	–	–		–	–	–	■	197	.0079	.055		–	–	–	6915894
	T8415	.031	■	738	.0098	.067	■	377	.0089	.067	■	673	.0098	.067	◪	1870	.0118	.067	■	164	.0079	.054	◪	115	.0049	.026	8553155
	T8430	.031	■	640	.0098	.067	■	344	.0091	.067	◪	525	.0098	.067	◪	1772	.0118	.067	◪	131	.0079	.055	◪	98	.0051	.028	7977431
	T9325	.031	■	787	.0098	.067	■	459	.0091	.067	◪	738	.0098	.067		–	–	–	◪	164	.0079	.055		–	–	–	6915896
WNMG 333-SM	**T7325**	.047	◪	656	.0118	.067	■	509	.0106	.067		–	–	–		–	–	–	■	213	.0094	.055		–	–	–	7156468
	T8430	.047	■	640	.0118	.067	■	344	.0106	.067	◪	525	.0118	.067	◪	1772	.0142	.067	◪	131	.0094	.055	◪	98	.0059	.039	7977432
	T9325	.047	■	787	.0118	.067	■	459	.0106	.067	◪	738	.0118	.067		–	–	–	◪	164	.0094	.055		–	–	–	6915899
WNMG 431-SM	**T6310**	.016	■	509	.0079	.079	■	361	.0071	.079	■	410	.0079	.079	◪	1526	.0094	.079	■	148	.0071	.063	◪	98	.0051	.012	6915900
	T7325	.016	◪	591	.0079	.079	■	459	.0071	.079		–	–	–		–	–	–	■	180	.0071	.063		–	–	–	7156478
	T7335	.016	◪	574	.0079	.079	■	443	.0071	.079		–	–	–		–	–	–	■	180	.0071	.063		–	–	–	6915901
	T8415	.016	■	656	.0079	.079	■	344	.0071	.079	■	607	.0079	.079	◪	1673	.0094	.079	■	148	.0071	.063	◪	115	.0051	.013	8553161
	T8430	.016	■	591	.0079	.079	■	312	.0071	.079	◪	476	.0079	.079	◪	1624	.0094	.079	◪	115	.0071	.063	◪	98	.0051	.012	7977437
	T9325	.016	■	722	.0079	.079	■	427	.0071	.079	◪	673	.0079	.079		–	–	–	◪	148	.0071	.063		–	–	–	6915904
	T9415	.016	■	919	.0079	.079		–	–	–	◪	869	.0079	.079		–	–	–		–	–	–	◪	180	.0051	.012	8244323
WNMG 432-SM	**T6310**	.031	■	574	.0098	.079	■	410	.0091	.079	■	459	.0098	.079	◪	1722	.0118	.079	■	164	.0079	.063	◪	115	.0051	.028	6915905
	T7325	.031	◪	656	.0098	.079	■	509	.0091	.079		–	–	–		–	–	–	■	213	.0079	.063		–	–	–	7156488
	T7335	.031	◪	623	.0098	.079	■	476	.0091	.079		–	–	–		–	–	–	■	197	.0079	.063		–	–	–	6915906
	T8415	.031	■	738	.0098	.079	■	377	.0089	.079	■	673	.0098	.079	◪	1870	.0118	.079	■	164	.0079	.063	◪	115	.0049	.026	8553166
	T8430	.031	■	640	.0098	.079	■	344	.0091	.079	◪	525	.0098	.079	◪	1772	.0118	.079	◪	131	.0079	.063	◪	98	.0051	.028	7977173
	T9325	.031	■	771	.0098	.079	■	459	.0091	.079	◪	722	.0098	.079		–	–	–	◪	164	.0079	.063		–	–	–	6915909
	T9415	.031	■	1001	.0098	.079		–	–	–	◪	935	.0098	.079		–	–	–		–	–	–	◪	197	.0051	.028	8183411
WNMG 433-SM	**T6310**	.047	■	574	.0118	.079	■	410	.0106	.079	■	459	.0118	.079	◪	1722	.0142	.079	■	164	.0094	.063	◪	115	.0059	.039	6915910
	T7325	.047	◪	640	.0118	.079	■	492	.0106	.079		–	–	–		–	–	–	■	197	.0094	.063		–	–	–	7156495
	T7335	.047	◪	623	.0118	.079	■	476	.0106	.079		–	–	–		–	–	–	■	197	.0094	.063		–	–	–	6915911
	T8415	.047	■	738	.0118	.079	■	377	.0106	.079	■	673	.0118	.079	◪	1870	.0142	.079	■	164	.0094	.063	◪	115	.0059	.039	8553168
	T8430	.047	■	623	.0118	.079	■	344	.0106	.079	◪	509	.0118	.079	◪	1722	.0142	.079	◪	131	.0094	.063	◪	98	.0059	.039	7977444
	T9325	.047	■	771	.0118	.079	■	459	.0106	.079	◪	722	.0118	.079		–	–	–	◪	164	.0094	.063		–	–	–	6915914
	T9415	.047	■	984	.0118	.079		–	–	–	◪	935	.0118	.079		–	–	–		–	–	–	◪	197	.0059	.039	8183414

M

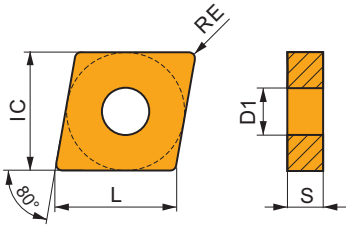


M chip breaker is versatile and the first choice for medium machining of Cast irons. It features positive rake angle and negative/stable, moderate T-land. It's also suitable for Steels, and conditionally for Hard materials.

PRAMET

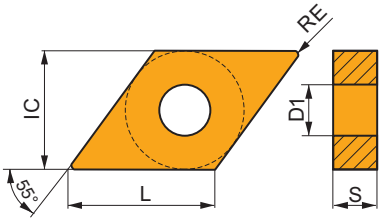
CNMG

	IC (inch)	D1 (inch)	L (inch)	S (inch)
32	.375	.150	.382	.125
43	.500	.203	.508	.187
54	.625	.250	.634	.250
64	.750	.313	.760	.250



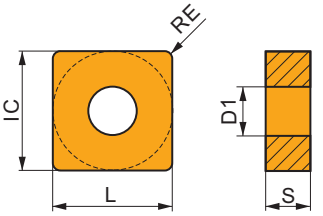
DNMG

	IC (inch)	D1 (inch)	L (inch)	S (inch)
33	.375	.150	.457	.187
43	.500	.203	.610	.187
44	.500	.203	.610	.250



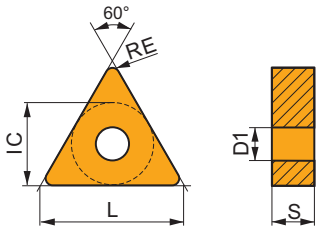
SNMG

	IC (inch)	D1 (inch)	L (inch)	S (inch)
43	.500	.203	.500	.187
54	.625	.250	.625	.250
64	.750	.313	.750	.250



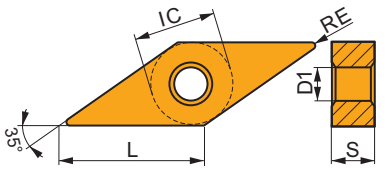
TNMG

	IC (inch)	D1 (inch)	L (inch)	S (inch)
33	.375	.150	.650	.187
43	.500	.203	.866	.187



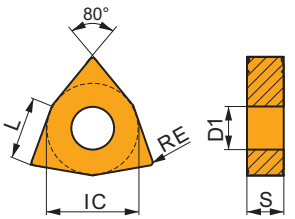
VNMG

	IC (inch)	D1 (inch)	L (inch)	S (inch)
33	.375	.150	.654	.187

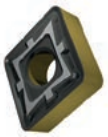
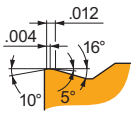


WNMG

	IC (inch)	D1 (inch)	L (inch)	S (inch)
33	.375	.150	.256	.187
43	.500	.203	.343	.187

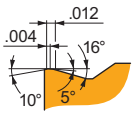


Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our cutting conditions app for further options.

Product		RE	P						M						K						N						S						H						MID
			vc		f		ap		vc		f		ap		vc		f		ap		vc		f		ap		vc		f		ap		vc		f		ap		
		(inch)	(ft/min)		(in/rev)		(inch)		(ft/min)		(in/rev)		(inch)		(ft/min)		(in/rev)		(inch)		(ft/min)		(in/rev)		(inch)		(ft/min)		(in/rev)		(inch)		(ft/min)		(in/rev)		(inch)		
								**M** chip breaker is versatile and the first choice for medium machining of Cast irons. It features positive rake angle and negative/stable, moderate T-land. It's also suitable for Steels, and conditionally for Hard materials.																															
CNMG 322-M	**T9325**	.031	■	673	.0126	.071		–	–	–		623	.0126	.071		–	–	–		–	–	–		–	–	–		–	–	–	6753877
	T9335	.031	■	591	.0126	.071		–	–	–		–	–	–		–	–	–		–	–	–		–	–	–		–	–	–	6754854
	T9415	.031	■	902	.0126	.071		–	–	–	◪	853	.0126	.071		–	–	–		–	–	–	◪	180	.0063	.020	8345268
CNMG 431-M	**T5315**	.016	◪	804	.0079	.083		–	–	–	■	755	.0079	.083		–	–	–		–	–	–	◪	148	.0051	.012	6755793
	T9325	.016	■	689	.0079	.083		–	–	–	◪	640	.0079	.083		–	–	–		–	–	–		–	–	–	6753880
	T9335	.016	■	591	.0079	.083		–	–	–		–	–	–		–	–	–		–	–	–		–	–	–	6754855
	T9415	.016	■	869	.0079	.083		–	–	–	◪	820	.0079	.083		–	–	–		–	–	–	◪	164	.0051	.012	8244149
CNMG 432-M	**6640**	.031	■	541	.0126	.083		–	–	–	■	509	.0126	.083		–	–	–		–	–	–		–	–	–	6751506
	T5305	.031	◪	919	.0126	.083		–	–	–	■	869	.0126	.083		–	–	–		–	–	–	◪	180	.0063	.028	6755742
	T5315	.031	◪	820	.0126	.083		–	–	–	■	771	.0126	.083		–	–	–		–	–	–	◪	164	.0063	.028	6755794
	T8430	.031	■	558	.0126	.083		–	–	–	◪	443	.0126	.083		–	–	–		–	–	–	◪	82	.0063	.028	7977105
	T9310	.031	■	804	.0126	.083		–	–	–	◪	755	.0126	.083		–	–	–		–	–	–	◪	148	.0063	.028	6755028
	T9315	.031	■	738	.0126	.083		–	–	–	◪	689	.0126	.083		–	–	–		–	–	–	◪	148	.0063	.028	6753722
	T9325	.031	■	656	.0126	.083		–	–	–	◪	623	.0126	.083		–	–	–		–	–	–		–	–	–	6753778
	T9335	.031	■	591	.0126	.083		–	–	–		–	–	–		–	–	–		–	–	–		–	–	–	6754856
	T9415	.031	■	886	.0126	.083		–	–	–	◪	837	.0126	.083		–	–	–		–	–	–	◪	164	.0063	.028	8183352
CNMG 433-M	**T5305**	.047	◪	902	.0157	.083		–	–	–	■	853	.0157	.083		–	–	–		–	–	–	◪	180	.0079	.039	6755780
	T5315	.047	◪	804	.0157	.083		–	–	–	■	755	.0157	.083		–	–	–		–	–	–	◪	148	.0079	.039	6755798
	T9315	.047	■	722	.0157	.083		–	–	–	◪	673	.0157	.083		–	–	–		–	–	–	◪	131	.0079	.039	6753723
	T9325	.047	■	640	.0157	.083		–	–	–	◪	607	.0157	.083		–	–	–		–	–	–		–	–	–	6753793
	T9335	.047	■	558	.0157	.083		–	–	–		–	–	–		–	–	–		–	–	–		–	–	–	6754859
	T9415	.047	■	869	.0157	.083		–	–	–	◪	820	.0157	.083		–	–	–		–	–	–	◪	164	.0079	.039	8183356
CNMG 434-M	**T9325**	.063	■	656	.0157	.083		–	–	–	◪	623	.0157	.083		–	–	–		–	–	–		–	–	–	6753893
	T9335	.063	■	574	.0157	.083		–	–	–		–	–	–		–	–	–		–	–	–		–	–	–	6754862
CNMG 542-M	**T9325**	.031	■	623	.0126	.142		–	–	–	◪	591	.0126	.142		–	–	–		–	–	–		–	–	–	6753895
	T9335	.031	■	558	.0126	.142		–	–	–		–	–	–		–	–	–		–	–	–		–	–	–	6754864
	T9415	.031	■	837	.0126	.142		–	–	–	◪	787	.0126	.142		–	–	–		–	–	–	◪	164	.0063	.028	8244246
CNMG 543-M	**T9325**	.047	■	607	.0157	.142		–	–	–	◪	574	.0157	.142		–	–	–		–	–	–		–	–	–	6753898
	T9335	.047	■	525	.0157	.142		–	–	–		–	–	–		–	–	–		–	–	–		–	–	–	6754866
	T9415	.047	■	820	.0157	.142		–	–	–	◪	771	.0157	.142		–	–	–		–	–	–	◪	164	.0079	.039	8244248
CNMG 544-M	**T9325**	.063	■	623	.0157	.142		–	–	–	◪	591	.0157	.142		–	–	–		–	–	–		–	–	–	6753903
	T9335	.063	■	541	.0157	.142		–	–	–		–	–	–		–	–	–		–	–	–		–	–	–	6754868
CNMG 642-M	**6630**	.031	■	574	.0126	.165		–	–	–	◪	541	.0126	.165		–	–	–		–	–	–		–	–	–	6751543
	T9325	.031	■	623	.0126	.165		–	–	–	◪	591	.0126	.165		–	–	–		–	–	–		–	–	–	6753905
	T9335	.031	■	541	.0126	.165		–	–	–		–	–	–		–	–	–		–	–	–		–	–	–	6754870
	T9415	.031	■	820	.0126	.165		–	–	–	◪	771	.0126	.165		–	–	–		–	–	–	◪	164	.0063	.028	8244253
CNMG 643-M	**6630**	.047	■	558	.0157	.165		–	–	–	◪	525	.0157	.165		–	–	–		–	–	–		–	–	–	6751545
	6640	.047	■	476	.0157	.165		–	–	–	■	443	.0157	.165		–	–	–		–	–	–		–	–	–	6751546
	T9325	.047	■	607	.0157	.165		–	–	–	◪	574	.0157	.165		–	–	–		–	–	–		–	–	–	6753795
	T9335	.047	■	525	.0157	.165		–	–	–		–	–	–		–	–	–		–	–	–		–	–	–	6754872
	T9415	.047	■	804	.0157	.165		–	–	–	◪	755	.0157	.165		–	–	–		–	–	–	◪	148	.0079	.039	8183390
CNMG 644-M	**T9325**	.063	■	623	.0157	.165		–	–	–	◪	591	.0157	.165		–	–	–		–	–	–		–	–	–	6753909
	T9335	.063	■	541	.0157	.165		–	–	–		–	–	–		–	–	–		–	–	–		–	–	–	6754875
	T9415	.063	■	837	.0157	.165		–	–	–	◪	787	.0157	.165		–	–	–		–	–	–	◪	164	.0079	.051	8345530

Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our cutting conditions app for further options.

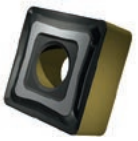
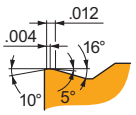
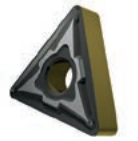
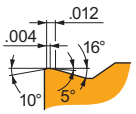
Product		RE	P				M				K				N				S				H				MID
			vc (ft/min)	f (in/rev)	ap (inch)		vc (ft/min)	f (in/rev)	ap (inch)		vc (ft/min)	f (in/rev)	ap (inch)		vc (ft/min)	f (in/rev)	ap (inch)		vc (ft/min)	f (in/rev)	ap (inch)		vc (ft/min)	f (in/rev)	ap (inch)		



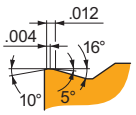
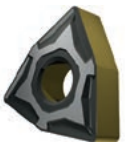
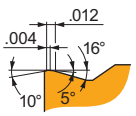
M chip breaker is versatile and the first choice for medium machining of Cast irons. It features positive rake angle and negative/stable, moderate T-land. It's also suitable for Steels, and conditionally for Hard materials.

DNMG 331-M	**T5315**	.016	◩	689	.0079	.047		–	–	–	■	640	.0079	.047		–	–	–		–	–	–	◩	131	.0055	.012	6755744
	T9325	.016	■	574	.0079	.047		–	–	–	◩	541	.0079	.047		–	–	–		–	–	–		–	–	–	6753941
	T9335	.016	■	492	.0079	.047		–	–	–		–	–	–		–	–	–		–	–	–		–	–	–	6754895
	T9415	.016	■	738	.0079	.047		–	–	–	◩	689	.0079	.047		–	–	–		–	–	–	◩	148	.0055	.012	8345544
DNMG 332-M	**T5315**	.031	◩	705	.0118	.047		–	–	–	■	656	.0118	.047		–	–	–		–	–	–	◩	131	.0059	.028	6755745
	T9325	.031	■	574	.0118	.047		–	–	–	◩	541	.0118	.047		–	–	–		–	–	–		–	–	–	6753946
	T9335	.031	■	509	.0118	.047		–	–	–		–	–	–		–	–	–		–	–	–		–	–	–	6754896
	T9415	.031	■	771	.0118	.047		–	–	–	◩	722	.0118	.047		–	–	–		–	–	–	◩	148	.0059	.028	8244265
DNMG 333-M	**T9325**	.047	■	541	.0157	.047		–	–	–	◩	509	.0157	.047		–	–	–		–	–	–		–	–	–	6753950
	T9415	.047	■	722	.0157	.047		–	–	–	◩	673	.0157	.047		–	–	–		–	–	–	◩	131	.0079	.035	8345547
DNMG 431-M	**T5315**	.016	◩	656	.0079	.075		–	–	–	■	623	.0079	.075		–	–	–		–	–	–	◩	131	.0055	.012	7035037
	T9325	.016	■	558	.0079	.075		–	–	–	◩	525	.0079	.075		–	–	–		–	–	–		–	–	–	6753953
	T9415	.016	■	689	.0079	.075		–	–	–	◩	640	.0079	.075		–	–	–		–	–	–	◩	131	.0055	.012	8345548
DNMG 432-M	**T5315**	.031	◩	673	.0118	.075		–	–	–	■	623	.0118	.075		–	–	–		–	–	–	◩	131	.0059	.028	7035038
	T9325	.031	■	558	.0118	.075		–	–	–	◩	525	.0118	.075		–	–	–		–	–	–		–	–	–	6753956
	T9335	.031	■	476	.0118	.075		–	–	–		–	–	–		–	–	–		–	–	–		–	–	–	6754901
	T9415	.031	■	722	.0118	.075		–	–	–	◩	673	.0118	.075		–	–	–		–	–	–	◩	131	.0059	.028	8183393
DNMG 433-M	**T5315**	.047	◩	656	.0157	.075		–	–	–	■	623	.0157	.075		–	–	–		–	–	–	◩	131	.0079	.035	7035039
	T9315	.047	■	574	.0157	.075		–	–	–	◩	541	.0157	.075		–	–	–		–	–	–	◩	115	.0079	.035	6922891
	T9325	.047	■	525	.0157	.075		–	–	–	◩	492	.0157	.075		–	–	–		–	–	–		–	–	–	6753958
	T9415	.047	■	689	.0157	.075		–	–	–	◩	640	.0157	.075		–	–	–		–	–	–	◩	131	.0079	.035	8183394
DNMG 441-M	**T5315**	.016	◩	656	.0079	.075		–	–	–	■	623	.0079	.075		–	–	–		–	–	–	◩	131	.0055	.012	6755746
	T9325	.016	■	558	.0079	.075		–	–	–	◩	525	.0079	.075		–	–	–		–	–	–		–	–	–	6753962
	T9335	.016	■	476	.0079	.075		–	–	–		–	–	–		–	–	–		–	–	–		–	–	–	6754904
	T9415	.016	■	689	.0079	.075		–	–	–	◩	640	.0079	.075		–	–	–		–	–	–	◩	131	.0055	.012	8244272
DNMG 442-M	**T5315**	.031	◩	673	.0118	.075		–	–	–	■	623	.0118	.075		–	–	–		–	–	–	◩	131	.0059	.028	6755747
	T9315	.031	■	623	.0118	.075		–	–	–	◩	591	.0118	.075		–	–	–		–	–	–	◩	115	.0059	.028	6753740
	T9325	.031	■	558	.0118	.075		–	–	–	◩	525	.0118	.075		–	–	–		–	–	–		–	–	–	6753803
	T9335	.031	■	476	.0118	.075		–	–	–		–	–	–		–	–	–		–	–	–		–	–	–	6754905
	T9415	.031	■	722	.0118	.075		–	–	–	◩	673	.0118	.075		–	–	–		–	–	–	◩	131	.0059	.028	8183397
DNMG 443-M	**T5315**	.047	◩	656	.0157	.075		–	–	–	■	623	.0157	.075		–	–	–		–	–	–	◩	131	.0079	.035	6755749
	T9315	.047	■	574	.0157	.075		–	–	–	◩	541	.0157	.075		–	–	–		–	–	–	◩	115	.0079	.035	6754071
	T9325	.047	■	525	.0157	.075		–	–	–	◩	492	.0157	.075		–	–	–		–	–	–		–	–	–	6753968
	T9335	.047	■	459	.0157	.075		–	–	–		–	–	–		–	–	–		–	–	–		–	–	–	6754907
	T9415	.047	■	689	.0157	.075		–	–	–	◩	640	.0157	.075		–	–	–		–	–	–	◩	131	.0079	.035	8183398

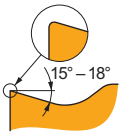
Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our cutting conditions app for further options.

Product		RE	P				M				K				N				S				H				MID
			vc (ft/min)	f (in/rev)	ap (inch)		vc (ft/min)	f (in/rev)	ap (inch)		vc (ft/min)	f (in/rev)	ap (inch)		vc (ft/min)	f (in/rev)	ap (inch)		vc (ft/min)	f (in/rev)	ap (inch)		vc (ft/min)	f (in/rev)	ap (inch)		
																											
M chip breaker is versatile and the first choice for medium machining of Cast irons. It features positive rake angle and negative/stable, moderate T-land. It's also suitable for Steels, and conditionally for Hard materials.																											
SNMG 432-M	**T5315**	.031	◪	853	.0126	.083		–	–	–	■	804	.0126	.083		–	–	–		–	–	–	◪	164	.0063	.028	6755770
	T9325	.031	■	689	.0126	.083		–	–	–	◪	640	.0126	.083		–	–	–		–	–	–		–	–	–	6753837
	T9335	.031	■	607	.0126	.083		–	–	–		–	–	–		–	–	–		–	–	–		–	–	–	6754931
	T9415	.031	■	919	.0126	.083		–	–	–	◪	869	.0126	.083		–	–	–		–	–	–	◪	180	.0063	.028	8345568
SNMG 433-M	**T9325**	.047	■	656	.0157	.083		–	–	–	◪	623	.0157	.083		–	–	–		–	–	–		–	–	–	6754009
	T9335	.047	■	574	.0157	.083		–	–	–		–	–	–		–	–	–		–	–	–		–	–	–	6754934
	T9415	.047	■	902	.0157	.083		–	–	–	◪	853	.0157	.083		–	–	–		–	–	–	◪	180	.0079	.039	8345570
SNMG 434-M	**T9325**	.063	■	689	.0157	.083		–	–	–	◪	640	.0157	.083		–	–	–		–	–	–		–	–	–	6754014
SNMG 543-M	**T9325**	.047	■	640	.0157	.134		–	–	–	◪	607	.0157	.134		–	–	–		–	–	–		–	–	–	6754017
	T9335	.047	■	558	.0157	.134		–	–	–		–	–	–		–	–	–		–	–	–		–	–	–	6754939
	T9415	.047	■	853	.0157	.134		–	–	–	◪	804	.0157	.134		–	–	–		–	–	–	◪	164	.0079	.039	8345572
SNMG 643-M	**6630**	.047	■	574	.0157	.157		–	–	–	◪	541	.0157	.157		–	–	–		–	–	–		–	–	–	6751577
	T9325	.047	■	623	.0157	.157		–	–	–	◪	591	.0157	.157		–	–	–		–	–	–		–	–	–	6754022
	T9335	.047	■	541	.0157	.157		–	–	–		–	–	–		–	–	–		–	–	–		–	–	–	6754942
	T9415	.047	■	837	.0157	.157		–	–	–	◪	787	.0157	.157		–	–	–		–	–	–	◪	164	.0079	.039	8345575
SNMG 644-M	**T9325**	.063	■	656	.0157	.157		–	–	–	◪	623	.0157	.157		–	–	–		–	–	–		–	–	–	6754025
	T9335	.063	■	574	.0157	.157		–	–	–		–	–	–		–	–	–		–	–	–		–	–	–	6754944
	T9415	.063	■	886	.0157	.157		–	–	–	◪	837	.0157	.157		–	–	–		–	–	–	◪	164	.0079	.051	8345576
																											
M chip breaker is versatile and the first choice for medium machining of Cast irons. It features positive rake angle and negative/stable, moderate T-land. It's also suitable for Steels, and conditionally for Hard materials.																											
TNMG 331-M	**T5315**	.016	◪	705	.0079	.063		–	–	–	■	656	.0079	.063		–	–	–		–	–	–	◪	131	.0055	.012	6755697
	T9325	.016	■	591	.0079	.063		–	–	–	◪	558	.0079	.063		–	–	–		–	–	–		–	–	–	6754107
	T9335	.016	■	509	.0079	.063		–	–	–		–	–	–		–	–	–		–	–	–		–	–	–	6754976
	T9415	.016	■	755	.0079	.063		–	–	–	◪	705	.0079	.063		–	–	–		–	–	–	◪	148	.0055	.012	8244297
TNMG 332-M	**T5305**	.031	◪	820	.0118	.063		–	–	–	■	771	.0118	.063		–	–	–		–	–	–	◪	164	.0059	.028	6755893
	T5315	.031	◪	738	.0118	.063		–	–	–	■	689	.0118	.063		–	–	–		–	–	–	◪	148	.0059	.028	6755699
	T9310	.031	■	722	.0118	.063		–	–	–	◪	673	.0118	.063		–	–	–		–	–	–	◪	131	.0059	.028	6755058
	T9325	.031	■	607	.0118	.063		–	–	–	◪	574	.0118	.063		–	–	–		–	–	–		–	–	–	6753847
	T9335	.031	■	525	.0118	.063		–	–	–		–	–	–		–	–	–		–	–	–		–	–	–	6754977
	T9415	.031	■	787	.0118	.063		–	–	–	◪	738	.0118	.063		–	–	–		–	–	–	◪	148	.0059	.028	8244299
TNMG 333-M	**T5315**	.047	◪	705	.0157	.063		–	–	–	■	656	.0157	.063		–	–	–		–	–	–	◪	131	.0079	.035	6755701
	T9325	.047	■	558	.0157	.063		–	–	–	◪	525	.0157	.063		–	–	–		–	–	–		–	–	–	6754117
	T9335	.047	■	476	.0157	.063		–	–	–		–	–	–		–	–	–		–	–	–		–	–	–	6754980
	T9415	.047	■	738	.0157	.063		–	–	–	◪	689	.0157	.063		–	–	–		–	–	–	◪	148	.0079	.035	8244303
TNMG 432-M	**T5315**	.031	◪	705	.0118	.083		–	–	–	■	656	.0118	.083		–	–	–		–	–	–	◪	131	.0059	.028	6755703
	T9325	.031	■	591	.0118	.083		–	–	–	◪	558	.0118	.083		–	–	–		–	–	–		–	–	–	6753850
	T9335	.031	■	509	.0118	.083		–	–	–		–	–	–		–	–	–		–	–	–		–	–	–	6754983
	T9415	.031	■	755	.0118	.083		–	–	–	◪	705	.0118	.083		–	–	–		–	–	–	◪	148	.0059	.028	8244307
TNMG 433-M	**T5315**	.047	◪	673	.0157	.083		–	–	–	■	623	.0157	.083		–	–	–		–	–	–	◪	131	.0079	.035	6755705
	T9325	.047	■	541	.0157	.083		–	–	–	◪	509	.0157	.083		–	–	–		–	–	–		–	–	–	6754487
	T9335	.047	■	459	.0157	.083		–	–	–		–	–	–		–	–	–		–	–	–		–	–	–	6754985
	T9415	.047	■	738	.0157	.083		–	–	–	◪	689	.0157	.083		–	–	–		–	–	–	◪	148	.0079	.035	8244310

Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our cutting conditions app for further options.

Product		RE	P				M				K				N				S				H			MID
			vc (ft/min)	f (in/rev)	ap (inch)		vc (ft/min)	f (in/rev)	ap (inch)		vc (ft/min)	f (in/rev)	ap (inch)		vc (ft/min)	f (in/rev)	ap (inch)		vc (ft/min)	f (in/rev)	ap (inch)		vc (ft/min)	f (in/rev)	ap (inch)	
																										
M chip breaker is versatile and the first choice for medium machining of Cast iron. It features positive rake angle and negative/stable, moderate T-land. It's also suitable for Steels, and conditionally for Hard materials.																										
VNMG 331-M	**T5315**	.016	◪	591	.0079	.047	–	–	–	■	558	.0079	.047	–	–	–	–	–	–	–	◪	115	.0055	.012	6755724
	T9325	.016	■	509	.0079	.047	–	–	–	◪	476	.0079	.047	–	–	–	–	–	–	–		–	–	–	6754435
	T9415	.016	■	640	.0079	.047	–	–	–	◪	607	.0079	.047	–	–	–	–	–	–	–	◪	115	.0055	.012	8345601
VNMG 332-M	**T5305**	.031	◪	673	.0118	.055	–	–	–	■	623	.0118	.055	–	–	–	–	–	–	–	◪	131	.0059	.028	6755906
	T5315	.031	◪	607	.0118	.055	–	–	–	■	574	.0118	.055	–	–	–	–	–	–	–	◪	115	.0059	.028	6755725
	T9325	.031	■	492	.0118	.055	–	–	–	◪	459	.0118	.055	–	–	–	–	–	–	–		–	–	–	6754438
	T9335	.031	■	427	.0118	.055	–	–	–		–	–	–	–	–	–	–	–	–	–		–	–	–	6755009
	T9415	.031	■	656	.0118	.055	–	–	–	◪	623	.0118	.055	–	–	–	–	–	–	–	◪	131	.0059	.028	8244316
VNMG 333-M	**T9325**	.047	■	459	.0157	.055	–	–	–	◪	427	.0157	.055	–	–	–	–	–	–	–		–	–	–	6754441
																										
M chip breaker is versatile and the first choice for medium machining of Cast iron. It features positive rake angle and negative/stable, moderate T-land. It's also suitable for Steels, and conditionally for Hard materials.																										
WNMG 331-M	**T5315**	.016	◪	820	.0079	.071	–	–	–	■	771	.0079	.071	–	–	–	–	–	–	–	◪	164	.0051	.012	6755732
	T9325	.016	■	705	.0079	.071	–	–	–	◪	656	.0079	.071	–	–	–	–	–	–	–		–	–	–	6754450
	T9415	.016	■	886	.0079	.071	–	–	–	◪	837	.0079	.071	–	–	–	–	–	–	–	◪	164	.0051	.012	8345606
WNMG 332-M	**T5315**	.031	◪	837	.0126	.071	–	–	–	■	787	.0126	.071	–	–	–	–	–	–	–	◪	164	.0063	.028	6755733
	T9325	.031	■	673	.0126	.071	–	–	–	◪	623	.0126	.071	–	–	–	–	–	–	–		–	–	–	6753858
	T9335	.031	■	591	.0126	.071	–	–	–		–	–	–	–	–	–	–	–	–	–		–	–	–	6755012
	T9415	.031	■	902	.0126	.071	–	–	–	◪	853	.0126	.071	–	–	–	–	–	–	–	◪	180	.0063	.028	8345608
WNMG 431-M	**T5315**	.016	◪	853	.0079	.047	–	–	–	■	804	.0079	.047	–	–	–	–	–	–	–	◪	164	.0051	.012	6755752
	T9325	.016	■	689	.0079	.083	–	–	–	◪	640	.0079	.083	–	–	–	–	–	–	–		–	–	–	6754462
	T9335	.016	■	591	.0079	.083	–	–	–		–	–	–	–	–	–	–	–	–	–		–	–	–	6755014
	T9415	.016	■	869	.0079	.083	–	–	–	◪	820	.0079	.083	–	–	–	–	–	–	–	◪	164	.0051	.012	8345612
WNMG 432-M	**T5305**	.031	◪	919	.0126	.083	–	–	–	■	869	.0126	.083	–	–	–	–	–	–	–	◪	180	.0063	.028	6755910
	T5315	.031	◪	820	.0126	.083	–	–	–	■	771	.0126	.083	–	–	–	–	–	–	–	◪	164	.0063	.028	6755753
	T8430	.031	■	558	.0126	.083	–	–	–	◪	443	.0126	.083	–	–	–	–	–	–	–	◪	82	.0063	.028	7977167
	T9310	.031	■	804	.0126	.083	–	–	–	◪	755	.0126	.083	–	–	–	–	–	–	–	◪	148	.0063	.028	6755070
	T9315	.031	■	738	.0126	.083	–	–	–	◪	689	.0126	.083	–	–	–	–	–	–	–	◪	148	.0063	.028	6754520
	T9325	.031	■	656	.0126	.083	–	–	–	◪	623	.0126	.083	–	–	–	–	–	–	–		–	–	–	6753859
	T9335	.031	■	591	.0126	.083	–	–	–		–	–	–	–	–	–	–	–	–	–		–	–	–	6755015
	T9415	.031	■	886	.0126	.083	–	–	–	◪	837	.0126	.083	–	–	–	–	–	–	–	◪	164	.0063	.028	8183410
WNMG 433-M	**T5305**	.047	◪	902	.0157	.083	–	–	–	■	853	.0157	.083	–	–	–	–	–	–	–	◪	180	.0079	.039	6755914
	T5315	.047	◪	804	.0157	.083	–	–	–	■	755	.0157	.083	–	–	–	–	–	–	–	◪	148	.0079	.039	6755756
	T9325	.047	■	640	.0157	.083	–	–	–	◪	607	.0157	.083	–	–	–	–	–	–	–		–	–	–	6754488
	T9335	.047	■	558	.0157	.083	–	–	–		–	–	–	–	–	–	–	–	–	–		–	–	–	6755018
	T9415	.047	■	869	.0157	.083	–	–	–	◪	820	.0157	.083	–	–	–	–	–	–	–	◪	164	.0079	.039	8183412

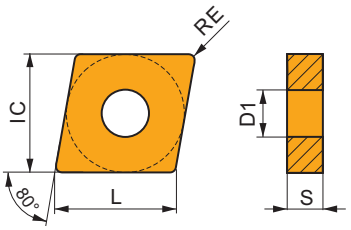
SI



SI chip breaker is sharp and designed for medium machining of Steels, Stainless steels. It features positive rake angle without T-land. It's also conditionally suitable for Non-ferrous alloys and Super-alloys.

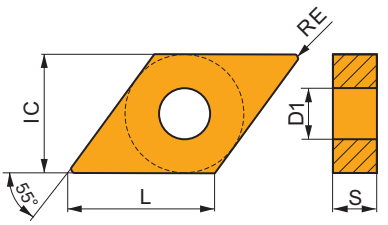
CNMG

	IC (inch)	D1 (inch)	L (inch)	S (inch)
43	.500	.203	.508	.187



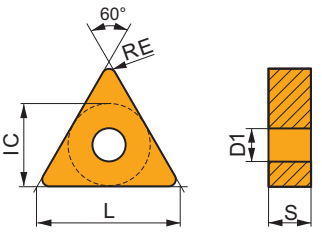
DNMG

	IC (inch)	D1 (inch)	L (inch)	S (inch)
33	.375	.150	.457	.187
43	.500	.203	.610	.187
44	.500	.203	.610	.250



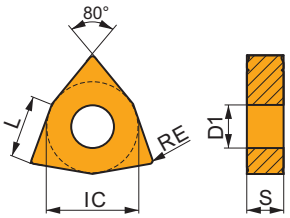
TNMG

	IC (inch)	D1 (inch)	L (inch)	S (inch)
33	.375	.150	.650	.187

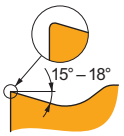
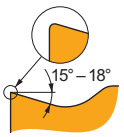
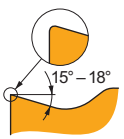


WNMG

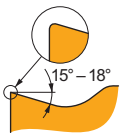
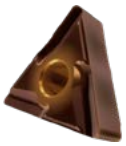
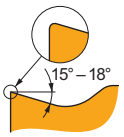
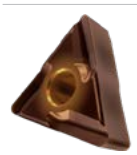
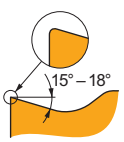
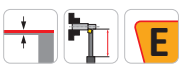
	IC (inch)	D1 (inch)	L (inch)	S (inch)
33	.375	.150	.256	.187
43	.500	.203	.343	.187



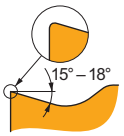
Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our cutting conditions app for further options.

Product		RE	P				M				K				N				S				H				MID
			vc (ft/min)	f (in/rev)	ap (inch)		vc (ft/min)	f (in/rev)	ap (inch)		vc (ft/min)	f (in/rev)	ap (inch)		vc (ft/min)	f (in/rev)	ap (inch)		vc (ft/min)	f (in/rev)	ap (inch)		vc (ft/min)	f (in/rev)	ap (inch)		
						**SI** chip breaker is sharp and designed for medium machining of Steels, Stainless steels. It features positive rake angle without T-land. It's also conditionally suitable for Non-ferrous alloys and Super-alloys.																					
CNMG 431R-SI	**T7335**	.016	◪ 705	.0079	.067	■ 541	.0071	.067	–	–	–		–	–	–	◪ 213	.0071	.055	–	–	–	6754750
	T8430	.016	■ 738	.0079	.067	■ 394	.0071	.067	–	–	–	◪ 2018	.0094	.067	◪ 148	.0071	.055	–	–	–	7977101
	T9325	.016	■ 886	.0079	.067	■ 525	.0071	.067	–	–	–		–	–	–	◪ 197	.0071	.055	–	–	–	6753776
CNMG 432R-SI	**T7325**	.031	◪ 705	.0138	.067	■ 541	.0126	.067	–	–	–		–	–	–	◪ 213	.0098	.055	–	–	–	7156200
	T7335	.031	◪ 673	.0138	.067	■ 509	.0126	.067	–	–	–		–	–	–	◪ 213	.0098	.055	–	–	–	6754754
	T8430	.031	■ 689	.0138	.067	■ 377	.0126	.067	–	–	–	◪ 1919	.0165	.067	◪ 148	.0098	.055	–	–	–	7977110
	T9325	.031	■ 837	.0138	.067	■ 492	.0126	.067	–	–	–		–	–	–	◪ 180	.0098	.055	–	–	–	6753783
CNMG 433R-SI	**T8430**	.047	■ 738	.0138	.067	■ 394	.0126	.067	–	–	–	◪ 2018	.0165	.067	◪ 148	.0098	.055	–	–	–	7977319
						**SI** chip breaker is sharp and designed for medium machining of Steels, Stainless steels. It features positive rake angle without T-land. It's also conditionally suitable for Non-ferrous alloys and Super-alloys.																					
CNMG 431L-SI	**T7335**	.016	◪ 705	.0079	.067	■ 541	.0071	.067	–	–	–		–	–	–	◪ 213	.0071	.055	–	–	–	6754748
	T8430	.016	■ 738	.0079	.067	■ 394	.0071	.067	–	–	–	◪ 2018	.0094	.067	◪ 148	.0071	.055	–	–	–	7977058
	T9325	.016	■ 886	.0079	.067	■ 525	.0071	.067	–	–	–		–	–	–	◪ 197	.0071	.055	–	–	–	6753879
CNMG 432L-SI	**T7325**	.031	◪ 705	.0138	.067	■ 541	.0126	.067	–	–	–		–	–	–	◪ 213	.0098	.055	–	–	–	7156195
	T7335	.031	◪ 673	.0138	.067	■ 509	.0126	.067	–	–	–		–	–	–	◪ 213	.0098	.055	–	–	–	6754752
	T8430	.031	■ 689	.0138	.067	■ 377	.0126	.067	–	–	–	◪ 1919	.0165	.067	◪ 148	.0098	.055	–	–	–	7977104
	T9325	.031	■ 837	.0138	.067	■ 492	.0126	.067	–	–	–		–	–	–	◪ 180	.0098	.055	–	–	–	6753883
CNMG 433L-SI	**T8430**	.047	■ 738	.0138	.067	■ 394	.0126	.067	–	–	–	◪ 2018	.0165	.067	◪ 148	.0098	.055	–	–	–	7977316
						**SI** chip breaker is sharp and designed for medium machining of Steels, Stainless steels. It features positive rake angle without T-land. It's also conditionally suitable for Non-ferrous alloys and Super-alloys.																					
DNMG 331R-SI	**T7325**	.016	◪ 607	.0079	.039	■ 459	.0071	.039	–	–	–		–	–	–	◪ 197	.0071	.031	–	–	–	7156262
	T7335	.016	◪ 591	.0079	.039	■ 459	.0071	.039	–	–	–		–	–	–	◪ 180	.0071	.031	–	–	–	6754780
	T8430	.016	■ 607	.0079	.039	■ 328	.0071	.039	–	–	–	◪ 1673	.0094	.039	◪ 131	.0071	.031	–	–	–	7977118
	T9325	.016	■ 738	.0079	.039	■ 443	.0071	.039	–	–	–		–	–	–	◪ 164	.0071	.031	–	–	–	6753943
DNMG 332R-SI	**T8430**	.031	■ 591	.0138	.039	■ 312	.0126	.039	–	–	–	◪ 1624	.0165	.039	◪ 115	.0098	.031	–	–	–	7977355
	T9325	.031	■ 689	.0138	.039	■ 410	.0126	.039	–	–	–		–	–	–	◪ 148	.0098	.031	–	–	–	6753949
DNMG 431R-SI	**T8430**	.016	■ 574	.0079	.059	■ 312	.0071	.059	–	–	–	◪ 1575	.0094	.059	◪ 115	.0071	.047	–	–	–	7977361
	T9325	.016	■ 722	.0079	.059	■ 427	.0071	.059	–	–	–		–	–	–	◪ 148	.0071	.047	–	–	–	7035031
DNMG 432R-SI	**T8430**	.031	■ 558	.0138	.059	■ 295	.0126	.059	–	–	–	◪ 1526	.0165	.059	◪ 115	.0098	.047	–	–	–	7977368
	T9325	.031	■ 656	.0138	.059	■ 394	.0126	.059	–	–	–		–	–	–	◪ 148	.0098	.047	–	–	–	6753957
DNMG 441R-SI	**T7325**	.016	◪ 591	.0079	.059	■ 459	.0071	.059	–	–	–		–	–	–	◪ 180	.0071	.047	–	–	–	7156290
	T7335	.016	◪ 558	.0079	.059	■ 427	.0071	.059	–	–	–		–	–	–	◪ 180	.0071	.047	–	–	–	6754789
	T8415	.016	■ 640	.0079	.059	■ 328	.0071	.059	–	–	–	◪ 1624	.0094	.059	◪ 148	.0071	.047	–	–	–	8553094
	T8430	.016	■ 574	.0079	.059	■ 312	.0071	.059	–	–	–	◪ 1575	.0094	.059	◪ 115	.0071	.047	–	–	–	7977122
	T9325	.016	■ 722	.0079	.059	■ 427	.0071	.059	–	–	–		–	–	–	◪ 148	.0071	.047	–	–	–	6753788
	T9335	.016	■ 607	.0079	.059	■ 361	.0071	.059	–	–	–		–	–	–	◪ 131	.0071	.047	–	–	–	8014992
DNMG 442R-SI	**T7325**	.031	◪ 591	.0138	.059	■ 459	.0126	.059	–	–	–		–	–	–	◪ 180	.0098	.047	–	–	–	7156299
	T7335	.031	◪ 558	.0138	.059	■ 427	.0126	.059	–	–	–		–	–	–	◪ 180	.0098	.047	–	–	–	6754793
	T8415	.031	■ 656	.0138	.059	■ 344	.0124	.059	–	–	–	◪ 1673	.0165	.059	◪ 148	.0096	.047	–	–	–	8553101
	T8430	.031	■ 558	.0138	.059	■ 295	.0126	.059	–	–	–	◪ 1526	.0165	.059	◪ 115	.0098	.047	–	–	–	7977128
	T9325	.031	■ 656	.0138	.059	■ 394	.0126	.059	–	–	–		–	–	–	◪ 148	.0098	.047	–	–	–	6753791
	T9335	.031	■ 591	.0138	.059	■ 344	.0126	.059	–	–	–		–	–	–	◪ 131	.0098	.047	–	–	–	8014994

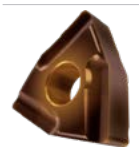
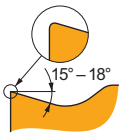
Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our cutting conditions app for further options.

Product		RE (inch)	P vc (ft/min)	P f (in/rev)	P ap (inch)	M vc (ft/min)	M f (in/rev)	M ap (inch)	K vc (ft/min)	K f (in/rev)	K ap (inch)	N vc (ft/min)	N f (in/rev)	N ap (inch)	S vc (ft/min)	S f (in/rev)	S ap (inch)	H vc (ft/min)	H f (in/rev)	H ap (inch)	MID
																					
			SI chip breaker is sharp and designed for medium machining of Steels, Stainless steels. It features positive rake angle without T-land. It's also conditionally suitable for Non-ferrous alloys and Super-alloys.																		
DNMG 331L-SI	**T8430**	.016	607	.0079	.039	328	.0071	.039	–	–	–	1673	.0094	.039	131	.0071	.031	–	–	–	7977346
	T9325	.016	738	.0079	.039	443	.0071	.039	–	–	–	–	–	–	164	.0071	.031	–	–	–	6753940
DNMG 332L-SI	**T8430**	.031	591	.0138	.039	312	.0126	.039	–	–	–	1624	.0165	.039	115	.0098	.031	–	–	–	7977352
	T9325	.031	689	.0138	.039	410	.0126	.039	–	–	–	–	–	–	148	.0098	.031	–	–	–	6753945
DNMG 431L-SI	**T8430**	.016	574	.0079	.059	312	.0071	.059	–	–	–	1575	.0094	.059	115	.0071	.047	–	–	–	7977359
	T9325	.016	722	.0079	.059	427	.0071	.059	–	–	–	–	–	–	148	.0071	.047	–	–	–	7035030
DNMG 432L-SI	**T8430**	.031	558	.0138	.059	295	.0126	.059	–	–	–	1526	.0165	.059	115	.0098	.047	–	–	–	7977364
	T9325	.031	656	.0138	.059	394	.0126	.059	–	–	–	–	–	–	148	.0098	.047	–	–	–	6753955
DNMG 441L-SI	**T7325**	.016	591	.0079	.059	459	.0071	.059	–	–	–	–	–	–	180	.0071	.047	–	–	–	7156286
	T7335	.016	558	.0079	.059	427	.0071	.059	–	–	–	–	–	–	180	.0071	.047	–	–	–	6754787
	T8315	.016	541	.0079	.059	312	.0071	.059	–	–	–	1624	.0094	.059	131	.0071	.047	–	–	–	6922728
	T8430	.016	574	.0079	.059	312	.0071	.059	–	–	–	1575	.0094	.059	115	.0071	.047	–	–	–	7977120
	T9325	.016	722	.0079	.059	427	.0071	.059	–	–	–	–	–	–	148	.0071	.047	–	–	–	6753961
	T9335	.016	607	.0079	.059	361	.0071	.059	–	–	–	–	–	–	131	.0071	.047	–	–	–	8014991
DNMG 442L-SI	**T7325**	.031	591	.0138	.059	459	.0126	.059	–	–	–	–	–	–	180	.0098	.047	–	–	–	7156294
	T7335	.031	558	.0138	.059	427	.0126	.059	–	–	–	–	–	–	180	.0098	.047	–	–	–	6754791
	T8415	.031	656	.0138	.059	344	.0124	.059	–	–	–	1673	.0165	.059	148	.0096	.047	–	–	–	8553099
	T8430	.031	558	.0138	.059	295	.0126	.059	–	–	–	1526	.0165	.059	115	.0098	.047	–	–	–	7977124
	T9325	.031	656	.0138	.059	394	.0126	.059	–	–	–	–	–	–	148	.0098	.047	–	–	–	6753789
	T9335	.031	591	.0138	.059	344	.0126	.059	–	–	–	–	–	–	131	.0098	.047	–	–	–	8014993
																					
			SI chip breaker is sharp and designed for medium machining of Steels, Stainless steels. It features positive rake angle without T-land. It's also conditionally suitable for Non-ferrous alloys and Super-alloys.																		
TNMG 331R-SI	**T7325**	.016	623	.0079	.059	476	.0071	.059	–	–	–	–	–	–	197	.0071	.047	–	–	–	7156381
	T7335	.016	591	.0079	.059	459	.0071	.059	–	–	–	–	–	–	180	.0071	.047	–	–	–	6754823
	T8315	.016	574	.0079	.059	344	.0071	.059	–	–	–	1722	.0094	.059	131	.0071	.047	–	–	–	6922737
	T8415	.016	689	.0079	.059	361	.0071	.059	–	–	–	1722	.0094	.059	148	.0071	.047	–	–	–	8553122
	T8430	.016	607	.0079	.059	328	.0071	.059	–	–	–	1673	.0094	.059	131	.0071	.047	–	–	–	7977139
	T9325	.016	755	.0079	.059	443	.0071	.059	–	–	–	–	–	–	164	.0071	.047	–	–	–	6753846
	T9335	.016	640	.0079	.059	377	.0071	.059	–	–	–	–	–	–	131	.0071	.047	–	–	–	8014999
TNMG 332R-SI	**T7325**	.031	623	.0138	.059	476	.0126	.059	–	–	–	–	–	–	197	.0098	.047	–	–	–	7156390
	T7335	.031	591	.0138	.059	459	.0126	.059	–	–	–	–	–	–	180	.0098	.047	–	–	–	6754827
	T8415	.031	705	.0138	.059	361	.0124	.059	–	–	–	1772	.0165	.059	148	.0096	.047	–	–	–	8553129
	T8430	.031	591	.0138	.059	312	.0126	.059	–	–	–	1624	.0165	.059	115	.0098	.047	–	–	–	7977145
	T9325	.031	705	.0138	.059	410	.0126	.059	–	–	–	–	–	–	148	.0098	.047	–	–	–	6754115
	T9335	.031	623	.0138	.059	361	.0126	.059	–	–	–	–	–	–	131	.0098	.047	–	–	–	8015001
	 																				
			SI chip breaker is sharp and designed for medium machining of Steels, Stainless steels. It features positive rake angle without T-land. It's also conditionally suitable for Non-ferrous alloys and Super-alloys.																		
TNMG 331L-SI	**T7325**	.016	623	.0079	.059	476	.0071	.059	–	–	–	–	–	–	197	.0071	.047	–	–	–	7156377
	T7335	.016	591	.0079	.059	459	.0071	.059	–	–	–	–	–	–	180	.0071	.047	–	–	–	6754821
	T8415	.016	689	.0079	.059	361	.0071	.059	–	–	–	1722	.0094	.059	148	.0071	.047	–	–	–	8553121
	T8430	.016	607	.0079	.059	328	.0071	.059	–	–	–	1673	.0094	.059	131	.0071	.047	–	–	–	7977137
	T9325	.016	755	.0079	.059	443	.0071	.059	–	–	–	–	–	–	164	.0071	.047	–	–	–	6754106
	T9335	.016	640	.0079	.059	377	.0071	.059	–	–	–	–	–	–	131	.0071	.047	–	–	–	8014998
TNMG 332L-SI	**T7325**	.031	623	.0138	.059	476	.0126	.059	–	–	–	–	–	–	197	.0098	.047	–	–	–	7156385
	T7335	.031	591	.0138	.059	459	.0126	.059	–	–	–	–	–	–	180	.0098	.047	–	–	–	6754825
	T8415	.031	705	.0138	.059	361	.0124	.059	–	–	–	1772	.0165	.059	148	.0096	.047	–	–	–	8553127
	T8430	.031	591	.0138	.059	312	.0126	.059	–	–	–	1624	.0165	.059	115	.0098	.047	–	–	–	7977141
	T9325	.031	705	.0138	.059	410	.0126	.059	–	–	–	–	–	–	148	.0098	.047	–	–	–	6754112
	T9335	.031	623	.0138	.059	361	.0126	.059	–	–	–	–	–	–	131	.0098	.047	–	–	–	8015000

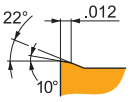
Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our cutting conditions app for further options.

Product		RE (inch)	P vc (ft/min)	P f (in/rev)	P ap (inch)	M vc (ft/min)	M f (in/rev)	M ap (inch)	K vc (ft/min)	K f (in/rev)	K ap (inch)	N vc (ft/min)	N f (in/rev)	N ap (inch)	S vc (ft/min)	S f (in/rev)	S ap (inch)	H vc (ft/min)	H f (in/rev)	H ap (inch)	MID
																					
WNMG 331R-SI	**T8430**	.016	■ 738	.0079	.067	■ 394	.0071	.067	–	–	–	◩ 2018	.0094	.067	◩ 148	.0071	.055	–	–	–	7977427
	T9325	.016	■ 886	.0079	.067	■ 525	.0071	.067	–	–	–	–	–	–	◩ 197	.0071	.055	–	–	–	6754452
WNMG 431R-SI	**T7325**	.016	◩ 722	.0079	.067	■ 558	.0071	.067	–	–	–	–	–	–	◩ 230	.0071	.055	–	–	–	7156476
	T7335	.016	◩ 705	.0079	.067	■ 541	.0071	.067	–	–	–	–	–	–	◩ 213	.0071	.055	–	–	–	6922745
	T8415	.016	■ 820	.0079	.067	■ 427	.0071	.067	–	–	–	◩ 2067	.0094	.067	◩ 180	.0071	.054	–	–	–	8553159
	T8430	.016	■ 738	.0079	.067	■ 394	.0071	.067	–	–	–	◩ 2018	.0094	.067	◩ 148	.0071	.055	–	–	–	7977163
	T9325	.016	■ 886	.0079	.067	■ 525	.0071	.067	–	–	–	–	–	–	◩ 197	.0071	.055	–	–	–	6754464
WNMG 432R-SI	**T7325**	.031	◩ 705	.0138	.067	■ 541	.0126	.067	–	–	–	–	–	–	◩ 213	.0098	.055	–	–	–	7156486
	T7335	.031	◩ 673	.0138	.067	■ 509	.0126	.067	–	–	–	–	–	–	◩ 213	.0098	.055	–	–	–	6922747
	T8315	.031	◩ 673	.0138	.067	■ 394	.0126	.067	–	–	–	◩ 2018	.0165	.067	◩ 164	.0098	.055	–	–	–	6922743
	T8430	.031	■ 689	.0138	.067	■ 377	.0126	.067	–	–	–	◩ 1919	.0165	.067	◩ 148	.0098	.055	–	–	–	7977172
	T9325	.031	■ 837	.0138	.067	■ 492	.0126	.067	–	–	–	–	–	–	◩ 180	.0098	.055	–	–	–	6754470
WNMG 433R-SI	**T8430**	.047	■ 738	.0138	.067	■ 394	.0126	.067	–	–	–	◩ 2018	.0165	.067	◩ 148	.0098	.055	–	–	–	7977443

SI chip breaker is sharp and designed for medium machining of Steels, Stainless steels. It features positive rake angle without T-land. It's also conditionally suitable for Non-ferrous alloys and Super-alloys.

																					
WNMG 331L-SI	**T8430**	.016	■ 738	.0079	.067	■ 394	.0071	.067	–	–	–	◩ 2018	.0094	.067	◩ 148	.0071	.055	–	–	–	7977423
	T9325	.016	■ 886	.0079	.067	■ 525	.0071	.067	–	–	–	–	–	–	◩ 197	.0071	.055	–	–	–	6754449
WNMG 431L-SI	**T7325**	.016	◩ 722	.0079	.067	■ 558	.0071	.067	–	–	–	–	–	–	◩ 230	.0071	.055	–	–	–	7156472
	T7335	.016	◩ 705	.0079	.067	■ 541	.0071	.067	–	–	–	–	–	–	◩ 213	.0071	.055	–	–	–	6922744
	T8415	.016	■ 820	.0079	.067	■ 427	.0071	.067	–	–	–	◩ 2067	.0094	.067	◩ 180	.0071	.054	–	–	–	8553158
	T8430	.016	■ 738	.0079	.067	■ 394	.0071	.067	–	–	–	◩ 2018	.0094	.067	◩ 148	.0071	.055	–	–	–	7977161
	T9325	.016	■ 886	.0079	.067	■ 525	.0071	.067	–	–	–	–	–	–	◩ 197	.0071	.055	–	–	–	6754461
WNMG 432L-SI	**T7325**	.031	◩ 705	.0138	.067	■ 541	.0126	.067	–	–	–	–	–	–	◩ 213	.0098	.055	–	–	–	7156481
	T7335	.031	◩ 673	.0138	.067	■ 509	.0126	.067	–	–	–	–	–	–	◩ 213	.0098	.055	–	–	–	6922746
	T8315	.031	◩ 673	.0138	.067	■ 394	.0126	.067	–	–	–	◩ 2018	.0165	.067	◩ 164	.0098	.055	–	–	–	6922742
	T8430	.031	■ 689	.0138	.067	■ 377	.0126	.067	–	–	–	◩ 1919	.0165	.067	◩ 148	.0098	.055	–	–	–	7977166
	T9325	.031	■ 837	.0138	.067	■ 492	.0126	.067	–	–	–	–	–	–	◩ 180	.0098	.055	–	–	–	6754467
WNMG 433L-SI	**T8430**	.047	■ 738	.0138	.067	■ 394	.0126	.067	–	–	–	◩ 2018	.0165	.067	◩ 148	.0098	.055	–	–	–	7977440

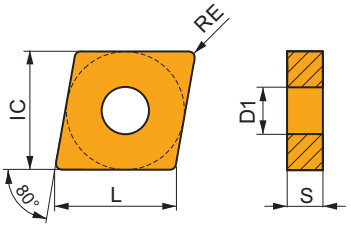
NMR



NMR chip breaker is versatile and the first choice for medium machining of Stainless steels. It features positive rake angle and positive, wide T-land. It's also suitable for Steels and Super-alloys.

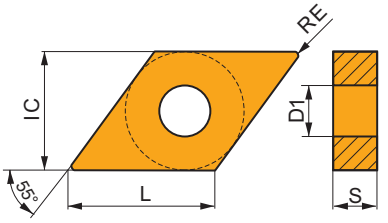
CNMG

	IC (inch)	D1 (inch)	L (inch)	S (inch)
32	.375	.150	.382	.125
43	.500	.203	.508	.187
54	.625	.250	.634	.250
64	.750	.313	.760	.250



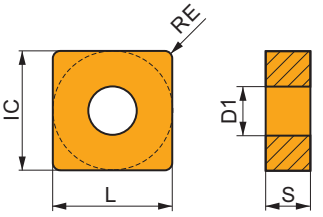
DNMG

	IC (inch)	D1 (inch)	L (inch)	S (inch)
33	.375	.150	.457	.187
43	.500	.203	.610	.187
44	.500	.203	.610	.250



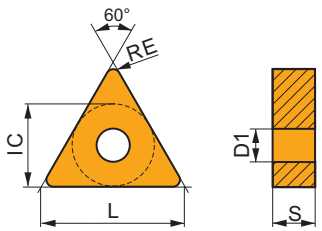
SNMG

	IC (inch)	D1 (inch)	L (inch)	S (inch)
43	.500	.203	.500	.187
54	.625	.250	.625	.250
64	.750	.313	.750	.250



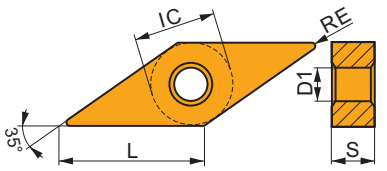
TNMG

	IC (inch)	D1 (inch)	L (inch)	S (inch)
33	.375	.150	.650	.187
43	.500	.203	.866	.187



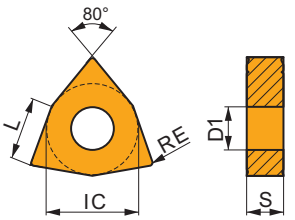
VNMG

	IC (inch)	D1 (inch)	L (inch)	S (inch)
33	.375	.150	.654	.187



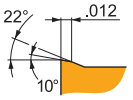
WNMG

	IC (inch)	D1 (inch)	L (inch)	S (inch)
33	.375	.150	.256	.187
43	.500	.203	.343	.187



Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our cutting conditions app for further options.

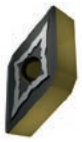
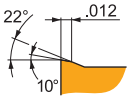
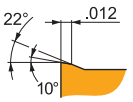
Product		RE	P						M						K						N						S						H						MID
			vc		f		ap		vc		f		ap		vc		f		ap		vc		f		ap		vc		f		ap		vc		f		ap	
		(inch)	(ft/min)		(in/rev)		(inch)		(ft/min)		(in/rev)		(inch)		(ft/min)		(in/rev)		(inch)		(ft/min)		(in/rev)		(inch)		(ft/min)		(in/rev)		(inch)		(ft/min)		(in/rev)		(inch)	



NMR chip breaker is versatile and the first choice for medium machining of Stainless steels. It features positive rake angle and positive, wide T-land. It's also suitable for Steels and Super-alloys.

CNMG 322-NMR	**T7325**	.031	◪	574	.0138	.063	■	443	.0126	.063	–	–	–	–	–	–	■	180	.0098	.051	–	–	–	7156184
	T7335	.031	◪	558	.0138	.063	■	427	.0126	.063	–	–	–	–	–	–	■	180	.0098	.051	–	–	–	7038025
CNMG 431-NMR	**T7325**	.016	◪	509	.0098	.106	■	394	.0091	.106	–	–	–	–	–	–	■	164	.0079	.087	–	–	–	7156189
	T7335	.016	◪	509	.0098	.079	■	394	.0091	.079	–	–	–	–	–	–	■	164	.0079	.063	–	–	–	7038029
	T8430	.016	■	492	.0098	.106	■	262	.0091	.106	–	–	–	–	–	–	◪	98	.0079	.087	–	–	–	7977314
	T9325	.016	■	623	.0098	.079	■	361	.0091	.079	–	–	–	–	–	–	◪	131	.0079	.063	–	–	–	7038028
	T9415	.016	■	804	.0098	.079		–	–	–	–	–	–	–	–	–		–	–	–	–	–	–	8345511
CNMG 432-NMR	**T6310**	.031	■	492	.0138	.106	■	344	.0126	.106	–	–	–	–	–	–	■	148	.0098	.087	–	–	–	7454461
	T7325	.031	◪	558	.0138	.106	■	427	.0126	.106	–	–	–	–	–	–	■	180	.0098	.087	–	–	–	7156198
	T7335	.031	◪	525	.0138	.106	■	394	.0126	.106	–	–	–	–	–	–	■	164	.0098	.087	–	–	–	7038033
	T8430	.031	■	509	.0138	.106	■	279	.0126	.106	–	–	–	–	–	–	◪	98	.0098	.087	–	–	–	7977108
	T9325	.031	■	623	.0138	.106	■	361	.0126	.106	–	–	–	–	–	–	◪	131	.0098	.087	–	–	–	7038032
	T9415	.031	■	837	.0138	.106		–	–	–	–	–	–	–	–	–		–	–	–	–	–	–	8244241
CNMG 433-NMR	**T6310**	.047	■	492	.0157	.106	■	344	.0142	.106	–	–	–	–	–	–	■	148	.011	.087	–	–	–	7454462
	T7325	.047	◪	558	.0157	.106	■	427	.0142	.106	–	–	–	–	–	–	■	180	.011	.087	–	–	–	7156207
	T7335	.047	◪	525	.0157	.106	■	394	.0142	.106	–	–	–	–	–	–	■	164	.011	.087	–	–	–	7038037
	T8430	.047	■	509	.0157	.106	■	279	.0142	.106	–	–	–	–	–	–	◪	98	.011	.087	–	–	–	7977318
	T9325	.047	■	623	.0157	.106	■	361	.0142	.106	–	–	–	–	–	–	◪	131	.011	.087	–	–	–	7038036
	T9415	.047	■	837	.0157	.106		–	–	–	–	–	–	–	–	–		–	–	–	–	–	–	8345519
CNMG 434-NMR	**T7325**	.063	◪	558	.0177	.106	■	427	.0161	.106	–	–	–	–	–	–	■	180	.0126	.087	–	–	–	7156211
	T7335	.063	◪	525	.0177	.106	■	394	.0161	.106	–	–	–	–	–	–	■	164	.0126	.087	–	–	–	7038039
	T8430	.063	■	509	.0177	.106	■	279	.0161	.106	–	–	–	–	–	–	◪	98	.0126	.087	–	–	–	8342345
CNMG 542-NMR	**T9325**	.031	■	607	.0138	.157	■	361	.0126	.157	–	–	–	–	–	–	◪	131	.0098	.126	–	–	–	7038041
	T9415	.031	■	804	.0138	.157		–	–	–	–	–	–	–	–	–		–	–	–	–	–	–	8345522
CNMG 543-NMR	**T7325**	.047	◪	541	.0157	.157	■	410	.0142	.157	–	–	–	–	–	–	■	164	.011	.126	–	–	–	7156218
	T7335	.047	◪	509	.0157	.157	■	394	.0142	.157	–	–	–	–	–	–	■	164	.011	.126	–	–	–	7038046
	T8430	.047	■	492	.0157	.157	■	262	.0142	.157	–	–	–	–	–	–	◪	98	.011	.126	–	–	–	7977325
	T9325	.047	■	607	.0157	.157	■	361	.0142	.157	–	–	–	–	–	–	◪	131	.011	.126	–	–	–	7038045
	T9415	.047	■	804	.0157	.157		–	–	–	–	–	–	–	–	–		–	–	–	–	–	–	8345524
CNMG 544-NMR	**T7325**	.063	◪	541	.0177	.157	■	410	.0161	.157	–	–	–	–	–	–	■	164	.0126	.126	–	–	–	7156221
	T7335	.063	◪	509	.0177	.157	■	394	.0161	.157	–	–	–	–	–	–	■	164	.0126	.126	–	–	–	7038049
	T8430	.063	■	492	.0177	.157	■	262	.0161	.157	–	–	–	–	–	–	◪	98	.0126	.126	–	–	–	7977327
	T9415	.063	■	787	.0177	.236		–	–	–	–	–	–	–	–	–		–	–	–	–	–	–	8345525
CNMG 642-NMR	**T6310**	.031	■	459	.0138	.205	■	328	.0126	.205	–	–	–	–	–	–	■	131	.0098	.165	–	–	–	7454463
	T7325	.031	◪	509	.0138	.205	■	394	.0126	.205	–	–	–	–	–	–	■	164	.0098	.165	–	–	–	7156223
	T7335	.031	◪	492	.0138	.205	■	377	.0126	.205	–	–	–	–	–	–	■	148	.0098	.165	–	–	–	7038052
	T9325	.031	■	591	.0138	.205	■	344	.0126	.205	–	–	–	–	–	–	◪	131	.0098	.165	–	–	–	7038051
	T9415	.031	■	738	.0138	.315		–	–	–	–	–	–	–	–	–		–	–	–	–	–	–	8345526
CNMG 643-NMR	**T6310**	.047	■	459	.0157	.205	■	328	.0142	.205	–	–	–	–	–	–	■	131	.011	.165	–	–	–	7462039
	T7325	.047	◪	525	.0157	.205	■	394	.0142	.205	–	–	–	–	–	–	■	164	.011	.165	–	–	–	7156226
	T7335	.047	◪	492	.0157	.205	■	377	.0142	.205	–	–	–	–	–	–	■	148	.011	.165	–	–	–	7038056
	T8430	.047	■	476	.0157	.205	■	262	.0142	.205	–	–	–	–	–	–	◪	98	.011	.165	–	–	–	7977328
	T9325	.047	■	591	.0157	.205	■	344	.0142	.205	–	–	–	–	–	–	◪	131	.011	.165	–	–	–	7038055
CNMG 644-NMR	**T7325**	.063	◪	525	.0177	.205	■	394	.0161	.205	–	–	–	–	–	–	■	164	.0126	.165	–	–	–	7156229
	T7335	.063	◪	492	.0177	.205	■	377	.0161	.205	–	–	–	–	–	–	■	148	.0126	.165	–	–	–	7038059
	T8430	.063	■	476	.0177	.205	■	262	.0161	.205	–	–	–	–	–	–	◪	98	.0126	.165	–	–	–	8342348
	T9325	.063	■	574	.0177	.205	■	344	.0161	.205	–	–	–	–	–	–	◪	115	.0126	.165	–	–	–	7038058
	T9415	.063	■	787	.0177	.205		–	–	–	–	–	–	–	–	–		–	–	–	–	–	–	8345531

Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our cutting conditions app for further options.

Product		RE	P				M				K				N				S				H				MID
			vc (ft/min)	f (in/rev)	ap (inch)		vc (ft/min)	f (in/rev)	ap (inch)		vc (ft/min)	f (in/rev)	ap (inch)		vc (ft/min)	f (in/rev)	ap (inch)		vc (ft/min)	f (in/rev)	ap (inch)		vc (ft/min)	f (in/rev)	ap (inch)		
																											
DNMG 331-NMR	**T7325**	.016	◪	492	.0079	.031	■	377	.0071	.031		–	–	–		–	–	–	■	148	.0071	.024		–	–	–	7156261
	T9325	.016	■	607	.0079	.031	■	361	.0071	.031		–	–	–		–	–	–	◪	131	.0071	.024		–	–	–	7038061
DNMG 332-NMR	**T7325**	.031	◪	509	.0118	.031	■	394	.0106	.031		–	–	–		–	–	–	■	164	.0094	.024		–	–	–	7156269
	T9415	.031	■	787	.0118	.031		–	–	–		–	–	–		–	–	–		–	–	–		–	–	–	8345546
DNMG 333-NMR	**T7325**	.047	◪	509	.0118	.063	■	394	.0106	.063		–	–	–		–	–	–	■	164	.0094	.051		–	–	–	7156274
DNMG 432-NMR	**T7325**	.031	◪	476	.0118	.075	■	361	.0106	.075		–	–	–		–	–	–	■	148	.0094	.059		–	–	–	7156282
	T8430	.031	■	443	.0118	.075	■	246	.0106	.075		–	–	–		–	–	–	◪	82	.0094	.059		–	–	–	7977367
	T9325	.031	■	558	.0118	.075	■	328	.0106	.075		–	–	–		–	–	–	◪	115	.0094	.059		–	–	–	7038070
	T9415	.031	■	722	.0118	.075		–	–	–		–	–	–		–	–	–		–	–	–		–	–	–	8345551
DNMG 441-NMR	**T7325**	.016	◪	459	.0079	.075	■	344	.0071	.075		–	–	–		–	–	–	■	148	.0071	.059		–	–	–	7156289
	T7335	.016	◪	427	.0079	.075	■	328	.0071	.075		–	–	–		–	–	–	■	131	.0071	.059		–	–	–	7038075
	T8430	.016	■	443	.0079	.075	■	246	.0071	.075		–	–	–		–	–	–	◪	82	.0071	.059		–	–	–	7977371
	T9325	.016	■	558	.0079	.075	■	328	.0071	.075		–	–	–		–	–	–	◪	115	.0071	.059		–	–	–	7038074
	T9415	.016	■	689	.0079	.075		–	–	–		–	–	–		–	–	–		–	–	–		–	–	–	8345553
DNMG 442-NMR	**T6310**	.031	■	410	.0118	.075	■	295	.0106	.075		–	–	–		–	–	–	■	115	.0094	.059		–	–	–	7454464
	T7325	.031	◪	476	.0118	.075	■	361	.0106	.075		–	–	–		–	–	–	■	148	.0094	.059		–	–	–	7156297
	T7335	.031	◪	459	.0118	.075	■	344	.0106	.075		–	–	–		–	–	–	■	148	.0094	.059		–	–	–	7038079
	T8430	.031	■	443	.0118	.075	■	246	.0106	.075		–	–	–		–	–	–	◪	82	.0094	.059		–	–	–	7977374
	T9325	.031	■	558	.0118	.075	■	328	.0106	.075		–	–	–		–	–	–	◪	115	.0094	.059		–	–	–	7038078
	T9415	.031	■	722	.0118	.075		–	–	–		–	–	–		–	–	–		–	–	–		–	–	–	8345557
DNMG 443-NMR	**T7325**	.047	◪	509	.0118	.075	■	394	.0106	.075		–	–	–		–	–	–	■	164	.0094	.059		–	–	–	7156304
	T8430	.047	■	476	.0118	.075	■	262	.0106	.075		–	–	–		–	–	–	◪	98	.0094	.059		–	–	–	7977379
	T9325	.047	■	591	.0118	.075	■	344	.0106	.075		–	–	–		–	–	–	◪	131	.0094	.059		–	–	–	7038082
	T9415	.047	■	771	.0118	.075		–	–	–		–	–	–		–	–	–		–	–	–		–	–	–	8345561
																											
SNMG 432-NMR	**T7325**	.031	◪	574	.0138	.102	■	443	.0126	.102		–	–	–		–	–	–	■	180	.0098	.083		–	–	–	7156337
	T7335	.031	◪	541	.0138	.102	■	410	.0126	.102		–	–	–		–	–	–	■	164	.0098	.083		–	–	–	7038087
	T8430	.031	■	541	.0138	.102	■	295	.0126	.102		–	–	–		–	–	–	◪	115	.0098	.083		–	–	–	7977133
	T9325	.031	■	656	.0138	.102	■	394	.0126	.102		–	–	–		–	–	–	◪	148	.0098	.083		–	–	–	7038086
SNMG 433-NMR	**T6310**	.047	■	525	.0157	.102	■	377	.0142	.102		–	–	–		–	–	–	■	148	.011	.083		–	–	–	7454466
	T7335	.047	◪	541	.0157	.102	■	410	.0142	.102		–	–	–		–	–	–	■	164	.011	.083		–	–	–	7038090
	T9325	.047	■	656	.0157	.102	■	394	.0142	.102		–	–	–		–	–	–	◪	148	.011	.083		–	–	–	7038089
SNMG 434-NMR	**T7325**	.063	◪	591	.0177	.102	■	459	.0161	.102		–	–	–		–	–	–	■	180	.0126	.083		–	–	–	7156346
SNMG 543-NMR	**T6310**	.047	■	492	.0157	.150	■	344	.0142	.150		–	–	–		–	–	–	■	148	.011	.118		–	–	–	7454467
	T7325	.047	◪	558	.0157	.150	■	427	.0142	.150		–	–	–		–	–	–	■	180	.011	.118		–	–	–	7156348
	T8430	.047	■	509	.0157	.150	■	279	.0142	.150		–	–	–		–	–	–	◪	98	.011	.118		–	–	–	8342372
	T9325	.047	■	623	.0157	.150	■	361	.0142	.150		–	–	–		–	–	–	◪	131	.011	.118		–	–	–	7038094
SNMG 643-NMR	**T6310**	.047	■	476	.0157	.205	■	328	.0142	.205		–	–	–		–	–	–	■	131	.011	.165		–	–	–	7454468
	T7325	.047	◪	541	.0157	.205	■	410	.0142	.205		–	–	–		–	–	–	■	164	.011	.165		–	–	–	7156351
	T7335	.047	◪	509	.0157	.205	■	394	.0142	.205		–	–	–		–	–	–	■	164	.011	.165		–	–	–	7038097
SNMG 644-NMR	**T6310**	.063	■	492	.0177	.205	■	344	.0161	.205		–	–	–		–	–	–	■	148	.0126	.165		–	–	–	7454469
	T7325	.063	◪	558	.0177	.205	■	427	.0161	.205		–	–	–		–	–	–	■	180	.0126	.165		–	–	–	7156354
	T7335	.063	◪	509	.0177	.205	■	394	.0161	.205		–	–	–		–	–	–	■	164	.0126	.165		–	–	–	7038100
	T8430	.063	■	492	.0177	.205	■	262	.0161	.205		–	–	–		–	–	–	◪	98	.0126	.165		–	–	–	8342374
	T9415	.063	■	820	.0177	.205		–	–	–		–	–	–		–	–	–		–	–	–		–	–	–	8345577

NMR chip breaker is versatile and the first choice for medium machining of Stainless steels. It features positive rake angle and positive, wide T-land. It's also suitable for Steels and Super-alloys.

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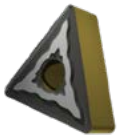
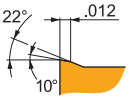
Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our cutting conditions app for further options.

Product		RE	P						M						K						N						S						H						MID
			vc		f		ap		vc		f		ap		vc		f		ap		vc		f		ap		vc		f		ap		vc		f		ap		
		(inch)	(ft/min)		(in/rev)		(inch)		(ft/min)		(in/rev)		(inch)		(ft/min)		(in/rev)		(inch)		(ft/min)		(in/rev)		(inch)		(ft/min)		(in/rev)		(inch)		(ft/min)		(in/rev)		(inch)		





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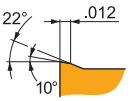
TNMG 331-NMR	**T6310**	.016	■	427	.0079	.067	■	295	.0071	.067	–	–	–	–	–	–	■	115	.0071	.055	–	–	–	7454470
	T7325	.016	◪	476	.0079	.067	■	361	.0071	.067	–	–	–	–	–	–	■	148	.0071	.055	–	–	–	7156380
	T7335	.016	◪	476	.0079	.067	■	361	.0071	.067	–	–	–	–	–	–	■	148	.0071	.055	–	–	–	7038104
	T8430	.016	■	476	.0079	.067	■	262	.0071	.067	–	–	–	–	–	–	◪	98	.0071	.055	–	–	–	7977404
	T9325	.016	■	591	.0079	.067	■	344	.0071	.067	–	–	–	–	–	–	◪	131	.0071	.055	–	–	–	7038103
TNMG 332-NMR	**T6310**	.031	■	459	.0118	.067	■	328	.0106	.067	–	–	–	–	–	–	■	131	.0094	.055	–	–	–	7454471
	T7325	.031	◪	509	.0118	.067	■	394	.0106	.067	–	–	–	–	–	–	■	164	.0094	.055	–	–	–	7156388
	T7335	.031	◪	476	.0118	.067	■	361	.0106	.067	–	–	–	–	–	–	■	148	.0094	.055	–	–	–	7038108
	T8430	.031	■	492	.0118	.067	■	262	.0106	.067	–	–	–	–	–	–	◪	98	.0094	.055	–	–	–	7977144
	T9325	.031	■	607	.0118	.067	■	361	.0106	.067	–	–	–	–	–	–	◪	131	.0094	.055	–	–	–	7038107
	T9415	.031	■	771	.0118	.067		–	–	–	–	–	–	–	–	–		–	–	–	–	–	–	8345594
TNMG 333-NMR	**T7325**	.047	◪	541	.0118	.067	■	410	.0106	.067	–	–	–	–	–	–	■	164	.0094	.055	–	–	–	7156394
	T8430	.047	■	509	.0118	.067	■	279	.0106	.067	–	–	–	–	–	–	◪	98	.0094	.055	–	–	–	8342377
	T9415	.047	■	820	.0118	.067		–	–	–	–	–	–	–	–	–		–	–	–	–	–	–	8345596
TNMG 432-NMR	**T6310**	.031	■	443	.0118	.083	■	312	.0106	.083	–	–	–	–	–	–	■	131	.0094	.067	–	–	–	7454472
	T7325	.031	◪	492	.0118	.083	■	377	.0106	.083	–	–	–	–	–	–	■	148	.0094	.067	–	–	–	7156399
	T7335	.031	◪	476	.0118	.083	■	361	.0106	.083	–	–	–	–	–	–	■	148	.0094	.067	–	–	–	7038114
	T8430	.031	■	476	.0118	.083	■	262	.0106	.083	–	–	–	–	–	–	◪	98	.0094	.067	–	–	–	7977149
	T9325	.031	■	591	.0118	.083	■	344	.0106	.083	–	–	–	–	–	–	◪	131	.0094	.067	–	–	–	7038113
TNMG 433-NMR	**T7325**	.047	◪	525	.0118	.083	■	394	.0106	.083	–	–	–	–	–	–	■	164	.0094	.067	–	–	–	7156403
	T9325	.047	■	623	.0118	.083	■	361	.0106	.083	–	–	–	–	–	–	◪	131	.0094	.067	–	–	–	7038116
	T9415	.047	■	804	.0118	.083		–	–	–	–	–	–	–	–	–		–	–	–	–	–	–	8345599



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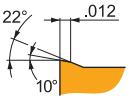
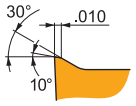
VNMG 331-NMR	**T7325**	.016	◪	410	.0079	.047	■	312	.0071	.047	–	–	–	–	–	–	■	131	.0071	.039	–	–	–	7156435
	T9325	.016	■	509	.0079	.047	■	295	.0071	.047	–	–	–	–	–	–	◪	98	.0071	.039	–	–	–	7038117
VNMG 332-NMR	**T7325**	.031	◪	427	.0118	.055	■	328	.0106	.055	–	–	–	–	–	–	■	131	.0094	.043	–	–	–	7156441
	T8430	.031	■	410	.0118	.055	■	213	.0106	.055	–	–	–	–	–	–	◪	82	.0094	.043	–	–	–	7977417
	T9325	.031	■	492	.0118	.055	■	295	.0106	.055	–	–	–	–	–	–	◪	98	.0094	.043	–	–	–	7038121
	T9415	.031	■	656	.0118	.055		–	–	–	–	–	–	–	–	–		–	–	–	–	–	–	8345604
VNMG 333-NMR	**T8430**	.047	■	427	.0118	.055	■	230	.0106	.055	–	–	–	–	–	–	◪	82	.0094	.043	–	–	–	7977421

Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our cutting conditions app for further options.

Product		RE	P			M			K			N			S			H			MID
			vc (ft/min)	f (in/rev)	ap (inch)	vc (ft/min)	f (in/rev)	ap (inch)	vc (ft/min)	f (in/rev)	ap (inch)	vc (ft/min)	f (in/rev)	ap (inch)	vc (ft/min)	f (in/rev)	ap (inch)	vc (ft/min)	f (in/rev)	ap (inch)	
																					
WNMG 331-NMR	**T6310**	.016	■	476	.0098	.063	■	328	.0091	.063	–	–	–	–	–	–	■	131	.0079	.051	–	–	–	7454474
	T7325	.016	◪	525	.0098	.063	■	394	.0091	.063	–	–	–	–	–	–	■	164	.0079	.051	–	–	–	7156456
	T8430	.016	■	541	.0098	.063	■	295	.0091	.063	–	–	–	–	–	–	◪	115	.0079	.051	–	–	–	7977426
	T9325	.016	■	656	.0098	.063	■	394	.0091	.063	–	–	–	–	–	–	◪	148	.0079	.051	–	–	–	7038126
WNMG 332-NMR	**T7325**	.031	◪	574	.0138	.063	■	443	.0126	.063	–	–	–	–	–	–	■	180	.0098	.051	–	–	–	7156463
	T7335	.031	◪	558	.0138	.063	■	427	.0126	.063	–	–	–	–	–	–	■	180	.0098	.051	–	–	–	7038129
	T8430	.031	■	509	.0138	.106	■	279	.0126	.106	–	–	–	–	–	–	◪	98	.0098	.087	–	–	–	8342378
	T9325	.031	■	656	.0138	.063	■	394	.0126	.063	–	–	–	–	–	–	◪	148	.0098	.051	–	–	–	7038128
WNMG 431-NMR	**T6310**	.016	■	459	.0098	.106	■	328	.0091	.106	–	–	–	–	–	–	■	131	.0079	.087	–	–	–	7454476
	T7325	.016	◪	509	.0098	.106	■	394	.0091	.106	–	–	–	–	–	–	■	164	.0079	.087	–	–	–	7156475
	T7335	.016	◪	492	.0098	.106	■	377	.0091	.106	–	–	–	–	–	–	■	148	.0079	.087	–	–	–	7038133
	T8430	.016	■	492	.0098	.106	■	262	.0091	.106	–	–	–	–	–	–	◪	98	.0079	.087	–	–	–	7977436
	T9415	.016	■	787	.0098	.106		–	–	–	–	–	–	–	–	–		–	–	–	–	–	–	8345614
WNMG 432-NMR	**T6310**	.031	■	492	.0138	.106	■	344	.0126	.106	–	–	–	–	–	–	■	148	.0098	.087	–	–	–	7454477
	T7325	.031	◪	558	.0138	.106	■	427	.0126	.106	–	–	–	–	–	–	■	180	.0098	.087	–	–	–	7156484
	T7335	.031	◪	525	.0138	.106	■	394	.0126	.106	–	–	–	–	–	–	■	164	.0098	.087	–	–	–	7038137
	T8430	.031	■	509	.0138	.106	■	279	.0126	.106	–	–	–	–	–	–	◪	98	.0098	.087	–	–	–	7977170
	T9325	.031	■	623	.0138	.106	■	361	.0126	.106	–	–	–	–	–	–	◪	131	.0098	.087	–	–	–	7038136
	T9415	.031	■	837	.0138	.106		–	–	–	–	–	–	–	–	–		–	–	–	–	–	–	8244325
WNMG 433-NMR	**T6310**	.047	■	492	.0157	.106	■	344	.0142	.106	–	–	–	–	–	–	■	148	.011	.087	–	–	–	7454478
	T7325	.047	◪	558	.0157	.106	■	427	.0142	.106	–	–	–	–	–	–	■	180	.011	.087	–	–	–	7156493
	T7335	.047	◪	525	.0157	.106	■	394	.0142	.106	–	–	–	–	–	–	■	164	.011	.087	–	–	–	7038141
	T8430	.047	■	509	.0157	.106	■	279	.0142	.106	–	–	–	–	–	–	◪	98	.011	.087	–	–	–	7977442
	T9325	.047	■	623	.0157	.106	■	361	.0142	.106	–	–	–	–	–	–	◪	131	.011	.087	–	–	–	7038140
	T9415	.047	■	837	.0157	.106		–	–	–	–	–	–	–	–	–		–	–	–	–	–	–	8345622

NMR chip breaker is versatile and the first choice for medium machining of Stainless steels. It features positive rake angle and positive, wide T-land. It's also suitable for Steels and Super-alloys.

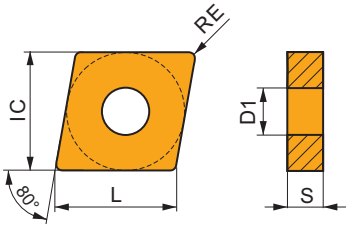
NM



NM chip breaker is sharp and designed for medium machining of Steels, Stainless steels and Super-alloys. It features highly positive rake angle and positive, moderate T-land. It's also conditionally suitable for Non-ferrous alloys.

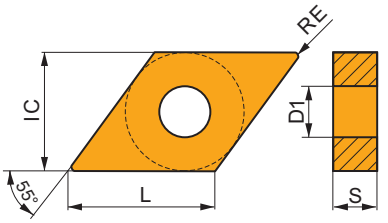
CNMG

	IC (inch)	D1 (inch)	L (inch)	S (inch)
43	.500	.203	.508	.187
54	.625	.250	.634	.250
64	.750	.313	.760	.250



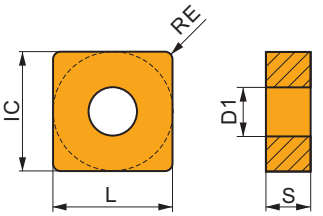
DNMG

	IC (inch)	D1 (inch)	L (inch)	S (inch)
33	.375	.150	.457	.187
43	.500	.203	.610	.187
44	.500	.203	.610	.250



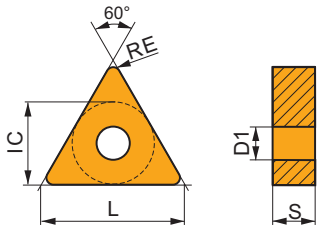
SNMG

	IC (inch)	D1 (inch)	L (inch)	S (inch)
43	.500	.203	.500	.187



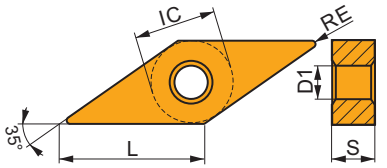
TNMG

	IC (inch)	D1 (inch)	L (inch)	S (inch)
33	.375	.150	.650	.187
43	.500	.203	.866	.187



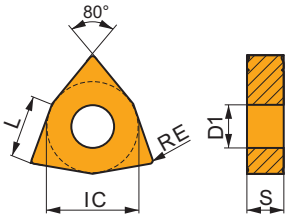
VNMG

	IC (inch)	D1 (inch)	L (inch)	S (inch)
33	.375	.150	.654	.187

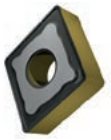
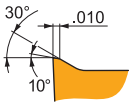
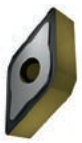
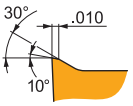


WNMG

	IC (inch)	D1 (inch)	L (inch)	S (inch)
33	.375	.150	.256	.187
43	.500	.203	.343	.187

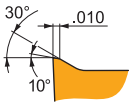


Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our cutting conditions app for further options.

Product		RE	P				M				K				N				S				H				MID
			vc (ft/min)	f (in/rev)	ap (inch)		vc (ft/min)	f (in/rev)	ap (inch)		vc (ft/min)	f (in/rev)	ap (inch)		vc (ft/min)	f (in/rev)	ap (inch)		vc (ft/min)	f (in/rev)	ap (inch)		vc (ft/min)	f (in/rev)	ap (inch)		
			**NM** chip breaker is sharp and designed for medium machining of Steels, Stainless steels and Super-alloys. It features highly positive rake angle and positive, moderate T-land. It's also conditionally suitable for Non-ferrous alloys.																								
CNMG 431-NM	**T7325**	.016	640	.0079	.083		492	.0071	.083		–	–	–		–	–	–		197	.0063	.067		–	–	–		7156188
	T7335	.016	623	.0079	.083		476	.0071	.083		–	–	–		–	–	–		197	.0063	.067		–	–	–		6754749
	T8430	.016	640	.0079	.083		344	.0071	.083		–	–	–		1772	.0094	.083		131	.0063	.067		–	–	–		7977100
	T9325	.016	787	.0079	.083		459	.0071	.083		–	–	–		–	–	–		164	.0063	.067		–	–	–		6753881
	T9415	.016	1001	.0079	.083		–	–	–		–	–	–		–	–	–		–	–	–		–	–	–		8345510
CNMG 432-NM	**T7325**	.031	705	.0098	.083		541	.0091	.083		–	–	–		–	–	–		213	.0079	.067		–	–	–		7156197
	T7335	.031	689	.0098	.083		525	.0091	.083		–	–	–		–	–	–		213	.0079	.067		–	–	–		6754753
	T8415	.031	804	.0098	.083		410	.0089	.083		–	–	–		2018	.0118	.083		180	.0079	.066		–	–	–		8553064
	T8430	.031	689	.0098	.083		377	.0091	.083		–	–	–		1919	.0118	.083		148	.0079	.067		–	–	–		7977107
	T9315	.031	951	.0098	.083		–	–	–		–	–	–		–	–	–		–	–	–		–	–	–		6922869
	T9325	.031	853	.0098	.083		509	.0091	.083		–	–	–		–	–	–		180	.0079	.067		–	–	–		6753884
	T9415	.031	1099	.0098	.083		–	–	–		–	–	–		–	–	–		–	–	–		–	–	–		8345516
CNMG 433-NM	**T7325**	.047	705	.0118	.083		541	.0106	.083		–	–	–		–	–	–		213	.0094	.067		–	–	–		7156206
	T7335	.047	689	.0118	.083		525	.0106	.083		–	–	–		–	–	–		213	.0094	.067		–	–	–		6754755
	T8430	.047	689	.0118	.083		377	.0106	.083		–	–	–		1919	.0142	.083		148	.0094	.067		–	–	–		7977113
	T9325	.047	837	.0118	.083		492	.0106	.083		–	–	–		–	–	–		180	.0094	.067		–	–	–		6753890
CNMG 542-NM	**T7325**	.031	640	.0118	.142		492	.0106	.142		–	–	–		–	–	–		197	.0106	.114		–	–	–		7156213
	T7335	.031	623	.0118	.142		476	.0106	.142		–	–	–		–	–	–		197	.0106	.114		–	–	–		6754756
	T8430	.031	607	.0118	.142		328	.0106	.142		–	–	–		1673	.0142	.142		131	.0106	.114		–	–	–		7977322
	T9325	.031	738	.0118	.142		443	.0106	.142		–	–	–		–	–	–		164	.0106	.114		–	–	–		6753896
CNMG 543-NM	**T7325**	.047	673	.0118	.142		509	.0106	.142		–	–	–		–	–	–		213	.0106	.114		–	–	–		7156217
	T7335	.047	656	.0118	.142		509	.0106	.142		–	–	–		–	–	–		213	.0106	.114		–	–	–		6754757
	T9325	.047	787	.0118	.142		459	.0106	.142		–	–	–		–	–	–		164	.0106	.114		–	–	–		6753900
CNMG 643-NM	**T7335**	.047	591	.0138	.165		459	.0126	.165		–	–	–		–	–	–		180	.0126	.134		–	–	–		6754758
	T8430	.047	591	.0138	.165		312	.0126	.165		–	–	–		1624	.0165	.165		115	.0126	.134		–	–	–		7977116
	T9325	.047	722	.0138	.165		427	.0126	.165		–	–	–		–	–	–		148	.0126	.134		–	–	–		6753907
			**NM** chip breaker is sharp and designed for medium machining of Steels, Stainless steels and Super-alloys. It features highly positive rake angle and positive, moderate T-land. It's also conditionally suitable for Non-ferrous alloys.																								
DNMG 331-NM	**T7335**	.016	541	.0079	.031		410	.0071	.031		–	–	–		–	–	–		164	.0079	.024		–	–	–		6754779
	T8430	.016	574	.0079	.031		312	.0071	.031		–	–	–		1575	.0094	.031		115	.0079	.024		–	–	–		7977348
DNMG 332-NM	**T7335**	.031	607	.0098	.031		459	.0091	.031		–	–	–		–	–	–		197	.0079	.024		–	–	–		6754782
	T8415	.031	705	.0098	.031		361	.0089	.031		–	–	–		1772	.0118	.031		148	.0079	.025		–	–	–		8553085
	T8430	.031	623	.0098	.031		344	.0091	.031		–	–	–		1722	.0118	.031		131	.0079	.024		–	–	–		7977354
	T9325	.031	755	.0098	.031		443	.0091	.031		–	–	–		–	–	–		164	.0079	.024		–	–	–		6753947
DNMG 432-NM	**T8430**	.031	574	.0098	.075		312	.0091	.075		–	–	–		1575	.0118	.075		115	.0079	.059		–	–	–		7977366
DNMG 441-NM	**T7325**	.016	525	.0079	.075		394	.0071	.075		–	–	–		–	–	–		164	.0079	.059		–	–	–		7156288
	T7335	.016	492	.0079	.075		377	.0071	.075		–	–	–		–	–	–		148	.0079	.059		–	–	–		6754788
	T8430	.016	509	.0079	.075		279	.0071	.075		–	–	–		1427	.0094	.075		98	.0079	.059		–	–	–		7977370
	T9325	.016	640	.0079	.075		377	.0071	.075		–	–	–		–	–	–		131	.0079	.059		–	–	–		6753963
DNMG 442-NM	**T7325**	.031	574	.0098	.075		443	.0091	.075		–	–	–		–	–	–		180	.0079	.059		–	–	–		7156296
	T7335	.031	558	.0098	.075		427	.0091	.075		–	–	–		–	–	–		180	.0079	.059		–	–	–		6754792
	T8430	.031	574	.0098	.075		312	.0091	.075		–	–	–		1575	.0118	.075		115	.0079	.059		–	–	–		7977126
	T9325	.031	689	.0098	.075		410	.0091	.075		–	–	–		–	–	–		148	.0079	.059		–	–	–		6753965
	T9415	.031	902	.0098	.075		–	–	–		–	–	–		–	–	–		–	–	–		–	–	–		8345556
DNMG 443-NM	**T7325**	.047	574	.0118	.075		443	.0106	.075		–	–	–		–	–	–		180	.0094	.059		–	–	–		7156303
	T7335	.047	558	.0118	.075		427	.0106	.075		–	–	–		–	–	–		180	.0094	.059		–	–	–		6754794

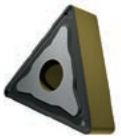
Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our cutting conditions app for further options.

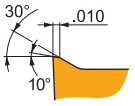
Product		RE	P				M				K				N				S				H				MID
				vc (ft/min)	f (in/rev)	ap (inch)		vc (ft/min)	f (in/rev)	ap (inch)		vc (ft/min)	f (in/rev)	ap (inch)		vc (ft/min)	f (in/rev)	ap (inch)		vc (ft/min)	f (in/rev)	ap (inch)		vc (ft/min)	f (in/rev)	ap (inch)	



NM chip breaker is sharp and designed for medium machining of Steels, Stainless steels and Super-alloys. It features highly positive rake angle and positive, moderate T-land. It's also conditionally suitable for Non-ferrous alloys.

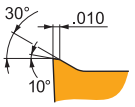
SNMG 432-NM	**T7335**	.031	◪	722	.0098	.083	■	558	.0091	.083		–	–	–		–	–	–	■	230	.0079	.067		–	–	–	6754803
	T8430	.031	■	738	.0098	.083	■	394	.0091	.083		–	–	–	◪	2018	.0118	.083	◪	148	.0079	.067		–	–	–	7977132
	T9325	.031	■	902	.0098	.083	■	541	.0091	.083		–	–	–		–	–	–	◪	197	.0079	.067		–	–	–	6754006





NM chip breaker is sharp and designed for medium machining of Steels, Stainless steels and Super-alloys. It features highly positive rake angle and positive, moderate T-land. It's also conditionally suitable for Non-ferrous alloys.

TNMG 331-NM	**T7325**	.016	◪	558	.0079	.075	■	427	.0071	.075		–	–	–		–	–	–	■	180	.0079	.059		–	–	–	7156379
	T7335	.016	◪	525	.0079	.075	■	394	.0071	.075		–	–	–		–	–	–	■	164	.0079	.059		–	–	–	6754822
	T8430	.016	■	558	.0079	.075	■	295	.0071	.075		–	–	–	◪	1526	.0094	.075	◪	115	.0079	.059		–	–	–	7977403
	T9325	.016	■	689	.0079	.075	■	410	.0071	.075		–	–	–		–	–	–	◪	148	.0079	.059		–	–	–	6754109
TNMG 332-NM	**T7325**	.031	◪	623	.0098	.075	■	476	.0091	.075		–	–	–		–	–	–	■	197	.0079	.059		–	–	–	7156387
	T7335	.031	◪	591	.0098	.075	■	459	.0091	.075		–	–	–		–	–	–	■	180	.0079	.059		–	–	–	6754826
	T8415	.031	■	705	.0098	.075	■	361	.0089	.075		–	–	–	◪	1772	.0118	.075	■	148	.0079	.060		–	–	–	8553128
	T8430	.031	■	607	.0098	.075	■	328	.0091	.075		–	–	–	◪	1673	.0118	.075	◪	131	.0079	.059		–	–	–	7977143
	T9325	.031	■	738	.0098	.075	■	443	.0091	.075		–	–	–		–	–	–	◪	164	.0079	.059		–	–	–	6754113
	T9415	.031	■	951	.0098	.075		–	–	–		–	–	–		–	–	–		–	–	–		–	–	–	8345593
TNMG 432-NM	**T7325**	.031	◪	623	.0098	.067	■	476	.0091	.067		–	–	–		–	–	–	■	197	.0079	.055		–	–	–	7156398
	T7335	.031	◪	607	.0098	.067	■	459	.0091	.067		–	–	–		–	–	–	■	197	.0079	.055		–	–	–	6754828
	T8415	.031	■	705	.0098	.067	■	361	.0089	.067		–	–	–	◪	1772	.0118	.067	■	148	.0079	.054		–	–	–	8553136
	T8430	.031	■	607	.0098	.067	■	328	.0091	.067		–	–	–	◪	1673	.0118	.067	◪	131	.0079	.055		–	–	–	7977148
TNMG 433-NM	**T7335**	.047	◪	591	.0118	.083	■	459	.0106	.083		–	–	–		–	–	–	■	180	.0094	.067		–	–	–	6754829
	T9325	.047	■	705	.0118	.083	■	410	.0106	.083		–	–	–		–	–	–	◪	148	.0094	.067		–	–	–	6754137

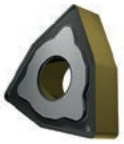


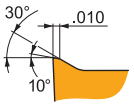
NM chip breaker is sharp and designed for medium machining of Steels, Stainless steels and Super-alloys. It features highly positive rake angle and positive, moderate T-land. It's also conditionally suitable for Non-ferrous alloys.

VNMG 331-NM	**T7325**	.016	◪	476	.0079	.047	■	361	.0071	.047		–	–	–		–	–	–	■	148	.0079	.039		–	–	–	7156434
	T7335	.016	◪	459	.0079	.047	■	344	.0071	.047		–	–	–		–	–	–	■	148	.0079	.039		–	–	–	6754836
	T8415	.016	■	525	.0079	.047	■	279	.0071	.047		–	–	–	◪	1329	.0094	.047	■	115	.0079	.038		–	–	–	8553142
	T8430	.016	■	476	.0079	.047	■	262	.0071	.047		–	–	–	◪	1329	.0094	.047	◪	98	.0079	.039		–	–	–	7977154
VNMG 332-NM	**T7325**	.031	◪	525	.0098	.055	■	394	.0091	.055		–	–	–		–	–	–	■	164	.0079	.043		–	–	–	7156440
	T8415	.031	■	591	.0098	.055	■	295	.0089	.055		–	–	–	◪	1476	.0118	.055	■	131	.0079	.044		–	–	–	8553145
	T8430	.031	■	509	.0098	.055	■	279	.0091	.055		–	–	–	◪	1427	.0118	.055	◪	98	.0079	.043		–	–	–	7977416
	T9325	.031	■	623	.0098	.055	■	361	.0091	.055		–	–	–		–	–	–	◪	131	.0079	.043		–	–	–	6754439

Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our cutting conditions app for further options.

Product		RE	P			M			K			N			S			H			MID
			vc (ft/min)	f (in/rev)	ap (inch)	vc (ft/min)	f (in/rev)	ap (inch)	vc (ft/min)	f (in/rev)	ap (inch)	vc (ft/min)	f (in/rev)	ap (inch)	vc (ft/min)	f (in/rev)	ap (inch)	vc (ft/min)	f (in/rev)	ap (inch)	





NM chip breaker is sharp and designed for medium machining of Steels, Stainless steels and Super-alloys. It features highly positive rake angle and positive, moderate T-land. It's also conditionally suitable for Non-ferrous alloys.

WNMG 331-NM	**T7335**	.016	◩ 640	.0079	.071	■ 492	.0071	.071	–	–	–	–	–	–	■ 197	.0063	.055	–	–	–	6754842
	T8430	.016	■ 607	.0098	.071	■ 328	.0091	.071	–	–	–	◩ 1673	.0118	.071	◩ 131	.0079	.055	–	–	–	7977425
WNMG 332-NM	**T7325**	.031	◩ 722	.0098	.071	■ 558	.0091	.071	–	–	–	–	–	–	■ 230	.0079	.055	–	–	–	7156462
	T7335	.031	◩ 705	.0098	.071	■ 541	.0091	.071	–	–	–	–	–	–	■ 213	.0079	.055	–	–	–	6754843
	T8430	.031	■ 722	.0098	.071	■ 394	.0091	.071	–	–	–	◩ 1969	.0118	.071	◩ 148	.0079	.055	–	–	–	7977159
	T9325	.031	■ 869	.0098	.071	■ 509	.0091	.071	–	–	–	–	–	–	◩ 180	.0079	.055	–	–	–	6754454
WNMG 333-NM	**T7325**	.047	◩ 722	.0118	.071	■ 558	.0106	.071	–	–	–	–	–	–	■ 230	.0094	.055	–	–	–	7156466
	T7335	.047	◩ 722	.0118	.047	■ 558	.0106	.047	–	–	–	–	–	–	■ 230	.0094	.039	–	–	–	6754844
	T9325	.047	■ 837	.0118	.071	■ 492	.0106	.071	–	–	–	–	–	–	◩ 180	.0094	.055	–	–	–	6754455
WNMG 431-NM	**T7325**	.016	◩ 640	.0079	.083	■ 492	.0071	.083	–	–	–	–	–	–	■ 197	.0063	.067	–	–	–	7156474
	T7335	.016	◩ 623	.0079	.083	■ 476	.0071	.083	–	–	–	–	–	–	■ 197	.0063	.067	–	–	–	6754846
	T8430	.016	■ 591	.0098	.083	■ 312	.0091	.083	–	–	–	◩ 1624	.0118	.083	◩ 115	.0079	.067	–	–	–	7977435
	T9325	.016	■ 787	.0079	.083	■ 459	.0071	.083	–	–	–	–	–	–	◩ 164	.0063	.067	–	–	–	6754463
	T9415	.016	■ 1001	.0079	.083	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	8345613
WNMG 432-NM	**T7325**	.031	◩ 705	.0098	.083	■ 541	.0091	.083	–	–	–	–	–	–	■ 213	.0079	.067	–	–	–	7156483
	T7335	.031	◩ 689	.0098	.083	■ 525	.0091	.083	–	–	–	–	–	–	■ 213	.0079	.067	–	–	–	6754848
	T8430	.031	■ 689	.0098	.083	■ 377	.0091	.083	–	–	–	◩ 1919	.0118	.083	◩ 148	.0079	.067	–	–	–	7977169
	T9315	.031	■ 951	.0098	.083	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	6922941
	T9325	.031	■ 853	.0098	.083	■ 509	.0091	.083	–	–	–	–	–	–	◩ 180	.0079	.067	–	–	–	6754468
	T9415	.031	■ 1099	.0098	.083	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	8345618
WNMG 433-NM	**T7325**	.047	◩ 705	.0118	.083	■ 541	.0106	.083	–	–	–	–	–	–	■ 213	.0094	.067	–	–	–	7156492
	T8415	.047	■ 804	.0118	.083	■ 410	.0106	.083	–	–	–	◩ 2018	.0142	.083	■ 180	.0094	.066	–	–	–	8553167
	T9325	.047	■ 837	.0118	.083	■ 492	.0106	.083	–	–	–	–	–	–	◩ 180	.0094	.067	–	–	–	6754489

.NMA

.NMA flat insert is designed for medium machining of Cast irons. It features neutral rake angle without T-land. It's also conditionally suitable for Hard materials.

PRAMET

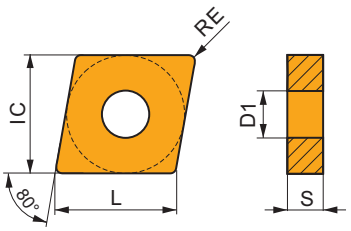
.NMA ..S

.NMA..S flat insert is designed for medium machining of Cast irons. It features neutral rake angle and negative, moderate T-land. It's also conditionally suitable for Hard materials.

PRAMET

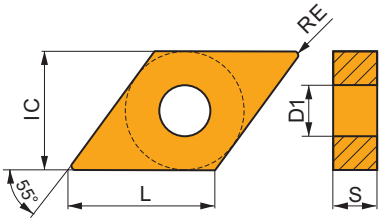
CNMA

	IC (inch)	D1 (inch)	L (inch)	S (inch)
43	.500	.203	.508	.187
54	.625	.250	.634	.250
64	.750	.313	.760	.250



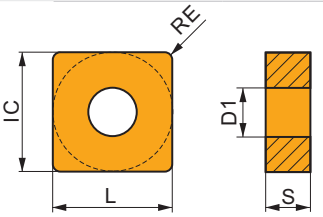
DNMA

	IC (inch)	D1 (inch)	L (inch)	S (inch)
43	.500	.203	.610	.187
44	.500	.203	.610	.250



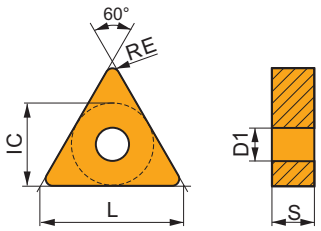
SNMA

	IC (inch)	D1 (inch)	L (inch)	S (inch)
43	.500	.203	.500	.187
54	.625	.250	.625	.250
64	.750	.313	.750	.250
85	1.000	.359	1.000	.313
86	1.000	.359	1.000	.375



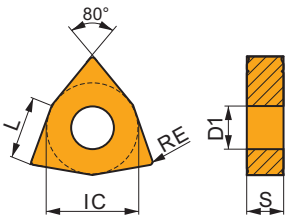
TNMA

	IC (inch)	D1 (inch)	L (inch)	S (inch)
33	.375	.150	.650	.187
43	.500	.203	.866	.187



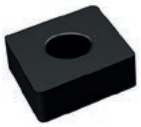
WNMA

	IC (inch)	D1 (inch)	L (inch)	S (inch)
43	.500	.203	.343	.187



Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our cutting conditions app for further options.

Product		RE (inch)	P vc (ft/min)	P f (in/rev)	P ap (inch)	M vc (ft/min)	M f (in/rev)	M ap (inch)	K vc (ft/min)	K f (in/rev)	K ap (inch)	N vc (ft/min)	N f (in/rev)	N ap (inch)	S vc (ft/min)	S f (in/rev)	S ap (inch)	H vc (ft/min)	H f (in/rev)	H ap (inch)	MID



.NMA flat insert is designed for medium machining of Cast irons. It features neutral rake angle without T-land. It's also conditionally suitable for Hard materials.

CNMA 431	**T5305**	.016	–	–	–	–	–	–	771	.0039	.157	–	–	–	–	–	–	164	.0039	.012	6755726
	T5315	.016	–	–	–	–	–	–	656	.0039	.157	–	–	–	–	–	–	131	.0039	.012	6922784
CNMA 432	**T5305**	.031	–	–	–	–	–	–	722	.0079	.157	–	–	–	–	–	–	148	.0039	.028	6755727
	T5315	.031	–	–	–	–	–	–	623	.0079	.157	–	–	–	–	–	–	131	.0039	.028	6755801
	T6310	.031	–	–	–	–	–	–	328	.0079	.157	–	–	–	–	–	–	82	.0039	.028	6922854
	T8415	.031	–	–	–	–	–	–	476	.0079	.157	–	–	–	–	–	–	82	.0055	.020	8552986
CNMA 433	**T5305**	.047	–	–	–	–	–	–	640	.0118	.157	–	–	–	–	–	–	131	.0059	.039	6755731
	T5315	.047	–	–	–	–	–	–	591	.0118	.157	–	–	–	–	–	–	115	.0059	.039	6755802
	T8415	.047	–	–	–	–	–	–	443	.0118	.157	–	–	–	–	–	–	82	.0083	.020	8552987
CNMA 434	**T5305**	.063	–	–	–	–	–	–	623	.0157	.157	–	–	–	–	–	–	131	.0079	.051	6755735
	T5315	.063	–	–	–	–	–	–	558	.0157	.157	–	–	–	–	–	–	115	.0079	.051	6922785
CNMA 543	**T5305**	.047	–	–	–	–	–	–	623	.0118	.197	–	–	–	–	–	–	131	.0059	.039	6755736
	T5315	.047	–	–	–	–	–	–	574	.0118	.197	–	–	–	–	–	–	115	.0059	.039	6922786
CNMA 643	**T5305**	.047	–	–	–	–	–	–	623	.0118	.236	–	–	–	–	–	–	131	.0059	.039	6755739
	T5315	.047	–	–	–	–	–	–	558	.0118	.236	–	–	–	–	–	–	115	.0059	.039	6922789
CNMA 644	**T5305**	.063	–	–	–	–	–	–	591	.0157	.236	–	–	–	–	–	–	115	.0079	.051	6755740
	T5315	.063	–	–	–	–	–	–	525	.0157	.236	–	–	–	–	–	–	98	.0079	.051	6922790

.NMA..S flat insert is designed for medium machining of Cast irons. It features neutral rake angle and negative, moderate T-land. It's also conditionally suitable for Hard materials.

CNMA 432S	**T5305**	.031	–	–	–	–	–	–	722	.0079	.157	–	–	–	–	–	–	148	.0039	.028	6755729
CNMA 433S	**T5305**	.047	–	–	–	–	–	–	623	.0157	.157	–	–	–	–	–	–	131	.0079	.051	6755734
CNMA 543S	**T5305**	.047	–	–	–	–	–	–	623	.0118	.197	–	–	–	–	–	–	131	.0059	.039	6755738
CNMA 644S	**T5305**	.063	–	–	–	–	–	–	591	.0157	.236	–	–	–	–	–	–	115	.0079	.051	6755741

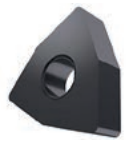
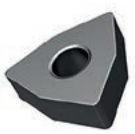
.NMA flat insert is designed for medium machining of Cast irons. It features neutral rake angle without T-land. It's also conditionally suitable for Hard materials.

DNMA 432	**T5305**	.031	–	–	–	–	–	–	623	.0079	.067	–	–	–	–	–	–	131	.0039	.028	6755822
DNMA 441	**T5305**	.016	–	–	–	–	–	–	673	.0039	.067	–	–	–	–	–	–	131	.0039	.012	6755823
	T5315	.016	–	–	–	–	–	–	591	.0039	.067	–	–	–	–	–	–	115	.0039	.012	6922793
	T8415	.016	–	–	–	–	–	–	427	.0039	.067	–	–	–	–	–	–	82	.0028	.020	8553076
DNMA 442	**T5305**	.031	–	–	–	–	–	–	623	.0079	.067	–	–	–	–	–	–	131	.0039	.028	6755824
	T5315	.031	–	–	–	–	–	–	541	.0079	.067	–	–	–	–	–	–	115	.0039	.028	6922794
	T8415	.031	–	–	–	–	–	–	410	.0079	.067	–	–	–	–	–	–	66	.0055	.020	8553077
DNMA 443	**T5305**	.047	–	–	–	–	–	–	656	.0079	.067	–	–	–	–	–	–	131	.0039	.035	6755825
	T5315	.047	–	–	–	–	–	–	574	.0079	.067	–	–	–	–	–	–	115	.0039	.035	6922795

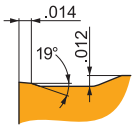
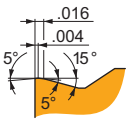
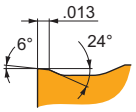
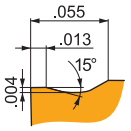
.NMA flat insert is designed for medium machining of Cast irons. It features neutral rake angle without T-land. It's also conditionally suitable for Hard materials.

SNMA 432	**T5305**	.031	–	–	–	–	–	–	755	.0079	.157	–	–	–	–	–	–	148	.0039	.028	6755857
	T5315	.031	–	–	–	–	–	–	656	.0079	.157	–	–	–	–	–	–	131	.0039	.028	6755767
	T8415	.031	–	–	–	–	–	–	492	.0079	.157	–	–	–	–	–	–	82	.0055	.020	8553106
SNMA 433	**T5305**	.047	–	–	–	–	–	–	673	.0118	.157	–	–	–	–	–	–	131	.0059	.039	6755858
	T5315	.047	–	–	–	–	–	–	623	.0118	.157	–	–	–	–	–	–	131	.0059	.039	6755768
SNMA 543	**T5305**	.047	–	–	–	–	–	–	656	.0118	.197	–	–	–	–	–	–	131	.0059	.039	6755860
SNMA 643	**T5305**	.047	–	–	–	–	–	–	640	.0118	.236	–	–	–	–	–	–	131	.0059	.039	6755861
	T5315	.047	–	–	–	–	–	–	591	.0118	.236	–	–	–	–	–	–	115	.0059	.039	6922797
SNMA 644	**T5305**	.063	–	–	–	–	–	–	623	.0157	.236	–	–	–	–	–	–	131	.0079	.051	6755692

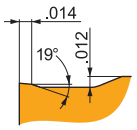
Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our cutting conditions app for further options.

Product		RE (inch)	P vc (ft/min)	P f (in/rev)	P ap (inch)	M vc (ft/min)	M f (in/rev)	M ap (inch)	K vc (ft/min)	K f (in/rev)	K ap (inch)	N vc (ft/min)	N f (in/rev)	N ap (inch)	S vc (ft/min)	S f (in/rev)	S ap (inch)	H vc (ft/min)	H f (in/rev)	H ap (inch)	MID
.NMA flat insert is designed for medium machining of Cast irons. It features neutral rake angle without T-land. It's also conditionally suitable for Hard materials.																					
SNMA 856	**T5305**	.094	–	–	–	–	–	–	312	.0236	.315	–	–	–	–	–	–	66	.0118	.079	6755863
	T5315	.094	–	–	–	–	–	–	295	.0236	.315	–	–	–	–	–	–	49	.0118	.079	6922799
SNMA 866	**T5305**	.094	–	–	–	–	–	–	312	.0236	.315	–	–	–	–	–	–	66	.0118	.079	6755865
	T5315	.094	–	–	–	–	–	–	295	.0236	.315	–	–	–	–	–	–	49	.0118	.079	6755693
.NMA..S flat insert is designed for medium machining of Cast irons. It features neutral rake angle and negative, moderate T-land. It's also conditionally suitable for Hard materials.																					
SNMA 644S	**T5305**	.063	–	–	–	–	–	–	640	.0118	.236	–	–	–	–	–	–	131	.0059	.039	6755862
SNMA 866S	**T5305**	.094	–	–	–	–	–	–	312	.0236	.315	–	–	–	–	–	–	66	.0118	.079	6755866
.NMA flat insert is designed for medium machining of Cast irons. It features neutral rake angle without T-land. It's also conditionally suitable for Hard materials.																					
TNMA 331	**T5305**	.016	–	–	–	–	–	–	722	.0039	.059	–	–	–	–	–	–	148	.0039	.012	6755885
	T5315	.016	–	–	–	–	–	–	623	.0039	.059	–	–	–	–	–	–	131	.0039	.012	6922800
TNMA 332	**T5305**	.031	–	–	–	–	–	–	673	.0079	.059	–	–	–	–	–	–	131	.0039	.028	6755886
	T5315	.031	–	–	–	–	–	–	591	.0079	.059	–	–	–	–	–	–	115	.0039	.028	6755784
	T6310	.031	–	–	–	–	–	–	295	.0079	.059	–	–	–	–	–	–	66	.0039	.028	6922859
	T8415	.031	–	–	–	–	–	–	443	.0079	.059	–	–	–	–	–	–	82	.0055	.020	8553117
TNMA 333	**T5305**	.047	–	–	–	–	–	–	705	.0079	.059	–	–	–	–	–	–	148	.0039	.035	6755888
	T5315	.047	–	–	–	–	–	–	623	.0079	.059	–	–	–	–	–	–	131	.0039	.035	6922801
TNMA 432	**T5305**	.031	–	–	–	–	–	–	640	.0079	.079	–	–	–	–	–	–	131	.0039	.028	6755889
	T5315	.031	–	–	–	–	–	–	574	.0079	.079	–	–	–	–	–	–	115	.0039	.028	6922802
	T8415	.031	–	–	–	–	–	–	427	.0079	.079	–	–	–	–	–	–	82	.0055	.020	8553118
TNMA 433	**T5305**	.047	–	–	–	–	–	–	673	.0079	.079	–	–	–	–	–	–	131	.0039	.035	6755890
	T5315	.047	–	–	–	–	–	–	607	.0079	.079	–	–	–	–	–	–	115	.0039	.035	6922803
.NMA..S flat insert is designed for medium machining of Cast irons. It features neutral rake angle and negative, moderate T-land. It's also conditionally suitable for Hard materials.																					
TNMA 332S	**T5305**	.031	–	–	–	–	–	–	673	.0079	.059	–	–	–	–	–	–	131	.0039	.028	6755887
																					
.NMA flat insert is designed for medium machining of Cast irons. It features neutral rake angle without T-land. It's also conditionally suitable for Hard materials.																					
WNMA 431	**T5305**	.016	–	–	–	–	–	–	771	.0039	.157	–	–	–	–	–	–	164	.0039	.012	6755907
	T5315	.016	–	–	–	–	–	–	656	.0039	.157	–	–	–	–	–	–	131	.0039	.012	6922804
WNMA 432	**T5305**	.031	–	–	–	–	–	–	722	.0079	.157	–	–	–	–	–	–	148	.0039	.028	6755908
	T5315	.031	–	–	–	–	–	–	623	.0079	.157	–	–	–	–	–	–	131	.0039	.028	6755728
	T8415	.031	–	–	–	–	–	–	476	.0079	.157	–	–	–	–	–	–	82	.0055	.020	8553148
WNMA 433	**T5305**	.047	–	–	–	–	–	–	640	.0118	.157	–	–	–	–	–	–	131	.0059	.039	6755909
	T5315	.047	–	–	–	–	–	–	591	.0118	.157	–	–	–	–	–	–	115	.0059	.039	6755730
	T8415	.047	–	–	–	–	–	–	443	.0118	.157	–	–	–	–	–	–	82	.0083	.020	8553149
																					
.NMA..S flat insert is designed for medium machining of Cast irons. It features neutral rake angle and negative, moderate T-land. It's also conditionally suitable for Hard materials.																					
WNMA 432S	**T5305**	.031	–	–	–	–	–	–	722	.0079	.157	–	–	–	–	–	–	148	.0039	.028	6755918

ROUGHING – NAVIGATOR

RM			**RM** chip breaker is robust and the first choice for roughing of Steels. It features positive rake angle and stable, wide T-land. It's also suitable for Stainless steels, Cast irons, and conditionally for Super-alloys.
R			**R** chip breaker is robust and designed for roughing of Steels and Cast irons. It features slightly positive rake angle and negative/stable, extra-wide double T-land. It's also conditionally suitable for Hard materials.
NRM			**NRM** chip breaker is versatile and the first choice for roughing of Stainless steels. It features positive rake angle and stable, wide T-land. It's also suitable for Steels and Super-alloys.
KR			**KR** chip breaker is robust and the first choice for roughing of Cast irons. It features slightly positive rake angle and , wide T-land. It's also suitable for Steels, and conditionally for Hard materials.

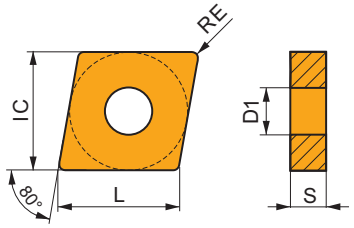
RM



RM chip breaker is robust and the first choice for roughing of Steels. It features positive rake angle and stable, wide T-land. It's also suitable for Stainless steels, Cast irons, and conditionally for Super-alloys.

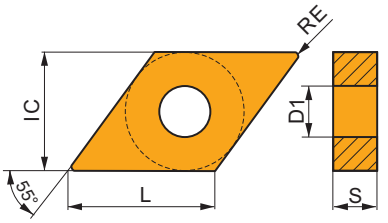
CNMG

	IC (inch)	D1 (inch)	L (inch)	S (inch)
43	.500	.203	.508	.187
54	.625	.250	.634	.250
64	.750	.313	.760	.250
86	1.000	.359	1.016	.375



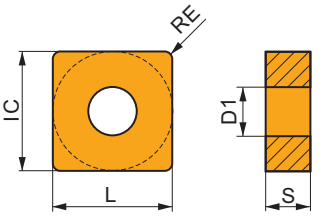
DNMG

	IC (inch)	D1 (inch)	L (inch)	S (inch)
33	.375	.150	.457	.187
43	.500	.203	.610	.187
44	.500	.203	.610	.250



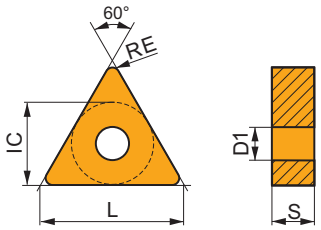
SNMG

	IC (inch)	D1 (inch)	L (inch)	S (inch)
43	.500	.203	.500	.187
54	.625	.250	.625	.250
64	.750	.313	.750	.250
86	1.000	.359	1.000	.375



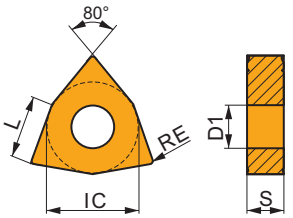
TNMG

	IC (inch)	D1 (inch)	L (inch)	S (inch)
33	.375	.150	.650	.187
43	.500	.203	.866	.187
54	.625	.250	1.083	.250
66	.750	.313	1.299	.375



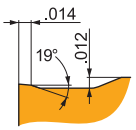
WNMG

	IC (inch)	D1 (inch)	L (inch)	S (inch)
33	.375	.150	.256	.187
43	.500	.203	.343	.187



Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our cutting conditions app for further options.

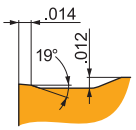
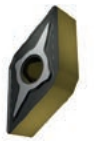
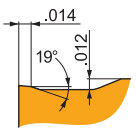
Product		RE	P			M			K			N			S			H			MID
			vc (ft/min)	f (in/rev)	ap (inch)	vc (ft/min)	f (in/rev)	ap (inch)	vc (ft/min)	f (in/rev)	ap (inch)	vc (ft/min)	f (in/rev)	ap (inch)	vc (ft/min)	f (in/rev)	ap (inch)	vc (ft/min)	f (in/rev)	ap (inch)	



RM chip breaker is robust and the first choice for roughing of Steels. It features positive rake angle and stable, wide T-land. It's also suitable for Stainless steels, Cast irons, and conditionally for Super-alloys.

CNMG 432-RM	**T5305**	.031	902	.0157	.157	–	–	–	853	.0157	.157	–	–	–	–	–	–	–	–	–	6755778
	T5315	.031	820	.0157	.157	–	–	–	771	.0157	.157	–	–	–	–	–	–	–	–	–	6755695
	T6310	.031	509	.0157	.157	361	.0142	.157	410	.0157	.157	–	–	–	148	.011	.126	–	–	–	6922771
	T7325	.031	591	.0157	.157	459	.0142	.157	–	–	–	–	–	–	180	.011	.126	–	–	–	7156199
	T7335	.031	541	.0157	.157	410	.0142	.157	–	–	–	–	–	–	164	.011	.126	–	–	–	6922685
	T8315	.031	541	.0157	.157	312	.0142	.157	509	.0157	.157	–	–	–	131	.011	.126	–	–	–	6753588
	T8415	.031	640	.0157	.157	328	.0142	.157	591	.0157	.157	–	–	–	148	.011	.126	–	–	–	8553065
	T8430	.031	541	.0157	.157	295	.0142	.157	443	.0157	.157	–	–	–	115	.011	.126	–	–	–	7977109
	T9325	.031	656	.0157	.157	394	.0142	.157	623	.0157	.157	–	–	–	148	.011	.126	–	–	–	6753781
	T9335	.031	558	.0157	.157	328	.0142	.157	–	–	–	–	–	–	115	.011	.126	–	–	–	6754858
	T9415	.031	869	.0157	.157	–	–	–	820	.0157	.157	–	–	–	–	–	–	–	–	–	8183354
CNMG 433-RM	**T5305**	.047	919	.0177	.157	–	–	–	869	.0177	.157	–	–	–	–	–	–	–	–	–	6755786
	T5315	.047	820	.0177	.157	–	–	–	771	.0177	.157	–	–	–	–	–	–	–	–	–	6755708
	T7325	.047	591	.0177	.157	459	.0161	.157	–	–	–	–	–	–	180	.0126	.126	–	–	–	7156208
	T7335	.047	558	.0177	.157	427	.0161	.157	–	–	–	–	–	–	180	.0126	.126	–	–	–	6922686
	T8415	.047	656	.0177	.157	344	.0159	.157	607	.0177	.157	–	–	–	148	.0124	.126	–	–	–	8553068
	T8430	.047	558	.0177	.157	295	.0161	.157	443	.0177	.157	–	–	–	115	.0126	.126	–	–	–	7977114
	T9315	.047	722	.0177	.157	–	–	–	673	.0177	.157	–	–	–	–	–	–	–	–	–	6753725
	T9325	.047	656	.0177	.157	394	.0161	.157	623	.0177	.157	–	–	–	148	.0126	.126	–	–	–	6753891
	T9335	.047	574	.0177	.157	344	.0161	.157	–	–	–	–	–	–	115	.0126	.126	–	–	–	6754861
	T9415	.047	886	.0177	.157	–	–	–	837	.0177	.157	–	–	–	–	–	–	–	–	–	8183357
CNMG 434-RM	**T5315**	.063	837	.0197	.157	–	–	–	787	.0197	.157	–	–	–	–	–	–	–	–	–	6755800
	T7335	.063	574	.0197	.157	443	.0177	.157	–	–	–	–	–	–	180	.0138	.126	–	–	–	6922687
	T8430	.063	558	.0197	.157	295	.0177	.157	443	.0197	.157	–	–	–	115	.0138	.126	–	–	–	7977321
	T9325	.063	673	.0197	.157	394	.0177	.157	623	.0197	.157	–	–	–	148	.0138	.126	–	–	–	6753894
	T9335	.063	574	.0197	.157	344	.0177	.157	–	–	–	–	–	–	115	.0138	.126	–	–	–	6754863
	T9415	.063	902	.0197	.157	–	–	–	853	.0197	.157	–	–	–	–	–	–	–	–	–	8244245
CNMG 542-RM	**T5305**	.031	869	.0157	.236	–	–	–	820	.0157	.236	–	–	–	–	–	–	–	–	–	6755789
	T5315	.031	787	.0157	.236	–	–	–	738	.0157	.236	–	–	–	–	–	–	–	–	–	6755803
	T8430	.031	509	.0157	.236	279	.0142	.236	427	.0157	.236	–	–	–	98	.011	.189	–	–	–	7977323
	T9325	.031	623	.0157	.236	361	.0142	.236	591	.0157	.236	–	–	–	131	.011	.189	–	–	–	6753897
	T9335	.031	541	.0157	.236	312	.0142	.236	–	–	–	–	–	–	115	.011	.189	–	–	–	6754865
	T9415	.031	837	.0157	.236	–	–	–	787	.0157	.236	–	–	–	–	–	–	–	–	–	8244247
CNMG 543-RM	**T5305**	.047	886	.0177	.236	–	–	–	837	.0177	.236	–	–	–	–	–	–	–	–	–	6755791
	T8415	.047	640	.0177	.236	328	.0159	.236	591	.0177	.236	–	–	–	148	.0124	.189	–	–	–	8553071
	T8430	.047	509	.0177	.236	279	.0161	.236	427	.0177	.236	–	–	–	98	.0126	.189	–	–	–	7977326
	T9310	.047	755	.0177	.236	–	–	–	705	.0177	.236	–	–	–	–	–	–	–	–	–	6755034
	T9315	.047	705	.0177	.236	–	–	–	656	.0177	.236	–	–	–	–	–	–	–	–	–	6753824
	T9325	.047	640	.0177	.236	377	.0161	.236	607	.0177	.236	–	–	–	131	.0126	.189	–	–	–	6753902
	T9335	.047	541	.0177	.236	312	.0161	.236	–	–	–	–	–	–	115	.0126	.189	–	–	–	6754867
	T9415	.047	853	.0177	.236	–	–	–	804	.0177	.236	–	–	–	–	–	–	–	–	–	8244250
CNMG 544-RM	**T5305**	.063	886	.0197	.236	–	–	–	837	.0197	.236	–	–	–	–	–	–	–	–	–	6755809
	T5315	.063	804	.0197	.236	–	–	–	755	.0197	.236	–	–	–	–	–	–	–	–	–	6755805
	T7325	.063	574	.0197	.236	443	.0177	.236	–	–	–	–	–	–	180	.0138	.189	–	–	–	7156222
	T9310	.063	738	.0197	.236	–	–	–	689	.0197	.236	–	–	–	–	–	–	–	–	–	6755035
	T9315	.063	705	.0197	.236	–	–	–	656	.0197	.236	–	–	–	–	–	–	–	–	–	6753825
	T9325	.063	623	.0197	.236	361	.0177	.236	591	.0197	.236	–	–	–	131	.0138	.189	–	–	–	6753904
	T9335	.063	541	.0197	.236	312	.0177	.236	–	–	–	–	–	–	115	.0138	.189	–	–	–	6754869
	T9415	.063	869	.0197	.236	–	–	–	820	.0197	.236	–	–	–	–	–	–	–	–	–	8183359
CNMG 642-RM	**T5305**	.031	853	.0157	.295	–	–	–	804	.0157	.295	–	–	–	–	–	–	–	–	–	6755810
	T5315	.031	755	.0157	.295	–	–	–	705	.0157	.295	–	–	–	–	–	–	–	–	–	6755806
	T9325	.031	623	.0157	.295	361	.0142	.295	591	.0157	.295	–	–	–	131	.011	.236	–	–	–	6753906
	T9335	.031	525	.0157	.295	312	.0142	.295	–	–	–	–	–	–	115	.011	.236	–	–	–	6754871
	T9415	.031	820	.0157	.295	–	–	–	771	.0157	.295	–	–	–	–	–	–	–	–	–	8244254

Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our cutting conditions app for further options.

Product		RE	P				M				K				N				S				H				MID
			vc (ft/min)	f (in/rev)	ap (inch)		vc (ft/min)	f (in/rev)	ap (inch)		vc (ft/min)	f (in/rev)	ap (inch)		vc (ft/min)	f (in/rev)	ap (inch)		vc (ft/min)	f (in/rev)	ap (inch)		vc (ft/min)	f (in/rev)	ap (inch)		
																											
CNMG 643-RM	**T5305**	.047	◪	853	.0177	.295		–	–	–	■	804	.0177	.295		–	–	–		–	–	–		–	–	–	6755812
	T5315	.047	◪	787	.0177	.295		–	–	–	■	738	.0177	.295		–	–	–		–	–	–		–	–	–	6755807
	T7325	.047	◪	558	.0177	.295	■	427	.0161	.295		–	–	–		–	–	–	◪	180	.0126	.236		–	–	–	7156227
	T7335	.047	◪	525	.0177	.295	■	394	.0161	.295		–	–	–		–	–	–	◪	164	.0126	.236		–	–	–	6922692
	T8415	.047	■	640	.0177	.295	■	328	.0159	.295	■	591	.0177	.295		–	–	–	◪	148	.0124	.236		–	–	–	8553073
	T8430	.047	■	492	.0177	.295	■	262	.0161	.295	◪	410	.0177	.295		–	–	–	◪	98	.0126	.236		–	–	–	7977329
	T9325	.047	■	607	.0177	.295	■	361	.0161	.295	◪	574	.0177	.295		–	–	–	◪	131	.0126	.236		–	–	–	6753908
	T9335	.047	■	541	.0177	.295	■	312	.0161	.295		–	–	–		–	–	–	◪	115	.0126	.236		–	–	–	6754874
	T9415	.047	■	820	.0177	.295		–	–	–	◪	771	.0177	.295		–	–	–		–	–	–		–	–	–	8244255
CNMG 644-RM	**T5305**	.063	◪	869	.0197	.295		–	–	–	■	820	.0197	.295		–	–	–		–	–	–		–	–	–	6755814
	T6310	.063	■	509	.0197	.295	■	361	.0177	.295	■	410	.0197	.295		–	–	–	◪	148	.0138	.236		–	–	–	6922775
	T7335	.063	◪	525	.0197	.295	■	394	.0177	.295		–	–	–		–	–	–	◪	164	.0138	.236		–	–	–	6922693
	T8415	.063	■	640	.0197	.295	■	328	.0177	.295	■	591	.0197	.295		–	–	–	◪	148	.0138	.236		–	–	–	8553075
	T8430	.063	■	492	.0197	.295	■	262	.0177	.295	◪	410	.0197	.295		–	–	–	◪	98	.0138	.236		–	–	–	8342370
	T9315	.063	■	689	.0197	.295		–	–	–	◪	640	.0197	.295		–	–	–		–	–	–		–	–	–	6754078
	T9325	.063	■	623	.0197	.295	■	361	.0177	.295	◪	591	.0197	.295		–	–	–	◪	131	.0138	.236		–	–	–	6753910
	T9335	.063	■	525	.0197	.295	■	312	.0177	.295		–	–	–		–	–	–	◪	115	.0138	.236		–	–	–	6754877
	T9415	.063	■	837	.0197	.295		–	–	–	◪	787	.0197	.295		–	–	–		–	–	–		–	–	–	8183391
CNMG 866-RM	**T7335**	.094	◪	328	.0315	.472	■	246	.0283	.472		–	–	–		–	–	–	◪	98	.022	.378		–	–	–	6922694
	T9226	.094	■	295	.0315	.472	■	164	.0283	.472	◪	279	.0315	.472		–	–	–	◪	49	.022	.378		–	–	–	6931844
	T9325	.094	■	344	.0315	.472	■	197	.0283	.472	◪	312	.0315	.472		–	–	–	◪	66	.022	.378		–	–	–	6753911
	T9335	.094	■	279	.0315	.472	■	164	.0283	.472		–	–	–		–	–	–	◪	49	.022	.378		–	–	–	6754878
	T9415	.094	■	410	.0315	.472		–	–	–	◪	377	.0315	.472		–	–	–		–	–	–		–	–	–	8244258
																											
DNMG 332-RM	**T9325**	.031	■	558	.0157	.079	■	328	.0142	.079	◪	525	.0157	.079		–	–	–	◪	115	.011	.063		–	–	–	6753948
	T9415	.031	■	755	.0157	.079		–	–	–	◪	705	.0157	.079		–	–	–		–	–	–		–	–	–	8244266
DNMG 333-RM	**T9325**	.047	■	673	.0118	.079	■	394	.0106	.079	◪	623	.0118	.079		–	–	–	◪	148	.0083	.063		–	–	–	6753951
	T9415	.047	■	869	.0118	.079		–	–	–	◪	820	.0118	.079		–	–	–		–	–	–		–	–	–	8244267
DNMG 432-RM	**T9325**	.031	■	541	.0157	.118	■	312	.0142	.118	◪	509	.0157	.118		–	–	–	◪	115	.011	.094		–	–	–	7035035
	T9415	.031	■	722	.0157	.118		–	–	–	◪	673	.0157	.118		–	–	–		–	–	–		–	–	–	8244270
DNMG 433-RM	**T9325**	.047	■	558	.0157	.118	■	328	.0142	.118	◪	525	.0157	.118		–	–	–	◪	115	.011	.094		–	–	–	6753959
	T9335	.047	■	492	.0157	.118	■	295	.0142	.118		–	–	–		–	–	–	◪	98	.011	.094		–	–	–	6754903
	T9415	.047	■	755	.0157	.118		–	–	–	◪	705	.0157	.118		–	–	–		–	–	–		–	–	–	8244271
DNMG 442-RM	**T5305**	.031	◪	755	.0157	.118		–	–	–	■	705	.0157	.118		–	–	–		–	–	–		–	–	–	6755827
	T5315	.031	◪	673	.0157	.118		–	–	–	■	623	.0157	.118		–	–	–		–	–	–		–	–	–	6755748
	T7325	.031	◪	476	.0157	.118	■	361	.0142	.118		–	–	–		–	–	–	◪	148	.011	.094		–	–	–	7156298
	T7335	.031	◪	443	.0157	.118	■	344	.0142	.118		–	–	–		–	–	–	◪	131	.011	.094		–	–	–	6922696
	T8415	.031	■	525	.0157	.118	■	279	.0142	.118	■	476	.0157	.118		–	–	–	◪	115	.011	.094		–	–	–	8553100
	T8430	.031	■	443	.0157	.118	■	246	.0142	.118	◪	361	.0157	.118		–	–	–	◪	82	.011	.094		–	–	–	7977127
	T9325	.031	■	541	.0157	.118	■	312	.0142	.118	◪	509	.0157	.118		–	–	–	◪	115	.011	.094		–	–	–	6753966
	T9335	.031	■	459	.0157	.118	■	262	.0142	.118		–	–	–		–	–	–	◪	98	.011	.094		–	–	–	6754906
	T9415	.031	■	722	.0157	.118		–	–	–	◪	673	.0157	.118		–	–	–		–	–	–		–	–	–	8244274
DNMG 443-RM	**T5305**	.047	◪	787	.0157	.118		–	–	–	■	738	.0157	.118		–	–	–		–	–	–		–	–	–	6755829
	T5315	.047	◪	705	.0157	.118		–	–	–	■	656	.0157	.118		–	–	–		–	–	–		–	–	–	6755750
	T7325	.047	◪	509	.0157	.118	■	394	.0142	.118		–	–	–		–	–	–	◪	164	.011	.094		–	–	–	7156305
	T8430	.047	■	459	.0157	.118	■	246	.0142	.118	◪	377	.0157	.118		–	–	–	◪	98	.011	.094		–	–	–	7977380
	T9325	.047	■	558	.0157	.118	■	328	.0142	.118	◪	525	.0157	.118		–	–	–	◪	115	.011	.094		–	–	–	6753970
	T9335	.047	■	492	.0157	.118	■	295	.0142	.118		–	–	–		–	–	–	◪	98	.011	.094		–	–	–	6754908
	T9415	.047	■	755	.0157	.118		–	–	–	◪	705	.0157	.118		–	–	–		–	–	–		–	–	–	8244277
DNMG 444-RM	**T5315**	.063	◪	738	.0157	.118		–	–	–	■	689	.0157	.118		–	–	–		–	–	–		–	–	–	6755751
	T9325	.063	■	591	.0157	.118	■	344	.0142	.118	◪	558	.0157	.118		–	–	–	◪	131	.011	.094		–	–	–	6753971
	T9335	.063	■	509	.0157	.118	■	295	.0142	.118		–	–	–		–	–	–	◪	98	.011	.094		–	–	–	6754909
	T9415	.063	■	804	.0157	.118		–	–	–	◪	755	.0157	.118		–	–	–		–	–	–		–	–	–	8244281

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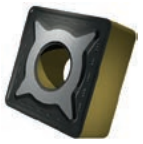
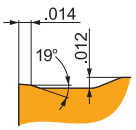
Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our cutting conditions app for further options.

Product		RE	P				M				K				N				S				H				MID
			vc (ft/min)	f (in/rev)	ap (inch)		vc (ft/min)	f (in/rev)	ap (inch)		vc (ft/min)	f (in/rev)	ap (inch)		vc (ft/min)	f (in/rev)	ap (inch)		vc (ft/min)	f (in/rev)	ap (inch)		vc (ft/min)	f (in/rev)	ap (inch)		
																											
SNMG 432-RM	**T5305**	.031	◪	951	.0157	.157		–	–	–	■	902	.0157	.157		–	–	–		–	–	–		–	–	–	6755870
	T7325	.031	◪	607	.0157	.157	■	459	.0142	.157		–	–	–		–	–	–	◪	197	.011	.126		–	–	–	7156338
	T8415	.031	■	689	.0157	.157	■	361	.0142	.157	■	623	.0157	.157		–	–	–	◪	148	.011	.126		–	–	–	8553109
	T8430	.031	■	574	.0157	.157	■	312	.0142	.157	◪	459	.0157	.157		–	–	–	◪	115	.011	.126		–	–	–	7977384
	T9325	.031	■	689	.0157	.157	■	410	.0142	.157	◪	640	.0157	.157		–	–	–	◪	148	.011	.126		–	–	–	6754007
	T9335	.031	■	591	.0157	.157	■	344	.0142	.157		–	–	–		–	–	–	◪	131	.011	.126		–	–	–	6754933
	T9415	.031	■	919	.0157	.157		–	–	–	◪	869	.0157	.157		–	–	–		–	–	–		–	–	–	8244284
SNMG 433-RM	**T7325**	.047	◪	623	.0177	.157	■	476	.0161	.157		–	–	–		–	–	–	◪	197	.0126	.126		–	–	–	7156343
	T7335	.047	◪	591	.0177	.157	■	459	.0161	.157		–	–	–		–	–	–	◪	180	.0126	.126		–	–	–	6922700
	T8415	.047	■	705	.0177	.157	■	361	.0159	.157	■	640	.0177	.157		–	–	–	◪	148	.0124	.126		–	–	–	8553112
	T9325	.047	■	689	.0177	.157	■	410	.0161	.157	◪	640	.0177	.157		–	–	–	◪	148	.0126	.126		–	–	–	6754012
	T9335	.047	■	607	.0177	.157	■	361	.0161	.157		–	–	–		–	–	–	◪	131	.0126	.126		–	–	–	6754936
	T9415	.047	■	919	.0177	.157		–	–	–	◪	869	.0177	.157		–	–	–		–	–	–		–	–	–	8244287
SNMG 434-RM	**T8430**	.063	■	574	.0197	.157	■	312	.0177	.157	◪	459	.0197	.157		–	–	–	◪	115	.0138	.126		–	–	–	7977390
	T9325	.063	■	705	.0197	.157	■	410	.0177	.157	◪	656	.0197	.157		–	–	–	◪	148	.0138	.126		–	–	–	6754016
	T9335	.063	■	591	.0197	.157	■	344	.0177	.157		–	–	–		–	–	–	◪	131	.0138	.126		–	–	–	6754938
	T9415	.063	■	951	.0197	.157		–	–	–	◪	902	.0197	.157		–	–	–		–	–	–		–	–	–	8244289
SNMG 543-RM	**T7325**	.047	◪	607	.0177	.197	■	459	.0161	.197		–	–	–		–	–	–	◪	197	.0126	.157		–	–	–	7156349
	T8415	.047	■	705	.0177	.197	■	361	.0159	.197	■	640	.0177	.197		–	–	–	◪	148	.0124	.157		–	–	–	8553114
	T9325	.047	■	673	.0177	.197	■	394	.0161	.197	◪	623	.0177	.197		–	–	–	◪	148	.0126	.157		–	–	–	6754019
	T9335	.047	■	591	.0177	.197	■	344	.0161	.197		–	–	–		–	–	–	◪	131	.0126	.157		–	–	–	6754940
	T9415	.047	■	902	.0177	.197		–	–	–	◪	853	.0177	.197		–	–	–		–	–	–		–	–	–	8244290
SNMG 544-RM	**T7335**	.063	◪	574	.0197	.197	■	443	.0177	.197		–	–	–		–	–	–	◪	180	.0138	.157		–	–	–	6922703
	T9325	.063	■	673	.0197	.197	■	394	.0177	.197	◪	623	.0197	.197		–	–	–	◪	148	.0138	.157		–	–	–	6754021
	T9335	.063	■	591	.0197	.197	■	344	.0177	.197		–	–	–		–	–	–	◪	131	.0138	.157		–	–	–	6754941
	T9415	.063	■	935	.0197	.197		–	–	–	◪	886	.0197	.197		–	–	–		–	–	–		–	–	–	8244291
SNMG 643-RM	**T5305**	.047	◪	902	.0177	.276		–	–	–	■	853	.0177	.276		–	–	–		–	–	–		–	–	–	6755878
	T5315	.047	◪	820	.0177	.276		–	–	–	■	771	.0177	.276		–	–	–		–	–	–		–	–	–	6755776
	T7325	.047	◪	591	.0177	.276	■	459	.0161	.276		–	–	–		–	–	–	◪	180	.0126	.220		–	–	–	7156352
	T7335	.047	◪	541	.0177	.276	■	410	.0161	.276		–	–	–		–	–	–	◪	164	.0126	.220		–	–	–	6922704
	T9325	.047	■	640	.0177	.276	■	377	.0161	.276	◪	607	.0177	.276		–	–	–	◪	131	.0126	.220		–	–	–	6754024
	T9335	.047	■	574	.0177	.276	■	344	.0161	.276		–	–	–		–	–	–	◪	115	.0126	.220		–	–	–	6754943
	T9415	.047	■	886	.0177	.276		–	–	–	◪	837	.0177	.276		–	–	–		–	–	–		–	–	–	8244292
SNMG 644-RM	**T5305**	.063	◪	935	.0197	.276		–	–	–	■	886	.0197	.276		–	–	–		–	–	–		–	–	–	6755879
	T7335	.063	◪	558	.0197	.276	■	427	.0177	.276		–	–	–		–	–	–	◪	180	.0138	.220		–	–	–	6922705
	T8415	.063	■	689	.0197	.276	■	361	.0177	.276	■	623	.0197	.276		–	–	–	◪	148	.0138	.220		–	–	–	8553116
	T8430	.063	■	541	.0197	.276	■	295	.0177	.276	◪	443	.0197	.276		–	–	–	◪	115	.0138	.220		–	–	–	8342375
	T9325	.063	■	656	.0197	.276	■	394	.0177	.276	◪	623	.0197	.276		–	–	–	◪	148	.0138	.220		–	–	–	6754027
	T9335	.063	■	574	.0197	.276	■	344	.0177	.276		–	–	–		–	–	–	◪	115	.0138	.220		–	–	–	6754945
	T9415	.063	■	886	.0197	.276		–	–	–	◪	837	.0197	.276		–	–	–		–	–	–		–	–	–	8244293
SNMG 866-RM	**T7325**	.094	◪	361	.0315	.472	■	279	.0283	.472		–	–	–		–	–	–	◪	115	.022	.378		–	–	–	7156357
	T7335	.094	◪	344	.0315	.472	■	262	.0283	.472		–	–	–		–	–	–	◪	98	.022	.378		–	–	–	6922706
	T9226	.094	■	312	.0315	.472	■	180	.0283	.472	◪	295	.0315	.472		–	–	–	◪	66	.022	.378		–	–	–	6931868
	T9315	.094	■	410	.0315	.472		–	–	–	◪	377	.0315	.472		–	–	–		–	–	–		–	–	–	6754054
	T9325	.094	■	361	.0315	.472	■	213	.0283	.472	◪	328	.0315	.472		–	–	–	◪	66	.022	.378		–	–	–	6754028
	T9335	.094	■	295	.0315	.472	■	164	.0283	.472		–	–	–		–	–	–	◪	66	.022	.378		–	–	–	6754946
	T9415	.094	■	427	.0315	.472		–	–	–	◪	394	.0315	.472		–	–	–		–	–	–		–	–	–	8183399

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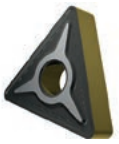
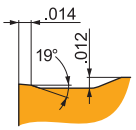
Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our cutting conditions app for further options.

Product		RE	P				M				K				N				S				H			MID
			vc	f	ap		vc	f	ap		vc	f	ap		vc	f	ap		vc	f	ap		vc	f	ap	
		(inch)	(ft/min)	(in/rev)	(inch)		(ft/min)	(in/rev)	(inch)		(ft/min)	(in/rev)	(inch)		(ft/min)	(in/rev)	(inch)		(ft/min)	(in/rev)	(inch)		(ft/min)	(in/rev)	(inch)	
																										

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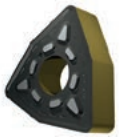
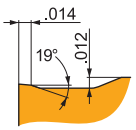
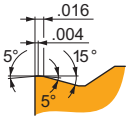
TNMG 332-RM	**T5305**	.031	◪	804	.0157	.118		–	–	–	■	755	.0157	.118		–	–	–		–	–	–		–	–	–	6755894
	T5315	.031	◪	705	.0157	.118		–	–	–	■	656	.0157	.118		–	–	–		–	–	–		–	–	–	6755700
	T7325	.031	◪	509	.0157	.118	■	394	.0142	.118		–	–	–		–	–	–	◪	164	.011	.094		–	–	–	7156389
	T7335	.031	◪	476	.0157	.118	■	361	.0142	.118		–	–	–		–	–	–	◪	148	.011	.094		–	–	–	6922707
	T9325	.031	■	574	.0157	.118	■	344	.0142	.118	◪	541	.0157	.118		–	–	–	◪	115	.011	.094		–	–	–	6754114
	T9335	.031	■	492	.0157	.118	■	295	.0142	.118		–	–	–		–	–	–	◪	98	.011	.094		–	–	–	6754979
	T9415	.031	■	771	.0157	.118		–	–	–	◪	722	.0157	.118		–	–	–		–	–	–		–	–	–	8244300
TNMG 333-RM	**T5305**	.047	◪	837	.0157	.118		–	–	–	■	787	.0157	.118		–	–	–		–	–	–		–	–	–	6755845
	T7335	.047	◪	509	.0157	.118	■	394	.0142	.118		–	–	–		–	–	–	◪	164	.011	.094		–	–	–	6922708
	T8430	.047	■	492	.0157	.118	■	262	.0142	.118	◪	410	.0157	.118		–	–	–	◪	98	.011	.094		–	–	–	7977409
	T9325	.047	■	607	.0157	.118	■	361	.0142	.118	◪	574	.0157	.118		–	–	–	◪	131	.011	.094		–	–	–	6753849
	T9335	.047	■	525	.0157	.118	■	312	.0142	.118		–	–	–		–	–	–	◪	115	.011	.094		–	–	–	6754982
	T9415	.047	■	804	.0157	.118		–	–	–	◪	755	.0157	.118		–	–	–		–	–	–		–	–	–	8244304
TNMG 432-RM	**T7325**	.031	◪	492	.0157	.157	■	377	.0142	.157		–	–	–		–	–	–	◪	148	.011	.126		–	–	–	7156400
	T9325	.031	■	558	.0157	.157	■	328	.0142	.157	◪	525	.0157	.157		–	–	–	◪	115	.011	.126		–	–	–	6754121
	T9335	.031	■	476	.0157	.157	■	279	.0142	.157		–	–	–		–	–	–	◪	98	.011	.126		–	–	–	6754984
	T9415	.031	■	738	.0157	.157		–	–	–	◪	689	.0157	.157		–	–	–		–	–	–		–	–	–	8244308
TNMG 433-RM	**T7325**	.047	◪	525	.0157	.157	■	394	.0142	.157		–	–	–		–	–	–	◪	164	.011	.126		–	–	–	7156404
	T7335	.047	◪	492	.0157	.157	■	377	.0142	.157		–	–	–		–	–	–	◪	148	.011	.126		–	–	–	6922710
	T9325	.047	■	591	.0157	.157	■	344	.0142	.157	◪	558	.0157	.157		–	–	–	◪	131	.011	.126		–	–	–	6754143
	T9335	.047	■	509	.0157	.157	■	295	.0142	.157		–	–	–		–	–	–	◪	98	.011	.126		–	–	–	6754986
	T9415	.047	■	771	.0157	.157		–	–	–	◪	722	.0157	.157		–	–	–		–	–	–		–	–	–	8244312
TNMG 434-RM	**T7325**	.063	◪	541	.0157	.157	■	410	.0142	.157		–	–	–		–	–	–	◪	164	.011	.126		–	–	–	7156406
	T9325	.063	■	607	.0157	.157	■	361	.0142	.157	◪	574	.0157	.157		–	–	–	◪	131	.011	.126		–	–	–	6754176
	T9335	.063	■	525	.0157	.157	■	312	.0142	.157		–	–	–		–	–	–	◪	115	.011	.126		–	–	–	6754987
	T9415	.063	■	820	.0157	.157		–	–	–	◪	771	.0157	.157		–	–	–		–	–	–		–	–	–	8244314
TNMG 543-RM	**T7325**	.047	◪	361	.0157	.236	■	279	.0142	.236		–	–	–		–	–	–	◪	115	.011	.189		–	–	–	7156517
	T9325	.047	■	394	.0157	.236	■	230	.0142	.236	◪	361	.0157	.236		–	–	–	◪	82	.011	.189		–	–	–	6926955
TNMG 544-RM	**T7325**	.063	◪	377	.0157	.236	■	279	.0142	.236		–	–	–		–	–	–	◪	115	.011	.189		–	–	–	7156407
	T9325	.063	■	410	.0157	.236	■	246	.0142	.236	◪	377	.0157	.236		–	–	–	◪	82	.011	.189		–	–	–	6754177
	T9335	.063	■	328	.0157	.236	■	197	.0142	.236		–	–	–		–	–	–	◪	66	.011	.189		–	–	–	6754988
	T9415	.063	■	459	.0157	.236		–	–	–	◪	427	.0157	.236		–	–	–		–	–	–		–	–	–	8244315
TNMG 546-RM	**T7325**	.094	◪	377	.0197	.236	■	279	.0177	.236		–	–	–		–	–	–	◪	115	.0138	.189		–	–	–	7156408
	T9325	.094	■	394	.0197	.236	■	230	.0177	.236	◪	361	.0197	.236		–	–	–	◪	82	.0138	.189		–	–	–	6754178
	T9335	.094	■	312	.0197	.236	■	180	.0177	.236		–	–	–		–	–	–	◪	66	.0138	.189		–	–	–	6754989
TNMG 548-RM	**T9335**	.126	■	295	.0236	.236	■	164	.0213	.236		–	–	–		–	–	–	◪	66	.0165	.189		–	–	–	6926956
TNMG 666-RM	**T9226**	.094	■	328	.0197	.394	■	197	.0177	.394	◪	312	.0197	.394		–	–	–	◪	66	.0138	.315		–	–	–	6931888
	T9335	.094	■	295	.0197	.394	■	164	.0177	.394		–	–	–		–	–	–	◪	66	.0138	.315		–	–	–	6754990

Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our cutting conditions app for further options.

Product		RE	P			M			K			N			S			H			MID
			vc (ft/min)	f (in/rev)	ap (inch)	vc (ft/min)	f (in/rev)	ap (inch)	vc (ft/min)	f (in/rev)	ap (inch)	vc (ft/min)	f (in/rev)	ap (inch)	vc (ft/min)	f (in/rev)	ap (inch)	vc (ft/min)	f (in/rev)	ap (inch)	
																					
RM chip breaker is robust and the first choice for roughing of Steels. It features positive rake angle and stable, wide T-land. It's also suitable for Stainless steels, Cast irons, and conditionally for Super-alloys.																					
WNMG 333-RM	**T9315**	.047	■ 755	.0177	.118	–	–	–	◪ 705	.0177	.118	–	–	–	–	–	–	–	–	–	6754514
	T9325	.047	■ 755	.0177	.047	■ 443	.0161	.047	◪ 705	.0177	.047	–	–	–	◪ 164	.0126	.039	–	–	–	6754458
	T9415	.047	■ 919	.0177	.118	–	–	–	◪ 869	.0177	.118	–	–	–	–	–	–	–	–	–	8183409
WNMG 432-RM	**T5305**	.031	◪ 902	.0157	.157	–	–	–	■ 853	.0157	.157	–	–	–	–	–	–	–	–	–	6755912
	T5315	.031	◪ 820	.0157	.157	–	–	–	■ 771	.0157	.157	–	–	–	–	–	–	–	–	–	6755754
	T7325	.031	◪ 591	.0157	.157	■ 459	.0142	.157	–	–	–	–	–	–	◪ 180	.011	.126	–	–	–	7156485
	T8415	.031	■ 640	.0157	.157	■ 328	.0142	.157	■ 591	.0157	.157	–	–	–	◪ 148	.011	.126	–	–	–	8553164
	T8430	.031	■ 541	.0157	.157	■ 295	.0142	.157	◪ 443	.0157	.157	–	–	–	◪ 115	.011	.126	–	–	–	7977171
	T9310	.031	■ 787	.0157	.157	–	–	–	◪ 738	.0157	.157	–	–	–	–	–	–	–	–	–	6755071
	T9325	.031	■ 656	.0157	.157	■ 394	.0142	.157	◪ 623	.0157	.157	–	–	–	◪ 148	.011	.126	–	–	–	6754469
	T9335	.031	■ 558	.0157	.157	■ 328	.0142	.157	–	–	–	–	–	–	◪ 115	.011	.126	–	–	–	6755017
	T9415	.031	■ 869	.0157	.157	–	–	–	◪ 820	.0157	.157	–	–	–	–	–	–	–	–	–	8244327
WNMG 433-RM	**T5315**	.047	◪ 820	.0177	.157	–	–	–	■ 771	.0177	.157	–	–	–	–	–	–	–	–	–	6755696
	T9325	.047	■ 656	.0177	.157	■ 394	.0161	.157	◪ 623	.0177	.157	–	–	–	◪ 148	.0126	.126	–	–	–	6754491
	T9335	.047	■ 574	.0177	.157	■ 344	.0161	.157	–	–	–	–	–	–	◪ 115	.0126	.126	–	–	–	6755019
	T9415	.047	■ 886	.0177	.157	–	–	–	◪ 837	.0177	.157	–	–	–	–	–	–	–	–	–	8244331
WNMG 434-RM	**T5305**	.063	◪ 919	.0197	.157	–	–	–	■ 869	.0197	.157	–	–	–	–	–	–	–	–	–	6755917
	T5315	.063	◪ 837	.0197	.157	–	–	–	■ 787	.0197	.157	–	–	–	–	–	–	–	–	–	6755758
	T8430	.063	■ 558	.0197	.157	■ 295	.0177	.157	◪ 443	.0197	.157	–	–	–	◪ 115	.0138	.126	–	–	–	7977445
	T9325	.063	■ 673	.0197	.157	■ 394	.0177	.157	◪ 623	.0197	.157	–	–	–	◪ 148	.0138	.126	–	–	–	6754493
	T9335	.063	■ 574	.0197	.157	■ 344	.0177	.157	–	–	–	–	–	–	◪ 115	.0138	.126	–	–	–	6755020
	T9415	.063	■ 902	.0197	.157	–	–	–	◪ 853	.0197	.157	–	–	–	–	–	–	–	–	–	8244333

R

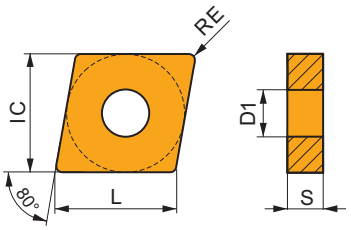


R chip breaker is robust and designed for roughing of Steels and Cast irons. It features slightly positive rake angle and negative/stable, extra-wide double T-land. It's also conditionally suitable for Hard materials.

PRAMET

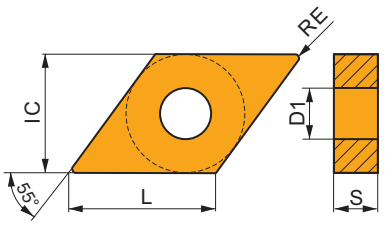
CNMG

	IC (inch)	D1 (inch)	L (inch)	S (inch)
43	.500	.203	.508	.187
54	.625	.250	.634	.250
64	.750	.313	.760	.250



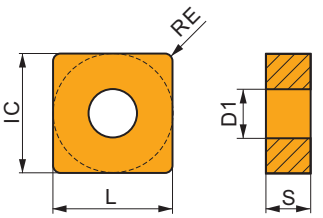
DNMG

	IC (inch)	D1 (inch)	L (inch)	S (inch)
43	.500	.203	.610	.187
44	.500	.203	.610	.250



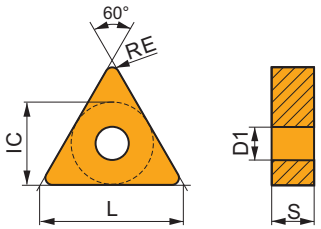
SNMG

	IC (inch)	D1 (inch)	L (inch)	S (inch)
43	.500	.203	.500	.187
54	.625	.250	.625	.250
64	.750	.313	.750	.250



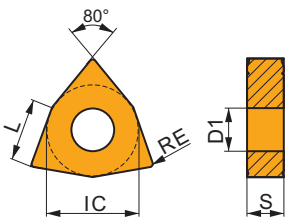
TNMG

	IC (inch)	D1 (inch)	L (inch)	S (inch)
33	.375	.150	.650	.187
43	.500	.203	.866	.187

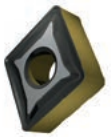
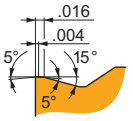
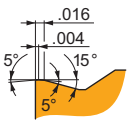


WNMG

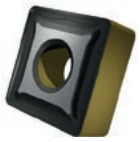
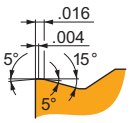
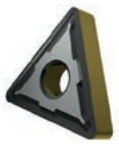
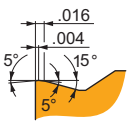
	IC (inch)	D1 (inch)	L (inch)	S (inch)
43	.500	.203	.343	.187



Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our cutting conditions app for further options.

Product		RE (inch)	P vc (ft/min)	P f (in/rev)	P ap (inch)	M vc (ft/min)	M f (in/rev)	M ap (inch)	K vc (ft/min)	K f (in/rev)	K ap (inch)	N vc (ft/min)	N f (in/rev)	N ap (inch)	S vc (ft/min)	S f (in/rev)	S ap (inch)	H vc (ft/min)	H f (in/rev)	H ap (inch)	MID
																					
			R chip breaker is robust and designed for roughing of Steels and Cast irons. It features slightly positive rake angle and negative/stable, extra-wide double T-land. It's also conditionally suitable for Hard materials.																		
CNMG 432-R	**6640**	.031	■ 459	.0157	.157	–	–	–	■ 427	.0157	.157	–	–	–	–	–	–	–	–	–	6751508
	T5305	.031	◪ 787	.0157	.157	–	–	–	■ 738	.0157	.157	–	–	–	–	–	–	◪ 148	.0079	.028	6755743
	T5315	.031	◪ 705	.0157	.157	–	–	–	■ 656	.0157	.157	–	–	–	–	–	–	◪ 131	.0079	.028	6922748
	T9325	.031	■ 574	.0157	.157	–	–	–	◪ 541	.0157	.157	–	–	–	–	–	–	–	–	–	6753780
	T9335	.031	■ 492	.0157	.157	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	6754857
	T9415	.031	■ 755	.0157	.157	–	–	–	◪ 705	.0157	.157	–	–	–	–	–	–	◪ 148	.0079	.028	8183353
CNMG 433-R	**T9325**	.047	■ 574	.0177	.157	–	–	–	◪ 541	.0177	.157	–	–	–	–	–	–	–	–	–	6753794
	T9335	.047	■ 509	.0177	.157	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	6754860
	T9415	.047	■ 771	.0177	.157	–	–	–	◪ 722	.0177	.157	–	–	–	–	–	–	◪ 148	.0091	.039	8345520
CNMG 434-R	**T9335**	.063	■ 492	.0197	.157	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	6922751
CNMG 542-R	**T5315**	.031	◪ 689	.0157	.217	–	–	–	■ 640	.0157	.217	–	–	–	–	–	–	◪ 131	.0079	.028	6922752
CNMG 543-R	**T5315**	.047	◪ 705	.0177	.217	–	–	–	■ 656	.0177	.217	–	–	–	–	–	–	◪ 131	.0091	.039	6922753
	T7335	.047	◪ 476	.0177	.217	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	7763058
	T9315	.047	■ 623	.0177	.217	–	–	–	◪ 591	.0177	.217	–	–	–	–	–	–	◪ 115	.0091	.039	6753726
	T9325	.047	■ 558	.0177	.217	–	–	–	◪ 525	.0177	.217	–	–	–	–	–	–	–	–	–	6753901
	T9415	.047	■ 755	.0177	.217	–	–	–	◪ 705	.0177	.217	–	–	–	–	–	–	◪ 148	.0091	.039	8244249
CNMG 643-R	**6630**	.047	■ 492	.0177	.276	–	–	–	◪ 459	.0177	.276	–	–	–	–	–	–	–	–	–	6751547
	6640	.047	■ 443	.0177	.276	–	–	–	■ 410	.0177	.276	–	–	–	–	–	–	–	–	–	6751548
	T5315	.047	◪ 689	.0177	.276	–	–	–	■ 640	.0177	.276	–	–	–	–	–	–	◪ 131	.0091	.039	6922755
	T9325	.047	■ 541	.0177	.276	–	–	–	◪ 509	.0177	.276	–	–	–	–	–	–	–	–	–	6753796
	T9335	.047	■ 476	.0177	.276	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	6754873
	T9415	.047	■ 738	.0177	.276	–	–	–	◪ 689	.0177	.276	–	–	–	–	–	–	◪ 148	.0091	.039	8345528
CNMG 644-R	**6630**	.063	■ 492	.0197	.276	–	–	–	◪ 459	.0197	.276	–	–	–	–	–	–	–	–	–	6751549
	6640	.063	■ 427	.0197	.276	–	–	–	■ 394	.0197	.276	–	–	–	–	–	–	–	–	–	6751550
	T9315	.063	■ 591	.0197	.276	–	–	–	◪ 558	.0197	.276	–	–	–	–	–	–	◪ 115	.0098	.051	6753728
	T9325	.063	■ 541	.0197	.276	–	–	–	◪ 509	.0197	.276	–	–	–	–	–	–	–	–	–	6753797
	T9335	.063	■ 476	.0197	.276	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	6754876
	T9415	.063	■ 738	.0197	.276	–	–	–	◪ 689	.0197	.276	–	–	–	–	–	–	◪ 148	.0098	.051	8244257
																					
			R chip breaker is robust and designed for roughing of Steels and Cast irons. It features slightly positive rake angle and negative/stable, extra-wide double T-land. It's also conditionally suitable for Hard materials.																		
DNMG 432-R	**T5315**	.031	◪ 574	.0157	.118	–	–	–	■ 541	.0157	.118	–	–	–	–	–	–	◪ 115	.0079	.028	7035040
DNMG 442-R	**T5305**	.031	◪ 656	.0157	.118	–	–	–	■ 623	.0157	.118	–	–	–	–	–	–	◪ 131	.0079	.028	6755826
	T5315	.031	◪ 574	.0157	.118	–	–	–	■ 541	.0157	.118	–	–	–	–	–	–	◪ 115	.0079	.028	6922757
	T9325	.031	■ 459	.0157	.118	–	–	–	◪ 427	.0157	.118	–	–	–	–	–	–	–	–	–	6753790
	T9415	.031	■ 623	.0157	.118	–	–	–	◪ 591	.0157	.118	–	–	–	–	–	–	◪ 115	.0079	.028	8345558
DNMG 443-R	**T5315**	.047	◪ 607	.0157	.118	–	–	–	■ 574	.0157	.118	–	–	–	–	–	–	◪ 115	.0079	.035	6922758
	T9325	.047	■ 492	.0157	.118	–	–	–	◪ 459	.0157	.118	–	–	–	–	–	–	–	–	–	6753792
	T9415	.047	■ 656	.0157	.118	–	–	–	◪ 623	.0157	.118	–	–	–	–	–	–	◪ 131	.0079	.035	8345562
DNMG 444-R	**T9325**	.063	■ 509	.0157	.118	–	–	–	◪ 476	.0157	.118	–	–	–	–	–	–	–	–	–	6922759

Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our cutting conditions app for further options.

Product		RE (inch)	P vc (ft/min)	P f (in/rev)	P ap (inch)	M vc (ft/min)	M f (in/rev)	M ap (inch)	K vc (ft/min)	K f (in/rev)	K ap (inch)	N vc (ft/min)	N f (in/rev)	N ap (inch)	S vc (ft/min)	S f (in/rev)	S ap (inch)	H vc (ft/min)	H f (in/rev)	H ap (inch)	MID
																					
	R chip breaker is robust and designed for roughing of Steels and Cast irons. It features slightly positive rake angle and negative/stable, extra-wide double T-land. It's also conditionally suitable for Hard materials.																				
SNMG 432-R	**6640**	.031	■ 476	.0157	.150	–	–	–	■ 443	.0157	.150	–	–	–	–	–	–	–	–	–	6751566
	T5305	.031	◪ 820	.0157	.150	–	–	–	■ 771	.0157	.150	–	–	–	–	–	–	◪ 164	.0079	.028	6755869
	T9325	.031	■ 591	.0157	.150	–	–	–	◪ 558	.0157	.150	–	–	–	–	–	–	–	–	–	6753838
	T9335	.031	■ 509	.0157	.150	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	6754932
SNMG 433-R	**T9325**	.047	■ 591	.0177	.150	–	–	–	◪ 558	.0177	.150	–	–	–	–	–	–	–	–	–	6754011
	T9335	.047	■ 525	.0177	.150	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	6754935
SNMG 434-R	**T9325**	.063	■ 607	.0197	.150	–	–	–	◪ 574	.0197	.150	–	–	–	–	–	–	–	–	–	6754015
	T9415	.063	■ 820	.0197	.150	–	–	–	◪ 771	.0197	.150	–	–	–	–	–	–	◪ 164	.0098	.051	8345571
SNMG 543-R	**T5315**	.047	◪ 755	.0177	.177	–	–	–	■ 705	.0177	.177	–	–	–	–	–	–	◪ 148	.0091	.039	6922760
	T9325	.047	■ 591	.0177	.177	–	–	–	◪ 558	.0177	.177	–	–	–	–	–	–	–	–	–	6754018
	T9415	.047	■ 804	.0177	.177	–	–	–	◪ 755	.0177	.177	–	–	–	–	–	–	◪ 148	.0091	.039	8345573
SNMG 544-R	**T5315**	.063	◪ 755	.0197	.177	–	–	–	■ 705	.0197	.177	–	–	–	–	–	–	◪ 148	.0098	.051	6922761
	T9325	.063	■ 591	.0197	.177	–	–	–	◪ 558	.0197	.177	–	–	–	–	–	–	–	–	–	6754020
SNMG 643-R	**6630**	.047	■ 525	.0177	.236	–	–	–	◪ 492	.0177	.236	–	–	–	–	–	–	–	–	–	6751579
	6640	.047	■ 459	.0177	.236	–	–	–	■ 427	.0177	.236	–	–	–	–	–	–	–	–	–	6751580
	T9325	.047	■ 574	.0177	.236	–	–	–	◪ 541	.0177	.236	–	–	–	–	–	–	–	–	–	6754023
SNMG 644-R	**6630**	.063	■ 541	.0197	.236	–	–	–	◪ 509	.0197	.236	–	–	–	–	–	–	–	–	–	6751581
	T9325	.063	■ 574	.0197	.236	–	–	–	◪ 541	.0197	.236	–	–	–	–	–	–	–	–	–	6754026
	T9335	.063	■ 492	.0197	.236	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	6922762
	T9415	.063	■ 787	.0197	.236	–	–	–	◪ 738	.0197	.236	–	–	–	–	–	–	◪ 148	.0098	.051	8345578
																					
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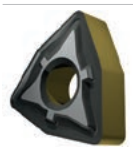
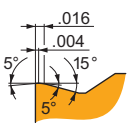
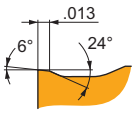
TNMG 332-R	**T5305**	.031	◪ 689	.0157	.118	–	–	–	■ 640	.0157	.118	–	–	–	–	–	–	◪ 131	.0079	.028	6922763
	T9325	.031	■ 492	.0157	.118	–	–	–	◪ 459	.0157	.118	–	–	–	–	–	–	–	–	–	6753848
	T9415	.031	■ 673	.0157	.118	–	–	–	◪ 623	.0157	.118	–	–	–	–	–	–	◪ 131	.0079	.028	8345595
TNMG 333-R	**T9335**	.047	■ 459	.0157	.118	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	6754981
	T9415	.047	■ 705	.0157	.118	–	–	–	◪ 656	.0157	.118	–	–	–	–	–	–	◪ 131	.0079	.035	8345597
TNMG 432-R	**T9325**	.031	■ 476	.0157	.157	–	–	–	◪ 443	.0157	.157	–	–	–	–	–	–	–	–	–	6754120
	T9415	.031	■ 640	.0157	.157	–	–	–	◪ 607	.0157	.157	–	–	–	–	–	–	◪ 115	.0079	.028	8345598
TNMG 433-R	**T9325**	.047	■ 509	.0157	.157	–	–	–	◪ 476	.0157	.157	–	–	–	–	–	–	–	–	–	6754141
	T9415	.047	■ 673	.0157	.157	–	–	–	◪ 623	.0157	.157	–	–	–	–	–	–	◪ 131	.0079	.035	8244311
TNMG 434-R	**T9325**	.063	■ 541	.0157	.157	–	–	–	◪ 509	.0157	.157	–	–	–	–	–	–	–	–	–	6754144
																					
	R chip breaker is robust and designed for roughing of Steels and Cast irons. It features slightly positive rake angle and negative/stable, extra-wide double T-land. It's also conditionally suitable for Hard materials.																				
WNMG 432-R	**T5305**	.031	◪ 804	.0157	.138	–	–	–	■ 755	.0157	.138	–	–	–	–	–	–	◪ 148	.0079	.028	6755911
	T5315	.031	◪ 722	.0157	.138	–	–	–	■ 673	.0157	.138	–	–	–	–	–	–	◪ 131	.0079	.028	6922767
	T9325	.031	■ 574	.0157	.138	–	–	–	◪ 541	.0157	.138	–	–	–	–	–	–	–	–	–	6753860
	T9335	.031	■ 509	.0157	.138	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	6755016
	T9415	.031	■ 771	.0157	.138	–	–	–	◪ 722	.0157	.138	–	–	–	–	–	–	◪ 148	.0079	.028	8244326
WNMG 433-R	**T5305**	.047	◪ 820	.0177	.138	–	–	–	■ 771	.0177	.138	–	–	–	–	–	–	◪ 164	.0091	.039	6755915
	T5315	.047	◪ 738	.0177	.138	–	–	–	■ 689	.0177	.138	–	–	–	–	–	–	◪ 148	.0091	.039	6922768
	T9310	.047	■ 705	.0177	.138	–	–	–	◪ 656	.0177	.138	–	–	–	–	–	–	◪ 131	.0091	.039	6922962
	T9325	.047	■ 591	.0177	.138	–	–	–	◪ 558	.0177	.138	–	–	–	–	–	–	–	–	–	6754490
	T9335	.047	■ 509	.0177	.138	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	6922769
	T9415	.047	■ 787	.0177	.138	–	–	–	◪ 738	.0177	.138	–	–	–	–	–	–	◪ 148	.0091	.039	8183413

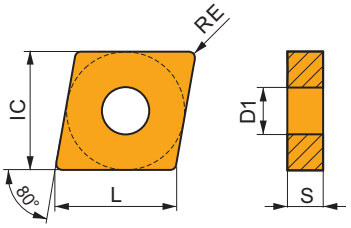
NRM



NRM chip breaker is versatile and the first choice for roughing of Stainless steels. It features positive rake angle and stable, wide T-land. It's also suitable for Steels and Super-alloys.

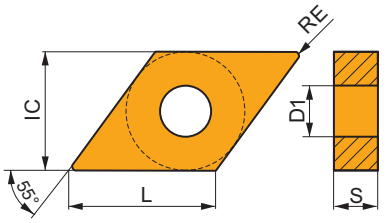
CNMG / CNMM

	IC (inch)	D1 (inch)	L (inch)	S (inch)
43	.500	.203	.508	.187
54	.625	.250	.634	.250
64	.750	.313	.760	.250
86	1.000	.359	1.016	.375



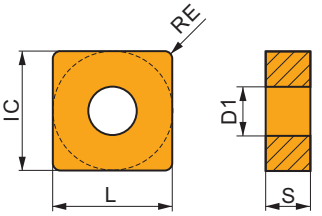
DNMG

	IC (inch)	D1 (inch)	L (inch)	S (inch)
44	.500	.203	.610	.250



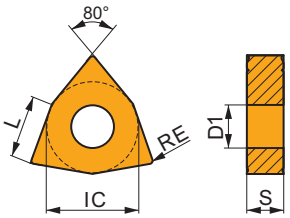
SNMG / SNMM

	IC (inch)	D1 (inch)	L (inch)	S (inch)
43	.500	.203	.500	.187
54	.625	.250	.625	.250
85	1.000	.359	1.000	.313
86	1.000	.359	1.000	.375

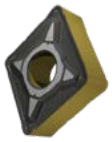
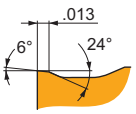
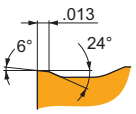
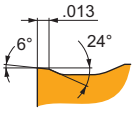
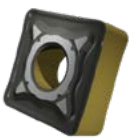
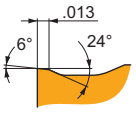


WNMG

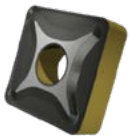
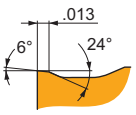
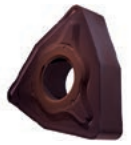
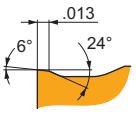
	IC (inch)	D1 (inch)	L (inch)	S (inch)
43	.500	.203	.343	.187



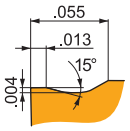
Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our cutting conditions app for further options.

Product		RE (inch)	P vc (ft/min)	P f (in/rev)	P ap (inch)	M vc (ft/min)	M f (in/rev)	M ap (inch)	K vc (ft/min)	K f (in/rev)	K ap (inch)	N vc (ft/min)	N f (in/rev)	N ap (inch)	S vc (ft/min)	S f (in/rev)	S ap (inch)	H vc (ft/min)	H f (in/rev)	H ap (inch)	MID
																					
NRM chip breaker is versatile and the first choice for roughing of Stainless steels. It features positive rake angle and stable, wide T-land. It's also suitable for Steels and Super-alloys.																					
CNMG 432-NRM	**T7325**	.031	525	.0138	.157	394	.0126	.157	–	–	–	–	–	–	164	.011	.126	–	–	–	7273473
	T8430	.031	492	.0138	.157	262	.0126	.157	–	–	–	–	–	–	98	.0098	.126	–	–	–	8342343
	T9415	.031	804	.0138	.157	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	8345514
CNMG 433-NRM	**T7325**	.047	541	.0157	.157	410	.0142	.157	–	–	–	–	–	–	164	.011	.126	–	–	–	7273476
	T8430	.047	492	.0157	.157	262	.0142	.157	–	–	–	–	–	–	98	.011	.126	–	–	–	8342344
	T9415	.047	804	.0157	.157	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	8345517
CNMG 542-NRM	**T7325**	.031	509	.0138	.236	394	.0126	.236	–	–	–	–	–	–	164	.011	.189	–	–	–	7273512
	T9415	.031	771	.0138	.236	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	8345521
CNMG 543-NRM	**T7325**	.047	509	.0157	.236	394	.0142	.236	–	–	–	–	–	–	164	.0126	.189	–	–	–	7273515
	T7335	.047	492	.0157	.236	377	.0142	.236	–	–	–	–	–	–	148	.0126	.189	–	–	–	7273516
	T9415	.047	771	.0157	.236	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	8345523
CNMG 544-NRM	**T7325**	.063	509	.0177	.236	394	.0161	.236	–	–	–	–	–	–	164	.0142	.189	–	–	–	7273518
	T7335	.063	492	.0177	.236	377	.0161	.236	–	–	–	–	–	–	148	.0142	.189	–	–	–	7273519
	T8430	.063	476	.0177	.236	262	.0161	.236	–	–	–	–	–	–	98	.0126	.189	–	–	–	8342346
	T9415	.063	787	.0177	.236	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	8244252
CNMG 643-NRM	**T7325**	.047	509	.0157	.315	394	.0142	.315	–	–	–	–	–	–	164	.0126	.252	–	–	–	7273524
	T8430	.047	459	.0157	.315	246	.0142	.315	–	–	–	–	–	–	98	.011	.252	–	–	–	8342347
	T9415	.047	755	.0157	.315	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	8345527
CNMG 644-NRM	**T7325**	.063	492	.0177	.315	377	.0161	.315	–	–	–	–	–	–	148	.0142	.252	–	–	–	7271033
	T7335	.063	476	.0177	.315	361	.0161	.315	–	–	–	–	–	–	148	.0142	.252	–	–	–	7271034
	T8430	.063	459	.0177	.315	246	.0161	.315	–	–	–	–	–	–	98	.0126	.252	–	–	–	8342349
	T9415	.063	755	.0177	.315	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	8345529
CNMG 866-NRM	**T7325**	.094	312	.0276	.394	230	.0248	.394	–	–	–	–	–	–	98	.0193	.315	–	–	–	7273542
	T7335	.094	295	.0276	.394	230	.0248	.394	–	–	–	–	–	–	82	.0193	.315	–	–	–	7273543
																					
NRM chip breaker is versatile and the first choice for roughing of Stainless steels. It features positive rake angle and stable, wide T-land. It's also suitable for Steels and Super-alloys.																					
CNMM 866-NRM	**T7325**	.094	312	.0276	.394	230	.0248	.394	–	–	–	–	–	–	98	.0193	.315	–	–	–	7273560
																					
NRM chip breaker is versatile and the first choice for roughing of Stainless steels. It features positive rake angle and stable, wide T-land. It's also suitable for Steels and Super-alloys.																					
DNMG 442-NRM	**T7335**	.031	427	.0118	.118	328	.0106	.118	–	–	–	–	–	–	131	.0094	.094	–	–	–	7595932
	T9415	.031	689	.0118	.118	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	8345554
																					
NRM chip breaker is versatile and the first choice for roughing of Stainless steels. It features positive rake angle and stable, wide T-land. It's also suitable for Steels and Super-alloys.																					
SNMG 432-NRM	**T7325**	.031	574	.0138	.102	443	.0126	.102	–	–	–	–	–	–	180	.011	.083	–	–	–	7273527
SNMG 433-NRM	**T8430**	.047	541	.0157	.118	295	.0142	.118	–	–	–	–	–	–	115	.011	.094	–	–	–	8342371
	T9415	.047	869	.0157	.118	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	8345569
SNMG 543-NRM	**T7325**	.047	558	.0157	.157	427	.0142	.157	–	–	–	–	–	–	180	.0126	.126	–	–	–	7273533
SNMG 544-NRM	**T7325**	.063	558	.0177	.197	427	.0161	.197	–	–	–	–	–	–	180	.0142	.157	–	–	–	7273536
	T8430	.063	492	.0177	.197	262	.0161	.197	–	–	–	–	–	–	98	.0126	.157	–	–	–	8342373
	T9415	.063	820	.0177	.197	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	8345574
SNMG 866-NRM	**T7325**	.094	344	.0276	.354	262	.0248	.354	–	–	–	–	–	–	98	.0193	.283	–	–	–	7273548
	T9415	.094	410	.0276	.354	–	–	–	377	.0276	.354	–	–	–	–	–	–	–	–	–	8345579

Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our cutting conditions app for further options.

Product		RE (inch)	P vc (ft/min)	P f (in/rev)	P ap (inch)	M vc (ft/min)	M f (in/rev)	M ap (inch)	K vc (ft/min)	K f (in/rev)	K ap (inch)	N vc (ft/min)	N f (in/rev)	N ap (inch)	S vc (ft/min)	S f (in/rev)	S ap (inch)	H vc (ft/min)	H f (in/rev)	H ap (inch)	MID
																					
NRM chip breaker is versatile and the first choice for roughing of Stainless steels. It features positive rake angle and stable, wide T-land. It's also suitable for Steels and Super-alloys.																					
SNMM 854-NRM	**T9415**	.063	■ 459	.0177	.354	–	–	–	◪ 427	.0177	.354	–	–	–	–	–	–	–	–	–	8504845
SNMM 856-NRM	**T9415**	.094	■ 427	.0256	.354	–	–	–	◪ 394	.0256	.354	–	–	–	–	–	–	–	–	–	8345586
SNMM 866-NRM	**T7325**	.094	◪ 344	.0276	.354	■ 262	.0248	.354	–	–	–	–	–	–	■ 98	.0193	.283	–	–	–	7273557
	T7335	.094	◪ 312	.0276	.354	■ 230	.0248	.354	–	–	–	–	–	–	■ 98	.0193	.283	–	–	–	7273558
	T8430	.094	■ 427	.0276	.354	■ 230	.0248	.354	◪ 344	.0276	.354	–	–	–	◪ 82	.0193	.283	–	–	–	8342376
																					
NRM chip breaker is versatile and the first choice for roughing of Stainless steels. It features positive rake angle and stable, wide T-land. It's also suitable for Steels and Super-alloys.																					
WNMG 432-NRM	**T7325**	.031	◪ 558	.0138	.106	■ 427	.0126	.106	–	–	–	–	–	–	■ 180	.011	.087	–	–	–	7595940
	T7335	.031	◪ 525	.0138	.106	■ 394	.0126	.106	–	–	–	–	–	–	■ 164	.011	.087	–	–	–	7595941
	T9415	.031	■ 837	.0138	.106	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	8345616
WNMG 433-NRM	**T7325**	.047	◪ 558	.0157	.106	■ 427	.0142	.106	–	–	–	–	–	–	■ 180	.011	.087	–	–	–	7595943
	T8430	.047	■ 509	.0157	.106	■ 279	.0142	.106	–	–	–	–	–	–	◪ 98	.011	.087	–	–	–	8342379
	T9415	.047	■ 837	.0157	.106	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	8345620

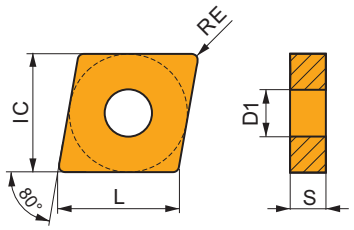
KR



KR chip breaker is robust and the first choice for roughing of Cast irons. It features slightly positive rake angle and , wide T-land. It's also suitable for Steels, and conditionally for Hard materials.

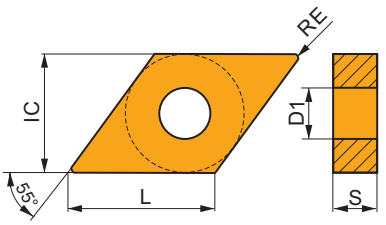
CNMG

	IC (inch)	D1 (inch)	L (inch)	S (inch)
43	.500	.203	.508	.187
54	.625	.250	.634	.250
64	.750	.313	.760	.250



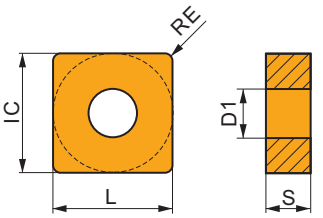
DNMG

	IC (inch)	D1 (inch)	L (inch)	S (inch)
44	.500	.203	.610	.250



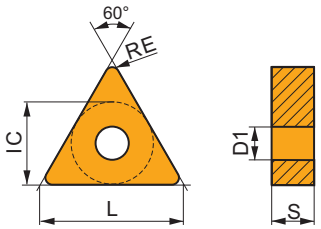
SNMG

	IC (inch)	D1 (inch)	L (inch)	S (inch)
43	.500	.203	.500	.187
54	.625	.250	.625	.250
64	.750	.313	.750	.250



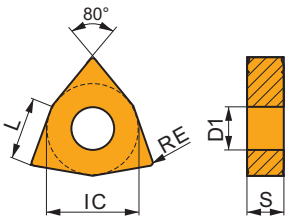
TNMG

	IC (inch)	D1 (inch)	L (inch)	S (inch)
33	.375	.150	.650	.187
43	.500	.203	.866	.187

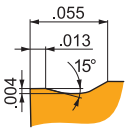
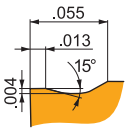
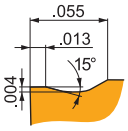
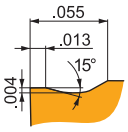
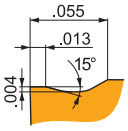


WNMG

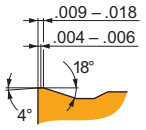
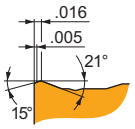
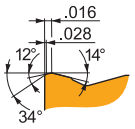
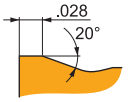
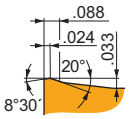
	IC (inch)	D1 (inch)	L (inch)	S (inch)
43	.500	.203	.343	.187



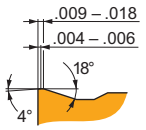
Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our cutting conditions app for further options.

Product		RE (inch)	P vc (ft/min)	P f (in/rev)	P ap (inch)	M vc (ft/min)	M f (in/rev)	M ap (inch)	K vc (ft/min)	K f (in/rev)	K ap (inch)	N vc (ft/min)	N f (in/rev)	N ap (inch)	S vc (ft/min)	S f (in/rev)	S ap (inch)	H vc (ft/min)	H f (in/rev)	H ap (inch)	MID
																					**KR** chip breaker is robust and the first choice for roughing of Cast irons. It features slightly positive rake angle and , wide T-land. It's also suitable for Steels, and conditionally for Hard materials.
CNMG 432-KR	**T5305**	.031	837	.0138	.157	–	–	–	787	.0138	.157	–	–	–	–	–	–	164	.0071	.028	6922716
	T5315	.031	738	.0138	.157	–	–	–	689	.0138	.157	–	–	–	–	–	–	148	.0071	.028	6922717
CNMG 433-KR	**T5305**	.047	837	.0157	.157	–	–	–	787	.0157	.157	–	–	–	–	–	–	164	.0079	.039	6755779
	T5315	.047	755	.0157	.157	–	–	–	705	.0157	.157	–	–	–	–	–	–	148	.0079	.039	6755797
CNMG 434-KR	**T5315**	.063	755	.0177	.157	–	–	–	705	.0177	.157	–	–	–	–	–	–	148	.0126	.031	8377237
CNMG 543-KR	**T5315**	.047	755	.0177	.177	–	–	–	705	.0177	.177	–	–	–	–	–	–	148	.0126	.031	8377238
CNMG 544-KR	**T5315**	.063	755	.0197	.177	–	–	–	705	.0197	.177	–	–	–	–	–	–	148	.0138	.031	8377239
CNMG 643-KR	**T5315**	.047	722	.0177	.276	–	–	–	673	.0177	.276	–	–	–	–	–	–	131	.0126	.031	8377240
CNMG 644-KR	**T5315**	.063	722	.0197	.276	–	–	–	673	.0197	.276	–	–	–	–	–	–	131	.0138	.031	8377241
																					**KR** chip breaker is robust and the first choice for roughing of Cast irons. It features slightly positive rake angle and , wide T-land. It's also suitable for Steels, and conditionally for Hard materials.
DNMG 442-KR	**T5315**	.031	640	.0138	.118	–	–	–	607	.0138	.118	–	–	–	–	–	–	115	.0098	.031	8377242
DNMG 443-KR	**T5315**	.047	640	.0157	.118	–	–	–	607	.0157	.118	–	–	–	–	–	–	115	.011	.031	8377243
																					**KR** chip breaker is robust and the first choice for roughing of Cast irons. It features slightly positive rake angle and , wide T-land. It's also suitable for Steels, and conditionally for Hard materials.
SNMG 432-KR	**T5305**	.031	869	.0138	.150	–	–	–	820	.0138	.150	–	–	–	–	–	–	164	.0071	.028	6755867
	T5315	.031	771	.0138	.150	–	–	–	722	.0138	.150	–	–	–	–	–	–	148	.0071	.028	6755769
SNMG 433-KR	**T5315**	.047	787	.0157	.150	–	–	–	738	.0157	.150	–	–	–	–	–	–	148	.0079	.039	6755694
SNMG 434-KR	**T5315**	.063	853	.0177	.150	–	–	–	804	.0177	.150	–	–	–	–	–	–	164	.0126	.031	8377244
SNMG 543-KR	**T5315**	.047	787	.0177	.177	–	–	–	738	.0177	.177	–	–	–	–	–	–	148	.0126	.031	8377245
SNMG 544-KR	**T5315**	.063	787	.0197	.177	–	–	–	738	.0197	.177	–	–	–	–	–	–	148	.0138	.031	8377246
SNMG 644-KR	**T5315**	.063	755	.0197	.276	–	–	–	705	.0197	.276	–	–	–	–	–	–	148	.0138	.031	8377247
																					**KR** chip breaker is robust and the first choice for roughing of Cast irons. It features slightly positive rake angle and , wide T-land. It's also suitable for Steels, and conditionally for Hard materials.
TNMG 332-KR	**T5305**	.031	722	.0138	.118	–	–	–	673	.0138	.118	–	–	–	–	–	–	131	.0071	.028	6755892
	T5315	.031	656	.0138	.118	–	–	–	623	.0138	.118	–	–	–	–	–	–	131	.0071	.028	6755698
TNMG 432-KR	**T5315**	.031	656	.0138	.157	–	–	–	623	.0138	.157	–	–	–	–	–	–	131	.0098	.031	8377248
TNMG 433-KR	**T5315**	.047	673	.0157	.157	–	–	–	623	.0157	.157	–	–	–	–	–	–	131	.011	.031	8377249
																					**KR** chip breaker is robust and the first choice for roughing of Cast irons. It features slightly positive rake angle and , wide T-land. It's also suitable for Steels, and conditionally for Hard materials.
WNMG 432-KR	**T5305**	.031	837	.0138	.138	–	–	–	787	.0138	.138	–	–	–	–	–	–	164	.0071	.028	6922718
	T5315	.031	755	.0138	.138	–	–	–	705	.0138	.138	–	–	–	–	–	–	148	.0071	.028	6922719
WNMG 433-KR	**T5315**	.047	771	.0157	.138	–	–	–	722	.0157	.138	–	–	–	–	–	–	148	.0079	.039	6755755

HEAVY ROUGHING – NAVIGATOR

OR		P	**OR** chip breaker is robust and the first choice for heavy roughing of Steels. It features positive rake angle and negative/stable, extra-wide double T-land. It's also suitable for Cast irons, and conditionally for Stainless steels and Super-alloys.
NR2		P	**NR2** chip breaker is robust and the first choice for heavy roughing of Stainless steels. It features positive rake angle and negative/negative, extra-wide double T-land. It's also suitable for Steels, and conditionally for Cast irons and Super-alloys.
HR		P	**HR** chip breaker is robust and designed for heavy roughing of Steels and Cast irons. It features slightly positive rake angle and negative/negative, extra-wide double T-land. It's also conditionally suitable for Stainless steels.
HR2		S	**HR2** chip breaker is robust and designed for heavy roughing of Steels and Cast irons. It features positive rake angle and stable, extra-wide double T-land. It's also conditionally suitable for Stainless steels.
923		S	**923** chip breaker is robust and designed for heavy roughing of Stainless steels. It features positive rake angle and negative/stable, extra-wide double T-land. It's also conditionally suitable for Steels and Cast irons.

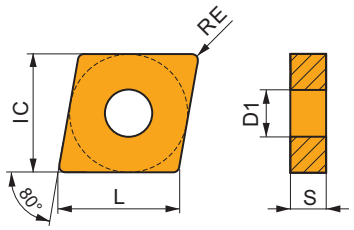
OR



OR chip breaker is robust and the first choice for heavy roughing of Steels. It features positive rake angle and negative/stable, extra-wide double T-land. It's also suitable for Cast irons, and conditionally for Stainless steels and Super-alloys.

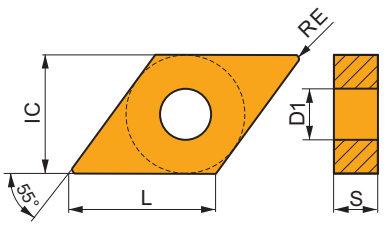
CNMM

	IC (inch)	D1 (inch)	L (inch)	S (inch)
43	.500	.203	.508	.187
54	.625	.250	.634	.250
64	.750	.313	.760	.250
86	1.000	.359	1.016	.375



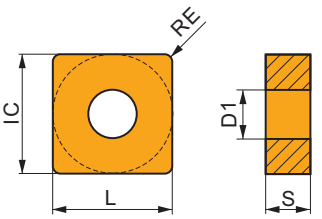
DNMM

	IC (inch)	D1 (inch)	L (inch)	S (inch)
44	.500	.203	.610	.250



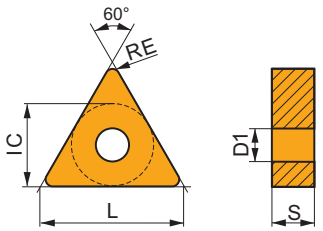
SNMM

	IC (inch)	D1 (inch)	L (inch)	S (inch)
43	.500	.203	.500	.187
54	.625	.250	.625	.250
64	.750	.313	.750	.250
85	1.000	.359	1.000	.313
86	1.000	.359	1.000	.375



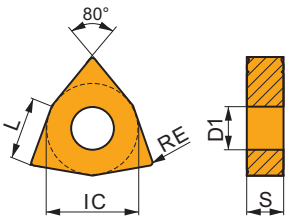
TNMM

	IC (inch)	D1 (inch)	L (inch)	S (inch)
33	.375	.150	.650	.187
43	.500	.203	.866	.187



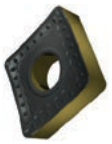
WNMM

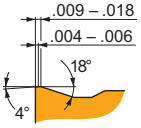
	IC (inch)	D1 (inch)	L (inch)	S (inch)
43	.500	.203	.343	.187
43	.500	.203	.343	.187



Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our cutting conditions app for further options.

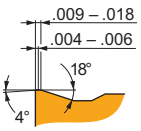
Product		RE (inch)	P vc (ft/min)	P f (in/rev)	P ap (inch)	M vc (ft/min)	M f (in/rev)	M ap (inch)	K vc (ft/min)	K f (in/rev)	K ap (inch)	N vc (ft/min)	N f (in/rev)	N ap (inch)	S vc (ft/min)	S f (in/rev)	S ap (inch)	H vc (ft/min)	H f (in/rev)	H ap (inch)	MID





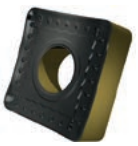
OR chip breaker is robust and the first choice for heavy roughing of Steels. It features positive rake angle and negative/stable, extra-wide double T-land. It's also suitable for Cast irons, and conditionally for Stainless steels and Super-alloys.

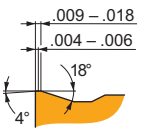
CNMM 432-OR	**T8430**	.031	492	.0157	.197	262	.0142	.197	410	.0157	.197	–	–	–	98	.011	.157	–	–	–	7977332
	T9325	.031	607	.0157	.197	361	.0142	.197	574	.0157	.197	–	–	–	131	.011	.157	–	–	–	6753914
	T9335	.031	525	.0157	.197	312	.0142	.197	–	–	–	–	–	–	115	.011	.157	–	–	–	6754879
	T9415	.031	820	.0157	.197	–	–	–	771	.0157	.197	–	–	–	–	–	–	–	–	–	8345533
CNMM 433-OR	**T9325**	.047	607	.0177	.197	361	.0161	.197	574	.0177	.197	–	–	–	131	.0142	.157	–	–	–	6753917
	T9335	.047	541	.0177	.197	312	.0161	.197	–	–	–	–	–	–	115	.0142	.157	–	–	–	6754880
	T9415	.047	820	.0177	.197	–	–	–	771	.0177	.197	–	–	–	–	–	–	–	–	–	8345534
CNMM 434-OR	**T9325**	.063	623	.0197	.197	361	.0177	.197	591	.0197	.197	–	–	–	131	.0157	.157	–	–	–	6754484
CNMM 542-OR	**T9325**	.031	591	.0157	.236	344	.0142	.236	558	.0157	.236	–	–	–	131	.0126	.189	–	–	–	6753919
	T9415	.031	804	.0157	.236	–	–	–	755	.0157	.236	–	–	–	–	–	–	–	–	–	8345535
CNMM 543-OR	**T8430**	.047	492	.0177	.236	262	.0161	.236	410	.0177	.236	–	–	–	98	.0142	.189	–	–	–	7977337
	T9325	.047	607	.0177	.236	361	.0161	.236	574	.0177	.236	–	–	–	131	.0142	.189	–	–	–	6753922
	T9415	.047	820	.0177	.236	–	–	–	771	.0177	.236	–	–	–	–	–	–	–	–	–	8345536
CNMM 544-OR	**T9325**	.063	591	.0197	.236	344	.0177	.236	558	.0197	.236	–	–	–	131	.0157	.189	–	–	–	6753924
	T9415	.063	820	.0197	.236	–	–	–	771	.0197	.236	–	–	–	–	–	–	–	–	–	8345537
CNMM 643-OR	**T8430**	.047	459	.0177	.354	246	.0161	.354	377	.0177	.354	–	–	–	98	.0142	.283	–	–	–	7977339
	T9325	.047	574	.0177	.354	344	.0161	.354	541	.0177	.354	–	–	–	115	.0142	.283	–	–	–	6753928
	T9335	.047	492	.0177	.354	295	.0161	.354	–	–	–	–	–	–	98	.0142	.283	–	–	–	6754886
	T9415	.047	787	.0177	.354	–	–	–	738	.0177	.354	–	–	–	–	–	–	–	–	–	8244259
CNMM 644-OR	**6630**	.063	525	.0197	.354	312	.0177	.354	492	.0197	.354	–	–	–	131	.0157	.283	–	–	–	6752090
	T8430	.063	459	.0197	.354	246	.0177	.354	377	.0197	.354	–	–	–	98	.0157	.283	–	–	–	7977341
	T9325	.063	574	.0197	.354	344	.0177	.354	541	.0197	.354	–	–	–	115	.0157	.283	–	–	–	6753799
	T9335	.063	509	.0197	.354	295	.0177	.354	–	–	–	–	–	–	98	.0157	.283	–	–	–	6754889
	T9415	.063	787	.0197	.354	–	–	–	738	.0197	.354	–	–	–	–	–	–	–	–	–	8345539
CNMM 646-OR	**T9315**	.094	541	.0315	.354	–	–	–	509	.0315	.354	–	–	–	–	–	–	–	–	–	6754110
	T9325	.094	492	.0315	.354	295	.0283	.354	459	.0315	.354	–	–	–	98	.022	.283	–	–	–	6753932
	T9415	.094	705	.0315	.354	–	–	–	656	.0315	.354	–	–	–	–	–	–	–	–	–	8345541
CNMM 866-OR	**6630**	.094	262	.0394	.472	148	.0354	.472	246	.0394	.472	–	–	–	66	.0276	.378	–	–	–	6752128
	T8430	.094	246	.0394	.472	131	.0354	.472	197	.0394	.472	–	–	–	49	.0276	.378	–	–	–	7977343
	T9325	.094	312	.0394	.472	180	.0354	.472	295	.0394	.472	–	–	–	66	.0276	.378	–	–	–	6754486
	T9415	.094	361	.0394	.472	–	–	–	328	.0394	.472	–	–	–	–	–	–	–	–	–	8345543



OR chip breaker is robust and the first choice for heavy roughing of Steels. It features positive rake angle and negative/stable, extra-wide double T-land. It's also suitable for Cast irons, and conditionally for Stainless steels and Super-alloys.

DNMM 442-OR	**T9325**	.031	509	.0157	.118	295	.0142	.118	476	.0157	.118	–	–	–	98	.011	.094	–	–	–	6753975
DNMM 443-OR	**T9325**	.047	541	.0157	.118	312	.0142	.118	509	.0157	.118	–	–	–	115	.0126	.094	–	–	–	6753976
	T9335	.047	476	.0157	.118	279	.0142	.118	–	–	–	–	–	–	98	.0126	.094	–	–	–	6754911
	T9415	.047	722	.0157	.118	–	–	–	673	.0157	.118	–	–	–	–	–	–	–	–	–	8345563
DNMM 444-OR	**T9325**	.063	541	.0177	.118	312	.0161	.118	509	.0177	.118	–	–	–	115	.0161	.094	–	–	–	6753977

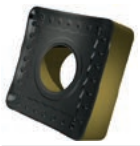
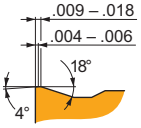
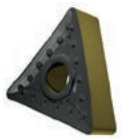
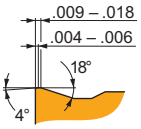




OR chip breaker is robust and the first choice for heavy roughing of Steels. It features positive rake angle and negative/stable, extra-wide double T-land. It's also suitable for Cast irons, and conditionally for Stainless steels and Super-alloys.

SNMM 432-OR	**T9325**	.031	640	.0157	.185	377	.0142	.185	607	.0157	.185	–	–	–	131	.0126	.150	–	–	–	6754124
	T9335	.031	574	.0157	.185	344	.0142	.185	–	–	–	–	–	–	115	.0126	.150	–	–	–	6754947
	T9415	.031	869	.0157	.185	–	–	–	820	.0157	.185	–	–	–	–	–	–	–	–	–	8345580
SNMM 433-OR	**T9325**	.047	656	.0177	.185	394	.0161	.185	623	.0177	.185	–	–	–	148	.0142	.150	–	–	–	6754127
	T9415	.047	886	.0177	.185	–	–	–	837	.0177	.185	–	–	–	–	–	–	–	–	–	8345581
SNMM 434-OR	**T9325**	.063	656	.0197	.185	394	.0177	.185	623	.0197	.185	–	–	–	148	.0157	.150	–	–	–	6754128

Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our cutting conditions app for further options.

Product		RE	P						M						K						N						S						H						MID
			vc		f		ap		vc		f		ap		vc		f		ap		vc		f		ap		vc		f		ap		vc		f		ap		
		(inch)	(ft/min)		(in/rev)		(inch)		(ft/min)		(in/rev)		(inch)		(ft/min)		(in/rev)		(inch)		(ft/min)		(in/rev)		(inch)		(ft/min)		(in/rev)		(inch)		(ft/min)		(in/rev)		(inch)		
																																							
OR chip breaker is robust and the first choice for heavy roughing of Steels. It features positive rake angle and negative/stable, extra-wide double T-land. It's also suitable for Cast irons, and conditionally for Stainless steels and Super-alloys.																																						
SNMM 542-OR	**T9325**	.031	623	.0157	.236		361	.0142	.236		591	.0157	.236		–	–	–		131	.0142	.189		–	–	–		6754129
SNMM 543-OR	**T9325**	.047	640	.0177	.236		377	.0161	.236		607	.0177	.236		–	–	–		131	.0142	.189		–	–	–		6754132
SNMM 544-OR	**T9325**	.063	623	.0197	.236		361	.0177	.236		591	.0197	.236		–	–	–		131	.0157	.189		–	–	–		6754134
	T9415	.063	869	.0197	.236		–	–	–		820	.0197	.236		–	–	–		–	–	–		–	–	–		8345582
SNMM 643-OR	**T8430**	.047	492	.0177	.315		262	.0161	.315		410	.0177	.315		–	–	–		98	.0142	.252		–	–	–		7977394
	T9325	.047	623	.0177	.315		361	.0161	.315		591	.0177	.315		–	–	–		131	.0142	.252		–	–	–		6754138
	T9335	.047	541	.0177	.315		312	.0161	.315		–	–	–		–	–	–		115	.0142	.252		–	–	–		6754953
	T9415	.047	820	.0177	.315		–	–	–		771	.0177	.315		–	–	–		–	–	–		–	–	–		8345583
SNMM 644-OR	**6630**	.063	574	.0197	.315		344	.0177	.315		541	.0197	.315		–	–	–		131	.0157	.252		–	–	–		6752091
	T8345	.063	410	.0197	.315		246	.0177	.315		377	.0197	.315		–	–	–		98	.0157	.252		–	–	–		6753690
	T8430	.063	509	.0197	.315		279	.0177	.315		427	.0197	.315		–	–	–		98	.0157	.252		–	–	–		7977396
	T9325	.063	607	.0197	.315		361	.0177	.315		574	.0197	.315		–	–	–		131	.0157	.252		–	–	–		6753839
	T9335	.063	525	.0197	.315		312	.0177	.315		–	–	–		–	–	–		115	.0157	.252		–	–	–		6754956
	T9415	.063	853	.0197	.315		–	–	–		804	.0197	.315		–	–	–		–	–	–		–	–	–		8345585
SNMM 646-OR	**T9325**	.094	541	.0315	.315		312	.0283	.315		509	.0315	.315		–	–	–		115	.022	.252		–	–	–		6754147
	T9415	.094	738	.0315	.315		–	–	–		689	.0315	.315		–	–	–		–	–	–		–	–	–		8244296
SNMM 854-OR	**T9226**	.063	377	.0197	.472		213	.0177	.472		344	.0197	.472		–	–	–		66	.0177	.378		–	–	–		6931871
	T9325	.063	394	.0217	.472		230	.0197	.472		361	.0217	.472		–	–	–		82	.0197	.378		–	–	–		6754149
SNMM 856-OR	**T8345**	.094	180	.0394	.472		98	.0354	.472		164	.0394	.472		–	–	–		33	.0276	.378		–	–	–		6753691
	T8430	.094	262	.0394	.472		148	.0354	.472		213	.0394	.472		–	–	–		49	.0276	.378		–	–	–		7977398
	T9325	.094	328	.0394	.472		197	.0354	.472		312	.0394	.472		–	–	–		66	.0276	.378		–	–	–		6754151
	T9335	.094	262	.0394	.472		148	.0354	.472		–	–	–		–	–	–		49	.0276	.378		–	–	–		6754964
	T9415	.094	394	.0394	.472		–	–	–		361	.0394	.472		–	–	–		–	–	–		–	–	–		8345588
SNMM 866-OR	**T8430**	.094	262	.0394	.472		148	.0354	.472		213	.0394	.472		–	–	–		49	.0276	.378		–	–	–		7977400
	T9325	.094	328	.0394	.472		197	.0354	.472		312	.0394	.472		–	–	–		66	.0276	.378		–	–	–		6754155
	T9335	.094	262	.0394	.472		148	.0354	.472		–	–	–		–	–	–		49	.0276	.378		–	–	–		6754968
	T9415	.094	394	.0394	.472		–	–	–		361	.0394	.472		–	–	–		–	–	–		–	–	–		8345590
																																							
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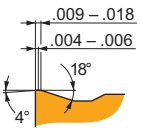
TNMM 332-OR	**T9325**	.031	541	.0157	.118		312	.0142	.118		509	.0157	.118		–	–	–		115	.011	.094		–	–	–		6754166
	T9415	.031	738	.0157	.118		–	–	–		689	.0157	.118		–	–	–		–	–	–		–	–	–		8345600
TNMM 432-OR	**T9325**	.031	525	.0157	.157		312	.0142	.157		492	.0157	.157		–	–	–		115	.0126	.126		–	–	–		6754170
	T9335	.031	459	.0157	.157		262	.0142	.157		–	–	–		–	–	–		98	.0126	.126		–	–	–		6754992
TNMM 433-OR	**T9325**	.047	574	.0157	.118		344	.0142	.118		541	.0157	.118		–	–	–		115	.0126	.094		–	–	–		6754173
	T9335	.047	492	.0157	.118		295	.0142	.118		–	–	–		–	–	–		98	.0126	.094		–	–	–		6754995
																																							
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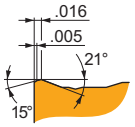
WNMM 432-OR	**T8430**	.031	509	.0157	.157		279	.0142	.157		427	.0157	.157		–	–	–		98	.011	.126		–	–	–		7977447
	T9325	.031	623	.0157	.157		361	.0142	.157		591	.0157	.157		–	–	–		131	.011	.126		–	–	–		6754496
	T9335	.031	541	.0157	.157		312	.0142	.157		–	–	–		–	–	–		115	.011	.126		–	–	–		6755021
WNMM 433-OR	**T9325**	.047	623	.0177	.157		361	.0161	.157		591	.0177	.157		–	–	–		131	.0142	.126		–	–	–		6754498
WNMM 434-OR	**T9325**	.063	640	.0197	.157		377	.0177	.157		607	.0197	.157		–	–	–		131	.0157	.126		–	–	–		6754499
WNMM 643-OR	**T9325**	.047	607	.0177	.236		361	.0161	.236		574	.0177	.236		–	–	–		131	.0142	.189		–	–	–		6754500
WNMM 644-OR	**T9325**	.063	591	.0197	.236		344	.0177	.236		558	.0197	.236		–	–	–		131	.0157	.189		–	–	–		6754501

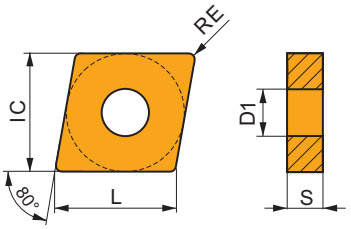
NR2



NR2 chip breaker is robust and the first choice for heavy roughing of Stainless steels. It features positive rake angle and negative/negative, extra-wide double T-land. It's also suitable for Steels, and conditionally for Cast irons and Super-alloys.

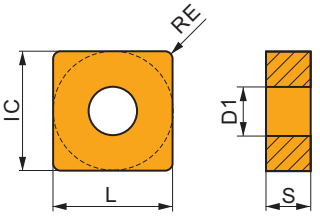
CNMM

	IC (inch)	D1 (inch)	L (inch)	S (inch)
43	.500	.203	.508	.187
54	.625	.250	.634	.250
64	.750	.313	.760	.250
86	1.000	.359	1.016	.375



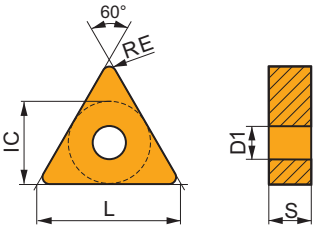
SNMM

	IC (inch)	D1 (inch)	L (inch)	S (inch)
43	.500	.203	.500	.187
54	.625	.250	.625	.250
64	.750	.313	.750	.250
85	1.000	.359	1.000	.313
86	1.000	.359	1.000	.375



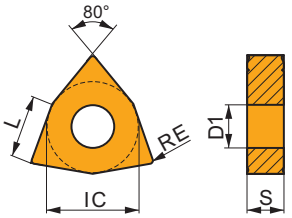
TNMM

	IC (inch)	D1 (inch)	L (inch)	S (inch)
43	.500	.203	.866	.187

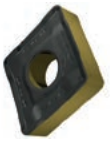
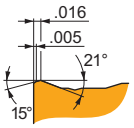


WNMM

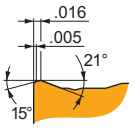
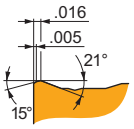
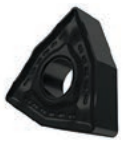
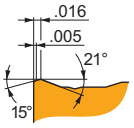
	IC (inch)	D1 (inch)	L (inch)	S (inch)
43	.500	.203	.343	.187



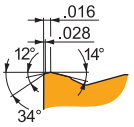
Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our cutting conditions app for further options.

Product		RE (inch)	P vc (ft/min)	P f (in/rev)	P ap (inch)	M vc (ft/min)	M f (in/rev)	M ap (inch)	K vc (ft/min)	K f (in/rev)	K ap (inch)	N vc (ft/min)	N f (in/rev)	N ap (inch)	S vc (ft/min)	S f (in/rev)	S ap (inch)	H vc (ft/min)	H f (in/rev)	H ap (inch)	MID
																					
			NR2 chip breaker is robust and the first choice for heavy roughing of Stainless steels. It features positive rake angle and negative/negative, extra-wide double T-land. It's also suitable for Steels, and conditionally for Cast irons and Super-alloys.																		
CNMM 432-NR2	**T7325**	.031	541	.0157	.197	410	.0142	.197	–	–	–	–	–	–	164	.011	.157	–	–	–	7156233
	T7335	.031	509	.0157	.197	394	.0142	.197	–	–	–	–	–	–	164	.011	.157	–	–	–	6754760
	T8430	.031	492	.0157	.197	262	.0142	.197	410	.0157	.197	–	–	–	98	.011	.157	–	–	–	7977331
	T9325	.031	607	.0157	.197	361	.0142	.197	574	.0157	.197	–	–	–	131	.011	.157	–	–	–	6753913
	T9415	.031	820	.0157	.197	–	–	–	771	.0157	.197	–	–	–	–	–	–	–	–	–	8345532
CNMM 433-NR2	**T7335**	.047	509	.0177	.197	394	.0161	.197	–	–	–	–	–	–	164	.0126	.157	–	–	–	6754762
	T8430	.047	492	.0177	.197	262	.0161	.197	410	.0177	.197	–	–	–	98	.0126	.157	–	–	–	7977334
	T9325	.047	607	.0177	.197	361	.0161	.197	574	.0177	.197	–	–	–	131	.0126	.157	–	–	–	6753916
CNMM 542-NR2	**T8430**	.031	492	.0157	.236	262	.0142	.236	410	.0157	.236	–	–	–	98	.0126	.189	–	–	–	7977335
	T9325	.031	591	.0157	.236	344	.0142	.236	558	.0157	.236	–	–	–	131	.0126	.189	–	–	–	6753918
CNMM 543-NR2	**T7325**	.047	541	.0177	.236	410	.0161	.236	–	–	–	–	–	–	164	.0142	.189	–	–	–	7156237
	T7335	.047	509	.0177	.236	394	.0161	.236	–	–	–	–	–	–	164	.0142	.189	–	–	–	6754764
	T8430	.047	492	.0177	.236	262	.0161	.236	410	.0177	.236	–	–	–	98	.0142	.189	–	–	–	7977336
	T9325	.047	607	.0177	.236	361	.0161	.236	574	.0177	.236	–	–	–	131	.0142	.189	–	–	–	6753921
CNMM 544-NR2	**T7325**	.063	541	.0197	.236	410	.0177	.236	–	–	–	–	–	–	164	.0157	.189	–	–	–	7156238
	T7335	.063	525	.0197	.236	394	.0177	.236	–	–	–	–	–	–	164	.0157	.189	–	–	–	6754765
	T9325	.063	591	.0197	.236	344	.0177	.236	558	.0197	.236	–	–	–	131	.0157	.189	–	–	–	6753923
CNMM 643-NR2	**T7325**	.047	509	.0177	.354	394	.0161	.354	–	–	–	–	–	–	164	.0142	.283	–	–	–	7156239
	T7335	.047	476	.0177	.354	361	.0161	.354	–	–	–	–	–	–	148	.0142	.283	–	–	–	6754766
	T8430	.047	459	.0177	.354	246	.0161	.354	377	.0177	.354	–	–	–	98	.0142	.283	–	–	–	7977338
	T9325	.047	574	.0177	.354	344	.0161	.354	541	.0177	.354	–	–	–	115	.0142	.283	–	–	–	6753927
CNMM 644-NR2	**T7325**	.063	525	.0197	.354	394	.0177	.354	–	–	–	–	–	–	164	.0157	.283	–	–	–	7156240
	T7335	.063	492	.0197	.354	377	.0177	.354	–	–	–	–	–	–	148	.0157	.283	–	–	–	6754767
	T8430	.063	459	.0197	.354	246	.0177	.354	377	.0197	.354	–	–	–	98	.0157	.283	–	–	–	7977340
	T9325	.063	574	.0197	.354	344	.0177	.354	541	.0197	.354	–	–	–	115	.0157	.283	–	–	–	6753930
	T9415	.063	787	.0197	.354	–	–	–	738	.0197	.354	–	–	–	–	–	–	–	–	–	8244260
CNMM 646-NR2	**T7335**	.094	427	.0315	.354	328	.0283	.354	–	–	–	–	–	–	131	.022	.283	–	–	–	6754768
	T9325	.094	492	.0315	.354	295	.0283	.354	459	.0315	.354	–	–	–	98	.022	.283	–	–	–	6753931
CNMM 866-NR2	**T7335**	.094	312	.0315	.472	230	.0283	.472	–	–	–	–	–	–	98	.022	.378	–	–	–	6754769
	T8430	.094	262	.0315	.472	148	.0283	.472	213	.0315	.472	–	–	–	49	.022	.378	–	–	–	7977342
	T9325	.094	328	.0315	.472	197	.0283	.472	312	.0315	.472	–	–	–	66	.022	.378	–	–	–	6754485
	T9415	.094	394	.0315	.472	–	–	–	361	.0315	.472	–	–	–	–	–	–	–	–	–	8345542

Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our cutting conditions app for further options.

Product		RE (inch)	P vc (ft/min)	P f (in/rev)	P ap (inch)	M vc (ft/min)	M f (in/rev)	M ap (inch)	K vc (ft/min)	K f (in/rev)	K ap (inch)	N vc (ft/min)	N f (in/rev)	N ap (inch)	S vc (ft/min)	S f (in/rev)	S ap (inch)	H vc (ft/min)	H f (in/rev)	H ap (inch)	MID
																					
NR2 chip breaker is robust and the first choice for heavy roughing of Stainless steels. It features positive rake angle and negative/negative, extra-wide double T-land. It's also suitable for Steels, and conditionally for Cast irons and Super-alloys.																					
SNMM 432-NR2	**T7325**	.031	574	.0157	.185	443	.0142	.185	–	–	–	–	–	–	180	.0126	.150	–	–	–	7156359
	T7335	.031	558	.0157	.185	427	.0142	.185	–	–	–	–	–	–	180	.0126	.150	–	–	–	6754806
	T8430	.031	541	.0157	.185	295	.0142	.185	443	.0157	.185	–	–	–	115	.0126	.150	–	–	–	7977391
	T9325	.031	640	.0157	.185	377	.0142	.185	607	.0157	.185	–	–	–	131	.0126	.150	–	–	–	6754123
SNMM 433-NR2	**T7335**	.047	541	.0177	.185	410	.0161	.185	–	–	–	–	–	–	164	.0142	.150	–	–	–	6754807
	T8430	.047	541	.0177	.185	295	.0161	.185	443	.0177	.185	–	–	–	115	.0142	.150	–	–	–	7977392
SNMM 543-NR2	**T7335**	.047	541	.0177	.236	410	.0161	.236	–	–	–	–	–	–	164	.0142	.189	–	–	–	6754808
	T8430	.047	541	.0177	.236	295	.0161	.236	443	.0177	.236	–	–	–	115	.0142	.189	–	–	–	7977393
	T9325	.047	640	.0177	.236	377	.0161	.236	607	.0177	.236	–	–	–	131	.0142	.189	–	–	–	6754131
SNMM 544-NR2	**T7335**	.063	541	.0197	.236	410	.0177	.236	–	–	–	–	–	–	164	.0157	.189	–	–	–	6754809
	T9325	.063	623	.0197	.236	361	.0177	.236	591	.0197	.236	–	–	–	131	.0157	.189	–	–	–	6754133
SNMM 643-NR2	**T7335**	.047	525	.0177	.315	394	.0161	.315	–	–	–	–	–	–	164	.0142	.252	–	–	–	6754810
	T9325	.047	623	.0177	.315	361	.0161	.315	591	.0177	.315	–	–	–	131	.0142	.252	–	–	–	6754136
SNMM 644-NR2	**T7325**	.063	574	.0197	.315	443	.0177	.315	–	–	–	–	–	–	180	.0157	.252	–	–	–	7156364
	T7335	.063	525	.0197	.315	394	.0177	.315	–	–	–	–	–	–	164	.0157	.252	–	–	–	6754811
	T8430	.063	509	.0197	.315	279	.0177	.315	427	.0197	.315	–	–	–	98	.0157	.252	–	–	–	7977395
	T9325	.063	607	.0197	.315	361	.0177	.315	574	.0197	.315	–	–	–	131	.0157	.252	–	–	–	6754142
	T9415	.063	853	.0197	.315	–	–	–	804	.0197	.315	–	–	–	–	–	–	–	–	–	8183400
SNMM 646-NR2	**T7325**	.094	509	.0315	.315	394	.0283	.315	–	–	–	–	–	–	164	.022	.252	–	–	–	7156365
	T7335	.094	476	.0315	.315	361	.0283	.315	–	–	–	–	–	–	148	.022	.252	–	–	–	6754812
	T9325	.094	541	.0315	.315	312	.0283	.315	509	.0315	.315	–	–	–	115	.022	.252	–	–	–	6754146
SNMM 856-NR2	**T8430**	.094	279	.0315	.472	148	.0283	.472	230	.0315	.472	–	–	–	49	.022	.378	–	–	–	7977135
	T9325	.094	344	.0315	.472	197	.0283	.472	312	.0315	.472	–	–	–	66	.022	.378	–	–	–	6754150
	T9415	.094	410	.0315	.472	–	–	–	377	.0315	.472	–	–	–	–	–	–	–	–	–	8183401
SNMM 866-NR2	**T7325**	.094	344	.0315	.472	262	.0283	.472	–	–	–	–	–	–	98	.022	.378	–	–	–	7156367
	T7335	.094	328	.0315	.472	246	.0283	.472	–	–	–	–	–	–	98	.022	.378	–	–	–	6754814
	T9325	.094	344	.0315	.472	197	.0283	.472	312	.0315	.472	–	–	–	66	.022	.378	–	–	–	6754154
	T9415	.094	410	.0315	.472	–	–	–	377	.0315	.472	–	–	–	–	–	–	–	–	–	8345589
																					
NR2 chip breaker is robust and the first choice for heavy roughing of Stainless steels. It features positive rake angle and negative/negative, extra-wide double T-land. It's also suitable for Steels, and conditionally for Cast irons and Super-alloys.																					
TNMM 432-NR2	**T9325**	.031	525	.0157	.157	312	.0142	.157	492	.0157	.157	–	–	–	115	.011	.126	–	–	–	6754169
TNMM 433-NR2	**T8430**	.047	459	.0157	.157	246	.0142	.157	377	.0157	.157	–	–	–	98	.0126	.126	–	–	–	7977151
																					
NR2 chip breaker is robust and the first choice for heavy roughing of Stainless steels. It features positive rake angle and negative/negative, extra-wide double T-land. It's also suitable for Steels, and conditionally for Cast irons and Super-alloys.																					
WNMM 432-NR2	**T7335**	.031	525	.0157	.157	394	.0142	.157	–	–	–	–	–	–	164	.011	.126	–	–	–	6754852
WNMM 433-NR2	**T9325**	.047	623	.0177	.157	361	.0161	.157	591	.0177	.157	–	–	–	131	.0126	.126	–	–	–	6754497

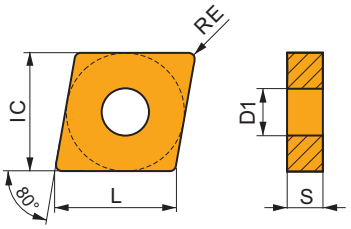
HR



HR chip breaker is robust and designed for heavy roughing of Steels and Cast irons. It features slightly positive rake angle and negative/negative, extra-wide double T-land. It's also conditionally suitable for Stainless steels.

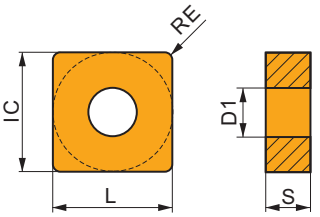
CNMM

	IC (inch)	D1 (inch)	L (inch)	S (inch)
64	.750	.313	.760	.250
86	1.000	.359	1.016	.375



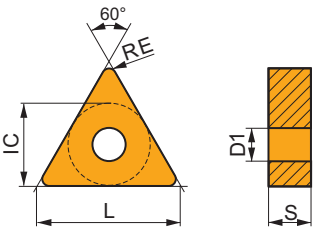
SNMM

	IC (inch)	D1 (inch)	L (inch)	S (inch)
64	.750	.313	.750	.250
85	1.000	.359	1.000	.313
86	1.000	.359	1.000	.375

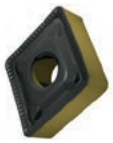
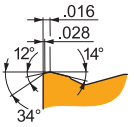
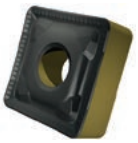
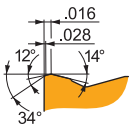
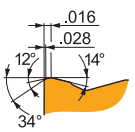


TNMM

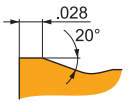
	IC (inch)	D1 (inch)	L (inch)	S (inch)
54	.625	.250	1.083	.250



Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our cutting conditions app for further options.

Product		RE	P						M						K						N						S						H						MID
			vc (ft/min)		f (in/rev)		ap (inch)		vc (ft/min)		f (in/rev)		ap (inch)		vc (ft/min)		f (in/rev)		ap (inch)		vc (ft/min)		f (in/rev)		ap (inch)		vc (ft/min)		f (in/rev)		ap (inch)		vc (ft/min)		f (in/rev)		ap (inch)	
			**HR** chip breaker is robust and designed for heavy roughing of Steels and Cast irons. It features slightly positive rake angle and negative/negative, extra-wide double T-land. It's also conditionally suitable for Stainless steels.																																				
CNMM 644-HR	**6630**	.063	279	.0236	.394		164	.0213	.394		262	.0236	.394	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	6751594
	6640	.063	246	.0236	.394		148	.0213	.394		230	.0236	.394	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	6751586
	T8345	.063	180	.0236	.394		98	.0213	.394		164	.0236	.394	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	6753678
	T9325	.063	344	.0236	.394		197	.0213	.394		312	.0236	.394	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	6753798
	T9335	.063	262	.0236	.394		148	.0213	.394		–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	6754888
CNMM 646-HR	**6630**	.094	295	.0256	.394		164	.0232	.394		279	.0256	.394	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	6751593
	T8345	.094	197	.0256	.394		115	.0232	.394		180	.0256	.394	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	6753679
	T9325	.094	328	.0256	.394		197	.0232	.394		312	.0256	.394	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	6753801
	T9335	.094	279	.0256	.394		164	.0232	.394		–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	6754891
	T9415	.094	394	.0256	.394		–	–	–		361	.0256	.394	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	8183392
CNMM 866-HR	**6630**	.094	279	.0256	.551		164	.0232	.551		262	.0256	.551	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	6751615
	T8345	.094	180	.0256	.551		98	.0232	.551		164	.0256	.551	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	6753681
	T9315	.094	361	.0256	.551		–	–	–		328	.0256	.551	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	6933562
	T9325	.094	328	.0256	.551		197	.0232	.551		312	.0256	.551	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	6753802
	T9335	.094	262	.0256	.551		148	.0232	.551		–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	6754892
	T9415	.094	394	.0256	.551		–	–	–		361	.0256	.551	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	8244262
			**HR** chip breaker is robust and designed for heavy roughing of Steels and Cast irons. It features slightly positive rake angle and negative/negative, extra-wide double T-land. It's also conditionally suitable for Stainless steels.																																				
SNMM 644-HR	**6630**	.063	295	.0236	.354		164	.0213	.354		279	.0236	.354	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	6751613
	T8345	.063	197	.0236	.354		115	.0213	.354		180	.0236	.354	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	6753682
	T9325	.063	361	.0236	.354		213	.0213	.354		328	.0236	.354	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	6754140
	T9335	.063	279	.0236	.354		164	.0213	.354		–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	6754955
SNMM 646-HR	**T9315**	.094	394	.0256	.354		–	–	–		361	.0256	.354	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	6922918
	T9325	.094	377	.0256	.354		213	.0232	.354		344	.0256	.354	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	6754145
	T9415	.094	427	.0256	.354		–	–	–		394	.0256	.354	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	8244295
SNMM 854-HR	**T8345**	.063	197	.0236	.512		115	.0213	.512		180	.0236	.512	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	6753684
	T9325	.063	328	.0236	.512		197	.0213	.512		312	.0236	.512	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	6754148
	T9335	.063	279	.0236	.512		164	.0213	.512		–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	6754960
SNMM 856-HR	**6630**	.094	295	.0256	.512		164	.0232	.512		279	.0256	.512	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	6751562
	6640	.094	262	.0256	.512		148	.0232	.512		246	.0256	.512	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	6751563
	T8345	.094	180	.0256	.512		98	.0232	.512		164	.0256	.512	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	6753685
	T9325	.094	344	.0256	.512		197	.0232	.512		312	.0256	.512	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	6753841
	T9335	.094	279	.0256	.512		164	.0232	.512		–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	6754963
	T9415	.094	410	.0256	.512		–	–	–		377	.0256	.512	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	8345587
SNMM 858-HR	**T9325**	.126	312	.0315	.512		180	.0283	.512		295	.0315	.512	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	6754153
SNMM 866-HR	**6630**	.094	295	.0256	.512		164	.0232	.512		279	.0256	.512	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	6752029
	T8345	.094	180	.0256	.512		98	.0232	.512		164	.0256	.512	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	6753686
	T9325	.094	344	.0256	.512		197	.0232	.512		312	.0256	.512	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	6753842
	T9335	.094	279	.0256	.512		164	.0232	.512		–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	6753298
	T9415	.094	410	.0256	.512		–	–	–		377	.0256	.512	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	8183403
SNMM 868-HR	**T9325**	.126	312	.0315	.512		180	.0283	.512		295	.0315	.512	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	6754157
			**HR** chip breaker is robust and designed for heavy roughing of Steels and Cast irons. It features slightly positive rake angle and negative/negative, extra-wide double T-land. It's also conditionally suitable for Stainless steels.																																				
TNMM 544-HR	**T9325**	.063	295	.0236	.276		164	.0213	.276		279	.0236	.276	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	6754180
	T9335	.063	246	.0236	.276		148	.0213	.276		–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	6754998
TNMM 546-HR	**T9226**	.094	262	.0256	.276		148	.0232	.276		246	.0256	.276	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	6931891

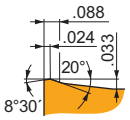
HR2



HR2 chip breaker is robust and designed for heavy roughing of Steels and Cast irons. It features positive rake angle and stable, extra-wide double T-land. It's also conditionally suitable for Stainless steels.

PRAMET

923

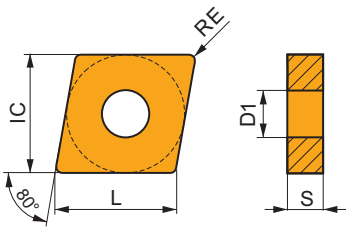


923 chip breaker is robust and designed for heavy roughing of Stainless steels. It features positive rake angle and negative/stable, extra-wide double T-land. It's also conditionally suitable for Steels and Cast irons.

PRAMET

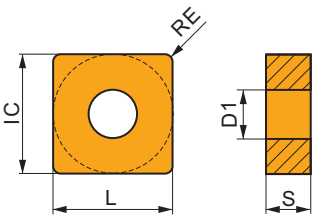
CNMM

	IC (inch)	D1 (inch)	L (inch)	S (inch)
64	.750	.313	.760	.250
86	1.000	.359	1.016	.375

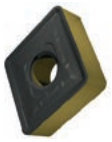
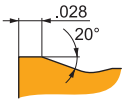
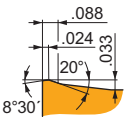
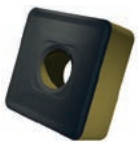
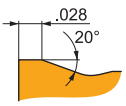
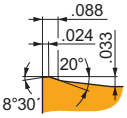


SNMM

	IC (inch)	D1 (inch)	L (inch)	S (inch)
64	.750	.313	.750	.250
85	1.000	.359	1.000	.313
86	1.000	.359	1.000	.375



Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our cutting conditions app for further options.

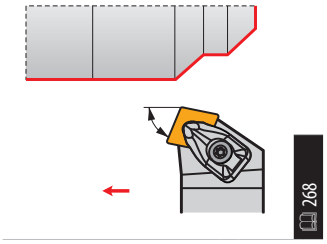
Product		RE (inch)	P vc (ft/min)	P f (in/rev)	P ap (inch)	M vc (ft/min)	M f (in/rev)	M ap (inch)	K vc (ft/min)	K f (in/rev)	K ap (inch)	N vc (ft/min)	N f (in/rev)	N ap (inch)	S vc (ft/min)	S f (in/rev)	S ap (inch)	H vc (ft/min)	H f (in/rev)	H ap (inch)	MID
																					
HR2 chip breaker is robust and designed for heavy roughing of Steels and Cast irons. It features positive rake angle and stable, extra-wide double T-land. It's also conditionally suitable for Stainless steels.																					
CNMM 644-HR2	**T9226**	.063	279	.0256	.394	164	.0232	.394	262	.0256	.394	–	–	–	–	–	–	–	–	–	7036347
	T9335	.063	262	.0256	.394	148	.0232	.394	–	–	–	–	–	–	–	–	–	–	–	–	7036348
	T9415	.063	377	.0256	.394	–	–	–	344	.0256	.394	–	–	–	–	–	–	–	–	–	8345538
CNMM 646-HR2	**T9226**	.094	262	.0335	.394	148	.0303	.394	246	.0335	.394	–	–	–	–	–	–	–	–	–	7036350
	T9415	.094	361	.0335	.394	–	–	–	328	.0335	.394	–	–	–	–	–	–	–	–	–	8345540
CNMM 866-HR2	**T9335**	.094	246	.0335	.472	148	.0303	.472	–	–	–	–	–	–	–	–	–	–	–	–	7015716
	T9415	.094	361	.0335	.472	–	–	–	328	.0335	.472	–	–	–	–	–	–	–	–	–	8244261
																					
923 chip breaker is robust and designed for heavy roughing of Stainless steels. It features positive rake angle and negative/stable, extra-wide double T-land. It's also conditionally suitable for Steels and Cast irons.																					
CNMM 866-923	**T9335**	.094	246	.0335	.472	148	.0303	.472	–	–	–	–	–	–	49	.0236	.378	–	–	–	6754894
CNMM 866S-923	**T8430**	.094	246	.0335	.472	131	.0303	.472	197	.0335	.472	–	–	–	49	.0236	.378	–	–	–	7977344
																					
HR2 chip breaker is robust and designed for heavy roughing of Steels and Cast irons. It features positive rake angle and stable, extra-wide double T-land. It's also conditionally suitable for Stainless steels.																					
SNMM 644-HR2	**T9335**	.063	279	.0256	.350	164	.0232	.350	–	–	–	–	–	–	–	–	–	–	–	–	7036354
	T9415	.063	410	.0256	.350	–	–	–	377	.0256	.350	–	–	–	–	–	–	–	–	–	8345584
SNMM 646-HR2	**T9335**	.094	262	.0335	.350	148	.0303	.350	–	–	–	–	–	–	–	–	–	–	–	–	7036357
	T9415	.094	394	.0335	.350	–	–	–	361	.0335	.350	–	–	–	–	–	–	–	–	–	8244294
SNMM 856-HR2	**T9226**	.094	279	.0335	.433	164	.0303	.433	262	.0335	.433	–	–	–	–	–	–	–	–	–	7015719
	T9335	.094	262	.0335	.433	148	.0303	.433	–	–	–	–	–	–	–	–	–	–	–	–	7015750
SNMM 866-HR2	**T9226**	.094	279	.0335	.433	164	.0303	.433	262	.0335	.433	–	–	–	–	–	–	–	–	–	7015752
	T9315	.094	344	.0335	.433	–	–	–	312	.0335	.433	–	–	–	–	–	–	–	–	–	7015751
	T9335	.094	262	.0335	.433	148	.0303	.433	–	–	–	–	–	–	–	–	–	–	–	–	7015753
	T9415	.094	377	.0335	.433	–	–	–	344	.0335	.433	–	–	–	–	–	–	–	–	–	8183402
SNMM 868-HR2	**T9335**	.126	246	.0394	.433	148	.0354	.433	–	–	–	–	–	–	–	–	–	–	–	–	7036363
																					
923 chip breaker is robust and designed for heavy roughing of Stainless steels. It features positive rake angle and negative/stable, extra-wide double T-land. It's also conditionally suitable for Steels and Cast irons.																					
SNMM 644-923	**T8345**	.063	328	.0256	.350	197	.0232	.350	312	.0256	.350	–	–	–	82	.0205	.280	–	–	–	6753692
	T9335	.063	427	.0256	.350	246	.0232	.350	–	–	–	–	–	–	82	.0205	.280	–	–	–	6754958
SNMM 644S-923	**T8430**	.063	410	.0256	.350	213	.0232	.350	328	.0256	.350	–	–	–	82	.0205	.280	–	–	–	7977397
SNMM 856-923	**T9335**	.094	262	.0335	.433	148	.0303	.433	–	–	–	–	–	–	49	.0236	.346	–	–	–	6754965
SNMM 856S-923	**T8430**	.094	262	.0335	.433	148	.0303	.433	213	.0335	.433	–	–	–	49	.0236	.346	–	–	–	7977399
SNMM 866-923	**T8345**	.094	180	.0335	.433	98	.0303	.433	164	.0335	.433	–	–	–	33	.0236	.346	–	–	–	6753694
	T9226	.094	279	.0335	.433	164	.0303	.433	262	.0335	.433	–	–	–	49	.0236	.346	–	–	–	6931881
	T9335	.094	262	.0335	.433	148	.0303	.433	–	–	–	–	–	–	49	.0236	.346	–	–	–	6754969
SNMM 866S-923	**T8430**	.094	262	.0335	.433	148	.0303	.433	213	.0335	.433	–	–	–	49	.0236	.346	–	–	–	7977401
	T9415	.094	377	.0335	.433	–	–	–	344	.0335	.433	–	–	–	–	–	–	–	–	–	8345591

CN

ISO TURNING – EXTERNAL – NAVIGATOR

DCBN(RL) EXT 75°

CN..



268

DCKN(RL) EXT 75°

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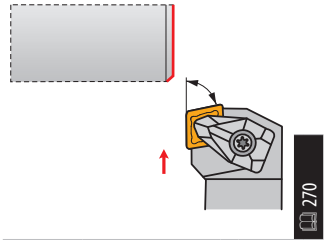

270

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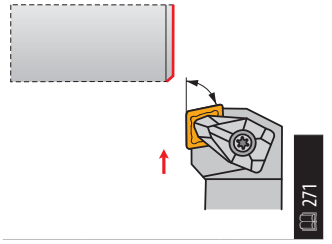

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DCLN(RL) EXT 95°

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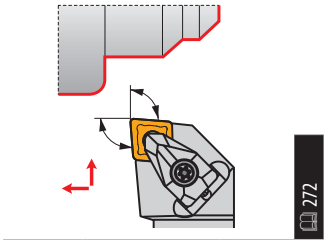

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IDCLN(RL) EXT 95°

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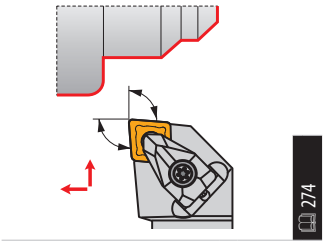

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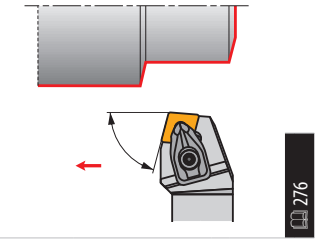
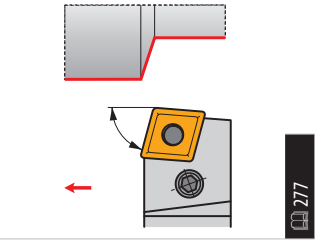


276

PCBN(RL) EXT 75°

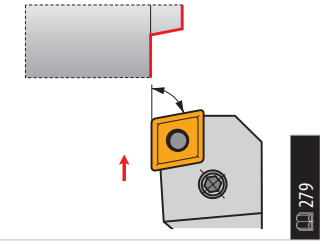
CN..



277

PCKN(RL) EXT 75°

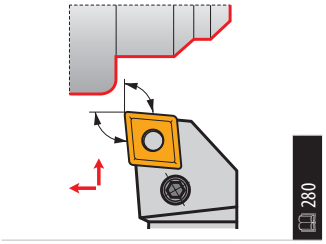
CN..



279

PCLN(RL) EXT 95°

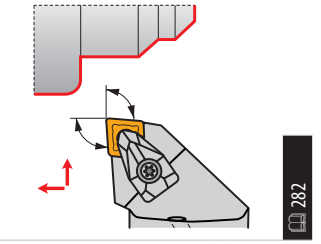
CN..



280

C.-DCLN(RL) EXT 95°

CN..



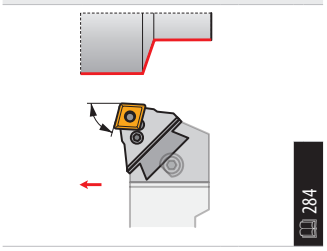
282

CN

ISO TURNING – HEAVY ROUGHING – NAVIGATOR

KHP-CBNR 75°

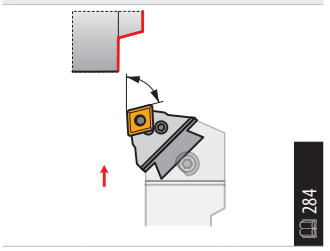
CN..



284

KHP-CBNL 75°

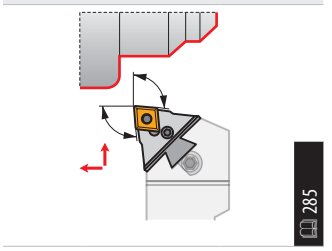
CN..



284

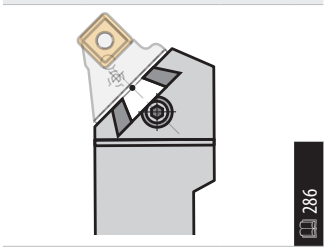
KHP-CLNR 95°

CN..



285

DKH(RL)



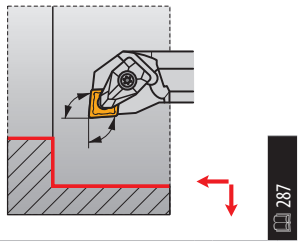
286

CN

ISO TURNING – INTERNAL – NAVIGATOR

DCLN(RL) INT 95°

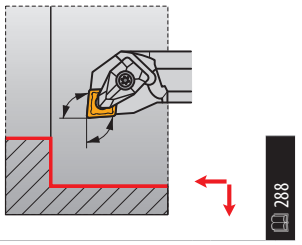
CN..



287

IDCLN(RL) INT 95°

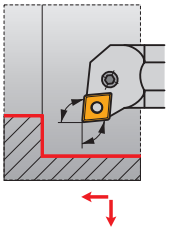
CN..



288

PCLN(RL) INT 95°

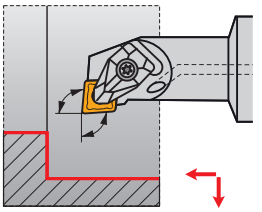
CN..



289

C.-DCLN(RL) INT 95°

CN..



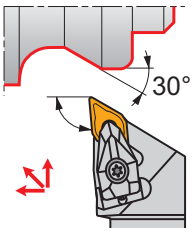
291

DN

ISO TURNING – EXTERNAL – NAVIGATOR

DDJN(RL) EXT 93°

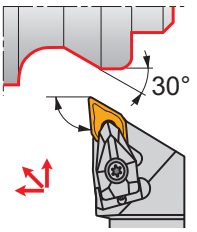
DN..



292

IDDJN(RL) EXT 93°

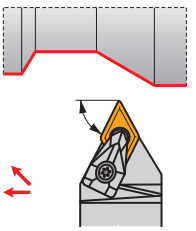
DN..



294

IDDPNN EXT 62,5°

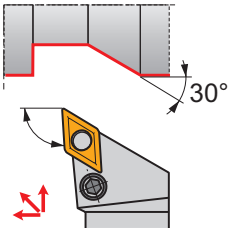
DN..



295

PDJN(RL) EXT 93°

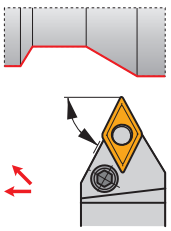
DN..



296

PDNN(RL) EXT 62°30´

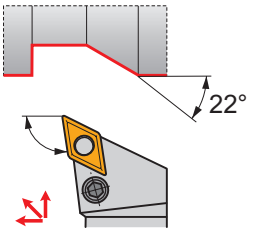
DN..



297

PDXN(RL) EXT 98°

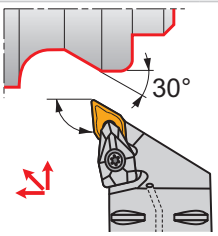
DN..



298

C.-DDJN(RL) EXT 93°

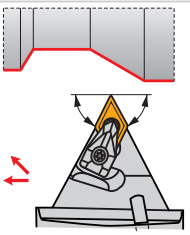
DN..



299

C.-DDNNN EXT 62.5°

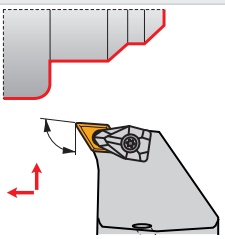
DN..



300

C.-DDUN(RL) EXT 93°

DN..



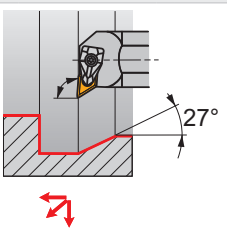
301

DN

ISO TURNING – INTERNAL – NAVIGATOR

DDUN(RL) INT 93°

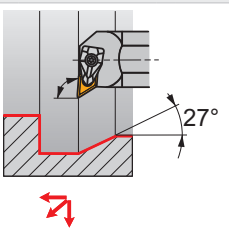
DN..



302

IDDUN(RL) INT 93°

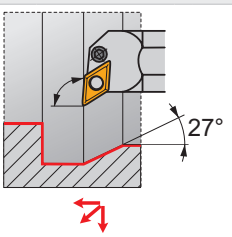
DN..



303

PDUN(RL) INT 93°

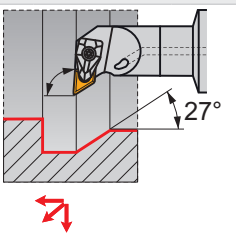
DN..



304

C.-DDUN(RL) INT 93°

DN..

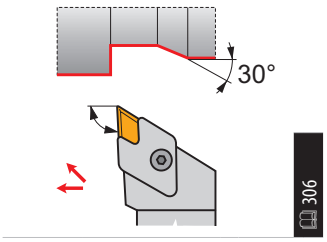


305

KN — ISO TURNING – EXTERNAL – NAVIGATOR

CKJN(RL) EXT 93°

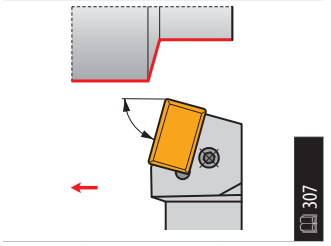
KN..



LN — ISO TURNING – EXTERNAL – NAVIGATOR

PLBN(RL) EXT 75°

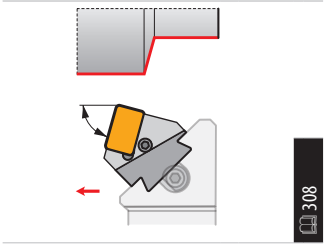
LN..



LN — ISO TURNING – HEAVY ROUGHING – NAVIGATOR

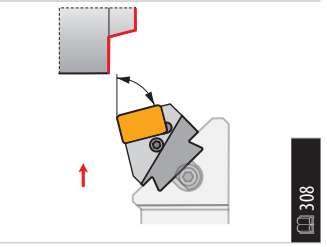
KHP-LBNR 75°

LN..

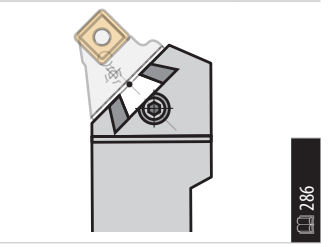


KHP-LBNL 75°

LN..



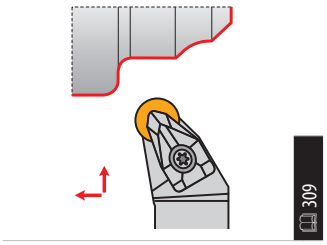
DKH(RL)



RN — ISO TURNING – EXTERNAL – NAVIGATOR

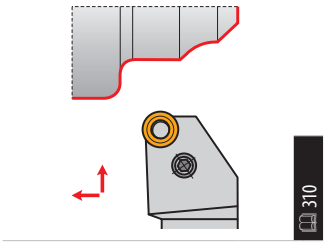
DRSN(RL) EXT

RN..



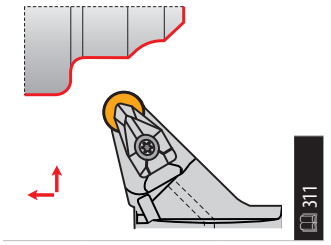
PRSN(RL) EXT

RN..



C.-DRSN(RL) EXT

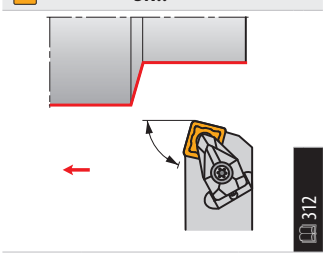
RN..



SN — ISO TURNING – EXTERNAL – NAVIGATOR

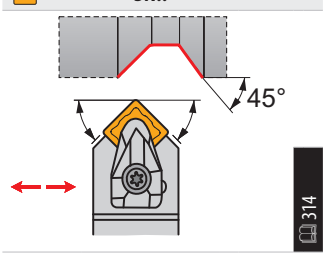
DSBN(RL) EXT 45°

SN..



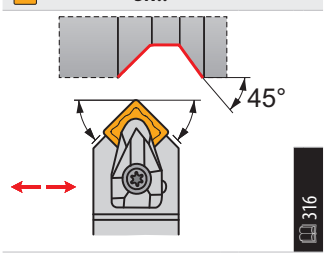
DSDNN EXT 45°

SN..



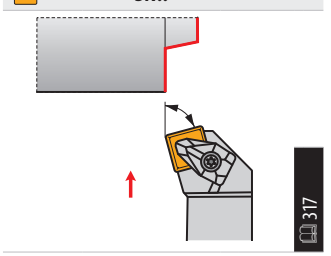
IDSDNN EXT 45°

SN..

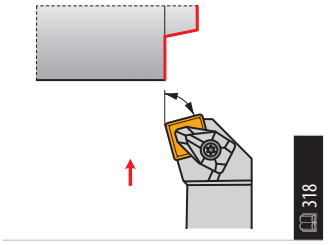


DSKN(RL) EXT 75°

SN..

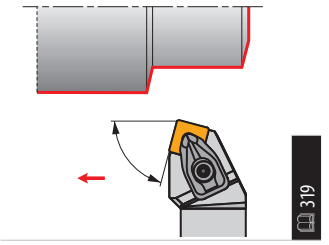


IDSKN(RL) EXT 75°
SN..



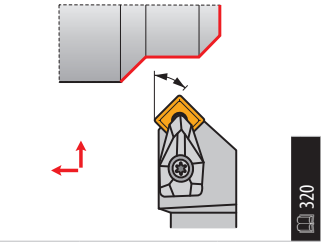
318

IDSRN(RL) EXT 75°
RN..



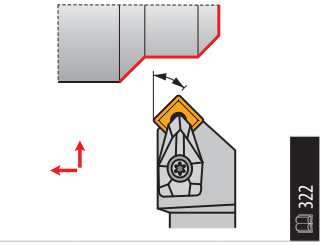
319

DSSN(RL) EXT 45°
SN..



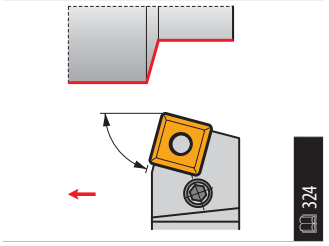
320

IDSSN(RL) EXT 45°
SN..



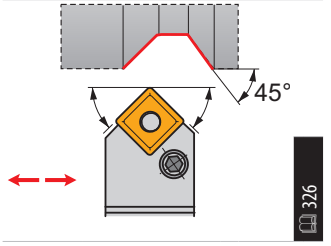
322

PSBN(RL) EXT 75°
SN..



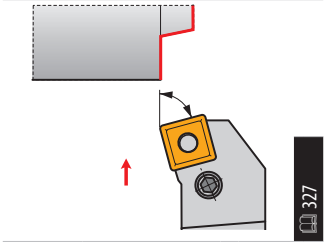
324

PSDNN EXT 45°
SN..



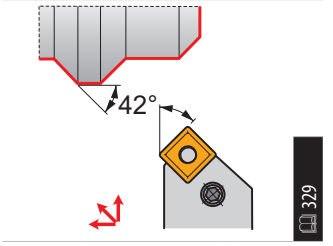
326

PSKN(RL) EXT 75°
SN..



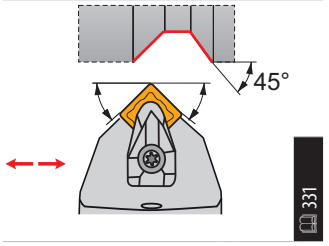
327

PSSN(RL) EXT 45°
SN..



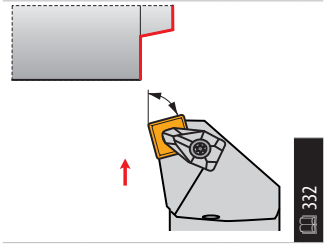
329

C.-DSDNN EXT 45°
SN..



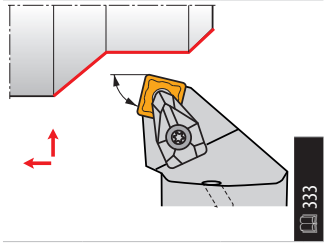
331

C.-DSKN(RL) EXT 75°
SN..



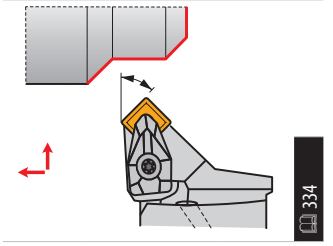
332

C.-DSRN(RL) EXT 75°
SN..



333

C.-DSSN(RL) EXT 45°
SN..

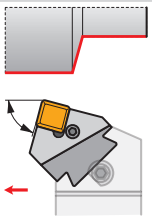


334

SN

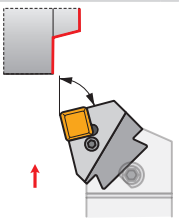
ISO TURNING – HEAVY ROUGHING – NAVIGATOR

KHP-SBNR 75°
SN..



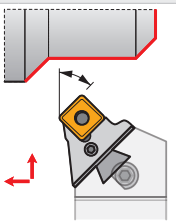
335

KHP-SBNL 75°
SN..



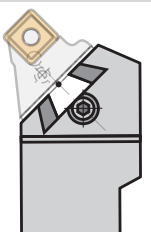
335

KHP-SSNR/L 45°
SN..



336

DKH(RL)

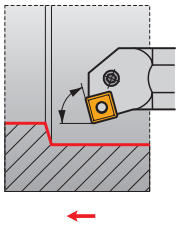


286

SN

ISO TURNING – INTERNAL – NAVIGATOR

PSKN(RL) INT 75°
SN..



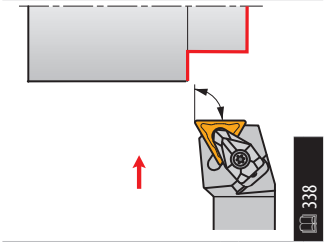
337

TN

ISO TURNING – EXTERNAL – NAVIGATOR

DTFN(RL) EXT 90°

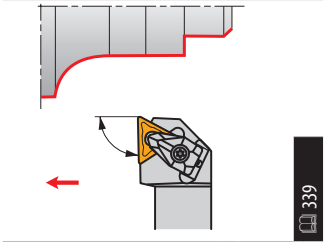
TN..



338

DTGN(RL) EXT 90°

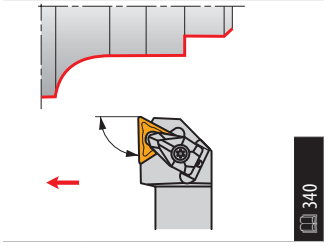
TN..



339

IDTGN(RL) EXT 90°

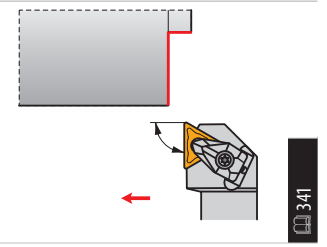
TN..



340

IDTJN(RL) EXT 93°

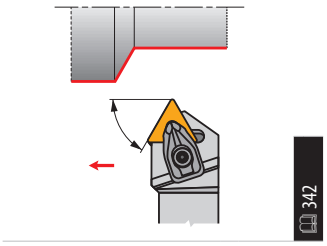
TN..



341

IDTTN(RL) EXT 60°

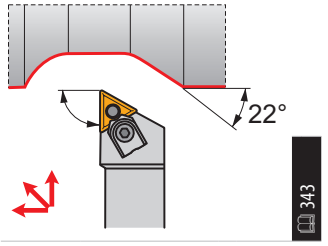
TN..



342

MTJN(RL) EXT 93°

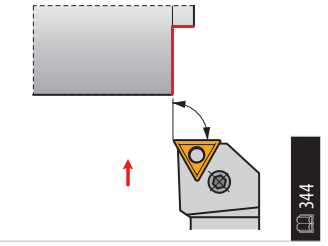
TN..



343

PTFN(RL) EXT 90°

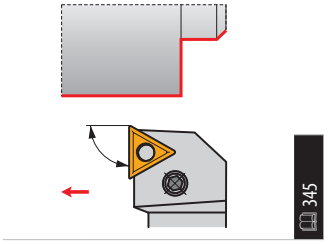
TN..



344

PTGN(RL) EXT 90°

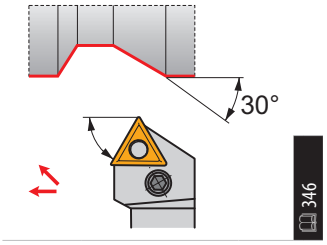
TN..



345

PTTN(RL) EXT 60°

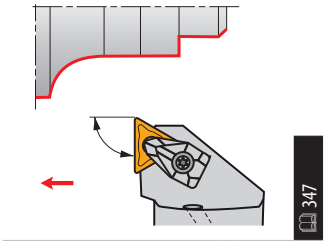
TN..



346

C.-DTJN(RL) EXT 93°

TN..



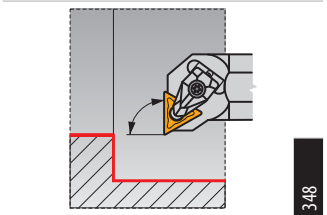
347

TN

ISO TURNING – INTERNAL – NAVIGATOR

DTFN(RL) INT 90°

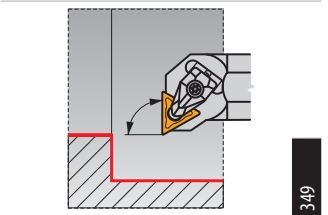
TN..



348

IDTFN(RL) INT 90°

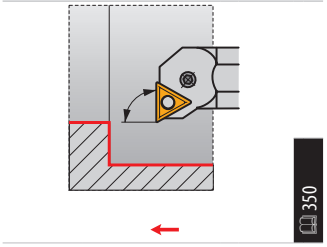
TN..



349

PTFN(RL) INT 90°

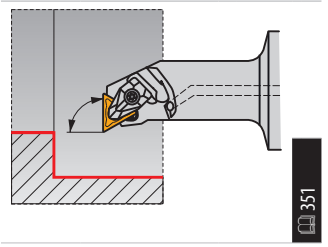
TN..



350

C.-DTFN(RL) INT 91°

TN..



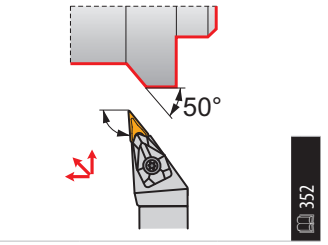
351

VN

ISO TURNING – EXTERNAL – NAVIGATOR

DVJN(RL) EXT 93°

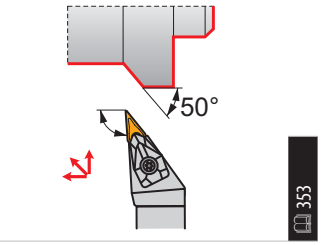
VN..



352

IDVJN(RL) EXT 93°

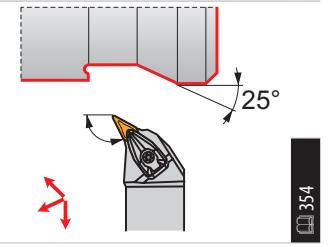
VN..



353

DVPN(RL) EXT 62°30´

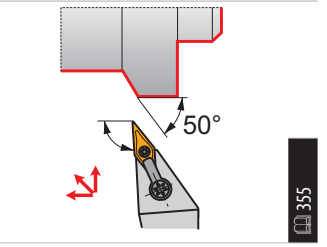
VN..



354

MVJN(RL) EXT 93°

VN..

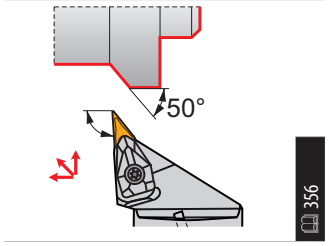


355

VN ISO TURNING – EXTERNAL – NAVIGATOR

C.-DVJN(RL) EXT 93°

VN..

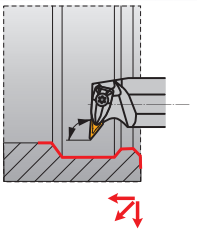


356

VN ISO TURNING – INTERNAL – NAVIGATOR

DVUN(RL) INT

VN..

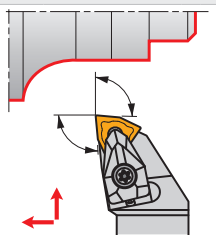


357

WN ISO TURNING – EXTERNAL – NAVIGATOR

DWLN(RL) EXT 95°

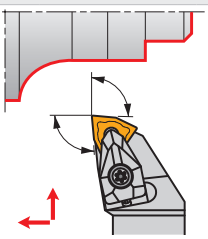
WN..



358

IDWLN(RL) EXT 95°

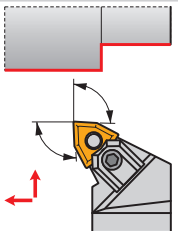
WN..



360

MWLN(RL) EXT 95°

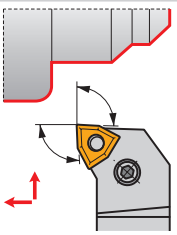
WN..



361

PWLN(RL) EXT 95°

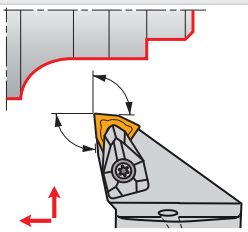
WN..



362

C.-DWLN(RL) EXT 95°

WN..

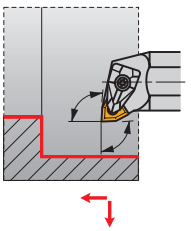


363

WN ISO TURNING – INTERNAL – NAVIGATOR

DWLN(RL) INT 95°

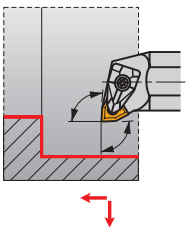
WN..



364

IDWLN(RL) INT 95°

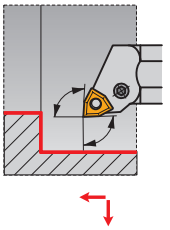
WN..



365

PWLN(RL) INT 95°

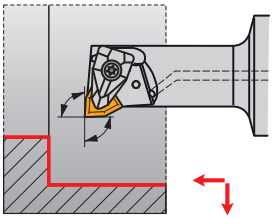
WN..



366

C.-DWLN(RL) INT 95°

WN..



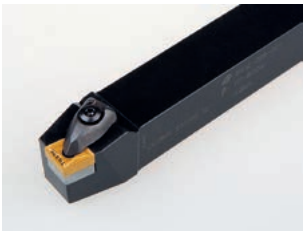
368

DCBN(RL) EXT

P M K N S H

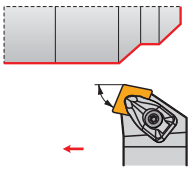
PRAMET

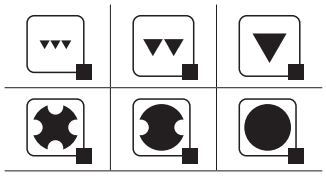
D

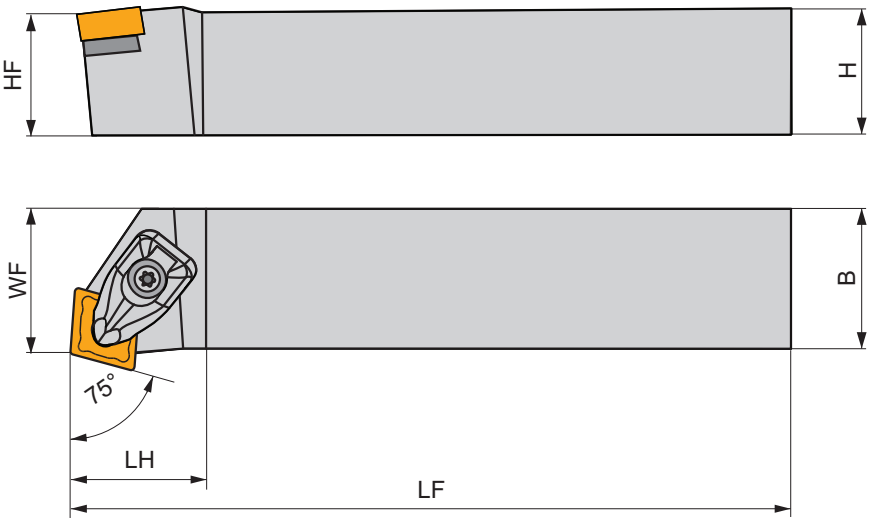


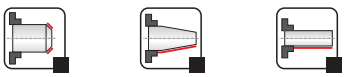
External Double Clamp Turning Holder with 75° Cutting Angle for CN.. Inserts

External Right/Left hand double clamp 75° tool holder. Suited for longitudinal and face turning without shoulder and chamfering with negative CN.. inserts. Body treated for longer tool life.









	Product	H (mm)	B (mm)	HF (mm)	WF (mm)	LF (mm)	LH (mm)	LAMS (°)	GAMO (°)	lbs				MID
R	DCBNR 2020 K 12	20	20	20	17	125	34.2	-6	-6	.95	GI043	DC12	AT001	7028404
	DCBNR 2525 M 12	25	25	25	22	150	34.6	-6	-6	1.68	GI043	DC12	AT001	7028405
	DCBNR 3225 P 12	32	25	32	22	170	34.6	-6	-6	2.40	GI043	DC12	AT001	7028407
	DCBNR 2525 M 16	25	25	25	22	150	41.5	-6	-6	1.75	GI050	DC16	AT005	7028406
	DCBNR 3225 P 16	32	25	32	22	170	32.0	-6	-6	2.36	GI050	DC16	AT005	7028408
	DCBNR 3232 P 19	32	32	32	27	170	46.1	-6	-6	3.06	GI042	DC19	–	7028409
L	DCBNL 2525 M 12	25	25	25	22	150	34.6	-6	-6	1.67	GI043	DC12	AT001	7028368
	DCBNL 3225 P 12	32	25	32	22	170	34.6	-6	-6	2.41	GI043	DC12	AT001	7028400
	DCBNL 2525 M 16	25	25	25	22	150	41.5	-6	-6	1.74	GI050	DC16	AT005	7028369
	DCBNL 3225 P 16	32	25	32	22	170	32.0	-6	-6	2.44	GI050	DC16	AT005	7028401
	DCBNL 3232 P 19	32	32	32	27	170	46.1	-6	-6	3.06	GI042	DC19	–	7028402

GI042	CN.. 64.. (CN.. 1906..)
GI043	CN.. 43.. (CN.. 1204..)
GI050	CN.. 54.. (CN.. 1606..)

		Nm				
DC12	DCS 12	3.9	DCS 234-01	US 2002-T15P	FLAG T15P/3,5	–
DC16	DCS 16	6.4	DCS 234-03	US 2007-T20P	–	LK T20P
DC19	DCS 19	6.4	DCS 236-01	US 2007-T20P	–	LK T20P

AT001a	CN.. 1207..	–	DCS 234-02
AT005a	CN.. 1607..	–	DCS 234-04
AT001b	CER CN.N 1204..	DCS 12C4	–
AT001c	CER CN.A 1204..	DCS 12C2	–
AT005b	CER CN.N 1606..	DCS 16C4	–
AT005c	CER CN.A 1606..	DCS 16C2	–

DCKN(RL) EXT

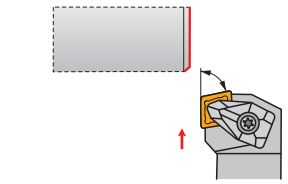
P M K N S H

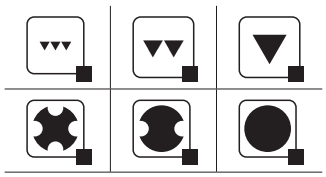
PRAMET

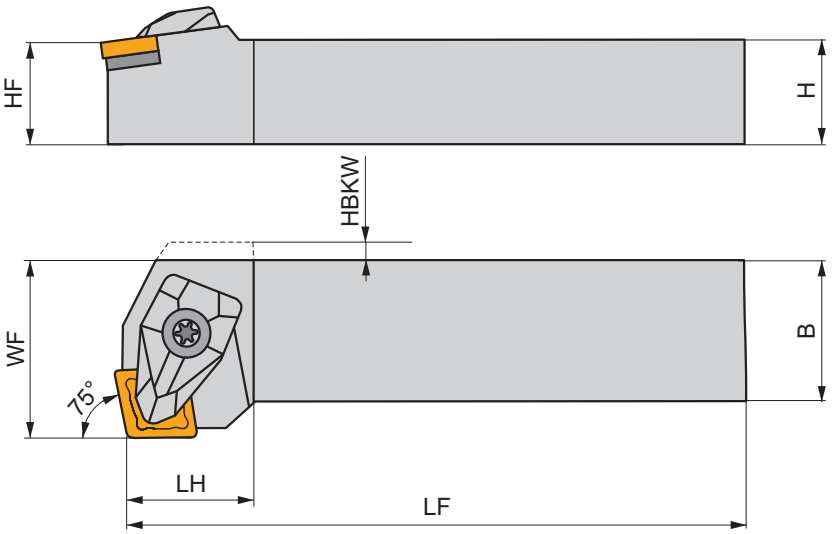
D

External Double Clamp Holder, 75° (Face) Cutting Angle for CN.. Inserts

External Right/Left hand double clamp 75° tool holder. Suited for face turning and occasionally chamfering with negative CN.. inserts. Body treated for longer tool life.







	Product	H (mm)	B (mm)	HF (mm)	WF (mm)	LF (mm)	LH (mm)	HBKW (mm)	LAMS (°)	GAMO (°)	lbs				MID
R	DCKNR 2020 K 12	20	20	20	25	125	21.2	4.5	-6	-6	1.01	GI043	DC12	AT001	7028415
	DCKNR 2525 M 12	25	25	25	32	150	21.1	–	-6	-6	1.76	GI043	DC12	AT001	7028416
	DCKNR 3232 P 16	32	32	32	40	170	26.0	–	-6	-6	3.21	GI050	DC16	AT005	7028418
L	DCKNL 2525 M 12	25	25	25	32	150	21.1	–	-6	-6	1.76	GI043	DC12	AT001	7028412
	DCKNL 3225 P 12	32	25	32	32	170	21.1	–	-6	-6	2.50	GI043	DC12	AT001	7028413
	DCKNL 3232 P 16	32	32	32	40	170	26.0	–	-6	-6	3.20	GI050	DC16	AT005	7028414

GI043	CN.. 43.. (CN.. 1204..)
GI050	CN.. 54.. (CN.. 1606..)

		Nm				
DC12	DCS 12	3.9	DCS 234-01	US 2002-T15P	FLAG T15P/3,5	–
DC16	DCS 16	6.4	DCS 234-03	US 2007-T20P	–	LK T20P

AT001a	CN.. 1207..	–	DCS 234-02
AT005a	CN.. 1607..	–	DCS 234-04
AT001b	CER CN.N 1204..	DCS 12C4	–
AT001c	CER CN.A 1204..	DCS 12C2	–
AT005b	CER CN.N 1606..	DCS 16C4	–
AT005c	CER CN.A 1606..	DCS 16C2	–

IDCKN(RL) EXT

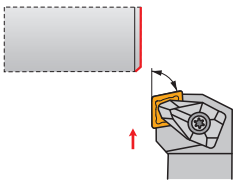
P M K N S H

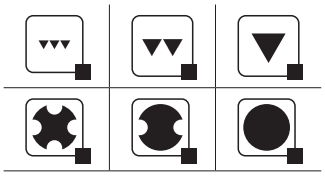
PRAMET

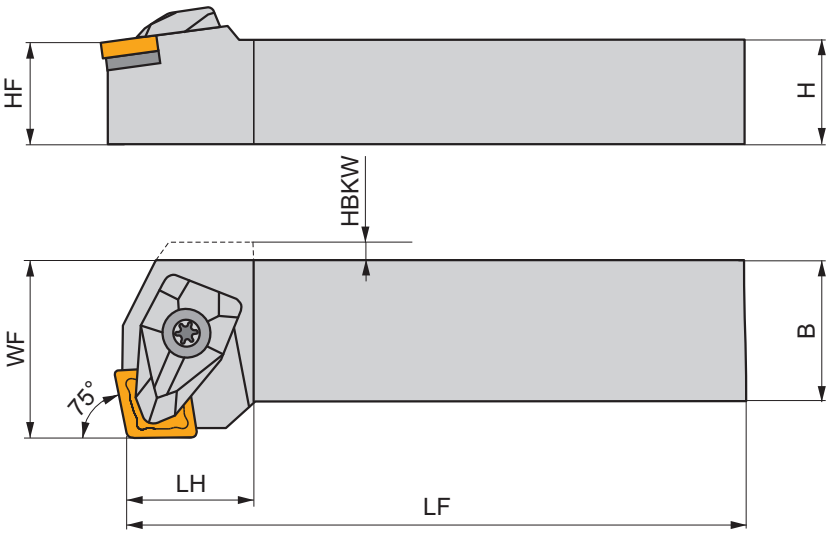
D

External Double Clamp Holder, 75° (Face) Cutting Angle for CN.. Inserts

External Right/Left hand double clamp 75° tool holder. Suited for face turning and occasionally chamfering with negative CN.. inserts. Body treated for longer tool life.







	Product	H (inch)	B (inch)	HF (inch)	WF (inch)	LF (inch)	LH (inch)	HBKW (inch)	LAMS (°)	GAMO (°)	lbs			MID
R	**DCKNR 16 4D**	1.000	1.000	1.000	1.250	6.000	1.300	–	-6	-6	1.76	GI043	DC12	6788545
L	**DCKNL 16 4D**	1.000	1.000	1.000	1.250	6.000	1.300	–	-6	-6	1.54	GI043	DC12	6788544

GI043	CN.. 43.. (CN.. 1204..)

DC12	DCS 12	3.9 Nm	DCS 234-01	US 2002-T15P	FLAG T15P/3,5

DCLN(RL) EXT

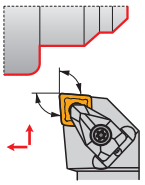
P M K N S H

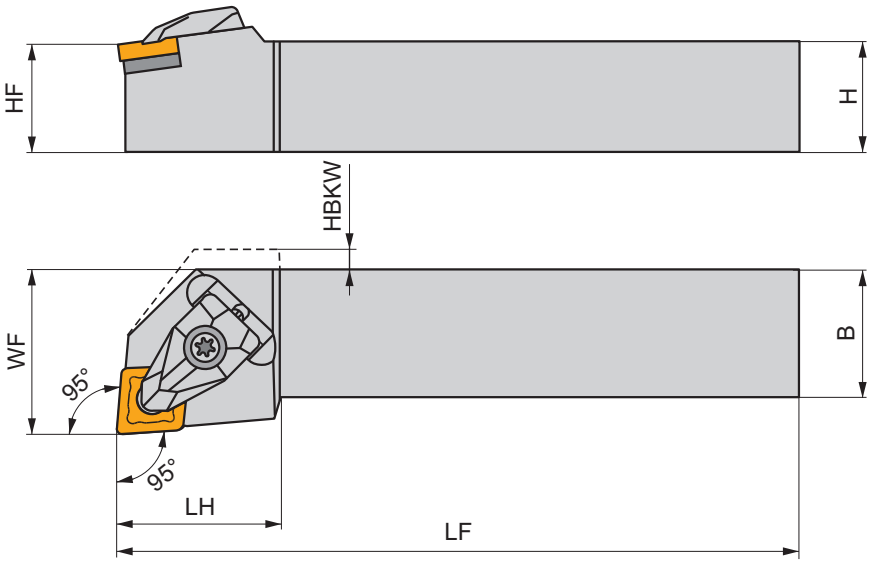
PRAMET

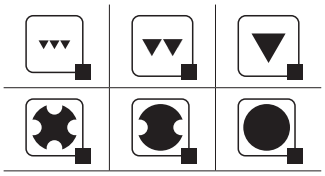
D

External Double Clamp Turning Holder with 95° Cutting Angle for CN.. Inserts

External Right/Left hand double clamp 95° tool holder. Suited for longitudinal turning, chamfering and facing with shoulder, using negative CN.. inserts and. Body treated for longer tool life.







	Product	H (mm)	B (mm)	HF (mm)	WF (mm)	LF (mm)	LH (mm)	HBKW (mm)	LAMS (°)	GAMO (°)	lbs				MID
R	DCLNR 1616 H 09	16	16	16	20	100	25.0	–	-6	-6	.54	GI133	DC09	–	6757916
	DCLNR 2020 K 09	20	20	20	25	125	25.0	–	-6	-6	.96	GI133	DC09	–	6757918
	DCLNR 2525 M 09	25	25	25	32	150	25.0	–	-6	-6	1.69	GI133	DC09	–	6757920
	DCLNR 1616 H 12	16	16	16	20	100	32.3	4.5	-6	-6	.57	GI043	DCI12	AT001	7028422
	DCLNR 2020 K 12	20	20	20	25	125	30.0	–	-6	-6	.97	GI043	DC12	AT001	6757922
	DCLNR 2525 M 12	25	25	25	32	150	30.0	–	-6	-6	1.65	GI043	DC12	AT001	6757924
	DCLNR 3225 P 12	32	25	32	32	170	30.0	–	-6	-6	2.35	GI043	DC12	AT001	6757926
	DCLNR 2525 M 16	25	25	25	32	150	39.0	–	-6	-6	1.78	GI050	DC16	AT005	7028423
	DCLNR 3225 P 16	32	25	32	32	170	35.0	–	-6	-6	2.50	GI050	DC16	AT005	6757928
	DCLNR 3232 P 19	32	32	32	40	170	40.0	–	-6	-6	3.09	GI042	DC19	–	6757930
	DCLNR 4040 S 19	40	40	40	50	250	43.4	–	-6	-6	7.06	GI042	DC19	–	7028424
L	DCLNL 1616 H 09	16	16	16	20	100	24.8	–	-6	-6	.49	GI133	DC09	–	6757917
	DCLNL 2020 K 09	20	20	20	25	125	24.8	–	-6	-6	.93	GI133	DC09	–	6757919
	DCLNL 2525 M 09	25	25	25	32	150	24.8	–	-6	-6	1.68	GI133	DC09	–	6757921
	DCLNL 1616 H 12	16	16	16	20	100	32.2	4.5	-6	-6	.56	GI043	DCI12	AT001	7028419
	DCLNL 2020 K 12	20	20	20	25	125	32.0	–	-6	-6	.97	GI043	DC12	AT001	6757923
	DCLNL 2525 M 12	25	25	25	32	150	32.0	–	-6	-6	1.59	GI043	DC12	AT001	6757925
	DCLNL 3225 P 12	32	25	32	32	170	32.0	–	-6	-6	2.43	GI043	DC12	AT001	6757927
	DCLNL 2525 M 16	25	25	25	32	150	39.0	–	-6	-6	1.79	GI050	DC16	AT005	7028420
	DCLNL 3225 P 16	32	25	32	32	170	39.0	–	-6	-6	2.43	GI050	DC16	AT005	6757929
	DCLNL 3232 P 19	32	32	32	40	170	43.2	–	-6	-6	3.11	GI042	DC19	–	6757931
	DCLNL 4040 S 19	40	40	40	50	250	43.4	–	-6	-6	7.19	GI042	DC19	–	7028421

GI042	CN.. 64.. (CN.. 1906..)
GI043	CN.. 43.. (CN.. 1204..)
GI050	CN.. 54.. (CN.. 1606..)
GI133	CN.. 32.. (CN.. 0903..)

DC09	DCS 09	1.7	DCS 236-04	US 2004-T09P	FLAG T09P	–
DC12	DCS 12	3.9	DCS 234-01	US 2002-T15P	FLAG T15P/3,5	–
DC16	DCS 16	6.4	DCS 234-03	US 2007-T20P	–	LK T20P
DC19	DCS 19	6.4	DCS 236-01	US 2007-T20P	–	LK T20P
DCI12	DCS 12	3.9	DCS 236-03	US 2002-T15P	FLAG T15P/3,5	–

AT001a	CN.. 1207..	–	DCS 234-02
AT005a	CN.. 1607..	–	DCS 234-04
AT001b	CER CN.N 1204..	DCS 12C4	–
AT001c	CER CN.A 1204..	DCS 12C2	–
AT005b	CER CN.N 1606..	DCS 16C4	–
AT005c	CER CN.A 1606..	DCS 16C2	–

IDCLN(RL) EXT

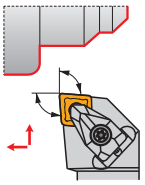
P M K N S H

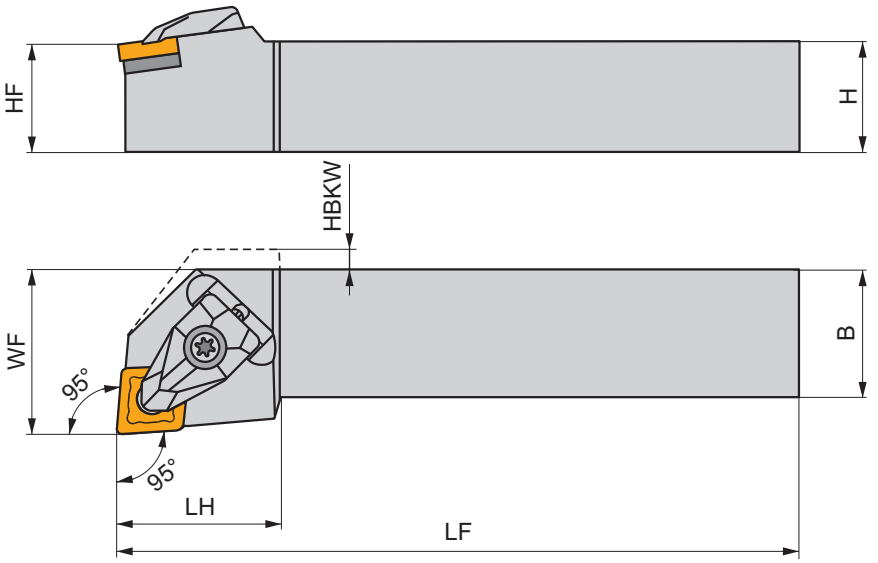
PRAMET

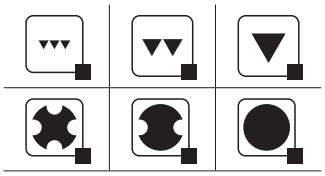
D

External Double Clamp Turning Holder with 95° Cutting Angle for CN.. Inserts

External Right/Left hand double clamp 95° tool holder. Suited for longitudinal turning, chamfering and facing with shoulder, using negative CN.. inserts and. Body treated for longer tool life.







	Product	H (inch)	B (inch)	HF (inch)	WF (inch)	LF (inch)	LH (inch)	HBKW (inch)	LAMS (°)	GAMO (°)	lbs			MID
R	DCLNR 10 3A	.625	.625	.625	.875	4.000	.980	–	-6	-6	.45	GI133	DC09	6788555
	DCLNR 12 3C	.750	.750	.750	1.000	5.000	.980	–	-6	-6	1.05	GI133	DC09	6788556
	DCLNR 12 4B	.750	.750	.750	1.000	4.500	1.260	–	-6	-6	.88	GI043	DC12	6788557
	DCLNR 16 4D	1.000	1.000	1.000	1.250	6.000	1.260	–	-6	-6	1.54	GI043	DC12	6788558
	DCLNR 85 4D	1.250	1.000	1.250	1.500	6.000	1.260	–	-6	-6	4.70	GI043	DC12	6788559
	DCLNR 85 5D	1.250	1.000	1.250	1.500	6.000	1.540	–	-6	-6	4.70	GI050	DC16	6788560
	DCLNR 20 6D	1.250	1.250	1.250	1.500	6.000	1.700	–	-6	-6	2.76	GI042	DC19	6788561
	DCLNR 24 6D	1.500	1.500	1.500	2.000	6.000	1.700	–	-6	-6	4.95	GI042	DC19	6788562
	DCLNR 24 8E	1.500	1.500	1.500	2.000	7.000	2.090	–	-6	-6	6.18	GI062	DC25	6788563
L	DCLNL 10 3A	.625	.625	.625	.875	4.000	.980	–	-6	-6	.45	GI133	DC09	6788546
	DCLNL 12 4B	.750	.750	.750	1.000	4.500	1.260	–	-6	-6	.88	GI043	DC12	6788548
	DCLNL 16 4D	1.000	1.000	1.000	1.250	6.000	1.260	–	-6	-6	1.54	GI043	DC12	6788549
	DCLNL 85 4D	1.250	1.000	1.250	1.500	6.000	1.260	–	-6	-6	4.70	GI043	DC12	6788550
	DCLNL 85 5D	1.250	1.000	1.250	1.500	6.000	1.540	–	-6	-6	4.70	GI050	DC16	6788551
	DCLNL 20 6D	1.250	1.250	1.250	1.500	6.000	1.700	–	-6	-6	2.76	GI042	DC19	6788552
	DCLNL 24 6D	1.500	1.500	1.500	2.000	6.000	1.700	–	-6	-6	4.95	GI042	DC19	6788553

GI042	CN.. 64.. (CN.. 1906..)
GI043	CN.. 43.. (CN.. 1204..)
GI050	CN.. 54.. (CN.. 1606..)
GI062	CN.. 86.. (CN.. 2509..)
GI133	CN.. 32.. (CN.. 0903..)

		Nm				
DC09	DCS 09	1.7	DCS 236-04	US 2004-T09P	FLAG T09P	–
DC12	DCS 12	3.9	DCS 234-01	US 2002-T15P	FLAG T15P/3,5	–
DC16	DCS 16	6.4	DCS 234-03	US 2007-T20P	–	LK T20P
DC19	DCS 19	6.4	DCS 236-01	US 2007-T20P	–	LK T20P
DC25	DCS 25	–	DCS 234-05	US 2008-T25P	–	LK T25P

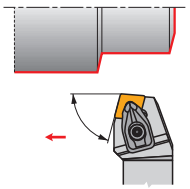
IDCRN(RL) EXT

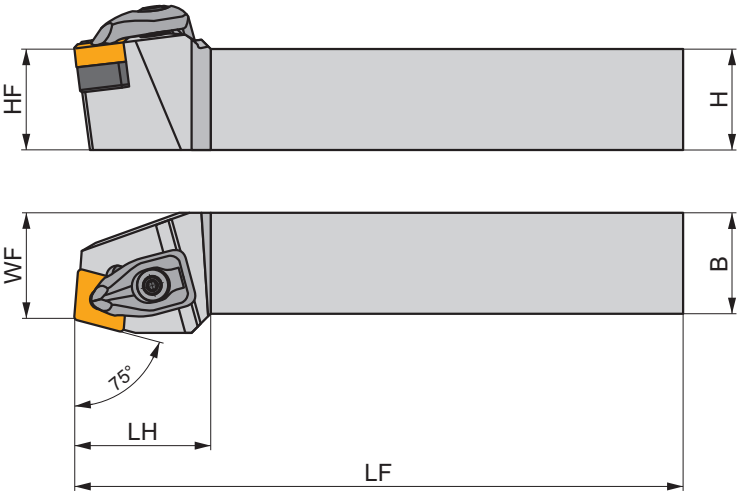
P M K N S H

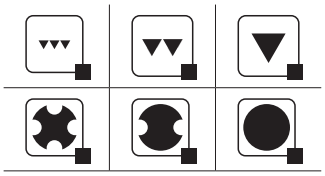
PRAMET

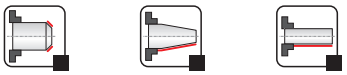
External Double Clamp Holder, 75° Cutting Angle for CN.. Inserts

External Right/Left hand double clamp 75° tool holder. Suited for taper and longitudinal turning and chamfering with negative CN... Body treated for longer tool life.









	Product	H (inch)	B (inch)	HF (inch)	WF (inch)	LF (inch)	LH (inch)	HBKW (inch)	LAMS (°)	GAMO (°)	lbs			MID
R	DCRNR 12 4B	.750	.750	.750	.855	4.500	1.350	–	-6	-6	.88	GI043	DC12	6788538
	DCRNR 16 4D	1.000	1.000	1.000	1.048	6.000	1.350	–	-6	-6	1.54	GI043	DC12	6788539
	DCRNR 20 4D	1.250	1.250	1.250	1.292	6.000	1.350	–	-6	-6	2.76	GI043	DC12	6788540
	DCRNR 20 5D	1.250	1.250	1.250	1.291	6.000	1.640	–	-6	-6	2.43	GI050	DC16	6788541
L	DCRNL 12 4B	.750	.750	.750	.855	4.500	1.350	–	-6	-6	.88	GI043	DC12	6788532
	DCRNL 16 4D	1.000	1.000	1.000	1.048	6.000	1.350	–	-6	-6	1.54	GI043	DC12	6788533
	DCRNL 20 4D	1.250	1.250	1.250	1.292	6.000	1.350	–	-6	-6	2.76	GI043	DC12	6788534
	DCRNL 20 5D	1.250	1.250	1.250	1.291	6.000	1.640	–	-6	-6	2.76	GI050	DC16	6788535

GI043	CN.. 43.. (CN.. 1204..)
GI050	CN.. 54.. (CN.. 1606..)

		Nm				
DC12	DCS 12	3.9	DCS 234-01	US 2002-T15P	FLAG T15P/3,5	–
DC16	DCS 16	6.4	DCS 234-03	US 2007-T20P	–	LK T20P

PCBN(RL) EXT

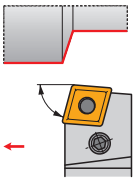
P M K N S H

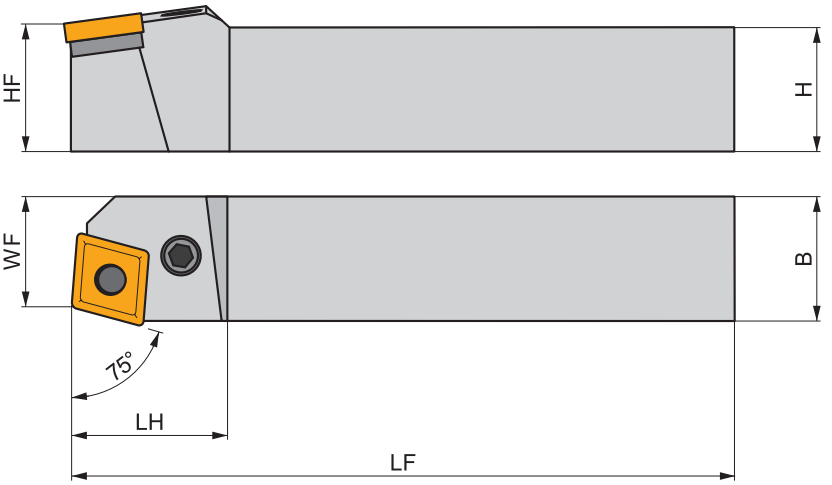
PRAMET

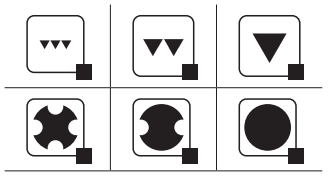
P

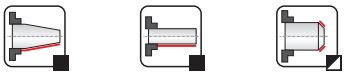
External Lever Lock Turning Holder with 75° Cutting Angle for CN.. Inserts

External Right/Left hand lever lock 75° tool holder. Suited for external chamfering, taper and longitudinal turning without shoulder, using negative CN.. inserts. Body treated for longer tool life.









	Product	H (mm)	B (mm)	HF (mm)	WF (mm)	LF (mm)	LH (mm)	LAMS (°)	GAMO (°)	lbs			MID
R	**PCBNR 2020 K 12**	20	20	20	17	125	28.0	-5	-6	.89	GI043	PC01	6757276
	PCBNR 2525 M 12	25	25	25	22	150	36.0	-6	-6	1.63	GI043	PC01	6756932
	PCBNR 3232 P 16	32	32	32	27	170	34.0	-5	-6	2.96	GI050	PC02	6757041
	PCBNR 3232 P 19	32	32	32	27	170	42.0	-5	-6	2.43	GI042	PC03	6756736
	PCBNR 4040 S 19	40	40	40	35	250	45.0	-6	-6	6.72	GI042	PC03	6758530
	PCBNR 4040 S 25	40	40	40	41	250	48.0	-5	-6	6.81	GI062	PC04	6757128
	PCBNR 5050 T 25	50	50	50	51	300	50.0	-5	-6	12.79	GI062	PC04	6757406
L	**PCBNL 2020 K 12**	20	20	20	17	125	28.0	-5	-6	.84	GI043	PC01	6757322
	PCBNL 2525 M 12	25	25	25	22	150	28.0	-5	-6	1.61	GI043	PC01	6757076
	PCBNL 3232 P 16	32	32	32	27	170	34.0	-5	-6	2.76	GI050	PC02	6757083
	PCBNL 3232 P 19	32	32	32	27	170	42.0	-5	-6	2.43	GI042	PC03	6756742
	PCBNL 4040 S 19	40	40	40	35	250	48.0	-5	-6	6.83	GI042	PC03	6758529
	PCBNL 4040 S 25	40	40	40	41	250	48.0	-5	-6	6.88	GI062	PC04	6757405
	PCBNL 5050 T 25	50	50	50	51	300	50.0	-5	-6	12.79	GI062	PC04	6757407

GI042	CN.. 64.. (CN.. 1906..)
GI043	CN.. 43.. (CN.. 1204..)
GI050	CN.. 54.. (CN.. 1606..)
GI062	CN.. 86.. (CN.. 2509..)

				Nm					
PC01	PCS 612	CL 012	CS 608	3.0	M 8x1	0.815	TR 12	MT 05	HXK 3
PC02	PCS 616	CL 016	CS 618	3.0	M 8x1	0.886	TR 15	MT 07	HXK 3
PC03	PCS 619	CL 019	CS 610	3.5	M 10x1	1.071	TR 19	MT 06	HXK 4
PC04	PCS 625	CL 025	CS 612	4.0	M 12x1	1.417	TR 25	MT 08	HXK 5

PCKN(RL) EXT

P M K N S H

PRAMET

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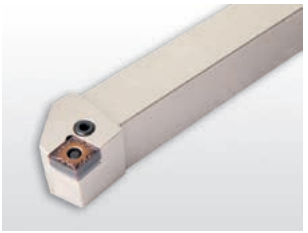
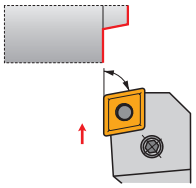
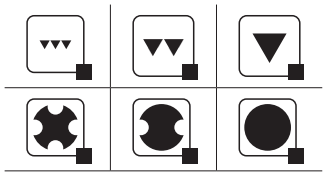
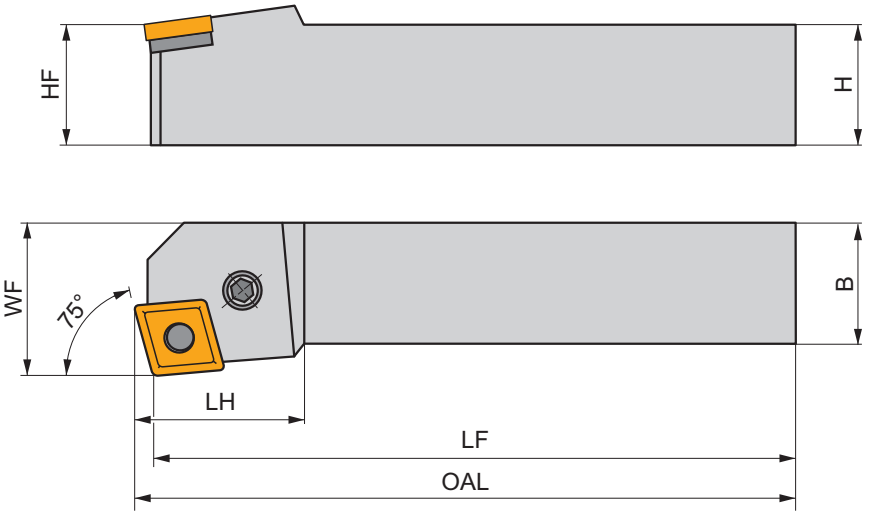


External Lever Lock Holder, 75° (Face Turning) Cutting Angle for CN.. Inserts

External Right/Left hand lever lock 75° tool holder. Suited for external chamfering and face turning with shoulder using negative CN.. inserts. Body treated for longer tool life.







	Product	H (mm)	B (mm)	HF (mm)	WF (mm)	LF (mm)	LH (mm)	LAMS (°)	GAMO (°)	lbs			MID
R	**PCKNR 2020 K 12**	20	20	20	25	125	28.0	-6	-5	.93	GI043	PC01	6757195
	PCKNR 2525 M 12	25	25	25	32	150	28.0	-6	-5	1.69	GI043	PC01	6756777
	PCKNR 3232 P 16	32	32	32	40	170	34.0	-6	-5	3.13	GI050	PC02	6757176
	PCKNR 3232 P 19	32	32	32	40	170	34.0	-6	-5	3.09	GI042	PC03	6757042
	PCKNR 4040 S 19	40	40	40	50	250	45.0	-6	-5	7.17	GI042	PC03	6758532
L	**PCKNL 2020 K 12**	20	20	20	25	125	28.0	-6	-5	.93	GI043	PC01	6757283
	PCKNL 2525 M 12	25	25	25	32	150	28.0	-6	-5	1.70	GI043	PC01	6757084
	PCKNL 3232 P 16	32	32	32	40	170	34.0	-6	-5	3.09	GI050	PC02	6757285
	PCKNL 3232 P 19	32	32	32	40	170	45.0	-6	-6	3.09	GI042	PC03	6757085
	PCKNL 4040 S 19	40	40	40	50	250	45.0	-6	-5	7.21	GI042	PC03	6758531

GI042	CN.. 64.. (CN.. 1906..)
GI043	CN.. 43.. (CN.. 1204..)
GI050	CN.. 54.. (CN.. 1606..)

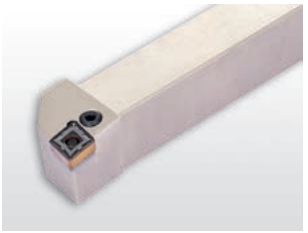
				Nm					
PC01	PCS 612	CL 012	CS 608	3.0	M 8x1	0.815	TR 12	MT 05	HXK 3
PC02	PCS 616	CL 016	CS 618	3.0	M 8x1	0.886	TR 15	MT 07	HXK 3
PC03	PCS 619	CL 019	CS 610	3.5	M 10x1	1.071	TR 19	MT 06	HXK 4

PCLN(RL) EXT

P M K N S H

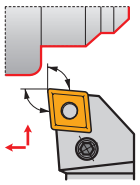
PRAMET

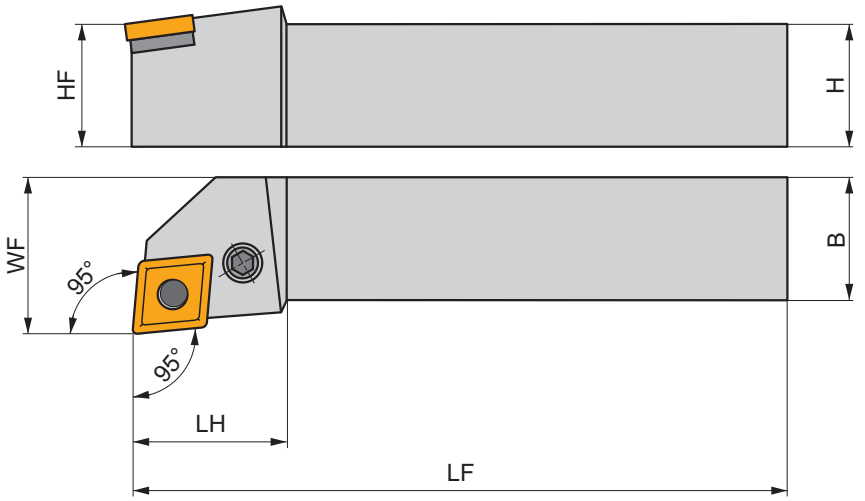
P

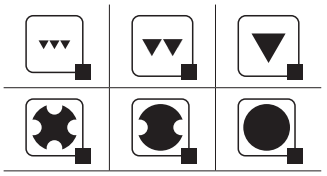


External Lever Lock Turning Holder with 95° Cutting Angle for CN.. Inserts

External Right/Left hand lever lock 95° tool holder. Suited for external taper, face, longitudinal with shoulder turning and chamfering with negative CN.. inserts. Body treated for longer tool life.







	Product	H (mm)	B (mm)	HF (mm)	WF (mm)	LF (mm)	LH (mm)	LAMS (°)	GAMO (°)	lbs			MID
R	PCLNR 2020 K 12	20	20	20	25	125	28.0	-6	-6	.82	GI043	PC01	6757056
	PCLNR 2525 M 12	25	25	25	32	150	28.0	-6	-6	1.50	GI043	PC01	6757057
	PCLNR 3225 P 12	32	25	32	32	170	28.0	-6	-6	2.16	GI043	PC01	6756822
	PCLNR 3225 P 16	32	25	32	32	170	34.0	-6	-6	2.40	GI050	PC02	6756776
	PCLNR 3232 P 19	32	32	32	40	170	45.0	-6	-6	3.03	GI042	PC03	6756900
	PCLNR 4040 S 19	40	40	40	50	250	45.0	-6	-6	6.83	GI042	PC03	6757909
	PCLNR 4040 S 25	40	40	40	50	250	45.0	-6	-6	6.94	GI062	PC04	6756842
	PCLNR 5050 T 25	50	50	50	60	300	50.0	-6	-6	13.01	GI062	PC04	6757143
L	PCLNL 2020 K 12	20	20	20	25	125	28.0	-6	-6	.92	GI043	PC01	6756933
	PCLNL 2525 M 12	25	25	25	32	150	28.0	-6	-6	1.65	GI043	PC01	6756739
	PCLNL 3225 P 12	32	25	32	32	170	28.0	-6	-6	2.35	GI043	PC01	6756740
	PCLNL 3225 P 16	32	25	32	32	170	34.0	-6	-6	2.39	GI050	PC02	6757075
	PCLNL 3232 P 19	32	32	32	40	170	42.0	-6	-6	3.05	GI042	PC03	6756962
	PCLNL 4040 S 19	40	40	40	50	250	45.0	-6	-6	6.97	GI042	PC03	6757910
	PCLNL 4040 S 25	40	40	40	50	250	45.0	-6	-6	6.99	GI062	PC04	6756843
	PCLNL 5050 T 25	50	50	50	60	300	50.0	-6	-6	13.01	GI062	PC04	6757142

GI042	CN.. 64.. (CN.. 1906..)
GI043	CN.. 43.. (CN.. 1204..)
GI050	CN.. 54.. (CN.. 1606..)
GI062	CN.. 86.. (CN.. 2509..)

PC01	PCS 612	CL 012	CS 608	3.0	M 8x1	0.815	TR 12	MT 05	HXK 3
PC02	PCS 616	CL 016	CS 618	3.0	M 8x1	0.886	TR 15	MT 07	HXK 3
PC03	PCS 619	CL 019	CS 610	3.5	M 10x1	1.071	TR 19	MT 06	HXK 4
PC04	PCS 625	CL 025	CS 612	4.0	M 12x1	1.417	TR 25	MT 08	HXK 5

C.-DCLN(RL) EXT

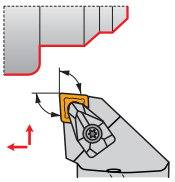
P M K N S H

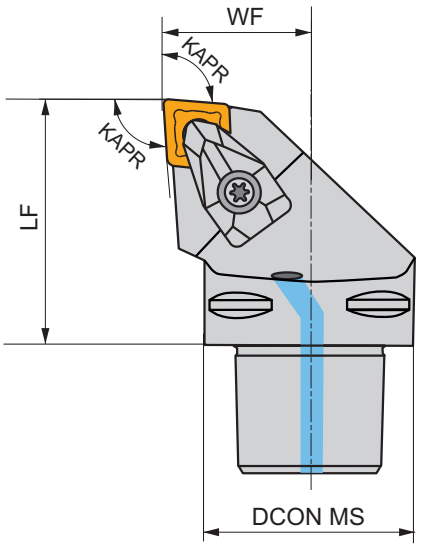
PRAMET

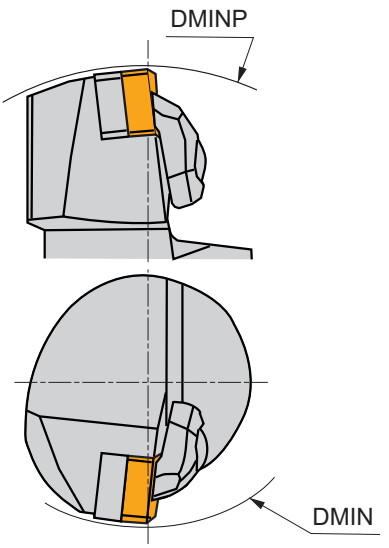
D

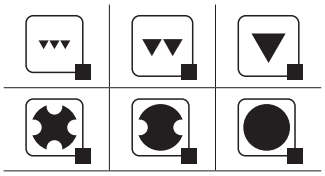
Ext. PSC Quick Change Tool, Double Clamp, 95° Cutting Angle for CN.. Inserts

External Right/Left hand double clamp tool, through coolant, with 95° cutting angle for longitudinal turning, chamfering and face turning with shoulder, using negative CN.. inserts. Polygon Shank Coupling. Body treated for longer tool life.









	Product	DCON MS (mm)	DMIN (mm)	DMINP (mm)	WF (mm)	LF (mm)	KAPR (°)	LAMS (°)	GAMO (°)		lbs				MID
R	C3-DCLNR-22045-12	32	60	121	22	45	95	-6	-6	✓	.56	GI043	C-DC12	AT001	7809762
	C4-DCLNR-27050-12	40	110	140	27	50	95	-6	-6	✓	.96	GI043	C-DC12	AT001	7809764
	C4-DCLNR-27055-16	40	125	145	27	55	95	-6	-6	✓	1.04	GI050	C-DC16	AT005	7809770
	C5-DCLNR-35060-12	50	110	165	35	60	95	-6	-6	✓	1.73	GI043	C-DC12	AT001	7809766
	C5-DCLNR-35060-16	50	125	165	35	60	95	-6	-6	✓	1.76	GI050	C-DC16	AT005	7809772
	C6-DCLNR-45065-12	63	110	190	45	65	95	-6	-6	✓	2.91	GI043	C-DC12	AT001	7809768
	C6-DCLNR-45065-16	63	125	190	45	65	95	-6	-6	✓	2.96	GI050	C-DC16	AT005	7809774
	C6-DCLNR-45065-19	63	81	190	45	65	95	-6	-6	✓	2.95	GI042	C-DC19	–	7809777
	C8-DCLNR-55080-19	80	100	250	55	80	95	-6	-6	✓	5.69	GI042	C-DC19	–	7809779
L	C4-DCLNL-27050-12	40	110	140	27	50	95	-6	-6	✓	.96	GI043	C-DC12	AT001	7809763
	C4-DCLNL-27055-16	40	125	145	27	55	95	-6	-6	✓	1.04	GI050	C-DC16	AT005	7809769
	C5-DCLNL-35060-12	50	110	165	35	60	95	-6	-6	✓	1.73	GI043	C-DC12	AT001	7809765
	C5-DCLNL-35060-16	50	125	165	35	60	95	-6	-6	✓	1.76	GI050	C-DC16	AT005	7809771
	C6-DCLNL-45065-12	63	110	190	45	65	95	-6	-6	✓	2.92	GI043	C-DC12	AT001	7809767
	C6-DCLNL-45065-16	63	125	190	45	65	95	-6	-6	✓	2.95	GI050	C-DC16	AT005	7809773
	C6-DCLNL-45065-19	63	81	190	45	65	95	-6	-6	✓	2.95	GI042	C-DC19	–	7809776
	C8-DCLNL-55080-16	80	125	250	55	80	95	-6	-6	✓	5.68	GI050	C-DC16	AT005	7809775
	C8-DCLNL-55080-19	80	100	250	55	80	95	-6	-6	✓	5.68	GI042	C-DC19	–	7809778

GI042	CN.. 64.. (CN.. 1906..)
GI043	CN.. 43.. (CN.. 1204..)
GI050	CN.. 54.. (CN.. 1606..)

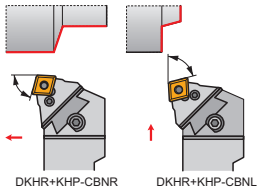
C-DC12	DCS 12	3.9	DCS 234-01	US 2002-T15P	FLAG T15P/3,5	–	CN 045-01
C-DC16	DCS 16	6.4	DCS 234-03	US 2007-T20P	–	LK T20P	CN 045-01
C-DC19	DCS 19	6.4	DCS 236-01	US 2007-T20P	–	LK T20P	CN 045-01

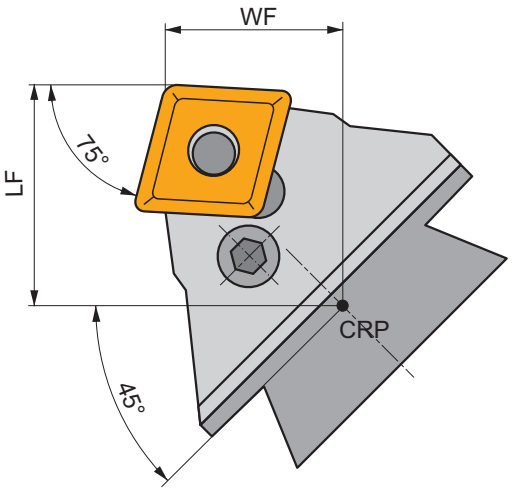
AT001a	CN.. 1207..	–	DCS 234-02
AT005a	CN.. 1607..	–	DCS 234-04
AT001b	CER CN.N 1204..	DCS 12C4	–
AT001c	CER CN.A 1204..	DCS 12C2	–
AT005b	CER CN.N 1606..	DCS 16C4	–
AT005c	CER CN.A 1606..	DCS 16C2	–

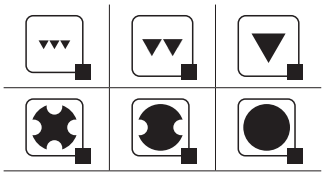
KHP-CBN(RL)

Modular KHP Lever Lock Turning Cartridge, 75° Cutting Angle for CN.. Inserts

Dovetailed Right/Left hand lever lock turning cartridge, 75° cutting angle, for mounting on DKH tool holder shank. Suited for heavy longitudinal turning without shoulder, face turning, taper and chamfer turning with negative CN.. inserts. Tool holder treated for longer tool life.





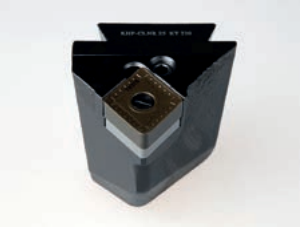


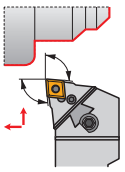
	Product	WF (mm)	LF (mm)	LAMS (°)	GAMO (°)	lbs			MID
R	**KHP-CBNR 25**	32	47	-6	-6	3.40	GI062	PC60	6758293
L	**KHP-CBNL 25**	32	47	-6	-6	3.44	GI062	PC60	6758292

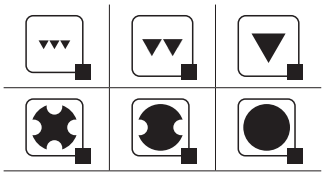
GI062	CN.. 86.. (CN.. 2509..)

PC60	CNU 250620	PU 06	US 39	8.0 Nm	M 10x1	1.299	NT 08	MT 08	HXK 5

KHP-CLN(RL)

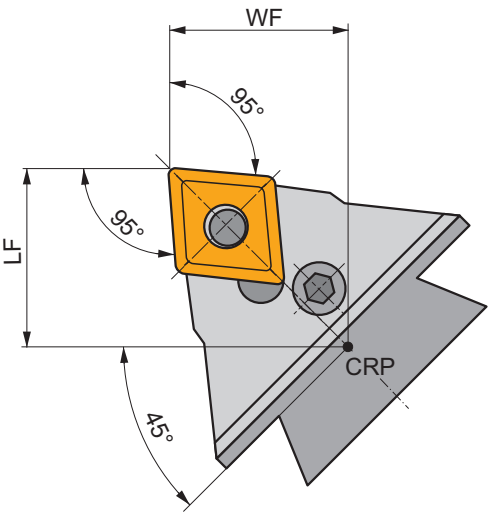


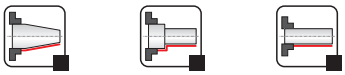




Modular KHP Lever Lock Turning Cartridge, 95° Cutting Angle for CN.. Inserts

Dovetailed Right/Left hand lever lock turning cartridge, 95° cutting angle, for mounting on DKH tool holder shank. Suited for heavy longitudinal turning with shoulder, face turning with shoulder, taper and chamfer turning with negative CN.. insert. Tool holder treated for longer tool life.





	Product	WF (mm)	LF (mm)	LAMS (°)	GAMO (°)	lbs			MID
R	**KHP-CLNR 19**	35	45	-6	-6	3.74	GI042	PC50	6757127
	KHP-CLNR 25	35	45	-6	-6	2.76	GI062	PC60	6758295
L	**KHP-CLNL 19**	35	45	-6	-6	2.87	GI042	PC50	6757221
	KHP-CLNL 25	35	45	-6	-6	2.76	GI062	PC60	6758294

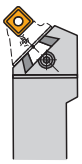
GI042	CN.. 64.. (CN.. 1906..)
GI062	CN.. 86.. (CN.. 2509..)

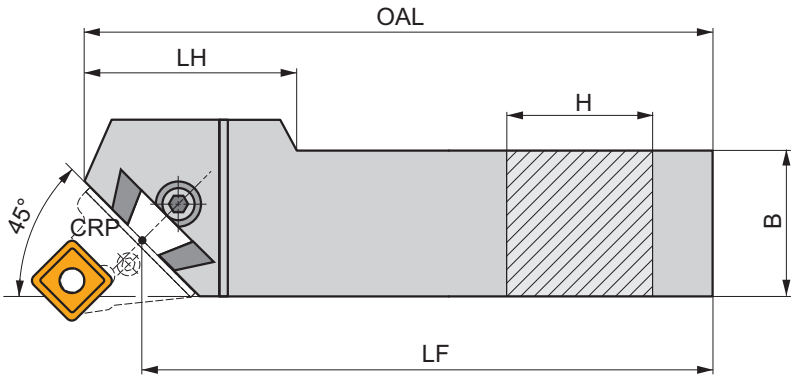
				Nm					
PC50	CNU 190416	PU 05	US 38	8.0	M 10x1	1.142	NT 06	MT 06	HXK 5
PC60	CNU 250620	PU 06	US 39	8.0	M 10x1	1.299	NT 08	MT 08	HXK 5

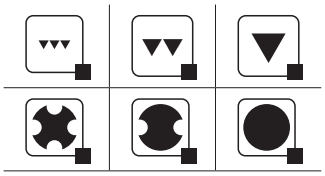
DKH(RL)

External Tool Holder Shank for KHP/KHS Heavy Turning Cartridges

Dovetailed Right/Left hand modular tool shank for KHP/KHS cartridges. Suited for heavy turning applications. Body treated for longer tool life.







	Product	H (mm)	B (mm)	LF (mm)	OAL (mm)	LH (mm)	lbs			MID
R	**DKHR 4050 V**	40	50	400	425	100.0	15.65	GI098	DKH10	6757384
	DKHR 5060 W	50	60	450	475	110.0	24.91	GI098	DKH10	6757219
	DKHR 6080 W-A	60	80	450	485	90.0	43.32	GI098	DKH10	6758501
L	**DKHL 4050 V**	40	50	400	425	100.0	15.65	GI098	DKH10	6757385
	DKHL 5060 W	50	60	450	475	110.0	24.91	GI098	DKH10	6757220
	DKHL 6080 W-A	60	80	450	485	90.0	42.51	GI098	DKH10	6758516

GI098	KHP	KHS

DKH10	SR 14	HXK 10

DCLN(RL) INT

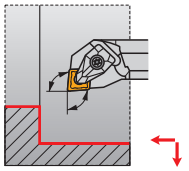
P M K N S H

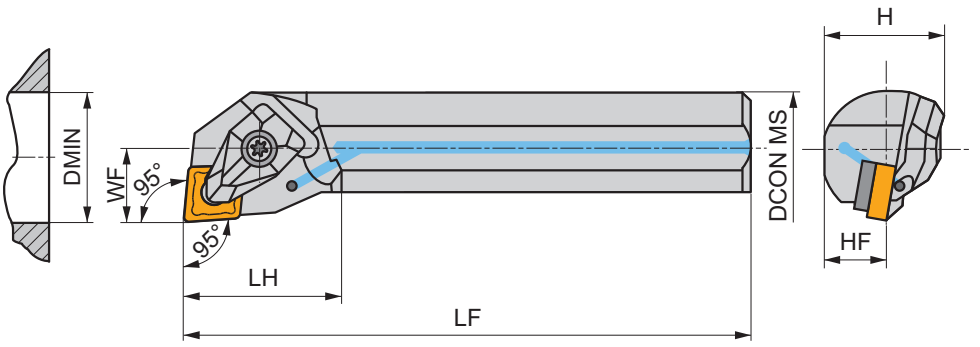
PRAMET

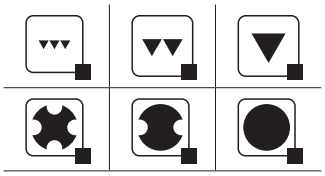
D

Internal Double Clamp Boring Bar with 95° Cutting Angle for CN.. Inserts

Internal Right/Left hand double clamp boring bar, through coolant, 95° cutting angle for CN.. inserts. For internal taper and longitudinal turning with shoulder and chamfer turning. Body treated for longer tool life.







	Product	DCON MS (mm)	DMIN (mm)	WF (mm)	H (mm)	HF (mm)	LF (mm)	LH (mm)	LAMS (°)	GAMO (°)		lbs			MID
R	A25T-DCLNR 09	25	32	17	23	11.5	300	31.0	-11	-6	✓	2.17	GI133	DC09	6758095
	A25T-DCLNR 12	25	32	17	23	11.5	300	31.0	-12	-6	✓	2.16	GI043	DCI12	6758097
	A32T-DCLNR 12	32	40	22	30	15	300	30.0	-10	-6	✓	3.71	GI043	DCI12	7028492
	A40T-DCLNR 12	40	50	27	37	18.5	300	32.0	-15	-6	✓	5.64	GI043	DC12	7028502
L	A25T-DCLNL 09	25	32	17	23	11.5	300	31.0	-11	-6	✓	2.18	GI133	DC09	6758096
	A25T-DCLNL 12	25	32	17	23	11.5	300	31.0	-12	-6	✓	2.16	GI043	DCI12	6758098
	A32T-DCLNL 12	32	40	22	30	15	300	30.0	-10	-6	✓	3.70	GI043	DCI12	7028491
	A40T-DCLNL 12	40	50	27	37	18.5	300	32.0	-15	-6	✓	5.62	GI043	DC12	7028501

GI043	CN.. 43.. (CN.. 1204..)
GI133	CN.. 32.. (CN.. 0903..)

		Nm			
DC09	DCS 09	1.7	DCS 236-04	US 2004-T09P	FLAG T09P
DC12	DCS 12	3.9	DCS 234-01	US 2002-T15P	FLAG T15P/3,5
DCI12	DCS 12	3.9	DCS 236-03	US 2002-T15P	FLAG T15P/3,5

IDCLN(RL) INT

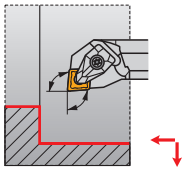
P M K N S H

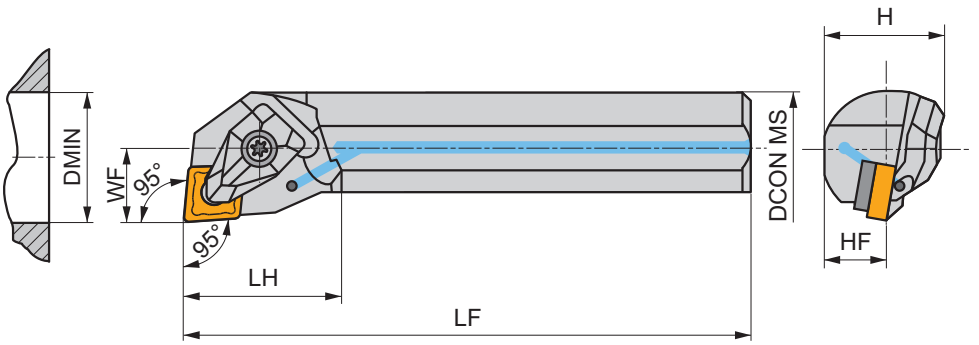
PRAMET

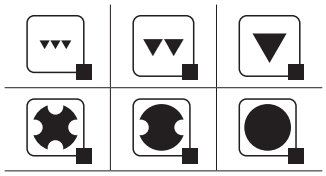
D

Internal Double Clamp Boring Bar with 95° Cutting Angle for CN.. Inserts

Internal Right/Left hand double clamp boring bar, through coolant, 95° cutting angle for CN.. inserts. For internal taper and longitudinal turning with shoulder and chamfer turning. Body treated for longer tool life.







	Product	DCON MS (inch)	DMIN (inch)	WF (inch)	H (inch)	HF (inch)	LF (inch)	LH (inch)	LAMS (°)	GAMO (°)		lbs			MID
R	A12S-DCLNR 3	.750	1.000	.500	.709	.355	10.000	1.024	-14	-6	✓	1.21	GI133	DC09	6788467
	A16T-DCLNR 4	1.000	1.280	.640	.906	.453	12.000	1.339	-12	-6	✓	1.54	GI043	DCI12	6788479
	A20T-DCLNR 4	1.250	1.468	.765	1.181	.591	12.000	1.299	-11	-6	✓	3.08	GI043	DCI12	6788493
	A24T-DCLNR 4	1.500	1.760	.890	1.374	.687	12.000	1.575	-16	-6	✓	5.14	GI043	DCI12	6788506
L	A12S-DCLNL 3	.750	1.000	.500	.709	.355	10.000	1.024	-14	-6	✓	1.21	GI133	DC09	6788466
	A16T-DCLNL 4	1.000	1.280	.640	.906	.453	12.000	1.339	-12	-6	✓	1.54	GI043	DCI12	6788478
	A20T-DCLNL 4	1.250	1.468	.765	1.181	.591	12.000	1.299	-11	-6	✓	3.08	GI043	DCI12	6788492
	A24T-DCLNL 4	1.500	1.760	.890	1.374	.687	12.000	1.575	-16	-6	✓	8.25	GI043	DCI12	6788504
	A24T-DCLNL 5	1.500	1.760	.890	1.374	.687	12.000	1.575	-18	-6	✓	8.25	GI050	DC16	6788505

GI043	CN.. 43.. (CN.. 1204..)
GI050	CN.. 54.. (CN.. 1606..)
GI133	CN.. 32.. (CN.. 0903..)

		Nm				
DC09	DCS 09	1.7	DCS 236-04	US 2004-T09P	FLAG T09P	–
DC16	DCS 16	6.4	DCS 234-03	US 2007-T20P	–	LK T20P
DCI12	DCS 12	3.9	DCS 236-03	US 2002-T15P	FLAG T15P/3,5	–

PCLN(RL) INT

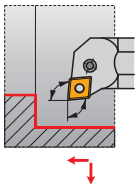
P M K N S H

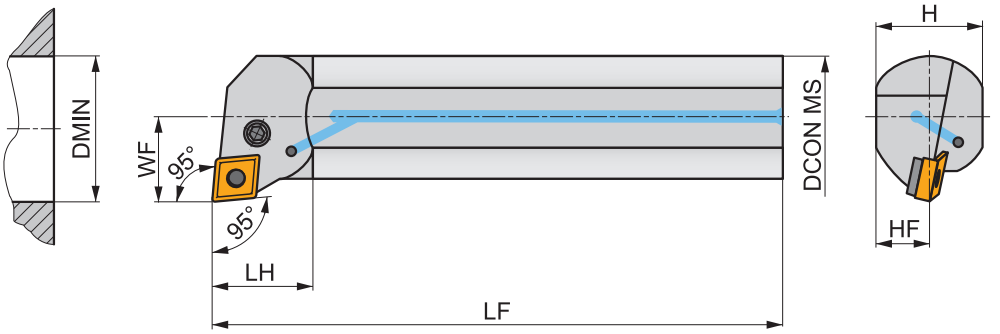
PRAMET

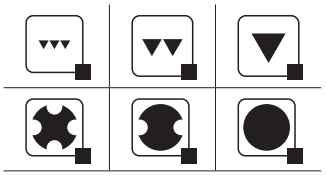
P

Internal Lever Lock Boring Bar with 95° Cutting Angle for CN.. Inserts

Internal Right/Left hand lever lock boring bar, through coolant available, 95° cutting angle for CN.. inserts. For internal taper and longitudinal turning with shoulder and chamfer turning. Body treated for longer tool life.







	Product	DCON MS (mm)	DMIN (mm)	WF (mm)	H (mm)	B (mm)	LF (mm)	LAMS (°)	GAMO (°)		lbs			MID
R	A16M-PCLNR 09	16	20	11	15	15.01	150	-14	-4	✓	.49	GI133	PC05	6761030
	A20Q-PCLNR 09	20	25	13	18	18	180	-13.5	-5	✓	.73	GI133	PC05	6761032
	A25R-PCLNR 12	25	31	17	23	23.01	200	-14	-4	–	1.54	GI043	PC06	6756938
	A32S-PCLNR 12	32	39	22	30	30	250	-12	-4	✓	3.09	GI043	PC07	6757246
	A40T-PCLNR 12	40	48	27	37	38	300	-12	-4	✓	5.29	GI043	PC01	6757112
	A40T-PCLNR 16	40	48	27	37	38	300	-12	-4	✓	5.84	GI050	PC02	6757122
	A50U-PCLNR 16	50	63	35	47	48.5	350	-12	-6	✓	11.46	GI050	PC02	6757315
	A60V-PCLNR 16	60	80	43	57	58.5	400	-12	-4	✓	19.18	GI050	PC02	6757324
	A50U-PCLNR 19	50	63	35	47	48.5	350	-12	-6	✓	11.46	GI042	PC08	6757228
	A60V-PCLNR 19	60	80	43	57	58.5	400	-11	-6	✓	18.13	GI042	PC08	6757336
L	A16M-PCLNL 09	16	20	11	15	15.01	150	-14	-4	✓	.44	GI133	PC05	6761029
	A20Q-PCLNL 09	20	25	13	18	18.01	180	-13	-4	–	.74	GI133	PC05	6761031
	A25R-PCLNL 12	25	31	17	23	23.01	200	-14	-4	✓	1.43	GI043	PC06	6757106
	A32S-PCLNL 12	32	39	22	30	30	250	-12	-4	✓	3.09	GI043	PC07	6757252
	A40T-PCLNL 12	40	50	27	38	38	300	-12	-6	✓	5.69	GI043	PC01	6757141
	A40T-PCLNL 16	40	48	27	37	38	300	-12	-4	✓	5.68	GI050	PC02	6757325
	A50U-PCLNL 16	50	61	35	47	48.49	350	-12	-4	✓	10.92	GI050	PC02	6757326
	A60V-PCLNL 16	60	80	43	57	58.5	400	-12	-4	✓	19.18	GI050	PC02	6757327

GI042	CN.. 64.. (CN.. 1906..)
GI043	CN.. 43.. (CN.. 1204..)

GI050	CN.. 54.. (CN.. 1606..)
GI133	CN.. 32.. (CN.. 0903..)

PC01	PCS 612	CL 012	CS 608	3.0	M 8x1	0.815	TR 12	MT 05	HXK 3
PC02	PCS 616	CL 016	CS 618	3.0	M 8x1	0.886	TR 15	MT 07	HXK 3
PC05	–	CL 005	CS 605	1.4	M 5x1	0.472	–	–	HXK 2
PC07	PCS 612	CL 312	CS 648	3.0	M 8x1	0.669	TR 12	MT 05	HXK 3
PC06	–	CL 212	CS 626	2.0	M 6x1	0.528	–	–	HXK 2.5
PC08	PCS 619	CL 219	CS 610	3.5	M 10x1	1.071	TR 29	MT 06	HXK 4

C.-DCLN(RL) INT

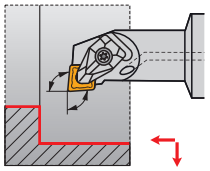
P M K N S H

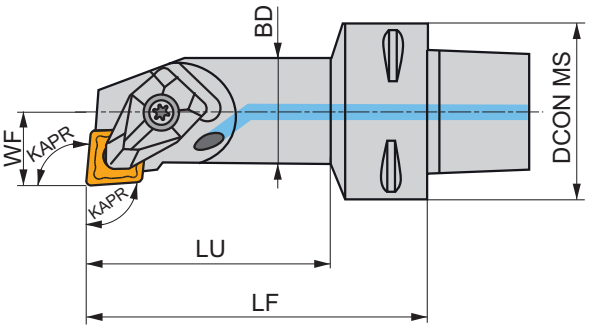
PRAMET

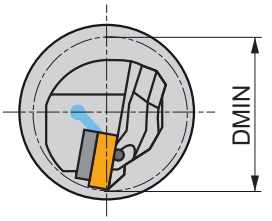
D

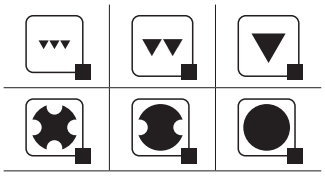
Int. PSC Quick Change Tool, Double Clamp, 95° Cutting Angle for CN.. Inserts

Internal Right/Left hand double clamp tool, through coolant, with 95° cutting angle for negative CN.. inserts. Suited for a wide range of internal turning applications. Polygon Shank Coupling with choice of lengths. Body treated for longer tool life.









	Product	DCON MS (mm)	DMIN (mm)	WF (mm)	LF (mm)	LU (mm)	BD (mm)	KAPR (°)	LAMS (°)	GAMO (°)		lbs			MID
R	C4-DCLNR-13080-09	40	25	13	80	57	20	95	-14	-6	✓	.94	GI133	DC09	7809861
	C4-DCLNR-17090-12	40	32	17	90	68	25	95	-12	-6	✓	1.16	GI043	DCI12	7809863
	C5-DCLNR-17090-12	50	32	17	90	66	25	95	-12	-6	✓	1.59	GI043	DCI12	7809865
	C6-DCLNR-17100-12	63	32	17	100	72	25	95	-12	-6	✓	2.53	GI043	DCI12	7809866
	C6-DCLNR-27140-16	63	50	27	140	114	40	95	-16	-6	✓	3.98	GI050	DC16	7809867
L	C4-DCLNL-17090-12	40	32	17	90	68	25	95	-12	-6	✓	1.16	GI043	DCI12	7809862
	C5-DCLNL-17090-12	50	32	17	90	66	25	95	-12	-6	✓	1.59	GI043	DCI12	7809864

GI043	CN.. 43.. (CN.. 1204..)
GI050	CN.. 54.. (CN.. 1606..)
GI133	CN.. 32.. (CN.. 0903..)

		Nm				
DC09	DCS 09	1.7	DCS 236-04	US 2004-T09P	FLAG T09P	–
DC16	DCS 16	6.4	DCS 234-03	US 2007-T20P	–	LK T20P
DCI12	DCS 12	3.9	DCS 236-03	US 2002-T15P	FLAG T15P/3,5	–

DDJN(RL) EXT

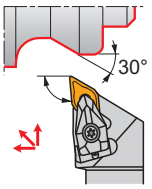
P M K N S H

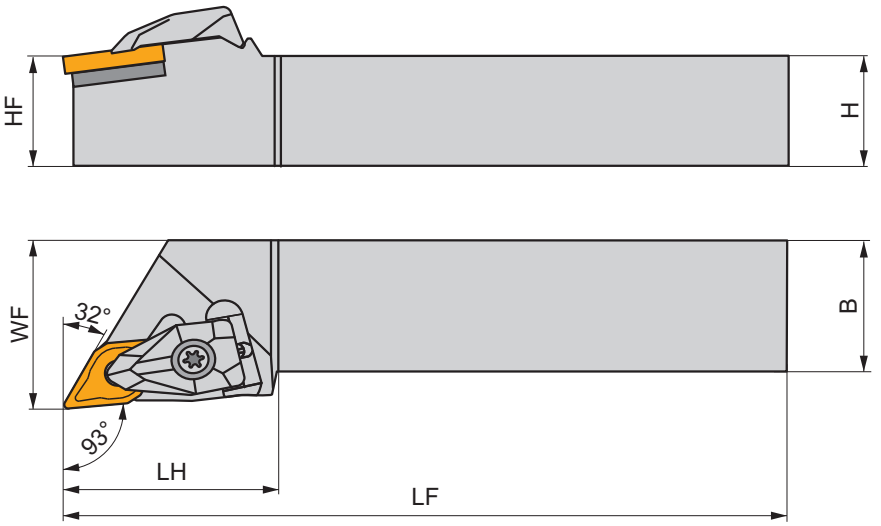
PRAMET

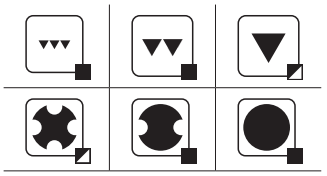
D

External Double Clamp Turning Holder with 93° Cutting Angle for DN.. Inserts

External Right/Left hand double clamp tool holder with 93° cutting angle. Suited for longitudinal turning with shoulder, copying, chamfering and facing with negative DN.. Body treated for longer tool life.







	Product	H (mm)	B (mm)	HF (mm)	WF (mm)	LF (mm)	LH (mm)	LAMS (°)	GAMO (°)	lbs				MID
R	DDJNR 2020 K 11	20	20	20	25	125	30.2	-7	-6	.90	GI046	DD11	–	6758539
	DDJNR 2525 M 11	25	25	25	32	150	30.2	-7	-6	1.63	GI046	DD11	–	6758541
	DDJNR 2020 K 15	20	20	20	25	125	39.4	-7	-6	.93	GI044	DD154	AT002	6757934
	DDJNR 2525 M 15	25	25	25	32	150	39.4	-7	-6	1.63	GI044	DD154	AT002	6757936
	DDJNR 3225 P 15	32	25	32	32	170	39.4	-7	-6	2.37	GI044	DD154	AT002	6757938
	DDJNR 3232 P 15	32	32	32	40	170	39.4	-7	-6	2.93	GI044	DD154	AT002	7028426
L	DDJNL 2020 K 11	20	20	20	25	125	30.2	-7	-6	.93	GI046	DD11	–	6758540
	DDJNL 2525 M 11	25	25	25	32	150	30.2	-7	-6	1.64	GI046	DD11	–	6758542
	DDJNL 2020 K 15	20	20	20	25	125	39.4	-7	-6	.93	GI044	DD154	AT002	6757935
	DDJNL 2525 M 15	25	25	25	32	150	39.4	-7	-6	1.64	GI044	DD154	AT002	6757937
	DDJNL 3225 P 15	32	25	32	32	170	39.4	-7	-6	2.23	GI044	DD154	AT002	6757939
	DDJNL 3232 P 15	32	32	32	40	170	39.4	-7	-6	2.95	GI044	DD154	AT002	7028425

GI044	DN.. 44.. (DN.. 1506..)
GI046	DN.. 33.. (DN.. 1104..)

		Nm			
DD11	DCS 09	1.7	DDS 267-01	US 2004-T09P	FLAG T09P
DD154	DCS 12	3.9	DDS 266-02	US 2002-T15P	FLAG T15P/3,5

AT002a	DN.. 1504..	–	DDS 266-01
AT002b	CER DN.N 1506..	DCS 12C4	–
AT002c	CER DN.A 1506..	DCS 12C2	–

IDDJN(RL) EXT

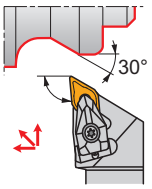
P M K N S H

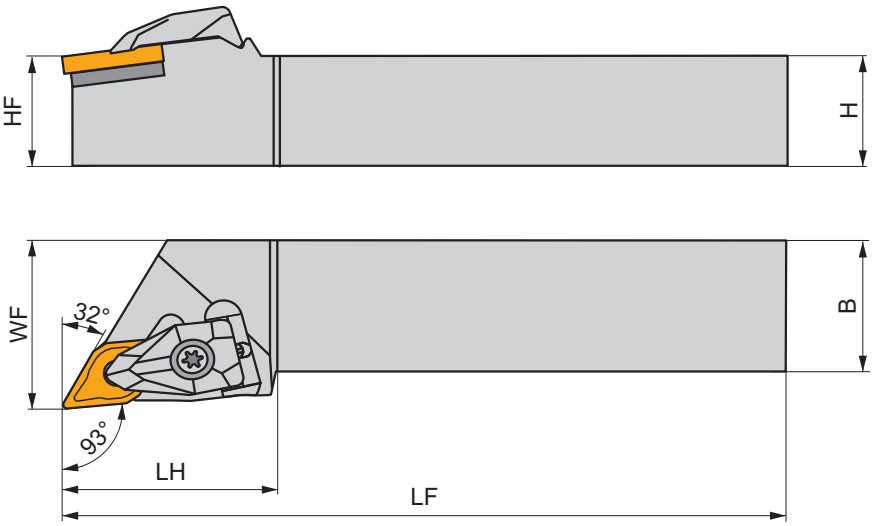
PRAMET

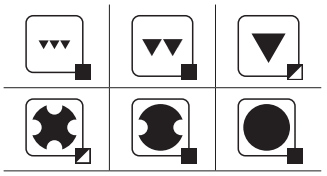
D

External Double Clamp Turning Holder with 93° Cutting Angle for DN.. Inserts

External Right/Left hand double clamp tool holder with 93° cutting angle. Suited for longitudinal turning with shoulder, copying, chamfering and facing with negative DN.. Body treated for longer tool life.







	Product	H (inch)	B (inch)	HF (inch)	WF (inch)	LF (inch)	LH (inch)	LAMS (°)	GAMO (°)	lbs			MID
R	DDJNR 12 3C	.750	.750	.750	1.000	5.000	1.190	-6	-6	1.05	GI046	DD11	6788569
	DDJNR 16 3D	1.000	1.000	1.000	1.250	6.000	1.190	-6	-6	1.54	GI046	DD11	6788571
	DDJNR 12 4B	.750	.750	.750	1.000	4.500	1.450	-6	-6	.88	GI044	DD176	6788570
	DDJNR 16 4D	1.000	1.000	1.000	1.250	6.000	1.550	-6	-6	1.54	GI044	DD176	6788572
	DDJNR 20 4D	1.250	1.250	1.250	1.500	6.000	1.550	-6	-6	2.76	GI044	DD176	6788573
L	DDJNL 12 3C	.750	.750	.750	1.000	5.000	1.190	-6	-6	1.05	GI046	DD11	6788564
	DDJNL 16 3D	1.000	1.000	1.000	1.250	6.000	1.190	-6	-6	1.54	GI046	DD11	6788566
	DDJNL 12 4B	.750	.750	.750	1.000	4.500	1.450	-6	-6	.88	GI044	DD176	6788565
	DDJNL 16 4D	1.000	1.000	1.000	1.250	6.000	1.550	-6	-6	1.54	GI044	DD176	6788567
	DDJNL 20 4D	1.250	1.250	1.250	1.500	6.000	1.550	-6	-6	2.76	GI044	DD176	6788568

GI044	DN.. 44.. (DN.. 1506..)
GI046	DN.. 33.. (DN.. 1104..)

		Nm			
DD11	DCS 09	1.7	DDS 267-01	US 2004-T09P	FLAG T09P
DD176	DCS 12	3.9	DDS 266-01	US 2002-T15P	FLAG T15P/3,5

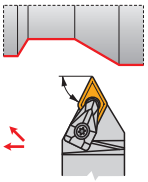
IDDPNN EXT

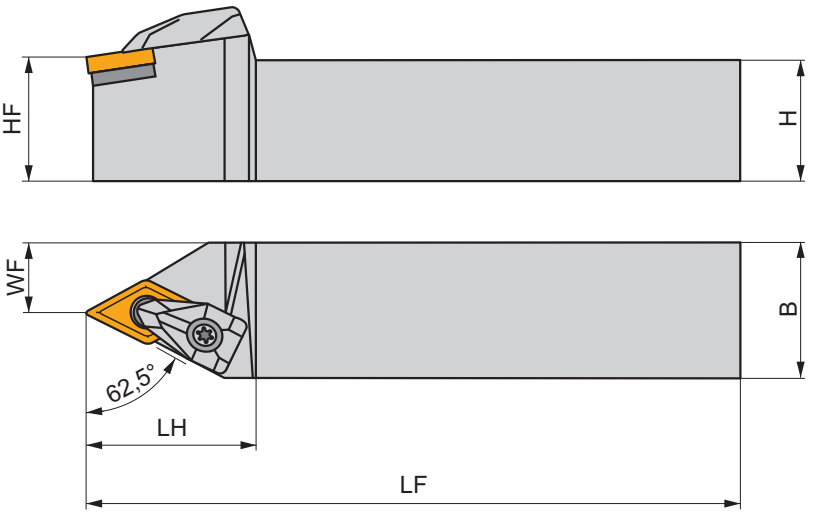
P M K N S H

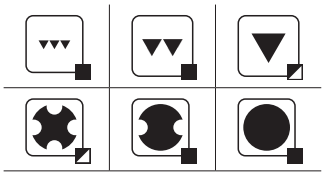
PRAMET

External Double Clamp Turning Holder, 62.5° Cutting Angle for DN.. Inserts

External neutral double clamp tool, with 62.5° cutting angle for taper and longitudinal turning without shoulder, copying and chamfering with negative DN.. inserts. Body treated for longer tool life.







	Product	H (inch)	B (inch)	HF (inch)	WF (inch)	LF (inch)	LH (inch)	LAMS (°)	GAMO (°)	lbs			MID
N	**DDPNN 12 3B**	.030	.750	.750	.375	4.500	1.230	-9	-5	1.05	GI046	DD11	6788574
	DDPNN 16 4D	.039	1.000	1.000	.500	6.000	1.610	-9	-5	1.54	GI044	DD176	6788575

GI044	DN.. 44.. (DN.. 1506..)
GI046	DN.. 33.. (DN.. 1104..)

		Nm			
DD11	DCS 09	1.7	DDS 267-01	US 2004-T09P	FLAG T09P
DD176	DCS 12	3.9	DDS 266-01	US 2002-T15P	FLAG T15P/3,5

PDJN(RL) EXT

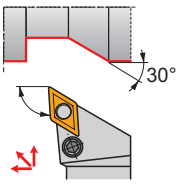
P M K N S H

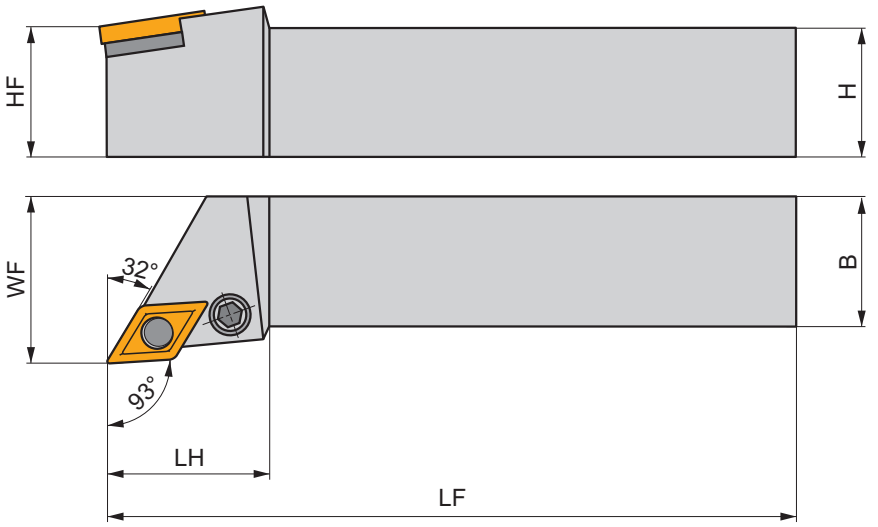
PRAMET

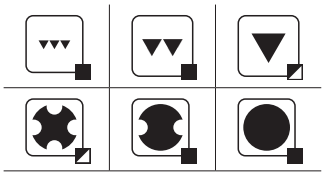
P

External Lever Lock Turning Holder with 93° Cutting Angle for DN.. Inserts

External Right/Left hand lever lock tool holder with 93° cutting angle. Suited for longitudinal turning with shoulder, copy turning up to 30°, and chamfering with negative DN.. inserts. Body treated for longer tool life.







	Product	H (mm)	B (mm)	HF (mm)	WF (mm)	LF (mm)	LH (mm)	LAMS (°)	GAMO (°)	lbs			MID
R	PDJNR 2020 K 11	20	20	20	25	125	28.0	-7	-6	.87	GI046	PD02	6756750
	PDJNR 2525 M 11	25	25	25	32	150	28.0	-7	-6	1.55	GI046	PD02	6756751
	PDJNR 2020 K 15	20	20	20	25	125	34.0	-7	-6	.87	GI044	PD01	6757088
	PDJNR 2525 M 15	25	25	25	32	150	34.0	-7	-6	1.60	GI044	PD01	6756966
	PDJNR 3225 P 15	32	25	32	32	170	34.0	-7	-6	2.30	GI044	PD01	6757055
	PDJNR 3232 P 15	32	32	32	40	170	34.0	-7	-6	2.87	GI044	PD01	6757036
L	PDJNL 2020 K 11	20	20	20	25	125	28.0	-7	-6	.87	GI046	PD02	6756747
	PDJNL 2525 M 11	25	25	25	32	150	28.0	-7	-6	1.61	GI046	PD02	6756748
	PDJNL 2020 K 15	20	20	20	25	125	40.0	-6	-6	.92	GI044	PD01	6756743
	PDJNL 2525 M 15	25	25	25	32	150	34.0	-7	-6	1.60	GI044	PD01	6756956
	PDJNL 3225 P 15	32	25	32	32	170	34.0	-7	-6	2.16	GI044	PD01	6756744
	PDJNL 3232 P 15	32	32	32	40	170	34.0	-7	-6	2.87	GI044	PD01	6757182

GI044	DN.. 44.. (DN.. 1506..)
GI046	DN.. 33.. (DN.. 1104..)

				Nm					
PD01	PDS 715	CL 415	CS 638	3.0	M 8x1	0.831	TR 12	MT 05	HXK 3
PD02	PDS 711	CL 009	CS 606	2.0	M 6x1	0.657	TR 09	MT 04	HXK 2.5

PDNN(RL) EXT

P M K N S H

PRAMET

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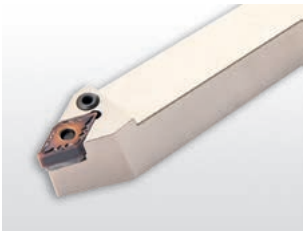
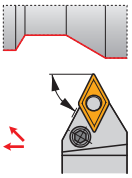
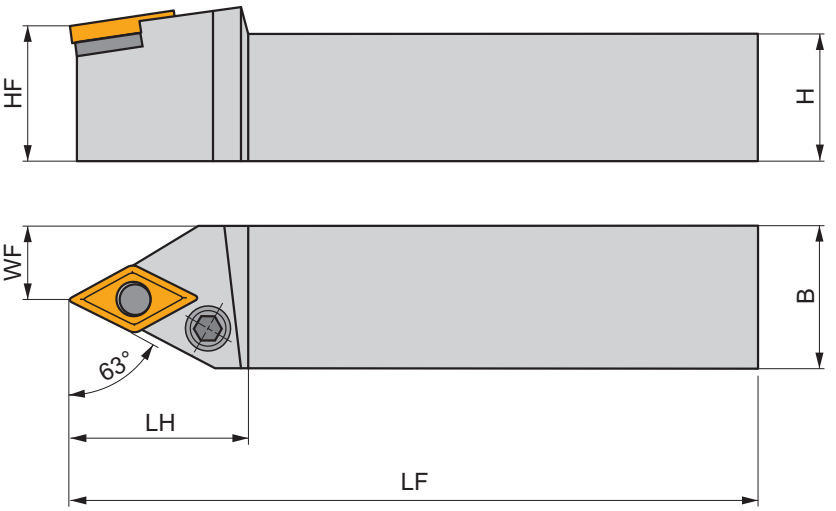
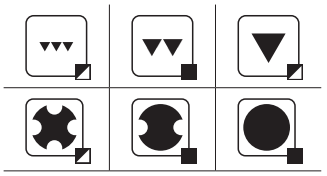


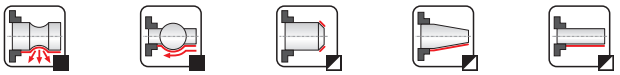
External Lever Lock Turning Holder with 63° Cutting Angle for DN.. Inserts

External Right/Left hand lever lock 63° (neutral) tool holder. Suited for longitudinal turning without shoulder, taper, copy, and chamfer turning with negative DN.. inserts. Body treated for longer tool life.









	Product	H (mm)	B (mm)	HF (mm)	WF (mm)	LF (mm)	LH (mm)	LAMS (°)	GAMO (°)	lbs			MID
R	**PDNNR 2020 K 11**	20	20	20	10	125	28.0	-6	-6	.82	GI046	PD02	6756755
	PDNNR 2525 M 11	25	25	25	12.5	150	25.0	-6	-6	1.32	GI046	PD02	6756756
	PDNNR 2525 M 15	25	25	25	12.5	150	34.0	-6	-6	1.52	GI044	PD01	6757044
	PDNNR 3225 P 15	32	25	32	12.5	170	34.0	-6	-6	2.21	GI044	PD01	6757903
L	**PDNNL 2020 K 11**	20	20	20	10	125	28.0	-6	-6	.88	GI046	PD02	6756753
	PDNNL 2525 M 11	25	25	25	12.5	150	25.0	-6	-6	1.32	GI046	PD02	6756754
	PDNNL 2525 M 15	25	25	25	12.5	150	34.0	-6	-6	1.53	GI044	PD01	6757086
	PDNNL 3225 P 15	32	25	32	12.5	170	34.0	-6	-6	2.20	GI044	PD01	6757904

GI044	DN.. 44.. (DN.. 1506..)
GI046	DN.. 33.. (DN.. 1104..)

				Nm					
PD01	PDS 715	CL 415	CS 638	3.0	M 8x1	0.831	TR 12	MT 05	HXK 3
PD02	PDS 711	CL 009	CS 606	2.0	M 6x1	0.657	TR 09	MT 04	HXK 2.5

PDXN(RL) EXT

P M K N S H

PRAMET

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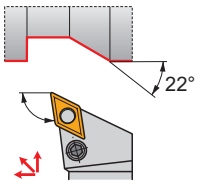
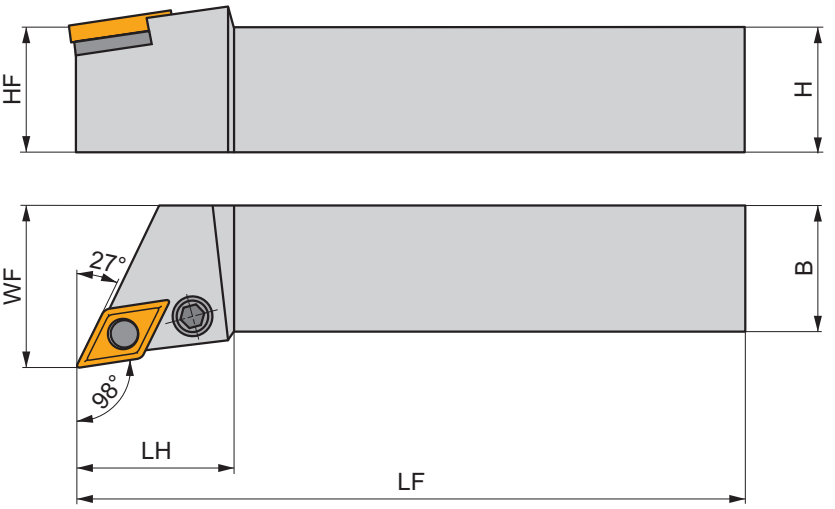
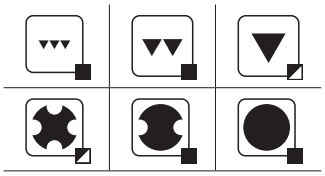
External Lever Lock Turning Holder with 98° Cutting Angle for DN.. Inserts

External Right/Left hand lever lock tool holder with 98° cutting angle. Suited for taper, longitudinal turning with shoulder, copy turning up to 22° and chamfering with negative DN.. inserts. Body treated for longer tool life.







	Product	H (mm)	B (mm)	HF (mm)	WF (mm)	LF (mm)	LH (mm)	LAMS (°)	GAMO (°)	lbs			MID
R	PDXNR 2020 K 15	20	20	20	25	125	40.0	-6	-6	.83	GI044	PD01	6757045
	PDXNR 2525 M 15	25	25	25	32	150	40.0	-6	-6	1.61	GI044	PD01	6756907
	PDXNR 3225 P 15	32	25	32	32	170	34.0	-8	-3	1.76	GI044	PD01	6757082
L	PDXNL 2020 K 15	20	20	20	25	125	34.0	-8	-3	.89	GI044	PD01	6757290
	PDXNL 2525 M 15	25	25	25	32	150	34.0	-8	-3	1.57	GI044	PD01	6757087
	PDXNL 3225 P 15	32	25	32	32	170	34.0	-8	-3	2.09	GI044	PD01	6757090

GI044	DN.. 44.. (DN.. 1506..)

PD01	PDS 715	CL 415	CS 638	3.0 Nm	M 8x1	0.831	TR 12	MT 05	HXK 3

C.-DDJN(RL) EXT

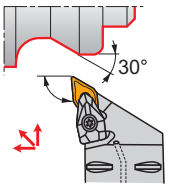
P M K N S H

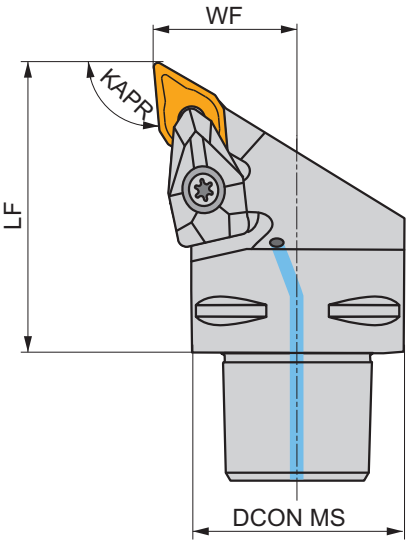
PRAMET

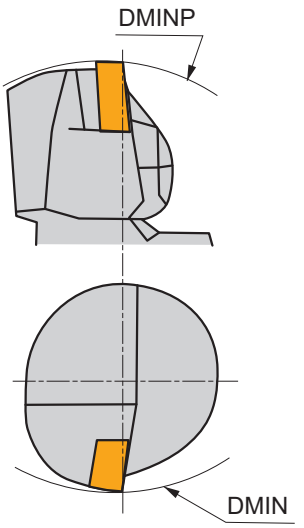
D

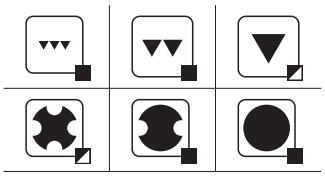
Ext. PSC Quick Change Tool, Double Clamp, 93° Cutting Angle for DN.. Inserts

External Right/Left hand double clamp tool, through coolant, with 93° cutting angle for taper and longitudinal turning with shoulder, copying and chamfering with negative DN.. inserts. Polygon Shank Coupling. Body treated for longer tool life.









	Product	DCON MS (mm)	DMIN (mm)	DMINP (mm)	WF (mm)	LF (mm)	KAPR (°)	LAMS (°)	GAMO (°)	✓	lbs				MID
R	**C4-DDJNR-27050-11**	40	60	140	27	50	93	-7	-6	✓	.85	GI046	C-DD11	–	7809781
	C4-DDJNR-27055-15	40	110	145	27	55	93	-7	-6	✓	.94	GI044	C-DD154-1	AT002	7809783
	C5-DDJNR-35060-15	50	110	165	35	60	93	-7	-6	✓	1.59	GI044	C-DD154-2	AT002	7809785
	C6-DDJNR-45065-15	63	110	190	45	65	93	-7	-6	✓	2.59	GI044	C-DD154-3	AT002	7809787
L	**C4-DDJNL-27050-11**	40	60	140	27	50	93	-7	-6	✓	.85	GI046	C-DD11	–	7809780
	C4-DDJNL-27055-15	40	110	145	27	55	93	-7	-6	✓	.94	GI044	C-DD154-1	AT002	7809782
	C5-DDJNL-35060-15	50	110	165	35	60	93	-7	-6	✓	1.59	GI044	C-DD154-2	AT002	7809784
	C6-DDJNL-45065-15	63	110	190	45	65	93	-7	-6	✓	2.60	GI044	C-DD154-3	AT002	7809786

GI044	DN.. 44.. (DN.. 1506..)
GI046	DN.. 33.. (DN.. 1104..)

		Nm				
C-DD11	DCS 09	1.7	DDS 267-01	US 2004-T09P	FLAG T09P	CN 034-01
C-DD154-1	DCS 12	3.9	DDS 266-02	US 2002-T15P	FLAG T15P/3,5	CN 034-01
C-DD154-2	DCS 12	3.9	DDS 266-02	US 2002-T15P	FLAG T15P/3,5	CN 045-01
C-DD154-3	DCS 12	3.9	DDS 266-02	US 2002-T15P	FLAG T15P/3,5	CN 034-02

AT002a	DN.. 1504..	–	DDS 266-01
AT002b	CER DN.N 1506..	DCS 12C4	–
AT002c	CER DN.A 1506..	DCS 12C2	–
AT002d	CER DN.N 1504..	DCS 12C4	DDS 266-01
AT002e	CER DN.A 1504..	DCS 12C2	DDS 266-01

C.-DDNNN EXT

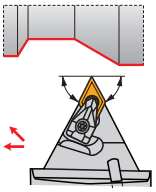
P M K N S H

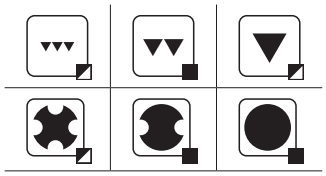
PRAMET

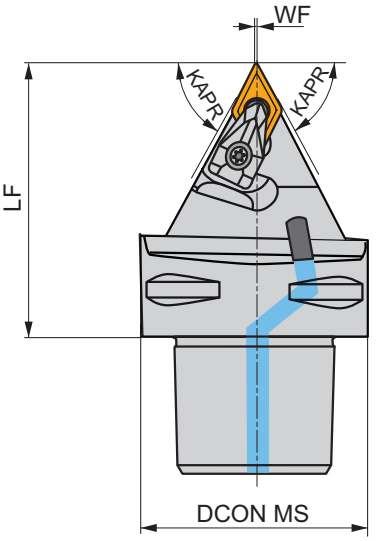
D

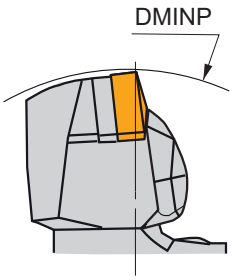
Ext. PSC Quick Change Tool, Double Clamp, 62.5° Cutting Angle for DN.. Inserts

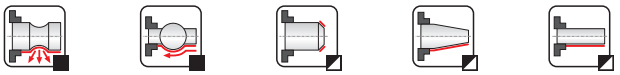
External Right/Left hand double clamp tool, through coolant, with 62.5° cutting angle for taper and longitudinal turning without shoulder, copying and chamfering with negative DN.. inserts. Polygon Shank Coupling. Body treated for longer tool life.











	Product	DCON MS (mm)	DMINP (mm)	WF (mm)	LF (mm)	KAPR (°)	LAMS (°)	GAMO (°)		lbs				MID
N	C5-DDNNN-00060-15	50	165	0.5	60	62.5	-9	-5	✓	1.38	GI044	C-DD154-2	AT002	7809791
	C6-DDNNN-00065-15	63	190	0.5	65	62.5	-9	-5	✓	2.34	GI044	C-DD154-2	AT002	7809792

GI044	DN.. 44.. (DN.. 1506..)

C-DD154-2	DCS 12	3.9 Nm	DDS 266-02	US 2002-T15P	FLAG T15P/3,5	CN 045-01

AT002a	DN.. 1504..	–	DDS 266-01
AT002b	CER DN.N 1506..	DCS 12C4	–
AT002c	CER DN.A 1506..	DCS 12C2	–
AT002d	CER DN.N 1504..	DCS 12C4	DDS 266-01
AT002e	CER DN.A 1504..	DCS 12C2	DDS 266-01

C.-DDUN(RL) EXT

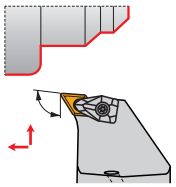
P M K N S H

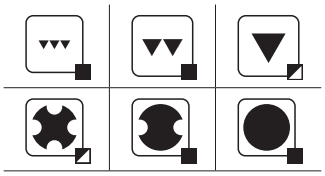
PRAMET

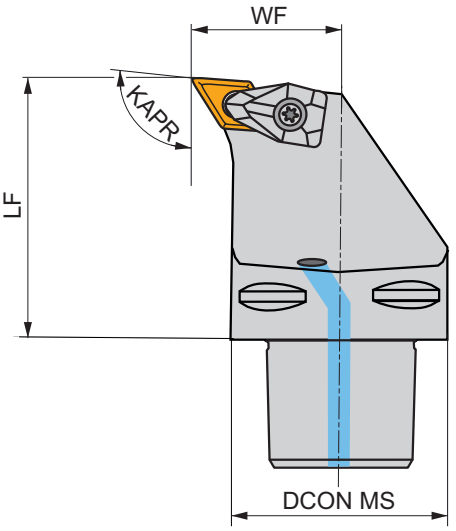
D

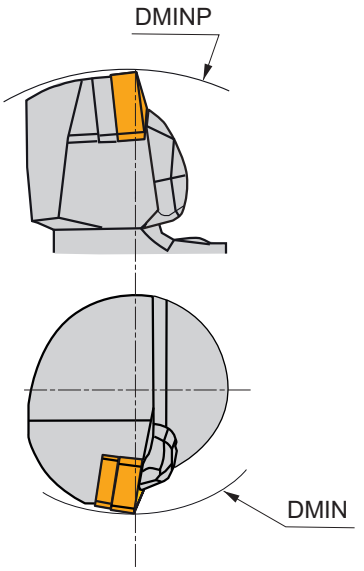
Ext. PSC Quick Change Tool, Double Clamp, 93° (Face) Cutting Angle, DN.. Inserts

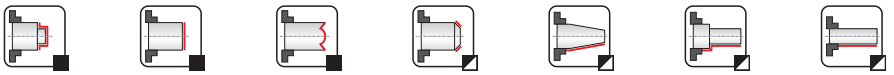
External Right/Left hand double clamp tool, through coolant, with 93° cutting angle for face turning with shoulder, face copy turning, taper turning, longitudinal turning and chamfering with negative DN.. inserts. Polygon Shank Coupling. Body treated for longer tool life.











	Product	DCON MS (mm)	DMIN (mm)	DMINP (mm)	WF (mm)	LF (mm)	KAPR (°)	LAMS (°)	GAMO (°)		lbs				MID
R	C5-DDUNR-35060-15	50	110	165	35	60	93	-7	-6	✓	1.81	GI044	C-DD154-3	AT002	7809789
	C6-DDUNR-45065-15	63	110	190	45	65	93	-7	-6	✓	3.07	GI044	C-DD154-3	AT002	7809790
L	C5-DDUNL-35060-15	50	110	165	35	60	93	-7	-6	✓	1.81	GI044	C-DD154-3	AT002	7809788

GI044	DN.. 44.. (DN.. 1506..)

C-DD154-3	DCS 12	3.9	DDS 266-02	US 2002-T15P	FLAG T15P/3,5	CN 034-02

AT002a	DN.. 1504..	–	DDS 266-01
AT002b	CER DN.N 1506..	DCS 12C4	–
AT002c	CER DN.A 1506..	DCS 12C2	–
AT002d	CER DN.N 1504..	DCS 12C4	DDS 266-01
AT002e	CER DN.A 1504..	DCS 12C2	DDS 266-01

DDUN(RL) INT

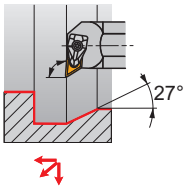
P M K N S H

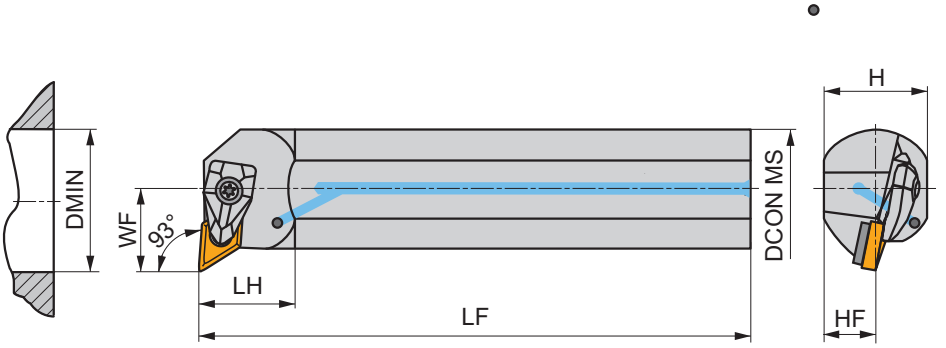
PRAMET

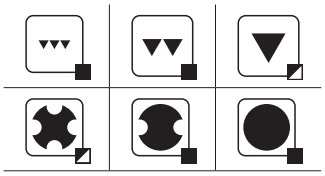
D

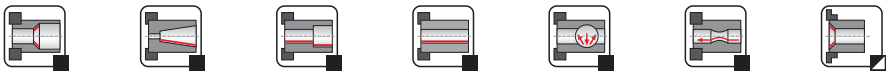
Internal Double Clamp Boring Bar with 93° Cutting Angle for DN.. Inserts

Internal Right/Left hand double clamp boring bar, through coolant, 93° cutting angle for DN.. inserts. Suited for wide range of internal turning applications, copy turning up to 27°.Body treated for longer tool life.









	Product	DCON MS (mm)	DMIN (mm)	WF (mm)	H (mm)	HF (mm)	LF (mm)	LH (mm)	LAMS (°)	GAMO (°)		lbs				MID
R	**A25T-DDUNR 11**	25	32	17	23	11.5	300	28.0	-12	-6	✓	2.12	GI046	DD11	–	7028480
	A32T-DDUNR 11	32	40	22	30	15	300	30.0	-10	-6	✓	3.71	GI046	DD11	–	7028488
	A40T-DDUNR 15	40	50	27	37	18.5	300	36.0	-11	-6	✓	5.70	GI044	DD154	AT002	7028496
	A50U-DDUNR 15	50	63	35	47	23.5	350	39.0	-8	-6	✓	11.54	GI044	DD154	AT002	7028506
L	**A25T-DDUNL 11**	25	32	17	23	11.5	300	28.0	-12	-6	✓	2.12	GI046	DD11	–	7028479
	A32T-DDUNL 11	32	40	22	30	15	300	30.0	-10	-6	✓	3.71	GI046	DD11	–	7028487
	A40T-DDUNL 15	40	50	27	37	18.5	300	36.0	-11	-6	✓	5.70	GI044	DD154	AT002	7028495
	A50U-DDUNL 15	50	63	35	47	23.5	350	39.0	-8	-6	✓	11.58	GI044	DD154	AT002	7028505

GI044	DN.. 44.. (DN.. 1506..)
GI046	DN.. 33.. (DN.. 1104..)

DD11	DCS 09	1.7	DDS 267-01	US 2004-T09P	FLAG T09P
DD154	DCS 12	3.9	DDS 266-02	US 2002-T15P	FLAG T15P/3,5

AT002a	DN.. 1504..	–	DDS 266-01
AT002b	CER DN.N 1506..	DCS 12C4	–
AT002c	CER DN.A 1506..	DCS 12C2	–

IDDUN(RL) INT

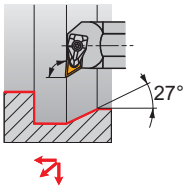
P M K N S H

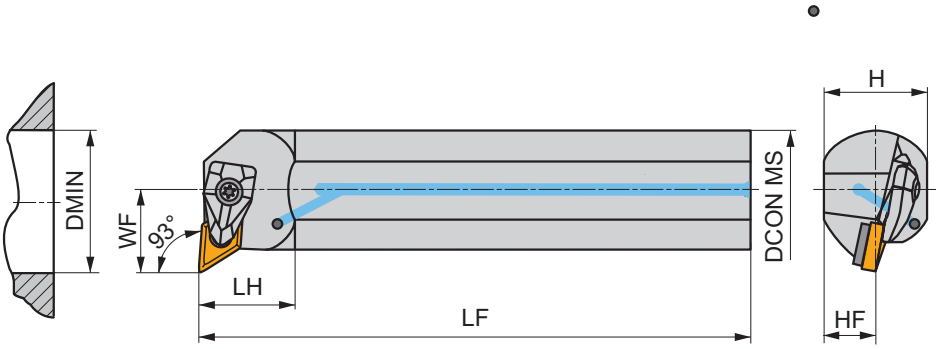
PRAMET

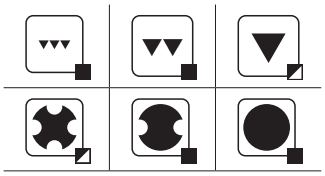
D

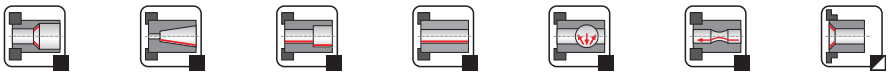
Internal Double Clamp Boring Bar with 93° Cutting Angle for DN.. Inserts

Internal Right/Left hand double clamp boring bar, through coolant, 93° cutting angle for DN.. inserts. Suited for wide range of internal turning applications, copy turning up to 27°.Body treated for longer tool life.









	Product	DCON MS (inch)	DMIN (inch)	WF (inch)	H (inch)	HF (inch)	LF (inch)	LH (inch)	LAMS (°)	GAMO (°)		lbs			MID
R	**A16T-DDUNR 3**	1.000	1.299	.750	.906	.453	12.000	1.142	-12	-6	✓	1.54	GI046	DD11	6788636
R	**A20T-DDUNR 4**	1.250	1.705	1.000	1.181	.591	12.000	1.181	-13	-6	✓	3.08	GI044	DD154	6788495
R	**A24T-DDUNR 4**	1.500	2.000	1.125	1.374	.687	12.000	1.299	-11	-6	✓	8.25	GI044	DD154	6788509
L	**A16T-DDUNL 3**	1.000	1.299	.750	.906	.453	12.000	1.142	-12	-6	✓	1.54	GI046	DD11	6788635

GI044	DN.. 44.. (DN.. 1506..)
GI046	DN.. 33.. (DN.. 1104..)

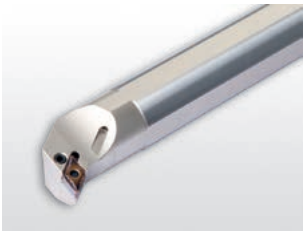
		Nm			
DD11	DCS 09	1.7	DDS 267-01	US 2004-T09P	FLAG T09P
DD154	DCS 12	3.9	DDS 266-02	US 2002-T15P	FLAG T15P/3,5

PDUN(RL) INT

P M K N S H

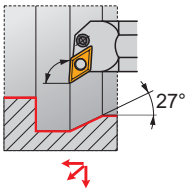
PRAMET

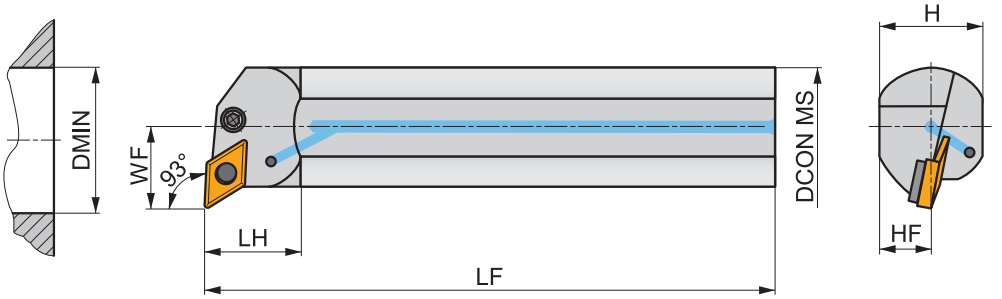
P

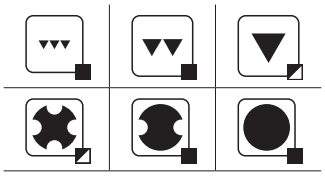


Internal Lever Lock Boring Bar with 93° Cutting Angle for DN.. Insert

Internal Right/Left hand lever lock boring bar, through coolant available, 93° cutting angle for DN.. inserts. For a wide range of internal turning applications, copy turning up to 27°. Body treated for longer tool life.







	Product	DCON MS (mm)	DMIN (mm)	WF (mm)	H (mm)	B (mm)	LF (mm)	LAMS (°)	GAMO (°)		lbs			MID
R	A25R-PDUNR 11	25	31	17	23	–	200	-14	-5	✓	1.55	GI046	PD02	8281407
	A32S-PDUNR 11	32	39	22	30	–	250	-14	-5	✓	3.12	GI046	PD02	8281411
	A32S-PDUNR 15	32	39	22	30	30	250	-14	-4	✓	3.17	GI044	PD04	6757270
	A40T-PDUNR 15	40	48	27	37	38	300	-11	-6	✓	5.29	GI044	PD03	6757215
	A50U-PDUNR 15	50	61	35	47	48.49	350	-14	-4	✓	10.92	GI044	PD03	6757216
	A60V-PDUNR 15	60	80	43	57	58.5	400	-14	-4	✓	18.12	GI044	PD03	6757363
L	A25R-PDUNL 11	25	31	17	23	–	200	-14	-5	✓	1.55	GI046	PD02	8281406
	A32S-PDUNL 11	32	39	22	30	–	250	-14	-5	✓	3.13	GI046	PD02	8281410
	A32S-PDUNL 15	32	39	22	30	30	250	-14	-4	✓	3.18	GI044	PD04	6757370
	A40T-PDUNL 15	40	48	27	37	38	300	-11	-6	✓	5.65	GI044	PD03	6757364
	A60V-PDUNL 15	60	80	43	57	58.5	400	-14	-4	✓	17.99	GI044	PD03	6757366

GI044	DN.. 44.. (DN.. 1506..)
GI046	DN.. 33.. (DN.. 1104..)

				Nm							
PD02	PDS 711	CL 009	CS 606	2.0	M 6x1	0.657	TR 09	MT 04	HXK 2.5	–	–
PD03	PDS 715	CL 415	CS 638	3.0	M 8x1	0.831	TR 12	MT 05	HXK 3	PDS 725	TR 35
PD04	PDS 715	CL 415	CS 648	3.0	M 8x1	0.669	TR 12	MT 05	HXK 3	PDS 725	TR 35

C.-DDUN(RL) INT

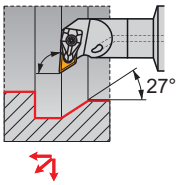
P M K N S H

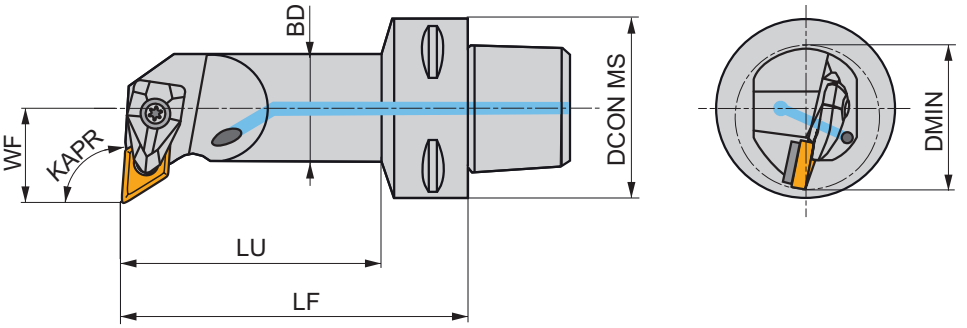
PRAMET

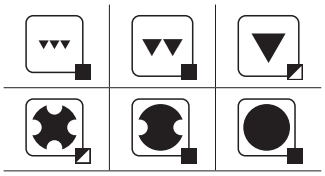
D

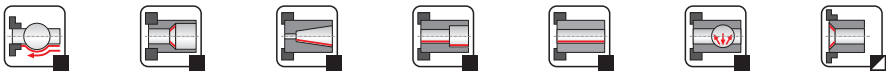
Int. PSC Quick Change Tool, Double Clamp, 93° Cutting Angle for DN.. Insert

Internal Right/Left hand double clamp tool, through coolant, with 93° cutting angle for internal turning applications including copy turning up to 27° with DN.. inserts. Polygon Shank Coupling. Body treated for longer tool life.









	Product	DCON MS (mm)	DMIN (mm)	WF (mm)	LF (mm)	LU (mm)	BD (mm)	KAPR (°)	LAMS (°)	GAMO (°)		lbs			MID
R	C4-DDUNR-17090-11	40	32	17	90	68	25	93	-12	-6	✓	1.13	GI046	DD11	7809869
L	C4-DDUNL-17090-11	40	32	17	90	68	25	93	-12	-6	✓	1.13	GI046	DD11	7809868

GI046	DN.. 33.. (DN.. 1104..)

DD11	DCS 09	1.7	DDS 267-01	US 2004-T09P	FLAG T09P

CKJN(RL) EXT

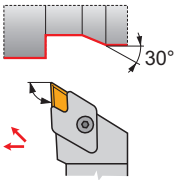
P M K N S H

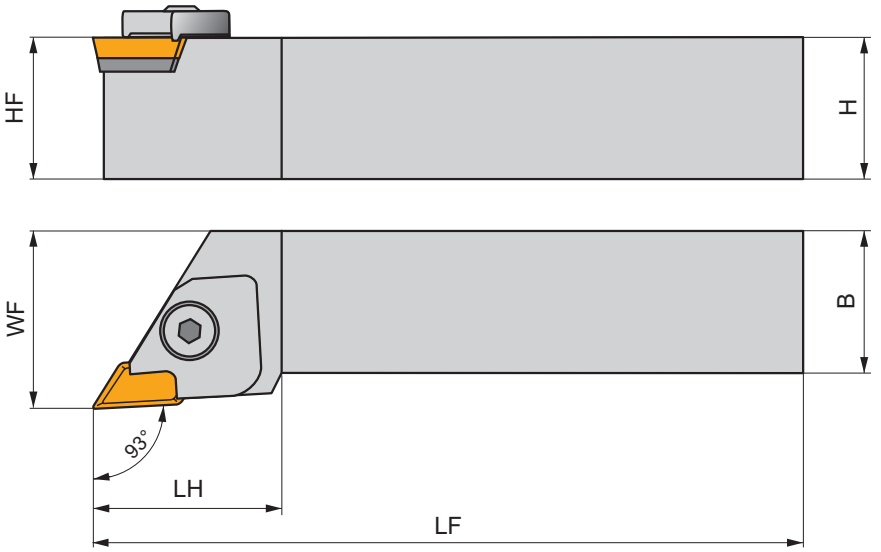
PRAMET

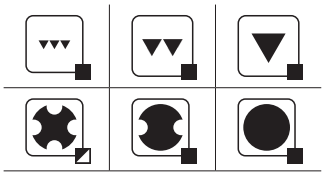
C

External Top Clamp Turning Holder with 93° Cutting Angle for KN.. Inserts

External Right/Left hand top clamp tool holder with 93° cutting angle. Suited for taper, longitudinal turning with shoulder, copy turning up to 30° and chamfering with negative KN.. inserts. Body treated for longer tool life.







	Product	H (mm)	B (mm)	HF (mm)	WF (mm)	LF (mm)	LH (mm)	LAMS (°)	GAMO (°)	lbs			MID
R	CKJNR 2020 K 16	20	20	20	30	125	34.0	1	-5	.88	GI066	R1	6756934
	CKJNR 2525 M 16	25	25	25	32	150	34.0	1	-5	1.54	GI066	R	6756895
	CKJNR 3225 P 16	32	25	32	32	170	34.0	1	-5	2.33	GI066	R	6757224
L	CKJNL 2020 K 16	20	20	20	30	125	34.0	1	-5	.93	GI067	L1	6757125
	CKJNL 2525 M 16	25	25	25	32	150	34.0	1	-5	1.62	GI067	L	6756896
	CKJNL 3225 P 16	32	25	32	32	170	34.0	1	-5	2.33	GI067	L	6757269

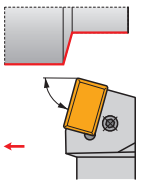
GI066	KN.X 1604…R
GI067	KN.X 1604…L

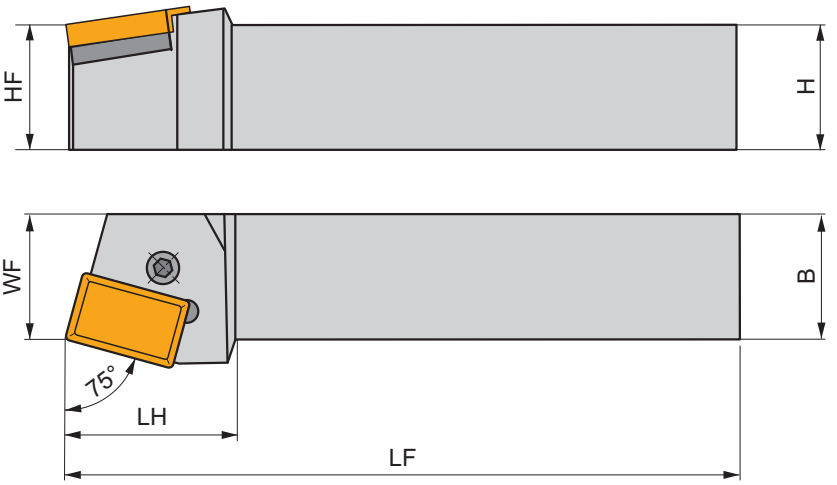
						Nm			
L	KNN 190412L	NT 03	–	UP 26	US 83	6.0	PR 07	K 23	HXK 4
L1	KNN 190412L	NT 03	–	UP 26	US 83	6.0	PR 07	K 22	HXK 4
R1	KNN 190412R	NT 03	UP 25	–	US 83	6.0	PR 07	K 22	HXK 4

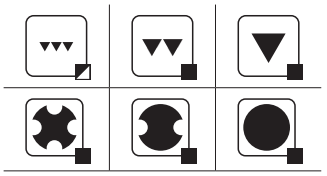
PLBN(RL) EXT

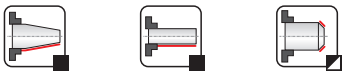
External Lever Lock Heavy Turning Holder, 75° Cutting Angle for LNUX Inserts

External Right/Left hand lever lock tool holder with 75° cutting angle for heavy turning. Suited for longitudinal turning without shoulder, taper and chamfer turning with negative LN.. inserts. Body treated for longer tool life.







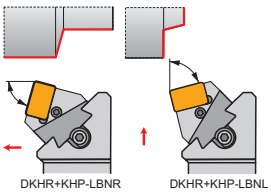


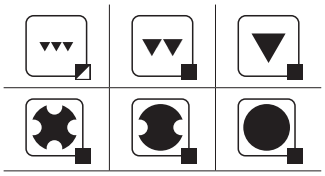
	Product	H (mm)	B (mm)	HF (mm)	WF (mm)	LF (mm)	LH (mm)	LAMS (°)	GAMO (°)	lbs			MID
R	**PLBNR 6060 V 40-A**	60	60	60	60	400	64.0	-6	-6	28.66	GI102	PL71	6757240
	PLBNR 6060 V 50	60	60	60	60	400	70.0	-6	-6	28.11	GI145	PL72	6758284
	PLBNR 6060 V 50-2	60	60	60	60	400	70.0	-6	-6	25.57	GI291	PL73	7045479
L	**PLBNL 6060 V 40-A**	60	60	60	60	400	64.0	-6	-6	24.56	GI102	PL71	6757421
	PLBNL 6060 V 50	60	60	60	60	400	70.0	-6	-6	28.86	GI145	PL72	6758283

GI102	LNUX 40....
GI145	LNUX 50....
GI291	LNMX 50....

				Nm							
PL71	LNX 400632	PU 06	PS 12040	8.0	M 12x1	1.575	NT 08	MT 08	HXK 5	–	–
PL72	LNX 500632	PU 06	PS 12040	8.0	M 12x1	1.575	NT 08	MT 08	HXK 5	–	–
PL73	LNX 500432P	–	–	–	–	–	–	–	–	UP 1515A-T15P	SDR T15P

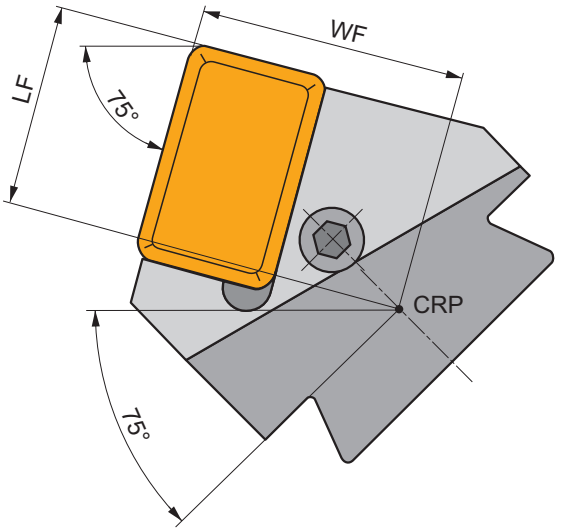
KHP-LBN(RL)





Modular KHP Lever Lock Turning Cartridge, 75° Cutting Angle for LNUX Inserts

Dovetailed Right/Left hand lever lock turning cartridge, 75° cutting angle, for mounting on DKH tool holder shank. Suited for heavy longitudinal turning without shoulder, taper and chamfer turning with negative LNUX inserts. Tool holder treated for longer tool life.



	Product	WF (mm)	LF (mm)	LAMS (°)	GAMO (°)	lbs			MID
L	**KHP-LBNR 40-A**	48	36	-6	-6	3.31	GI102	PL71	6758502
	KHP-LBNL 40-A	48	36	-6	-6	3.24	GI102	PL71	6758515

GI102	LNUX 40....

PL71	LNX 400632	PU 06	PS 12040	8.0 Nm	M 12x1	1.575	NT 08	MT 08	HXK 5

DRSN(RL) EXT

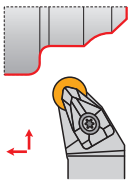
P M K H

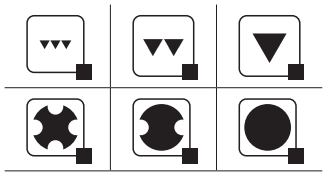
PRAMET

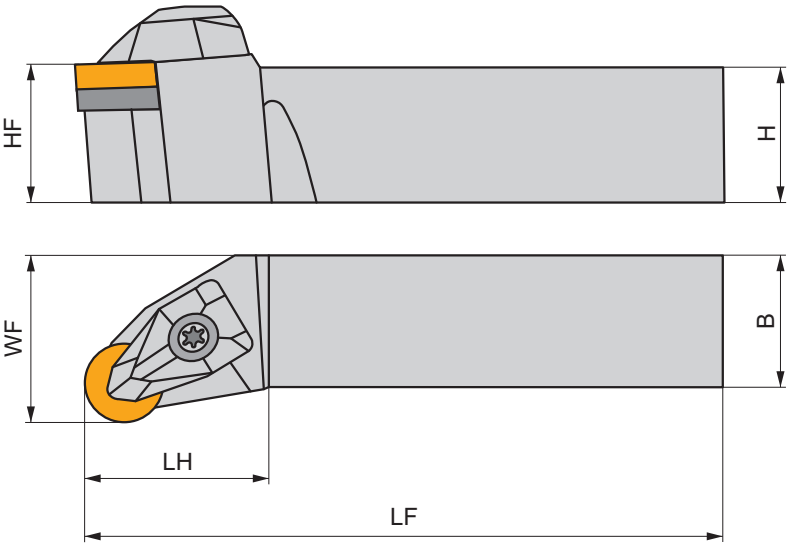
D

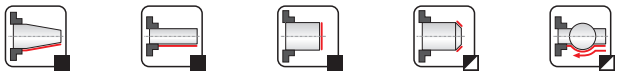
External Double Clamp Holder for RN.. Inserts

External Right/Left hand double clamp tool holder. Suited for longitudinal turning without shoulder, copy turning, taper and chamfer turning with negative round RN.. inserts. Body treated for longer tool life.









	Product	H (mm)	B (mm)	HF (mm)	WF (mm)	LF (mm)	LH (mm)	LAMS (°)	GAMO (°)	lbs			MID
R	**DRSNR 2525 M 12**	25	25	25	32	150	31.6	-6	-6	1.64	GI083	DR12	7028428
L	**DRSNL 2525 M 12**	25	25	25	32	150	31.6	-6	-6	1.65	GI083	DR12	7028427

GI083	RN.. 43.. (RN.. 120400)

DR12	DCS 12	3.9 Nm	DRS 155-02	US 2002-T15P	FLAG T15P/3,5

PRSN(RL) EXT

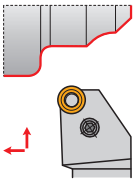
P M K H

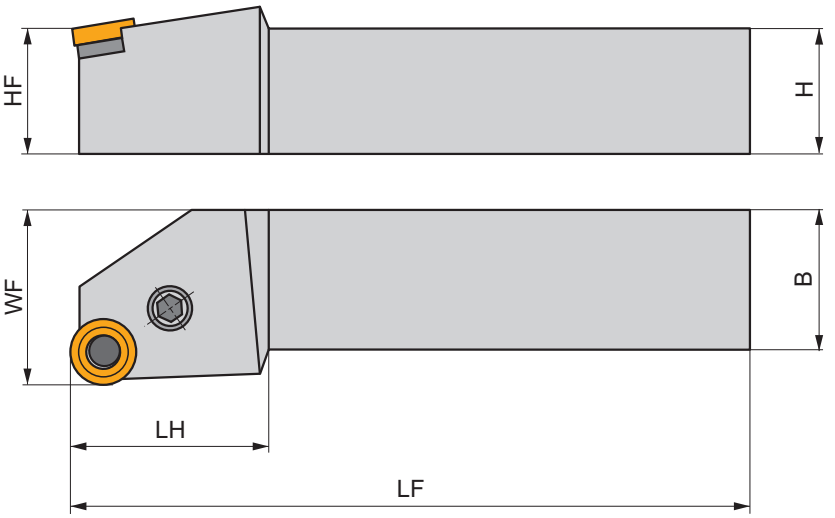
PRAMET

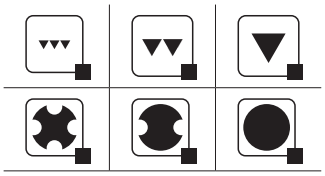
P

External Lever Lock Holder for RN.. Inserts

External Right/Left hand lever lock tool holder. Suited for longitudinal turning, copy turning up to 90°, taper and chamfer turning with negative round RN.. inserts. Body treated for longer tool life.







	Product	H (mm)	B (mm)	HF (mm)	WF (mm)	LF (mm)	LH (mm)	LAMS (°)	GAMO (°)	lbs			MID
R	**PRSNR 2525 M 12**	25	25	25	32	150	28.0	-6	-6	1.50	GI083	PR05	6757046
	PRSNR 3225 P 15	32	25	32	32	170	34.0	-6	-6	2.20	GI105	PR06	8281357
	PRSNR 4040 S 19	40	40	40	50	250	45.0	-6	-6	5.49	GI106	PR07	8281359
L	**PRSNL 2525 M 12**	25	25	25	32	150	28.0	-6	-6	1.63	GI083	PR05	6757291
	PRSNL 3225 P 15	32	25	32	32	170	34.0	-6	-6	2.20	GI105	PR06	8281356
	PRSNL 4040 S 19	40	40	40	50	250	45.0	-6	-6	5.49	GI106	PR07	8281358

GI083	RN.. 43.. (RN.. 120400)
GI105	RN.. 54.. (RN.. 150600)
GI106	RN.. 64.. (RN.. 190600)

				Nm					
PR05	PRS 912	CL 012	CS 608	3.0	M 8x1	0.815	TR 12	MT 05	HXK 3
PR06	PRS 915	CL 015	CS 708	3.0	M 8x1	0.925	TR 15	MT 07	HXK 3
PR07	PRS 919	CL 019	CS 610	3.5	M 10x1	1.071	TR 19	MT 06	HXK 4

C.-DRSN(RL) EXT

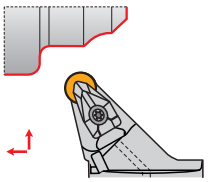
P M K H

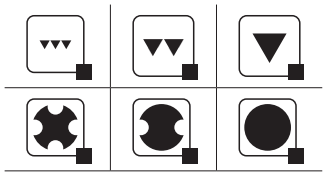
PRAMET

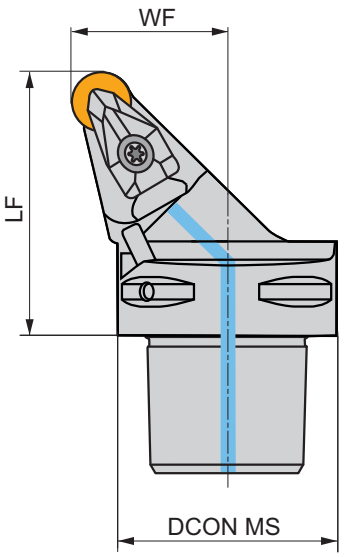
D

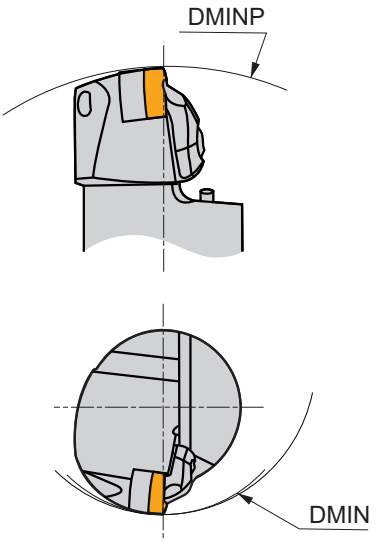
External PSC Quick Change Tool, Double Clamp for RN.. Inserts

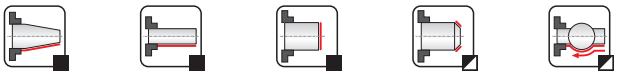
External Right/Left hand double clamp tool, through coolant, for longitudinal turning without shoulder, copy turning, taper and chamfer turning with negative round RN.. inserts. Polygon Shank Coupling. Body treated for longer tool life.











	Product	DCON MS (mm)	DMIN (mm)	DMINP (mm)	WF (mm)	LF (mm)	LAMS (°)	GAMO (°)		lbs			MID
R	C6-DRSNR-45065-12	63	110	190	45	65	-6	-6	✓	2.45	GI083	C-DR12	7809794
L	C6-DRSNL-45065-12	63	110	190	45	65	-6	-6	✓	2.44	GI083	C-DR12	7809793

GI083	RN.. 43.. (RN.. 120400)

C-DR12	DCS 12	3.9	DRS 155-02	US 2002-T15P	FLAG T15P/3,5	CN 045-01

DSBN(RL) EXT

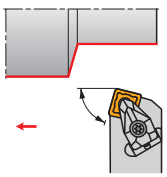
P M K N S H

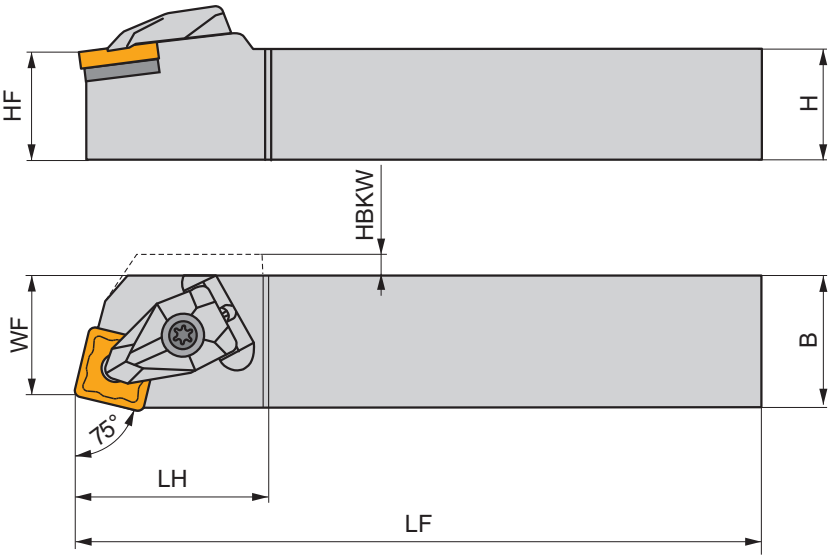
PRAMET

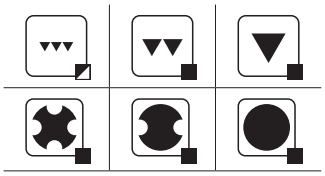
D

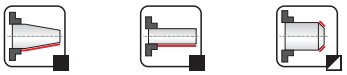
External Double Clamp Holder with 75° Cutting Angle for SN.. Inserts

External Right/Left hand double clamp tool holder with 75° cutting angle. Suited for longitudinal turning without shoulder, taper and chamfer turning with negative SN.. inserts. Body treated for longer tool life.









	Product	H (mm)	B (mm)	HF (mm)	WF (mm)	LF (mm)	LH (mm)	HBKW (mm)	LAMS (°)	GAMO (°)	lbs				MID
R	DSBNR 2525 M 12	25	25	25	22	150	34.3	–	-6	-6	1.63	GI029	DS12	AT003	6757940
	DSBNR 2525 M 15	25	25	25	22	150	41.6	2	-6	-6	1.76	GI082	DS15	AT006	7028433
	DSBNR 3225 P 15	32	25	32	22	170	41.7	2	-6	-6	2.36	GI082	DS15	AT006	6757942
	DSBNR 3232 P 19	32	32	32	27	170	46.4	–	-6	-6	3.04	GI026	DS19	–	6757944
	DSBNR 4040 S 19	40	40	40	35	250	46.5	–	-6	-6	6.91	GI026	DS19	–	7028434
L	DSBNL 2525 M 12	25	25	25	22	150	34.3	–	-6	-6	1.63	GI029	DS12	AT003	6757941
	DSBNL 2525 M 15	25	25	25	22	150	41.6	2	-6	-6	1.76	GI082	DS15	AT006	7028430
	DSBNL 3225 P 15	32	25	32	22	170	41.7	2	-6	-6	2.47	GI082	DS15	AT006	6757943
	DSBNL 4040 S 19	40	40	40	35	250	46.5	–	-6	-6	7.01	GI026	DS19	–	7028431

GI029	SN.. 43.. (SN.. 1204..)
GI082	SN.. 54.. (SN.. 1506..)
GI026	SN.. 64.. (SN.. 1906..)

		Nm				
DS12	DCS 12	3.9	DSS 425-01	US 2002-T15P	FLAG T15P/3,5	–
DS15	DCS 16	6.4	DSS 425-03	US 2007-T20P	–	LK T20P
DS19	DCS 19	6.4	DSS 425-04	US 2007-T20P	–	LK T20P

AT003a	SN.. 1207..	–	DSS 425-02
AT006a	SN.. 1507..	–	DSS 425-05
AT003b	CER SN.N 1204..	DCS 12C4	–
AT003c	CER SN.A 1204..	DCS 12C2	–
AT006b	CER CN.N 1606..	DCS 16C4	–
AT006c	CER CN.A 1606..	DCS 16C2	–

DSDNN EXT

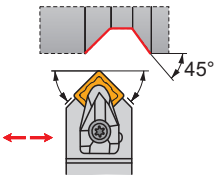
P M K N S H

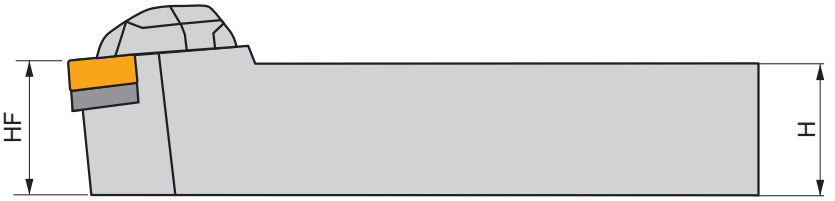
PRAMET

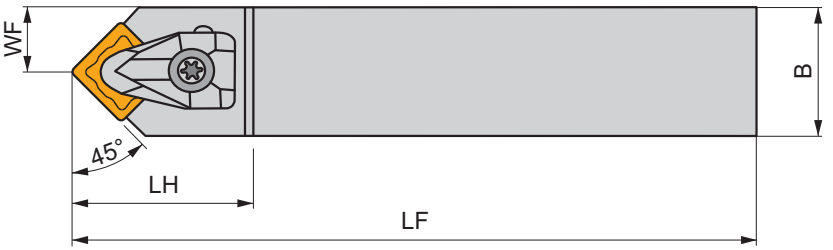
D

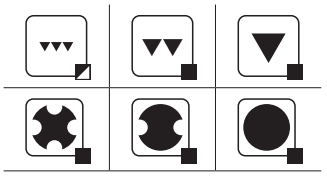
External Double Clamp Holder with 45° Cutting Angle for SN.. Inserts

External neutral double clamp tool holder with 45° cutting angle. Suited for longitudinal turning without shoulder, copy, taper and chamfer turning with negative SN.. inserts. Body treated for longer tool life.









	Product	H (mm)	B (mm)	HF (mm)	WF (mm)	LF (mm)	LH (mm)	LAMS (°)	GAMO (°)	lbs				MID
N	**DSDNN 2525 M 12**	25	25	25	12.8	150	36.5	-6	-6	1.63	GI029	DS12	AT003	7028435
	DSDNN 2525 M 15	25	25	25	12.8	150	44.8	-6	-6	1.68	GI082	DS15	AT006	7028436
	DSDNN 3232 P 19	32	32	32	16.5	170	49.5	-6	-6	2.99	GI026	DS19	–	7028437
	DSDNN 4040 S 25	40	40	40	21	250	57.2	-6	-6	6.90	GI027	DS25	–	7028438

GI029	SN.. 43.. (SN.. 1204..)
GI082	SN.. 54.. (SN.. 1506..)
GI026	SN.. 64.. (SN.. 1906..)
GI027	SN.. 85.. (SN.. 2507..)

		Nm				
DS12	DCS 12	3.9	DSS 425-01	US 2002-T15P	FLAG T15P/3,5	–
DS15	DCS 16	6.4	DSS 425-03	US 2007-T20P	–	LK T20P
DS19	DCS 19	6.4	DSS 425-04	US 2007-T20P	–	LK T20P
DS25	DCS 25	9.5	DSS 425-07	US 2008-T25P	–	LK T25P

AT003a	SN.. 1207..	–	DSS 425-02
AT006a	SN.. 1507..	–	DSS 425-05
AT003b	CER SN.N 1204..	DCS 12C4	–
AT003c	CER SN.A 1204..	DCS 12C2	–
AT006b	CER CN.N 1606..	DCS 16C4	–
AT006c	CER CN.A 1606..	DCS 16C2	–

IDSDNN EXT

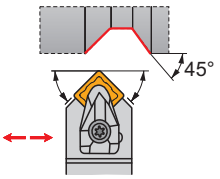
P M K N S H

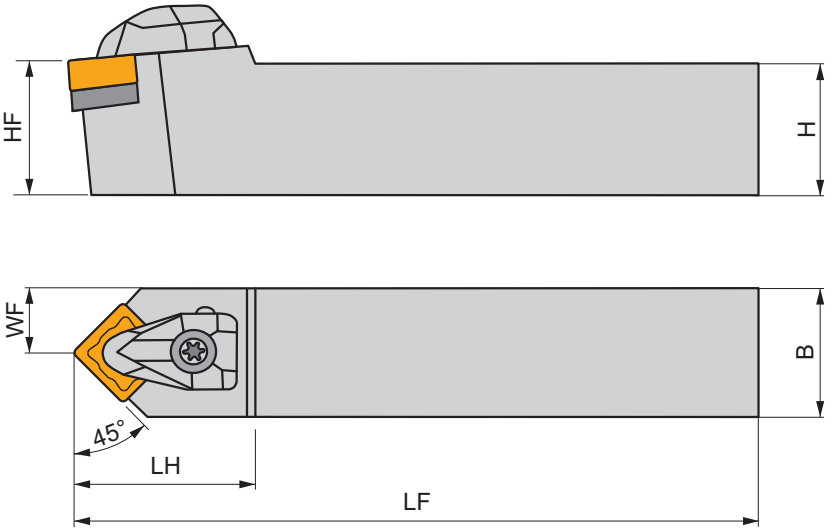
PRAMET

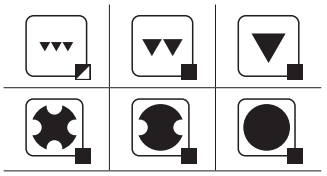
D

External Double Clamp Holder with 45° Cutting Angle for SN.. Inserts

External neutral double clamp tool holder with 45° cutting angle. Suited for longitudinal turning without shoulder, copy, taper and chamfer turning with negative SN.. inserts. Body treated for longer tool life.







	Product	H (inch)	B (inch)	HF (inch)	WF (inch)	LF (inch)	LH (inch)	LAMS (°)	GAMO (°)	lbs			MID
N	**DSDNN 12 4B**	.750	.750	.750	.386	4.500	1.450	-6	-6	.88	GI029	DS12	6788590
	DSDNN 16 4D	1.000	1.000	1.000	.512	6.000	1.450	-6	-6	1.54	GI029	DS12	6788591
	DSDNN 20 5D	1.250	1.250	1.250	.646	6.000	1.760	-6	-6	2.76	GI082	DS15	6788592
	DSDNN 20 6D	1.250	1.250	1.250	.646	6.000	1.970	-6	-6	2.76	GI026	DS19	6788593
	DSDNN 24 8D	1.500	1.500	1.500	.791	6.000	2.260	-6	-6	4.95	GI027	DS25	6788594

GI029	SN.. 43.. (SN.. 1204..)
GI082	SN.. 54.. (SN.. 1506..)
GI026	SN.. 64.. (SN.. 1906..)
GI027	SN.. 85.. (SN.. 2507..)

		Nm				
DS12	DCS 12	3.9	DSS 425-01	US 2002-T15P	FLAG T15P/3,5	–
DS15	DCS 16	6.4	DSS 425-03	US 2007-T20P	–	LK T20P
DS19	DCS 19	6.4	DSS 425-04	US 2007-T20P	–	LK T20P
DS25	DCS 25	9.5	DSS 425-07	US 2008-T25P	–	LK T25P

DSKN(RL) EXT

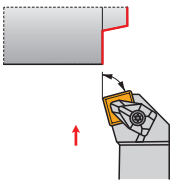
P M K N S H

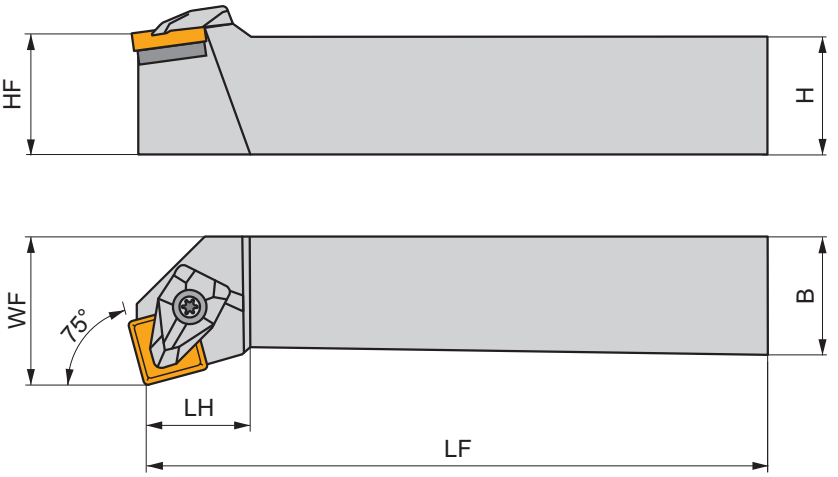
PRAMET

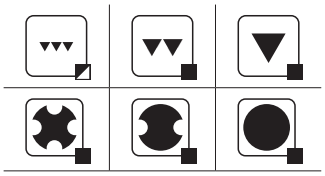
D

External Double Clamp Holder with 75° (Face) Cutting Angle for SN.. Inserts

External Right/Left hand double clamp tool holder with 75° cutting angle. Suited for facing without shoulder and chamfering with SN.. inserts. Body treated for longer tool life.







	Product	H (mm)	B (mm)	HF (mm)	WF (mm)	LF (mm)	LH (mm)	LAMS (°)	GAMO (°)	lbs				MID
R	**DSKNR 2525 M 12**	25	25	25	32	150	23.6	-6	-6	1.71	GI029	DS12	AT003	7028441
	DSKNR 3232 P 19	32	32	32	40	170	32.1	-6	-6	3.21	GI026	DS19	–	7028442
L	**DSKNL 2525 M 12**	25	25	25	32	150	23.6	-6	-6	1.74	GI029	DS12	AT003	7028439
	DSKNL 3232 P 19	32	32	32	40	170	32.1	-6	-6	3.21	GI026	DS19	–	7028440

GI029	SN.. 43.. (SN.. 1204..)
GI026	SN.. 64.. (SN.. 1906..)

		Nm				
DS12	DCS 12	3.9	DSS 425-01	US 2002-T15P	FLAG T15P/3,5	–
DS19	DCS 19	6.4	DSS 425-04	US 2007-T20P	–	LK T20P

AT003a	SN.. 1207..	–	DSS 425-02
AT003b	CER SN.N 1204..	DCS 12C4	–
AT003c	CER SN.A 1204..	DCS 12C2	–

IDSKN(RL) EXT

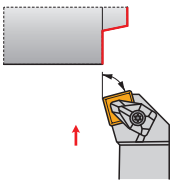
P M K N S H

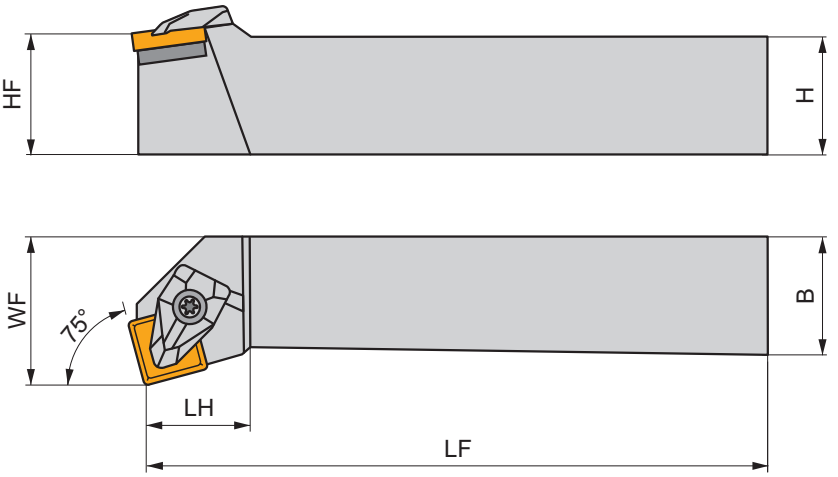
PRAMET

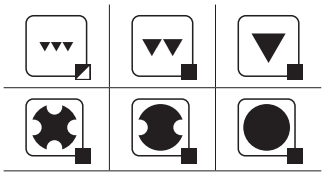
D

External Double Clamp Holder with 75° (Face) Cutting Angle for SN.. Inserts

External Right/Left hand double clamp tool holder with 75° cutting angle. Suited for facing without shoulder and chamfering with SN.. inserts. Body treated for longer tool life.







	Product	H (inch)	B (inch)	HF (inch)	WF (inch)	LF (inch)	LH (inch)	LAMS (°)	GAMO (°)	lbs			MID
R	**DSKNR 16 4D**	1.000	1.000	1.000	1.250	6.000	.930	-6	-6	1.54	GI029	DS12	6788597
	DSKNR 20 5D	1.250	1.250	1.250	1.500	6.000	1.140	-6	-6	2.76	GI082	DS15	6788598
L	**DSKNL 16 4D**	1.000	1.000	1.000	1.250	6.000	.930	-6	-6	1.54	GI029	DS12	6788595

GI029	SN.. 43.. (SN.. 1204..)
GI082	SN.. 54.. (SN.. 1506..)

		Nm				
DS12	DCS 12	3.9	DSS 425-01	US 2002-T15P	FLAG T15P/3,5	–
DS15	DCS 16	6.4	DSS 425-03	US 2007-T20P	–	LK T20P

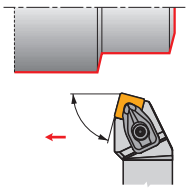
IDSRN(RL) EXT

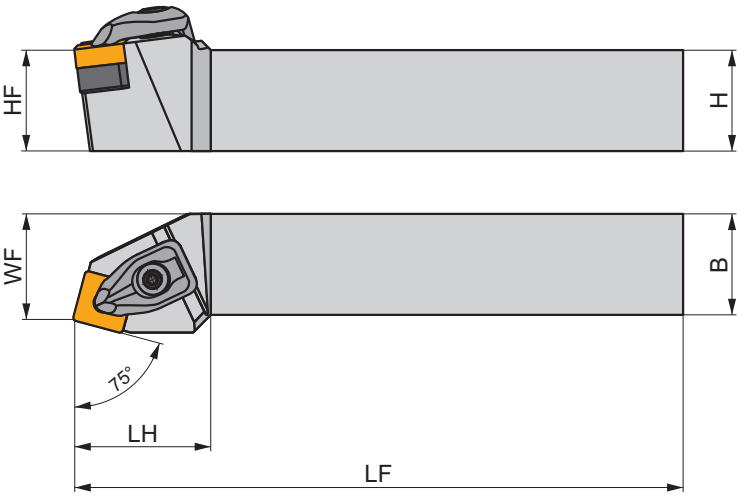
P M K N S H

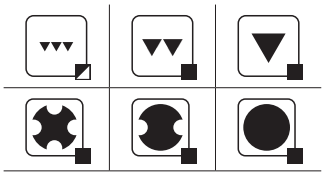
PRAMET

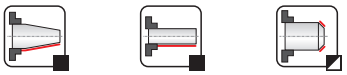
External Double Clamp Holder with 75° Cutting Angle for SN.. Inserts

External Right/Left hand double clamp 75° tool holder. Suited for taper and longitudinal turning and chamfering with negative SN.. inserts. Available with shanks .750x.750 up to 1.500x1.500 inch. Body treated for longer tool life.









	Product	H (inch)	B (inch)	HF (inch)	WF (inch)	LF (inch)	LAMS (°)	GAMO (°)	lbs			MID
R	DSRNR 16 4D	1.000	1.000	1.000	1.048	6.000	-6	-6	1.54	GI029	DS12	6788585
	DSRNR 20 5D	1.250	1.250	1.250	1.291	6.000	-6	-6	2.76	GI082	DS15	6788586
	DSRNR 24 6D	1.500	1.500	1.500	1.697	6.000	-6	-6	4.95	GI026	DS19	6788588
L	DSRNL 16 4D	1.000	1.000	1.000	1.048	6.000	-6	-6	1.54	GI029	DS12	6788579
	DSRNL 24 6D	1.500	1.500	1.500	1.697	6.000	-6	-6	4.95	GI026	DS19	6788582

GI029	SN.. 43.. (SN.. 1204..)
GI082	SN.. 54.. (SN.. 1506..)
GI026	SN.. 64.. (SN.. 1906..)

		Nm				
DS12	DCS 12	3.9	DSS 425-01	US 2002-T15P	FLAG T15P/3,5	–
DS15	DCS 16	6.4	DSS 425-03	US 2007-T20P	–	LK T20P
DS19	DCS 19	6.4	DSS 425-04	US 2007-T20P	–	LK T20P

DSSN(RL) EXT

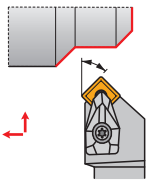
P M K N S H

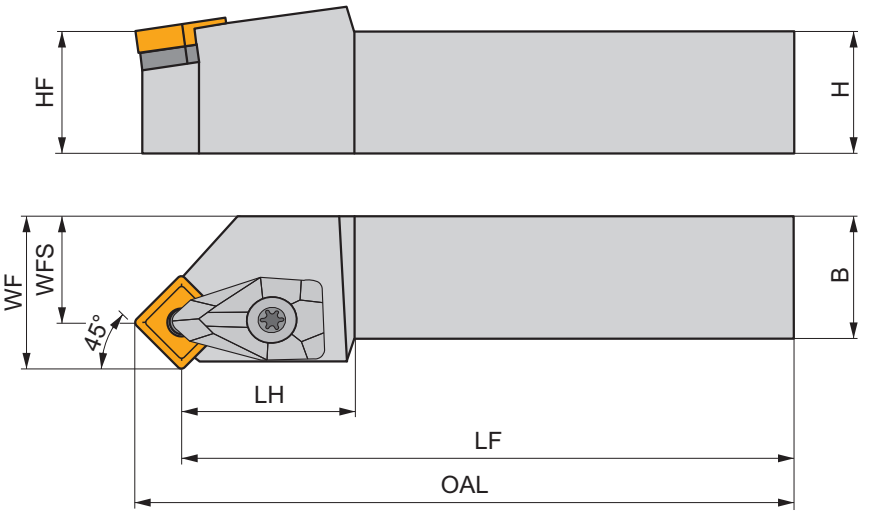
PRAMET

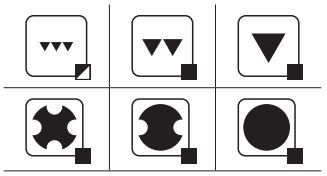
D

External Double Clamp Holder with 45° Cutting Angle for SN.. Inserts

External Right/Left hand double clamp tool holder with 45° cutting angle. Suited for longitudinal and facing without shoulder, taper, copy turning and chamfering with negative SN.. inserts. Body treated for longer tool life.







	Product	H (mm)	B (mm)	HF (mm)	WF (mm)	WFS (mm)	LF (mm)	OAL (mm)	LH (mm)	LAMS (°)	GAMO (°)	lbs				MID
R	**DSSNR 2020 K 12**	20	20	20	25	16.7	125	133.3	27.5	0	-8	.99	GI029	DS12	AT003	7028449
	DSSNR 2525 M 12	25	25	25	32	23.7	150	158.3	27.5	0	-8	1.76	GI029	DS12	AT003	7028450
	DSSNR 2525 M 15	25	25	25	32	21.8	150	160.2	32.0	0	-8	1.82	GI082	DS15	AT006	7028451
	DSSNR 3225 P 15	32	25	32	32	21.8	170	180.2	34.9	0	-8	2.55	GI082	DS15	AT006	7028452
	DSSNR 3232 P 19	32	32	32	40	27.5	170	182.5	37.0	0	-8	3.26	GI026	DS19	–	7028453
L	**DSSNL 2525 M 12**	25	25	25	32	23.7	150	158.3	27.5	0	-8	1.75	GI029	DS12	AT003	7028444
	DSSNL 2525 M 15	25	25	25	32	21.8	150	160.2	32.0	0	-8	1.82	GI082	DS15	AT006	7028445
	DSSNL 3225 P 15	32	25	32	32	21.8	170	180.2	34.9	0	-8	2.56	GI082	DS15	AT006	7028446
	DSSNL 3232 P 19	32	32	32	40	27.5	170	182.5	37.0	0	-8	3.26	GI026	DS19	–	7028447
	DSSNL 4040 S 19	40	40	40	50	37.5	250	262.5	37.7	0	-8	7.21	GI026	DS19	–	7028448

GI029	SN.. 43.. (SN.. 1204..)
GI082	SN.. 54.. (SN.. 1506..)
GI026	SN.. 64.. (SN.. 1906..)

		Nm				
DS12	DCS 12	3.9	DSS 425-01	US 2002-T15P	FLAG T15P/3,5	–
DS15	DCS 16	6.4	DSS 425-03	US 2007-T20P	–	LK T20P

DS19	DCS 19	6.4	DSS 425-04	US 2007-T20P	–	LKT20P

AT003a	SN.. 1207..	–	DSS 425-02
AT006a	SN.. 1507..	–	DSS 425-05
AT003b	CER SN.N 1204..	DCS 12C4	–
AT003c	CER SN.A 1204..	DCS 12C2	–
AT006b	CER CN.N 1606..	DCS 16C4	–
AT006c	CER CN.A 1606..	DCS 16C2	–

IDSSN(RL) EXT

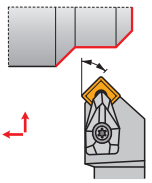
P M K N S H

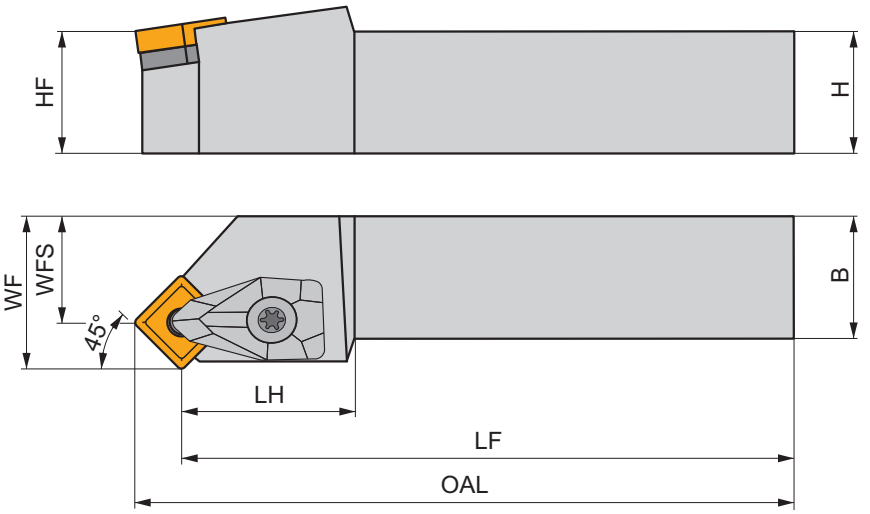
PRAMET

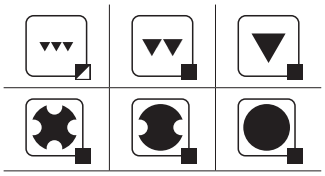
D

External Double Clamp Holder with 45° Cutting Angle for SN.. Inserts

External Right/Left hand double clamp tool holder with 45° cutting angle. Suited for longitudinal and facing without shoulder, taper, copy turning and chamfering with negative SN.. inserts. Body treated for longer tool life.







	Product	H (inch)	B (inch)	HF (inch)	WF (inch)	WFS (inch)	LF (inch)	OAL (inch)	LH (inch)	LAMS (°)	GAMO (°)	lbs				MID
R	DSSNR 12 4B	.750	.750	.750	1.000	.740	4.500	4.880	1.130	0	-8	.88	GI029	DS12	AT003	6788604
R	DSSNR 16 4D	1.000	1.000	1.000	1.250	.925	6.000	6.327	1.172	0	-8	1.54	GI029	DS12	AT003	6788605
R	DSSNR 20 5D	1.250	1.250	1.250	1.500	1.098	6.000	6.413	1.303	0	-8	2.76	GI082	DS15	AT006	6788606
R	DSSNR 24 6E	1.500	1.500	1.500	2.000	1.508	7.000	7.492	1.484	0	-8	6.18	GI026	DS19	–	6788608
L	DSSNL 16 4D	1.000	1.000	1.000	1.250	.925	6.000	6.327	1.172	0	-8	1.54	GI029	DS12	AT003	6788600
L	DSSNL 20 5D	1.250	1.250	1.250	1.500	1.098	6.000	6.413	1.303	0	-8	2.76	GI082	DS15	AT006	6788601

GI029	SN.. 43.. (SN.. 1204..)
GI082	SN.. 54.. (SN.. 1506..)
GI026	SN.. 64.. (SN.. 1906..)

		Nm				
DS12	DCS 12	3.9	DSS 425-01	US 2002-T15P	FLAG T15P/3,5	–
DS15	DCS 16	6.4	DSS 425-03	US 2007-T20P	–	LK T20P
DS19	DCS 19	6.4	DSS 425-04	US 2007-T20P	–	LK T20P

AT003a	SN.. 1207..	–	DSS 425-02
AT006a	SN.. 1507..	–	DSS 425-05
AT003b	CER SN.N 1204..	DCS 12C4	–
AT003c	CER SN.A 1204..	DCS 12C2	–
AT006b	CER CN.N 1606..	DCS 16C4	–
AT006c	CER CN.A 1606..	DCS 16C2	–

PSBN(RL) EXT

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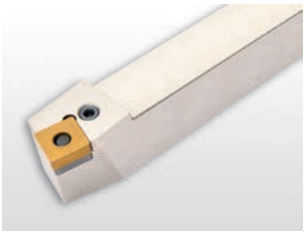
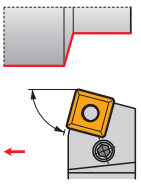
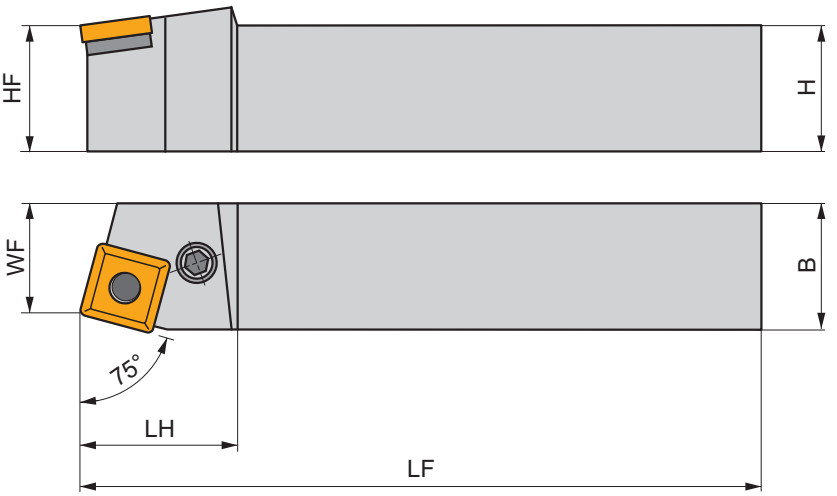
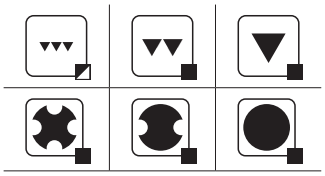


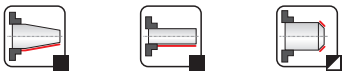
External Lever Lock Holder with 75° Cutting Angle for SN.. Inserts

External Right/Left hand lever lock tool holder with 75° cutting angle. Suited for longitudinal turning without shoulder, taper turning and chamfering with negative SN.. inserts. Body treated for longer tool life.









	Product	H (mm)	B (mm)	HF (mm)	WF (mm)	LF (mm)	LH (mm)	LAMS (°)	GAMO (°)	lbs			MID
R	**PSBNR 2020 K 12**	20	20	20	17	125	36.0	-6	-6	.93	GI029	PS01	6756985
	PSBNR 2525 M 12	25	25	25	22	150	28.0	-6	-6	1.63	GI029	PS01	6757226
	PSBNR 3232 P 15	32	32	32	27	170	34.0	-6	-6	2.92	GI082	PS04	8281401
	PSBNR 3232 P 19	32	32	32	27	170	42.0	-6	-6	2.87	GI026	PS02	6756685
	PSBNR 4040 S 19	40	40	40	35	250	48.0	-6	-6	6.83	GI026	PS02	6757912
	PSBNR 4040 S 25	40	40	40	35	250	48.0	-6	-6	6.28	GI027	PS03	6757238
	PSBNR 4040 S 2509	40	40	40	35	250	48.0	-6	-6	5.51	GI040	PS03	6756704
	PSBNR 4040 S 2512	40	40	40	35	250	48.0	-6	-6	6.61	GI162	PS05	8291185
	PSBNR 5050 T 2512	50	50	50	43	300	50.0	-6	-6	12.74	GI162	PS05	8291186
	PSBNR 5050 T 25	50	50	50	43	300	50.0	-6	-6	12.43	GI027	PS03	6758287
	PSBNR 5050 T 2509	50	50	50	43	300	50.0	-6	-6	12.13	GI040	PS03	6756706
L	**PSBNL 2020 K 12**	20	20	20	17	125	28.0	-6	-6	.87	GI029	PS01	6757051
	PSBNL 2525 M 12	25	25	25	22	150	28.0	-6	-6	1.62	GI029	PS01	6757071
	PSBNL 3232 P 15	32	32	32	27	170	34.0	-6	-6	2.93	GI082	PS04	8281400
	PSBNL 4040 S 2512	40	40	40	35	250	48.0	-6	-6	6.86	GI162	PS05	8291183
	PSBNL 5050 T 2512	50	50	50	43	300	50.0	-6	-6	12.71	GI162	PS05	8291184
	PSBNL 3232 P 19	32	32	32	27	170	42.0	-6	-6	2.94	GI026	PS02	6756958
	PSBNL 4040 S 19	40	40	40	35	250	48.0	-6	-6	6.82	GI026	PS02	6757913
	PSBNL 4040 S 25	40	40	40	35	250	48.0	-6	-6	6.76	GI027	PS03	6757239
	PSBNL 4040 S 2509	40	40	40	35	250	50.0	-6	-6	5.51	GI040	PS03	6756705
	PSBNL 5050 T 25	50	50	50	43	300	50.0	-6	-6	12.87	GI027	PS03	6758286
	PSBNL 5050 T 2509	50	50	50	43	300	50.0	-6	-6	12.79	GI040	PS03	6756707

GI029	SN.. 43.. (SN.. 1204..)
GI082	SN.. 54.. (SN.. 1506..)
GI026	SN.. 64.. (SN.. 1906..)
GI027	SN.. 85.. (SN.. 2507..)
GI040	SN.. 86.. (SN.. 2509..)
GI162	SN.. 2512.. (SN.. 2512..)

PS01	PSS 512	CL 012	CS 608	3.0	M 8x1	0.815	TR 12	MT 05	HXK 3
PS02	PSS 519	CL 019	CS 610	3.5	M 10x1	1.071	TR 19	MT 06	HXK 4
PS03	PSS 525	CL 025	CS 612	4.0	M 12x1	1.417	TR 25	MT 08	HXK 5
PS04	PSS 515	CL 016	CS 618	3.0	M 8x1	0.886	TR 15	MT 07	HXK 3
PS05	SNU 250624	PU 10-N	PS 12040	8.0	M 12x1	1.575	NT 08	MT 08	HXK 5

PSDNN EXT

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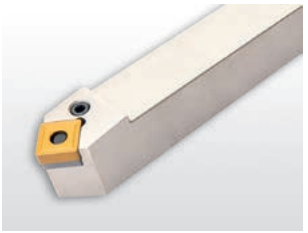
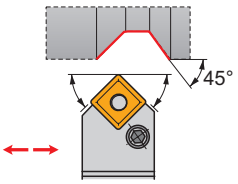
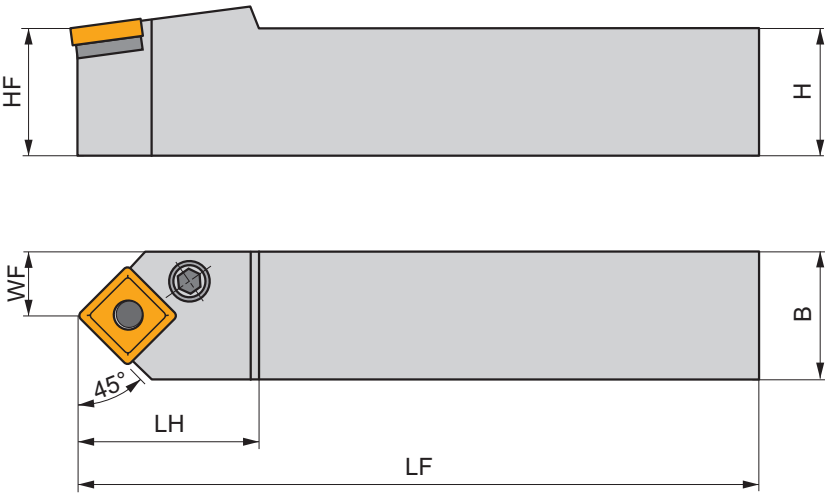
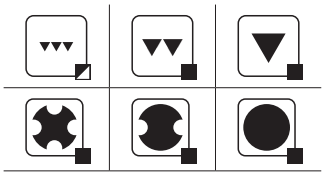


External Lever Lock Holder with 45° Cutting Angle for SN.. Inserts

External neutral lever lock tool holder with 45° cutting angle. Suited for longitudinal turning without shoulder, copy and taper turning and chamfering with negative SN.. inserts. Body treated for longer tool life.







	Product	H (mm)	B (mm)	HF (mm)	WF (mm)	LF (mm)	LH (mm)	LAMS (°)	GAMO (°)	lbs			MID
N	**PSDNN 2020 K 12**	20	20	20	10	125	28.0	-5	-5	.86	GI029	PS01	6757038
	PSDNN 2525 M 12	25	25	25	12.5	150	28.0	-5	-5	1.50	GI029	PS01	6756906
	PSDNN 3232 P 15	32	32	32	16	170	34.0	-5	-5	2.87	GI082	PS04	6757040
	PSDNN 3232 P 19	32	32	32	16	170	42.0	-5	-5	2.76	GI026	PS02	6756689
	PSDNN 4040 S 19	40	40	40	20	250	42.0	-5	-5	6.68	GI026	PS02	6758535
	PSDNN 4040 S 25	40	40	40	20	250	48.0	-5	-5	6.66	GI027	PS03	6758536
	PSDNN 5050 T 25	50	50	50	25	300	50.0	-5	-5	12.46	GI027	PS03	6758537

GI029	SN.. 43.. (SN.. 1204..)
GI082	SN.. 54.. (SN.. 1506..)
GI026	SN.. 64.. (SN.. 1906..)
GI027	SN.. 85.. (SN.. 2507..)

				Nm					
PS01	PSS 512	CL 012	CS 608	3.0	M 8x1	0.815	TR 12	MT 05	HXK 3
PS02	PSS 519	CL 019	CS 610	3.5	M 10x1	1.071	TR 19	MT 06	HXK 4
PS03	PSS 525	CL 025	CS 612	4.0	M 12x1	1.417	TR 25	MT 08	HXK 5
PS04	PSS 515	CL 016	CS 618	3.0	M 8x1	0.886	TR 15	MT 07	HXK 3

PSKN(RL) EXT

P M K N S H

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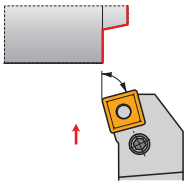
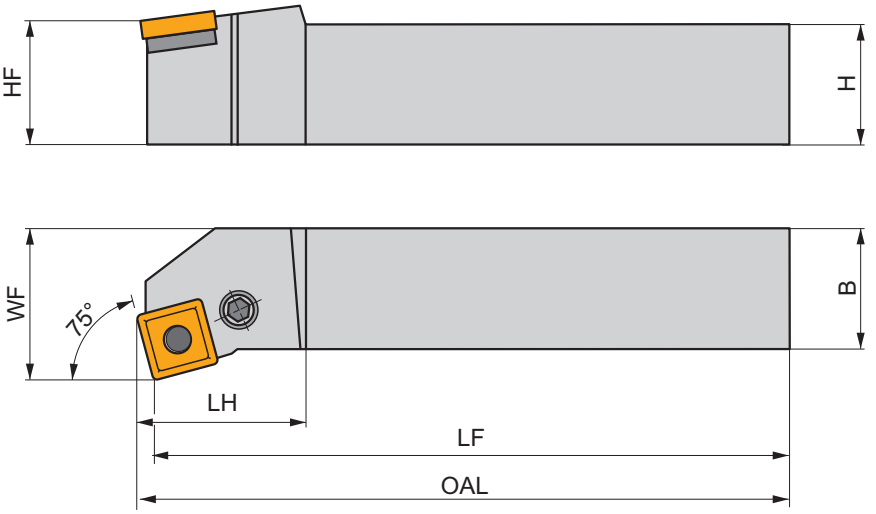
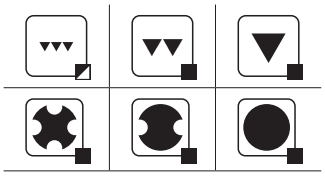
External Lever Lock Holder, 75° (Face Turning) Cutting Angle for SN.. Inserts

External Right/Left hand lever lock tool holder with 75° cutting angle. Suited for face turning without shoulder and chamfering with negative SN.. inserts. Body treated for longer tool life.







	Product	H (mm)	B (mm)	HF (mm)	WF (mm)	LF (mm)	OAL (mm)	LH (mm)	LAMS (°)	GAMO (°)	lbs			MID
R	PSKNR 2020 K 12	20	20	20	25	125	128.1	28.0	-6	-6	.93	GI029	PS01	6756988
	PSKNR 2525 M 12	25	25	25	32	150	153.1	28.0	-6	-6	1.67	GI029	PS01	6756688
	PSKNR 3232 P 19	32	32	32	40	170	174.6	45.0	-6	-6	3.09	GI026	PS02	6756989
	PSKNR 4040 S 19	40	40	40	50	250	254.6	45.0	-6	-6	7.11	GI026	PS02	6758445
	PSKNR 4040 S 25	40	40	40	50	250	256.5	50.0	-6	-6	7.23	GI027	PS03	6758504
	PSKNR 3232 P 15	32	32	32	40	170	173.9	42.0	-6	-6	3.08	GI082	PS04	8281403
	PSKNR 5050 T 25	50	50	50	60	300	306.5	50.0	-6	-6	13.34	GI027	PS03	6758289
	PSKNR 5050 T 2509	50	50	50	60	300	306.5	50.0	-6	-6	13.67	GI040	PS03	6756708
L	PSKNL 2020 K 12	20	20	20	25	125	128.1	28.0	-6	-6	.92	GI029	PS01	6757197
	PSKNL 2525 M 12	25	25	25	32	150	153.1	28.0	-6	-6	1.68	GI029	PS01	6757064
	PSKNL 3232 P 15	32	32	32	40	170	173.9	42.0	-6	-6	2.31	GI082	PS04	8281402
	PSKNL 3232 P 19	32	32	32	40	170	174.6	42.0	-6	-6	3.12	GI026	PS02	6757065
	PSKNL 4040 S 19	40	40	40	50	250	254.6	45.0	-6	-6	7.19	GI026	PS02	6758538
	PSKNL 4040 S 25	40	40	40	50	250	256.5	50.0	-6	-6	7.23	GI027	PS03	6758512
	PSKNL 5050 T 25	50	50	50	60	300	306.5	50.0	-6	-6	13.23	GI027	PS03	6758288
	PSKNL 5050 T 2509	50	50	50	60	300	306.5	50.0	-6	-6	13.67	GI040	PS03	6756709

GI029	SN.. 43.. (SN.. 1204..)
GI082	SN.. 54.. (SN.. 1506..)
GI026	SN.. 64.. (SN.. 1906..)
GI027	SN.. 85.. (SN.. 2507..)
GI040	SN.. 86.. (SN.. 2509..)

				Nm					
PS01	PSS 512	CL 012	CS 608	3.0	M 8x1	0.815	TR 12	MT 05	HXK 3
PS02	PSS 519	CL 019	CS 610	3.5	M 10x1	1.071	TR 19	MT 06	HXK 4
PS03	PSS 525	CL 025	CS 612	4.0	M 12x1	1.417	TR 25	MT 08	HXK 5
PS04	PSS 515	CL 016	CS 618	3.0	M 8x1	0.886	TR 15	MT 07	HXK 3

PSSN(RL) EXT

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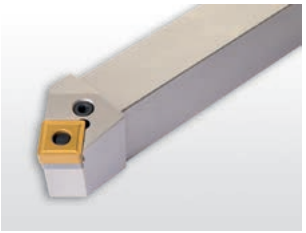
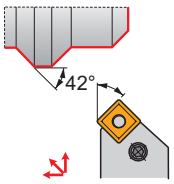
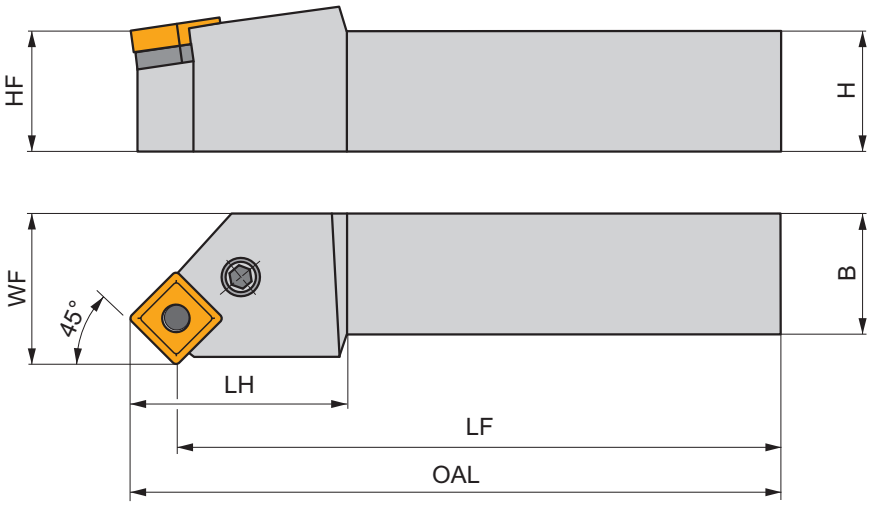
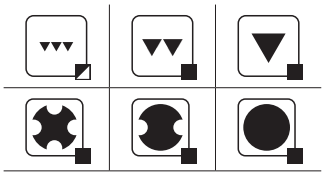


External Lever Lock Holder with 45° Cutting Angle for SN.. Inserts

External Right/Left hand lever lock tool holder with 45° cutting angle. Suited for longitudinal and face turning without shoulder, copy and taper turning and chamfering with negative SN.. inserts. Body treated for longer tool life.







	Product	H (mm)	B (mm)	HF (mm)	WF (mm)	LF (mm)	OAL (mm)	LH (mm)	LAMS (°)	GAMO (°)	lbs			MID
R	PSSNR 2020 K 12	20	20	20	25	125	133.3	28.0	0	-8	.92	GI029	PS01	6756909
	PSSNR 2525 M 12	25	25	25	32	150	158.3	28.0	0	-8	1.65	GI029	PS01	6756899
	PSSNR 3225 P 15	32	25	32	32	170	180.2	42.0	0	-8	2.44	GI082	PS04	6757130
	PSSNR 3232 P 19	32	32	32	40	170	182.5	45.0	0	-8	3.14	GI026	PS02	6756897
	PSSNR 4040 S 19	40	40	40	50	250	262.5	45.0	0	-8	7.01	GI026	PS02	8281405
	PSSNR 5050 T 2509	50	50	50	60	300	316	50.0	0	-8	13.35	GI040	PS03	6757888
L	PSSNL 2020 K 12	20	20	20	25	125	133.3	28.0	0	-8	.90	GI029	PS01	6757155
	PSSNL 2525 M 12	25	25	25	32	150	158.3	28.0	0	-8	1.67	GI029	PS01	6757066
	PSSNL 3225 P 15	32	25	32	32	170	180.2	42.0	0	-8	2.49	GI082	PS04	6757067
	PSSNL 3232 P 19	32	32	32	40	170	182.5	45.0	0	-8	3.15	GI026	PS02	6756738
	PSSNL 4040 S 19	40	40	40	50	250	262.5	45.0	0	-8	6.97	GI026	PS02	8281404
	PSSNL 5050 T 25	50	50	50	60	300	316	50.0	0	-8	13.23	GI027	PS03	6758290
	PSSNL 5050 T 2509	50	50	50	60	300	316	50.0	0	-8	13.19	GI040	PS03	6757889

GI029	SN.. 43.. (SN.. 1204..)
GI082	SN.. 54.. (SN.. 1506..)
GI026	SN.. 64.. (SN.. 1906..)
GI027	SN.. 85.. (SN.. 2507..)
GI040	SN.. 86.. (SN.. 2509..)

				Nm					
PS01	PSS 512	CL 012	CS 608	3.0	M 8x1	0.815	TR 12	MT 05	HXK 3
PS02	PSS 519	CL 019	CS 610	3.5	M 10x1	1.071	TR 19	MT 06	HXK 4
PS03	PSS 525	CL 025	CS 612	4.0	M 12x1	1.417	TR 25	MT 08	HXK 5
PS04	PSS 515	CL 016	CS 618	3.0	M 8x1	0.886	TR 15	MT 07	HXK 3

C.-DSDNN EXT

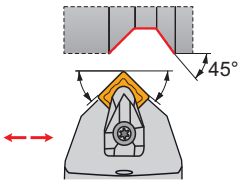
P M K N S H

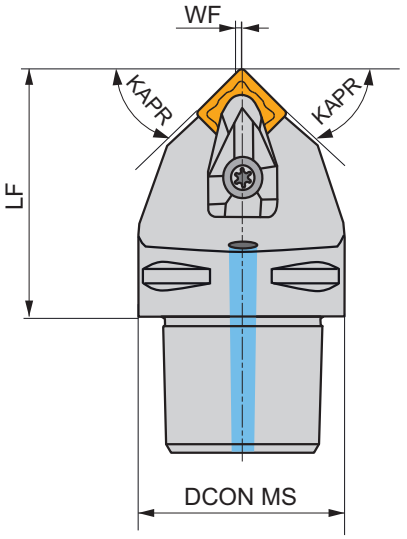
PRAMET

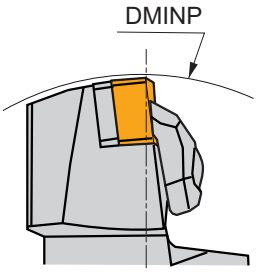
D

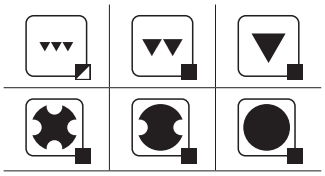
External PSC Quick Change Tool, Double Clamp, 45° Cutting Angle, SN.. Inserts

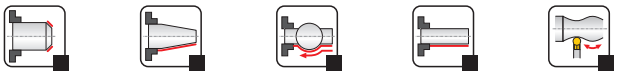
External neutral double clamp tool, through coolant, with 45° cutting angle for longitudinal turning without shoulder, copy turning, taper turning and chamfer turning with negative SN.. inserts. Polygon Shank Coupling. Body treated for longer tool life.











	Product	DCON MS (mm)	DMINP (mm)	WF (mm)	LF (mm)	KAPR (°)	LAMS (°)	GAMO (°)		lbs				MID
N	C4-DSDNN-00050-12	40	140	0.3	50	45	-6	-6	✓	.86	GI029	C-DS12-2	AT003	7809803
	C5-DSDNN-00060-12	50	165	0.3	60	45	-6	-6	✓	1.52	GI029	C-DS12-2	AT003	7809804
	C6-DSDNN-00070-19	63	195	0.5	70	45	-6	-6	✓	2.82	GI026	C-DS19	–	7809805

GI029	SN.. 43.. (SN.. 1204..)
GI026	SN.. 64.. (SN.. 1906..)

C-DS12-2	DCS 12	3.9	DSS 425-01	US 2002-T15P	FLAG T15P/3,5	–	CN 045-01
C-DS19	DCS 19	6.4	DSS 425-04	US 2007-T20P	–	LK T20P	CN 045-01

AT003a	SN.. 1207..	–	DSS 425-02
AT003b	CER SN.N 1204..	DCS 12C4	–
AT003c	CER SN.A 1204..	DCS 12C2	–

C.-DSKN(RL) EXT

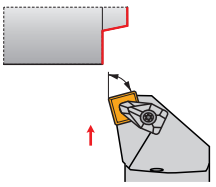
P M K N S H

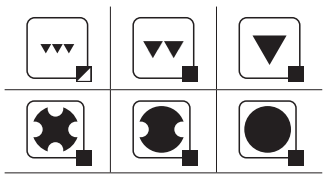
PRAMET

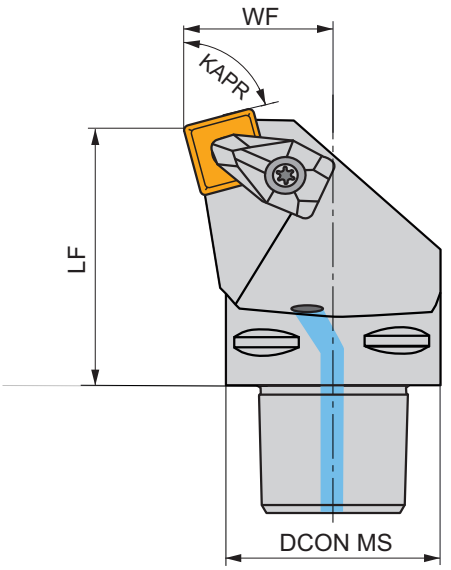
D

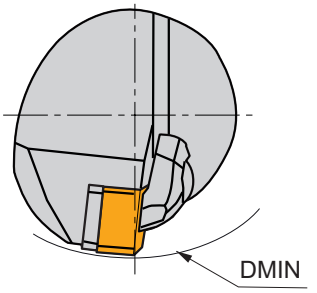
Ext. PSC Quick Change Tool, Double Clamp, 75° (Face) Cutting Angle, SN.. Inserts

External Right/Left hand double clamp tool, through coolant, with 75° cutting angle for face turning without shoulder and chamfering with negative SN.. inserts. Polygon Shank Coupling. Body treated for longer tool life.









	Product	DCON MS (mm)	DMIN (mm)	WF (mm)	LF (mm)	KAPR (°)	LAMS (°)	GAMO (°)		lbs				MID
R	C4-DSKNR-27050-12	40	110	27	50	75	-6	-6	✓	1.02	GI029	C-DS12-1	AT003	7809807
L	C4-DSKNL-27050-12	40	110	27	50	75	-6	-6	✓	1.02	GI029	C-DS12-1	AT003	7809806

GI029	SN.. 43.. (SN.. 1204..)

C-DS12-1	DCS 12	3.9	DSS 425-01	US 2002-T15P	FLAG T15P/3,5	CN 034-01

AT003a	SN.. 1207..	–	DSS 425-02
AT003b	CER SN.N 1204..	DCS 12C4	–
AT003c	CER SN.A 1204..	DCS 12C2	–

C.-DSRN(RL) EXT

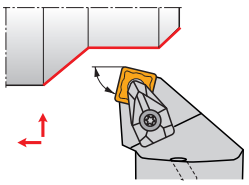
P M K N S H

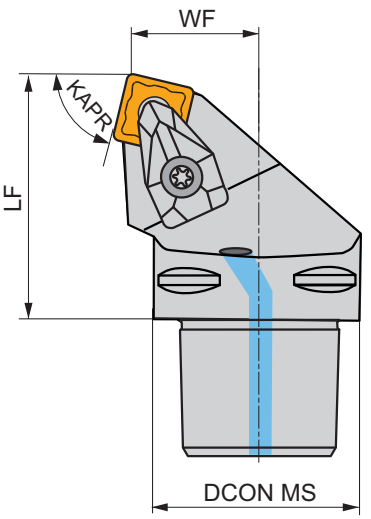
PRAMET

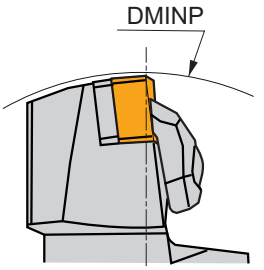
D

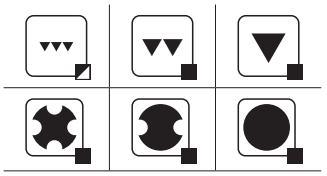
External PSC Quick Change Tool, Double Clamp, 75° Cutting Angle, SN.. Inserts

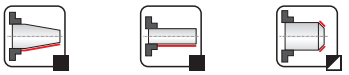
External Right/Left hand double clamp tool, through coolant, with 75° cutting angle for longitudinal turning without shoulder, taper turning and chamfering with negative SN.. inserts. Polygon Shank Coupling. Body treated for longer tool life.











	Product	DCON MS (mm)	DMINP (mm)	WF (mm)	LF (mm)	KAPR (°)	LAMS (°)	GAMO (°)		lbs				MID
R	C4-DSRNR-22050-12	40	140	22	50	75	-6	-6	✓	.88	GI029	C-DS12-1	AT003	7809796
	C6-DSRNR-35065-19	63	190	35	65	75	-6	-6	✓	2.86	GI026	C-DS19	–	7809798
L	C4-DSRNL-22050-12	40	140	22	50	75	-6	-6	✓	.91	GI029	C-DS12-1	AT003	7809795
	C6-DSRNL-35065-19	63	190	35	65	75	-6	-6	✓	2.86	GI026	C-DS19	–	7809797

GI029	SN.. 43.. (SN.. 1204..)
GI026	SN.. 64.. (SN.. 1906..)

		Nm					
C-DS12-1	DCS 12	3.9	DSS 425-01	US 2002-T15P	FLAG T15P/3,5	–	CN 034-01
C-DS19	DCS 19	6.4	DSS 425-04	US 2007-T20P	–	LK T20P	CN 045-01

AT003a	SN.. 1207..	–	DSS 425-02
AT003b	CER SN.N 1204..	DCS 12C4	–
AT003c	CER SN.A 1204..	DCS 12C2	–

C.-DSSN(RL) EXT

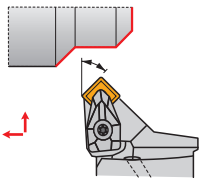
P M K N S H

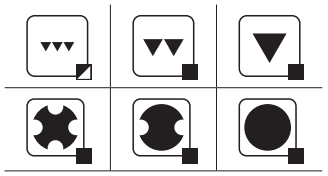
PRAMET

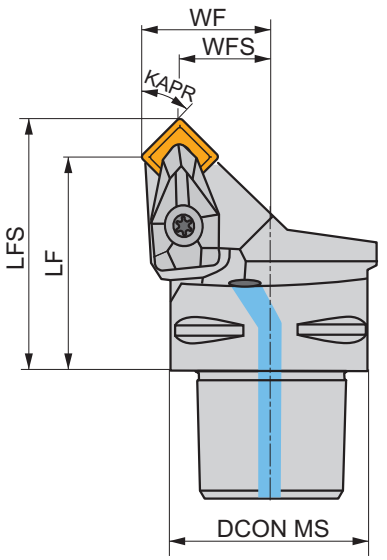
D

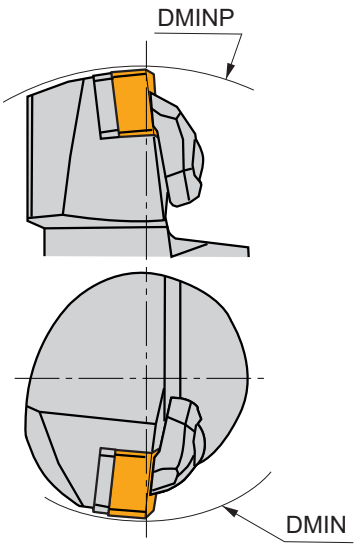
External PSC Quick Change Tool, Double Clamp, 45° Cutting Angle, SN.. Inserts

External Right/Left hand double clamp tool, through coolant, with 45° cutting angle for longitudinal and face turning without shoulder, taper turning, copy turning and chamfering with negative SN.. insert. Polygon Shank Coupling. Body treated for longer tool life.









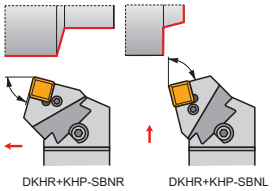
	Product	DCON MS (mm)	DMIN (mm)	DMINP (mm)	WF (mm)	WFS (mm)	LF (mm)	LFS (mm)	KAPR (°)	LAMS (°)	GAMO (°)		lbs				MID
R	**C4-DSSNR-27042-12**	40	110	140	27	18.7	42	50.3	45	0	-8	✓	.83	GI029	C-DS12-1	AT003	7809800
	C5-DSSNR-35052-12	50	110	165	35	26.7	52	60.3	45	0	-8	✓	1.51	GI029	C-DS12-3	AT003	7809802
L	**C4-DSSNL-27042-12**	40	110	140	27	18.7	42	50.3	45	0	-8	✓	.79	GI029	C-DS12-1	AT003	7809799
	C5-DSSNL-35052-12	50	110	165	35	26.7	52	60.3	45	0	-8	✓	1.51	GI029	C-DS12-3	AT003	7809801

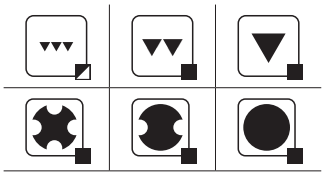
GI029	SN.. 43.. (SN.. 1204..)

		Nm				
C-DS12-1	DCS 12	3.9	DSS 425-01	US 2002-T15P	FLAG T15P/3,5	CN 034-01
C-DS12-3	DCS 12	3.9	DSS 425-01	US 2002-T15P	FLAG T15P/3,5	CN 034-02

AT003a	SN.. 1207..	–	DSS 425-02
AT003b	CER SN.N 1204..	DCS 12C4	–
AT003c	CER SN.A 1204..	DCS 12C2	–

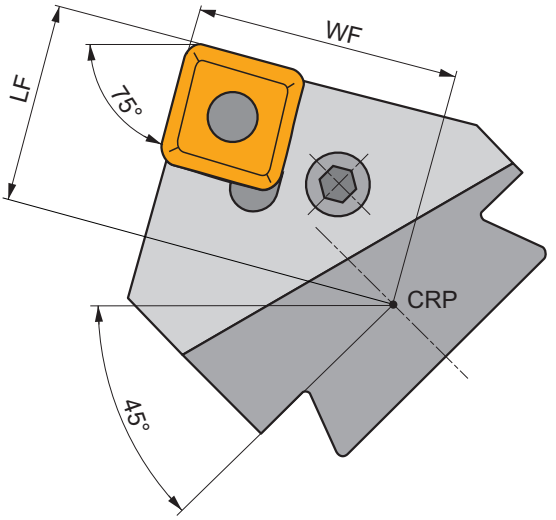
KHP-SBN(RL)





Modular KHP Lever Lock Turning Cartridge, 75° Cutting Angle for SN.. Inserts

Dovetailed Right/Left hand lever lock turning cartridge, 75° cutting angle, for mounting on DKH tool holder shank. Suited for heavy longitudinal turning without shoulder, face turning, taper and chamfer turning with negative SN.. inserts. Tool holder treated for longer tool life.

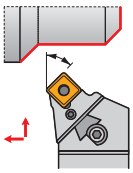


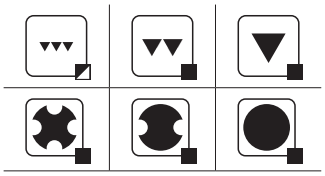
	Product	WF (mm)	LF (mm)	LAMS (°)	GAMO (°)	lbs			MID
R	KHP-SBNR 19	47	36	-6	-6	3.33	GI026	PS50	7045621
	KHP-SBNR 25	47	36	-6	-6	3.24	GI027	PS60	6758298
	KHP-SBNR 2509	47	36	-6	-6	3.20	GI040	PS70	6758299
L	KHP-SBNL 19	47	36	-6	-6	4.22	GI026	PS50	7045620
	KHP-SBNL 25	47	36	-6	-6	3.26	GI027	PS60	6758296
	KHP-SBNL 2509	47	36	-6	-6	3.22	GI040	PS70	6758297

GI026	SN.. 64.. (SN.. 1906..)
GI027	SN.. 85.. (SN.. 2507..)
GI040	SN.. 86.. (SN.. 2509..)

				Nm					
PS50	SNU 190416	PU 05	US 38	8.0	M 10x1	1.142	NT 06	MT 06	HXK 5
PS60	SNU 250624	PU 06	US 39	8.0	M 10x1	1.299	NT 08	MT 08	HXK 5
PS70	SNU 250624	PU 06	US 47	8.0	M 12x1	1.417	NT 08	MT 08	HXK 5

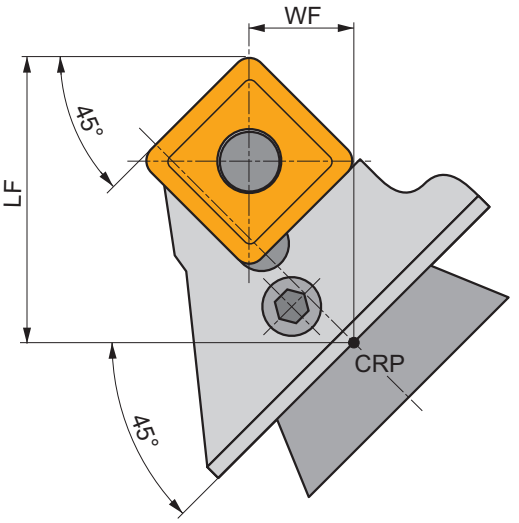
KHP-SSN(RL)

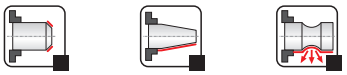




Modular KHP Lever Lock Turning Cartridge, 45° Cutting Angle for SN.. Inserts

Dovetailed Right/Left hand lever lock turning cartridge, 45° cutting angle, for mounting on DKH tool holder shank. Suited for heavy longitudinal turning without shoulder, face turning, copy, taper and chamfer turning with negative SN.. inserts. Tool holder treated for longer tool life.





	Product	WF (mm)	LF (mm)	LAMS (°)	GAMO (°)	lbs			MID
R	KHP-SSNR 25	15	45	-6	-6	2.16	GI027	PS60	6757321
L	KHP-SSNL 25	15	45	-6	-6	2.87	GI027	PS60	6757222

GI027	SN.. 85.. (SN.. 2507..)

PS60	SNU 250624	PU 06	US 39	8.0 Nm	M 10x1	1.299	NT 08	MT 08	HXK 5

PSKN(RL) INT

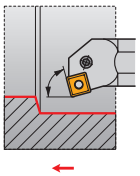
P M K N S H

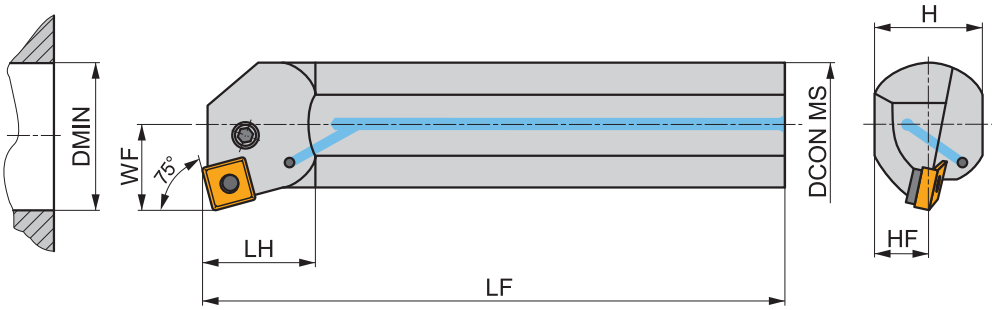
PRAMET

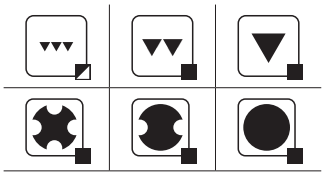
P

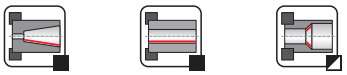
Internal Lever Lock Boring Bar with 75° Cutting Angle for SN.. Inserts

Internal Right/Left hand lever lock boring bar, through coolant, 75° cutting angle for SN.. inserts. For internal taper and longitudinal turning without shoulder and chamfer turning. Body treated for longer tool life.









	Product	DCON MS (mm)	DMIN (mm)	WF (mm)	H (mm)	B (mm)	LF (mm)	LAMS (°)	GAMO (°)		lbs			MID
R	A32S-PSKNR 12	32	39	22	30	30	250	-10	-6	✓	3.20	GI029	PS06	6757329
	A40T-PSKNR 15	40	48	27	37	38	300	-11	-6	✓	5.73	GI082	PS04	6757309
	A50U-PSKNR 15	50	61	35	47	48.49	350	-11	-6	✓	11.46	GI082	PS04	6757310
	A50U-PSKNR 19	50	63	35	47	48.5	350	-12	-6	✓	11.46	GI026	PS07	6757211
L	A50U-PSKNL 15	50	61	35	47	48.49	350	-11	-6	✓	11.46	GI082	PS04	6757313

GI029	SN.. 43.. (SN.. 1204..)
GI082	SN.. 54.. (SN.. 1506..)
GI026	SN.. 64.. (SN.. 1906..)

				Nm					
PS04	PSS 515	CL 016	CS 618	3.0	M 8x1	0.886	TR 15	MT 07	HXK 3
PS06	PSS 512	CL 312	CS 648	3.0	M 8x1	0.669	TR 12	MT 05	HXK 3
PS07	PSS 519	CL 219	CS 710	3.5	M 10x1	1.197	TR 29	MT 06	HXK 4

DTFN(RL) EXT

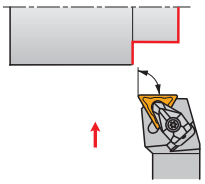
P M K N S H

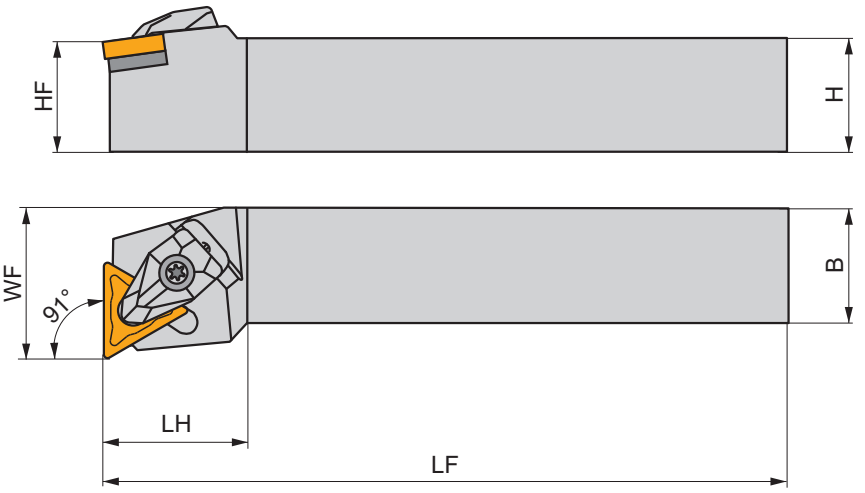
PRAMET

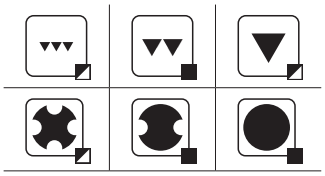
D

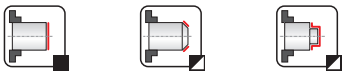
External Double Clamp Holder with 91° (Face) Cutting Angle for TN.. Inserts

External Right/Left hand double clamp tool holder with 91° cutting angle. Suited for face turning with shoulder and chamfering with negative TN.. inserts. Body treated for longer tool life.









	Product	H (mm)	B (mm)	HF (mm)	WF (mm)	LF (mm)	LH (mm)	LAMS (°)	GAMO (°)	lbs			MID
R	**DTFNR 2020 K 16**	20	20	20	25	125	23.6	-6	-6	.94	GI024	DT16	7028458
	DTFNR 2525 M 16	25	25	25	32	150	23.6	-6	-6	1.69	GI024	DT16	7028459
	DTFNR 2525 M 22	25	25	25	32	150	30.5	-6	-6	1.74	GI025	DT22	7028460
L	**DTFNL 2020 K 16**	20	20	20	25	125	23.6	-6	-6	.94	GI024	DT16	7028455
	DTFNL 2525 M 16	25	25	25	32	150	23.6	-6	-6	1.68	GI024	DT16	7028456

GI024	TN.. 33.. (TN.. 1604..)
GI025	TN.. 43.. (TN.. 2204..)

		Nm			
DT16	DCS 09	1.7	DTS 315-02	US 2004-T09P	FLAG T09P
DT22	DCS 12	3.9	DTS 315-04	US 2002-T15P	FLAG T15P/3,5

DTGN(RL) EXT

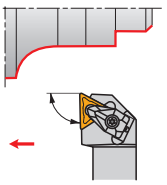
P M K N S H

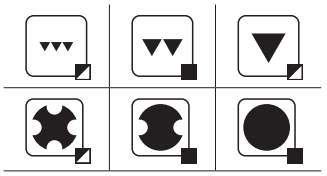
PRAMET

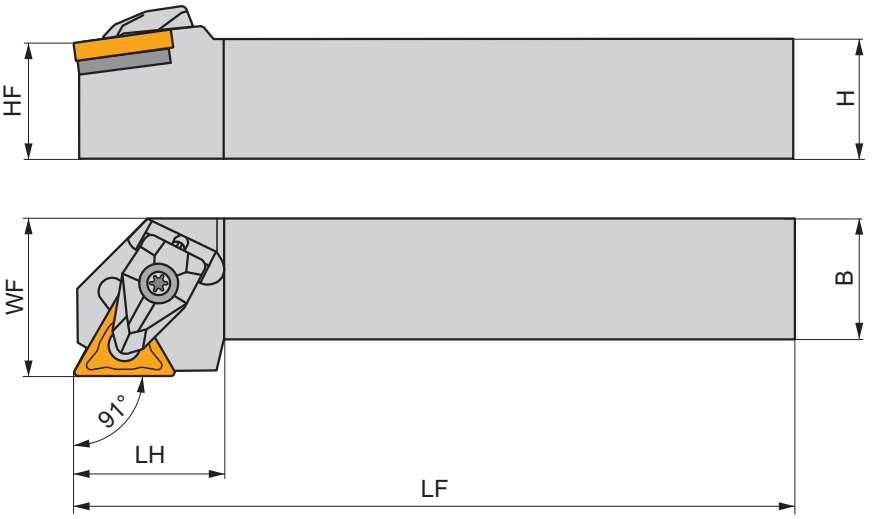
D

External Double Clamp Holder with 91° Cutting Angle for TN.. Inserts

External Right/Left hand double clamp tool holder with 91° cutting angle. Suited for longitudinal turning with shoulder, taper turning and chamfering with negative TN.. inserts. Body treated for longer tool life.







	Product	H (mm)	B (mm)	HF (mm)	WF (mm)	LF (mm)	LH (mm)	LAMS (°)	GAMO (°)	lbs			MID
R	DTGNR 2020 K 16	20	20	20	25	125	25.4	-6	-6	.94	GI024	DT16	6757948
	DTGNR 2525 M 16	25	25	25	32	150	24.6	-6	-6	1.68	GI024	DT16	6757950
	DTGNR 2525 M 22	25	25	25	32	150	32.1	-6	-6	1.79	GI025	DT22	6757952
	DTGNR 3232 P 22	32	32	32	40	170	33.1	-6	-6	3.12	GI025	DT22	7028462
L	DTGNL 2020 K 16	20	20	20	25	125	25.4	-6	-6	.97	GI024	DT16	6757949
	DTGNL 2525 M 16	25	25	25	32	150	24.6	-6	-6	1.72	GI024	DT16	6757951
	DTGNL 2525 M 22	25	25	25	32	150	32.1	-6	-6	1.72	GI025	DT22	6757953

GI024	TN.. 33.. (TN.. 1604..)
GI025	TN.. 43.. (TN.. 2204..)

DT16	DCS 09	1.7	DTS 315-02	US 2004-T09P	FLAG T09P
DT22	DCS 12	3.9	DTS 315-04	US 2002-T15P	FLAG T15P/3,5

IDTGN(RL) EXT

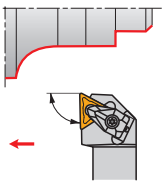
P M K N S H

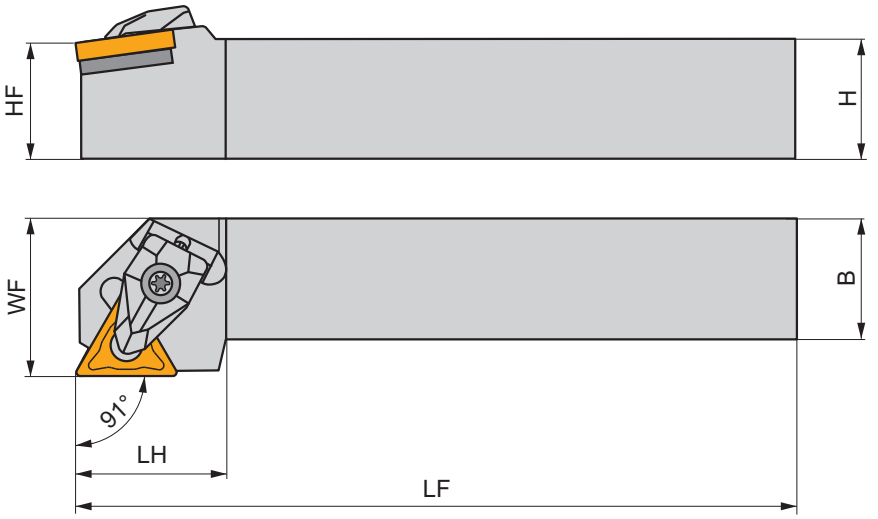
PRAMET

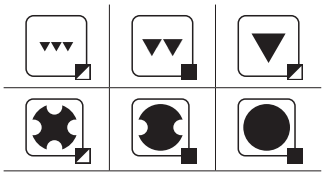
D

External Double Clamp Holder with 91° Cutting Angle for TN.. Inserts

External Right/Left hand double clamp tool holder with 91° cutting angle. Suited for longitudinal turning with shoulder, taper turning and chamfering with negative TN.. inserts. Body treated for longer tool life.







	Product	H (inch)	B (inch)	HF (inch)	WF (inch)	LF (inch)	LH (inch)	LAMS (°)	GAMO (°)	lbs			MID
R	DTGNR 12 3B	.750	.750	.750	1.000	4.500	.970	-6	-6	.88	GI024	DT16	6788614
	DTGNR 16 3D	1.000	1.000	1.000	1.250	6.000	.970	-6	-6	1.54	GI024	DT16	6788615
	DTGNR 16 4D	1.000	1.000	1.000	1.250	6.000	1.260	-6	-6	1.54	GI025	DT22	6788616
	DTGNR 20 4D	1.250	1.250	1.250	1.500	6.000	1.310	-6	-6	2.76	GI025	DT22	6788617
	DTGNR 24 5D	1.500	1.500	1.500	2.000	6.000	1.550	-6	-6	4.95	GI077	DT27	6788618
L	DTGNL 12 3B	.750	.750	.750	1.000	4.500	.970	-6	-6	.88	GI024	DT16	6788609
	DTGNL 16 3D	1.000	1.000	1.000	1.250	6.000	.970	-6	-6	1.54	GI024	DT16	6788610
	DTGNL 16 4D	1.000	1.000	1.000	1.250	6.000	1.260	-6	-6	1.54	GI025	DT22	6788611
	DTGNL 20 4D	1.250	1.250	1.250	1.500	6.000	1.310	-6	-6	2.76	GI025	DT22	6788612
	DTGNL 24 5D	1.500	1.500	1.500	2.000	6.000	1.550	-6	-6	4.95	GI077	DT27	6788613

GI024	TN.. 33.. (TN.. 1604..)
GI025	TN.. 43.. (TN.. 2204..)
GI077	TN.. 54.. (TN.. 2706..)

		Nm			
DT16	DCS 09	1.7	DTS 315-02	US 2004-T09P	FLAG T09P
DT22	DCS 12	3.9	DTS 315-04	US 2002-T15P	FLAG T15P/3,5
DT27	DCS 16	6.4	DTS 315-05	US 2007-T20P	FLAG T09P

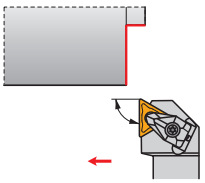
IDTJN(RL) EXT

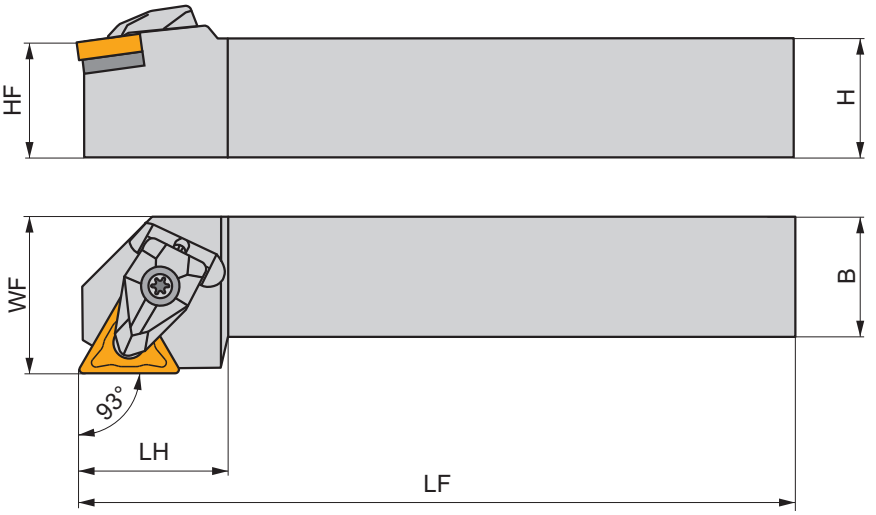
P M K N S H

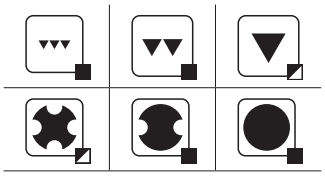
PRAMET

External Double Clamp Holder with 93° Cutting Angle for TN.. Inserts

External Right/Left hand double clamp tool holder with 60° cutting angle. Suited for longitudinal turning with shoulder, taper turning and chamfering with negative TN.. inserts. Body treated for longer tool life.







	Product	H (inch)	B (inch)	HF (inch)	WF (inch)	LF (inch)	LAMS (°)	GAMO (°)	lbs			MID
R	DTJNR 12 3B	.750	.750	.750	1.000	4.500	-6	-6	.81	GI024	DT16	6788523
	DTJNR 16 3D	1.000	1.000	1.000	1.250	6.000	-6	-6	1.74	GI024	DT16	6788524
	DTJNR 20 4D	1.250	1.250	1.250	1.500	6.000	-6	-6	2.73	GI025	DT22	6788525
L	DTJNL 12 3B	7.500	.750	.750	1.000	4.500	-6	-6	.88	GI024	DT16	6788520
	DTJNL 16 3D	1.000	1.000	1.000	1.250	6.000	-6	-6	1.54	GI024	DT16	6788521
	DTJNL 20 4D	1.250	1.250	1.250	1.500	6.000	-6	-6	2.76	GI025	DT22	6788522

GI024	TN.. 33.. (TN.. 1604..)
GI025	TN.. 43.. (TN.. 2204..)

DT16	DCS 09	1.7	DTS 315-02	US 2004-T09P	FLAG T09P
DT22	DCS 12	3.9	DTS 315-04	US 2002-T15P	FLAG T15P/3,5

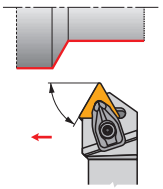
IDTTN(RL) EXT

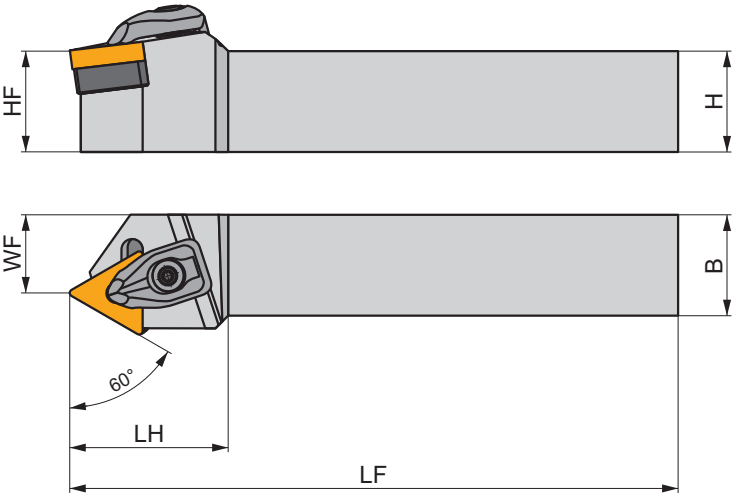
P M K N S H

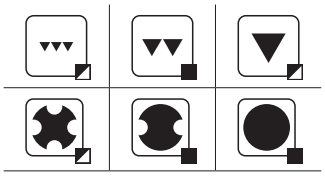
PRAMET

External Double Clamp Holder with 60° Cutting Angle for TN.. Inserts

External Right/Left hand double clamp tool holder with 60° cutting angle. Suited for longitudinal turning with shoulder, taper and copy turning up to 30° and chamfering with negative TN.. inserts. Body treated for longer tool life.







	Product	H (inch)	B (inch)	HF (inch)	WF (inch)	LF (inch)	LAMS (°)	GAMO (°)	lbs			MID
R	**DTTNR 12 3B**	.750	.750	.750	.598	4.500	-6	-6	.88	GI024	DT16	6788621
	DTTNR 16 4D	1.000	1.000	1.000	.791	6.000	-6	-6	1.54	GI025	DT22	6788622
L	**DTTNL 12 3B**	.750	.750	.750	.598	4.500	-6	-6	.88	GI024	DT16	6788619
	DTTNL 16 4D	1.000	1.000	1.000	.791	6.000	-6	-6	1.54	GI025	DT22	6788620

GI024	TN.. 33.. (TN.. 1604..)
GI025	TN.. 43.. (TN.. 2204..)

		Nm			
DT16	DCS 09	1.7	DTS 315-02	US 2004-T09P	FLAG T09P
DT22	DCS 12	3.9	DTS 315-04	US 2002-T15P	FLAG T15P/3,5

MTJN(RL) EXT

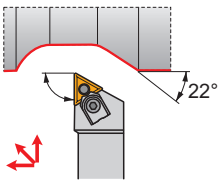
P M K N S H

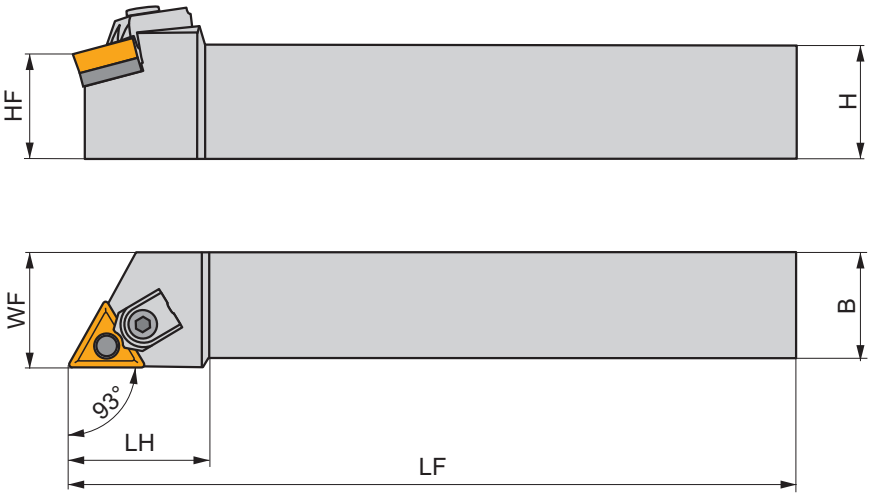
PRAMET

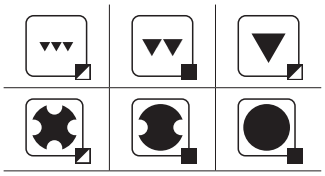
M

External Multi-Clamp Holder with 93° Cutting Angle for TN.. Inserts

External Right/Left hand multi-clamp tool holder with 93° cutting angle. Suited for longitudinal turning with shoulder, taper and copy turning up to 22°, and chamfering with negative TN.. inserts. Body treated for longer tool life.







	Product	H (mm)	B (mm)	HF (mm)	WF (mm)	LF (mm)	LH (mm)	LAMS (°)	GAMO (°)	lbs			MID
R	**MTJNR 2020 K 16**	20	20	20	25	125	34.0	-6	-6	.93	GI024	MT16	6758418
	MTJNR 2525 M 16	25	25	25	32	150	34.0	-6	-6	1.68	GI024	MT16	6758420
	MTJNR 3232 P 22	32	32	32	40	175	42.0	-6	-6	3.01	GI025	MT22	6758422
L	**MTJNL 2020 K 16**	20	20	20	25	125	34.0	-6	-6	.95	GI024	MT16	6758419
	MTJNL 2525 M 16	25	25	25	32	150	34.0	-6	-6	1.66	GI024	MT16	6758421
	MTJNL 3232 P 22	32	32	32	40	175	42.0	-6	-6	3.03	GI025	MT22	6758423

GI024	TN.. 33.. (TN.. 1604..)
GI025	TN.. 43.. (TN.. 2204..)

		Nm				
MT16	UE 16	3.0	MTN 160312	UC 52	HS 93	HXK 5
MT22	UE 22	5.0	MTN 220612	UC 61	HS 94	HXK 5

PTFN(RL) EXT

P M K N S H

PRAMET

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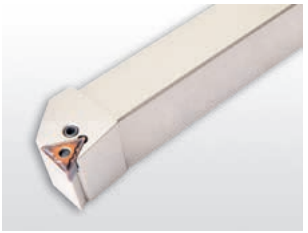
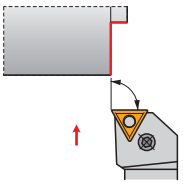
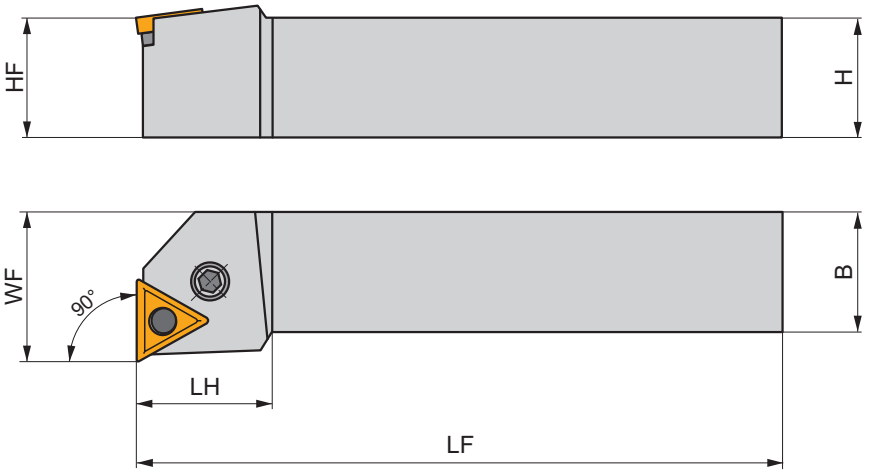
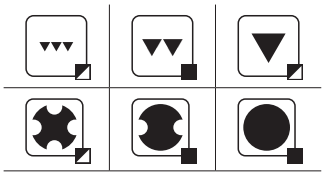


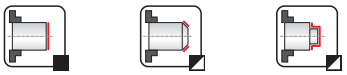
External Lever Lock Holder with 90° (Face) Cutting Angle for TN.. Inserts

External Right/Left hand lever lock tool holder with 90° cutting angle. Suited for face turning with shoulder and chamfering with negative TN.. inserts. Body treated for longer tool life.









	Product	H (mm)	B (mm)	HF (mm)	WF (mm)	LF (mm)	LH (mm)	LAMS (°)	GAMO (°)	lbs			MID
R	**PTFNR 2020 K 16**	20	20	20	25	125	22.0	-6	-6	.91	GI024	PT01	6757132
	PTFNR 2525 M 16	25	25	25	32	150	28.0	-6	-6	1.66	GI024	PT01	6756986
	PTFNR 3225 P 22	32	25	32	32	170	36.0	-6	-6	2.31	GI025	PT02	6756987
	PTFNR 4040 S 27	40	40	40	50	250	45.0	-6	-6	7.11	GI077	PT03	8268908
L	**PTFNL 2525 M 22**	25	25	25	32	150	28.0	-6	-6	1.54	GI025	PT02	6757061
	PTFNL 3225 P 22	32	25	32	32	170	36.0	-6	-6	2.51	GI025	PT02	6757131
	PTFNL 4040 S 27	40	40	40	50	250	45.0	-6	-6	6.97	GI077	PT03	8268907

GI024	TN.. 33.. (TN.. 1604..)
GI025	TN.. 43.. (TN.. 2204..)
GI077	TN.. 54.. (TN.. 2706..)

				Nm					
PT01	PTS 416	CL 009	CS 606	2.0	M 6x1	0.657	TR 09	MT 04	HXK 2.5
PT02	PTS 422	CL 012	CS 608	3.0	M 8x1	0.815	TR 12	MT 05	HXK 3
PT03	PTS 427	CL 015	CS 708	3.0	M 8x1	0.925	TR 15	MT 07	HXK 3

PTGN(RL) EXT

P M K N S H

PRAMET

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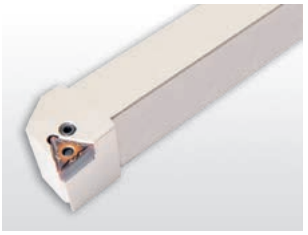
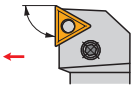
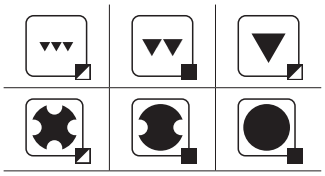
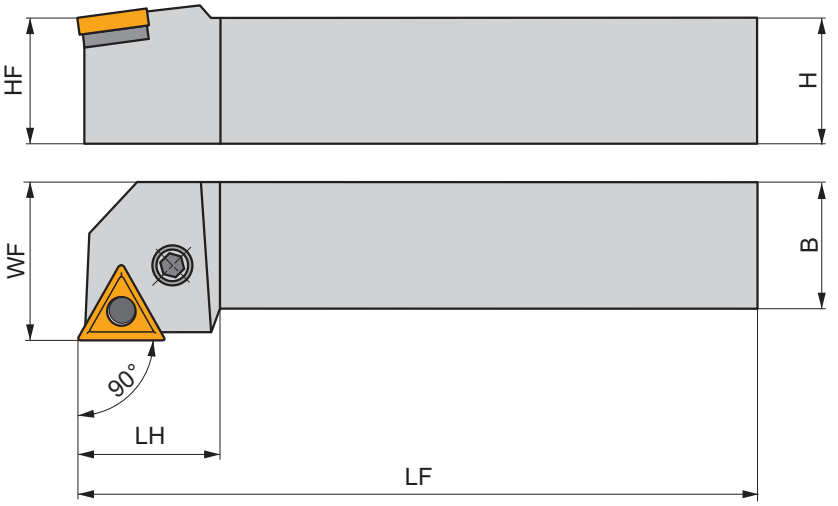


External Lever Lock Holder with 90° Cutting Angle for TN.. Inserts

External Right/Left hand lever lock tool holder with 90° cutting angle. Suited for longitudinal turning with shoulder, taper turning and chamfering with negative TN.. inserts. Body treated for longer tool life.







	Product	H (mm)	B (mm)	HF (mm)	WF (mm)	LF (mm)	LH (mm)	LAMS (°)	GAMO (°)	lbs			MID
R	PTGNR 1616 H 16	16	16	16	20	100	22.0	-6	-6	.44	GI024	PT01	6757134
	PTGNR 2020 K 16	20	20	20	25	125	22.0	-6	-6	.89	GI024	PT01	6756680
	PTGNR 2525 M 16	25	25	25	32	150	28.0	-6	-6	1.61	GI024	PT01	6756681
	PTGNR 2525 M 22	25	25	25	32	150	28.0	-6	-6	1.67	GI025	PT02	6756682
	PTGNR 3232 P 22	32	32	32	40	170	28.0	-6	-6	2.98	GI025	PT02	6757173
	PTGNR 4040 S 27	40	40	40	50	250	45.0	-6	-6	6.95	GI077	PT03	8268920
L	PTGNL 1616 H 16	16	16	16	20	100	22.0	-6	-6	.47	GI024	PT01	6757074
	PTGNL 2020 K 16	20	20	20	25	125	22.0	-6	-6	.88	GI024	PT01	6757047
	PTGNL 2525 M 16	25	25	25	32	150	28.0	-6	-6	1.68	GI024	PT01	6757133
	PTGNL 2525 M 22	25	25	25	32	150	28.0	-6	-6	1.67	GI025	PT02	6757050
	PTGNL 3232 P 22	32	32	32	40	170	28.0	-6	-6	2.95	GI025	PT02	6757411
	PTGNL 4040 S 27	40	40	40	50	250	45.0	-6	-6	6.92	GI077	PT03	8268909

GI024	TN.. 33.. (TN.. 1604..)
GI025	TN.. 43.. (TN.. 2204..)
GI077	TN.. 54.. (TN.. 2706..)

				Nm					
PT01	PTS 416	CL 009	CS 606	2.0	M 6x1	0.657	TR 09	MT 04	HXK 2.5
PT02	PTS 422	CL 012	CS 608	3.0	M 8x1	0.815	TR 12	MT 05	HXK 3
PT03	PTS 427	CL 015	CS 708	3.0	M 8x1	0.925	TR 15	MT 07	HXK 3

PTTN(RL) EXT

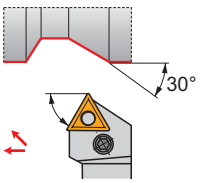
P M K N S H

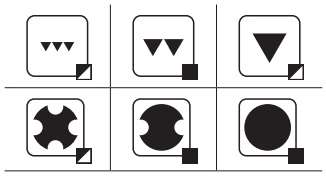
PRAMET

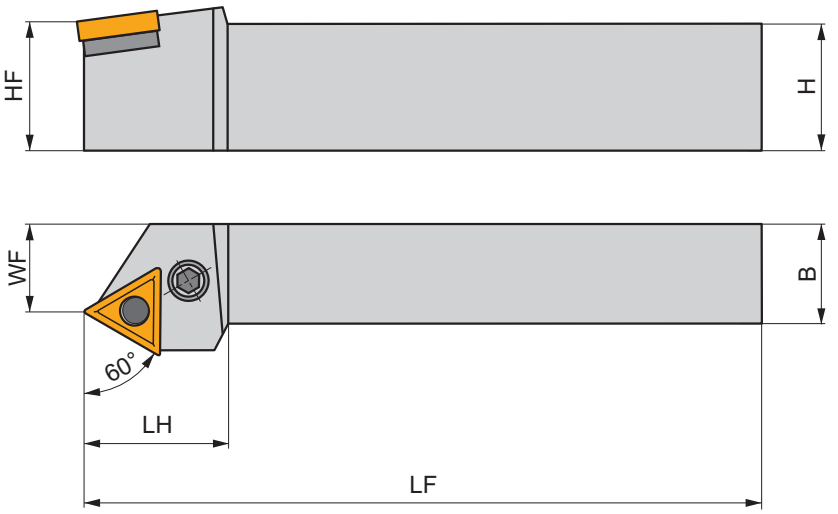
P

External Lever Lock Holder with 60° Cutting Angle for TN.. Inserts

External Right/Left hand lever lock tool holder with 60° cutting angle. Suited for longitudinal turning with shoulder, taper and copy turning up to 30° and chamfering with negative TN.. inserts. Body treated for longer tool life.







	Product	H (mm)	B (mm)	HF (mm)	WF (mm)	LF (mm)	LH (mm)	LAMS (°)	GAMO (°)	lbs			MID
R	**PTTNR 2020 K 16**	20	20	20	17	125	28.0	-6	-6	.94	GI024	PT01	6757043
	PTTNR 2525 M 16	25	25	25	22	150	28.0	-6	-6	1.39	GI024	PT01	6757251
	PTTNR 2525 M 22	25	25	25	22	150	34.0	-6	-6	1.61	GI025	PT02	6757177
	PTTNR 3225 P 22	32	25	32	22	170	34.0	-6	-6	2.25	GI025	PT02	6757178
L	**PTTNL 2020 K 16**	20	20	20	17	125	28.0	-6	-6	.84	GI024	PT01	6757286
	PTTNL 3225 P 22	32	25	32	22	170	34.0	-6	-6	2.29	GI025	PT02	6757289

GI024	TN.. 33.. (TN.. 1604..)
GI025	TN.. 43.. (TN.. 2204..)

				Nm					
PT01	PTS 416	CL 009	CS 606	2.0	M 6x1	0.657	TR 09	MT 04	HXK 2.5
PT02	PTS 422	CL 012	CS 608	3.0	M 8x1	0.815	TR 12	MT 05	HXK 3

C.-DTJN(RL) EXT

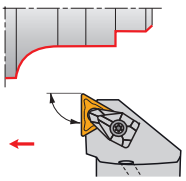
P M K N S H

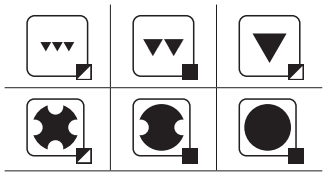
PRAMET

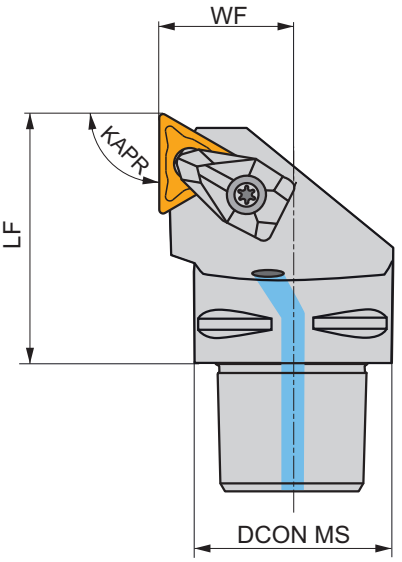
D

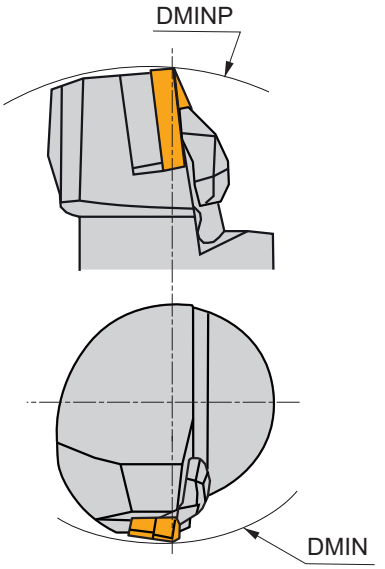
External PSC Quick Change Tool, Double Clamp, 93° Cutting Angle, TN.. Inserts

External Right/Left hand double clamp tool, through coolant, with 93° cutting angle for longitudinal turning with shoulder, taper turning and chamfering with negative TN.. inserts. Polygon Shank Coupling. Body treated for longer tool life.









	Product	DCON MS (mm)	DMIN (mm)	DMINP (mm)	WF (mm)	LF (mm)	KAPR (°)	LAMS (°)	GAMO (°)		lbs			MID
R	C4-DTJNR-27050-16	40	110	140	27	50	93	-6	-6	✓	.96	GI024	C-DT16	7809809
	C5-DTJNR-35060-16	50	110	165	35	60	93	-6	-6	✓	1.73	GI024	C-DT16	7809811
L	C4-DTJNL-27050-16	40	110	140	27	50	93	-6	-6	✓	.96	GI024	C-DT16	7809808
	C5-DTJNL-35060-16	50	110	165	35	60	93	-6	-6	✓	1.74	GI024	C-DT16	7809810

GI024	TN.. 33.. (TN.. 1604..)

C-DT16	DCS 09	1.7	DTS 315-02	US 2004-T09P	FLAG T09P	CN 045-01

DTFN(RL) INT

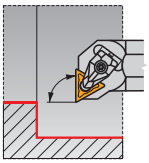
P M K N S H

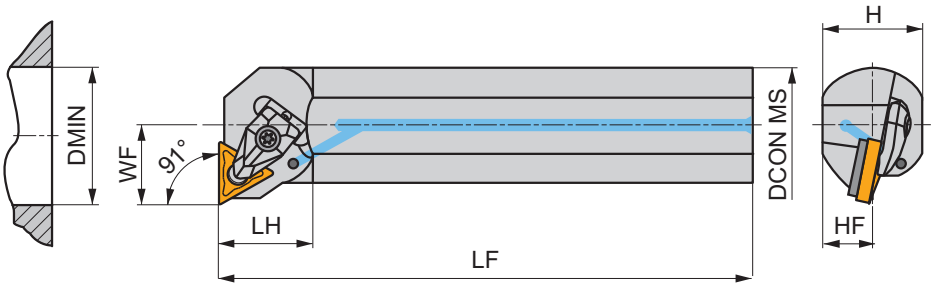
PRAMET

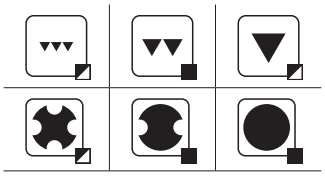
D

Internal Double Clamp Holder with 91° Cutting Angle for TN.. Inserts

Internal Right/Left hand double clamp boring bar, through coolant, 91° cutting angle for TN.. inserts. For internal taper and longitudinal turning with shoulder and chamfer turning. Body treated for longer tool life.







	Product	DCON MS (mm)	DMIN (mm)	WF (mm)	H (mm)	HF (mm)	LF (mm)	LH (mm)	LAMS (°)	GAMO (°)		lbs			MID
R	A25T-DTFNR 16	25	32	17	23	11.5	300	32.0	-12	-6	✓	2.11	GI024	DTI16	7028482
	A32T-DTFNR 16	32	40	22	30	15	300	33.0	-10	-6	✓	3.69	GI024	DTI16	7028494
	A40T-DTFNR 22	40	50	27	37	18.5	300	36.0	-13	-6	✓	5.69	GI025	DT22	7028504
L	A25T-DTFNL 16	25	32	17	23	11.5	300	32.0	-12	-6	✓	2.11	GI024	DTI16	7028481
	A32T-DTFNL 16	32	40	22	30	15	300	33.0	-10	-6	✓	3.69	GI024	DTI16	7028493
	A40T-DTFNL 22	40	50	27	37	18.5	300	36.0	-13	-6	✓	5.68	GI025	DT22	7028503

GI024	TN.. 33.. (TN.. 1604..)
GI025	TN.. 43.. (TN.. 2204..)

		Nm			
DT22	DCS 12	3.9	DTS 315-04	US 2002-T15P	FLAG T15P/3,5
DTI16	DCS 09	1.7	DTS 316-01	US 2004-T09P	FLAG T09P

IDTFN(RL) INT

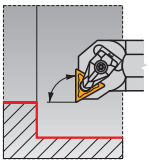
P M K N S H

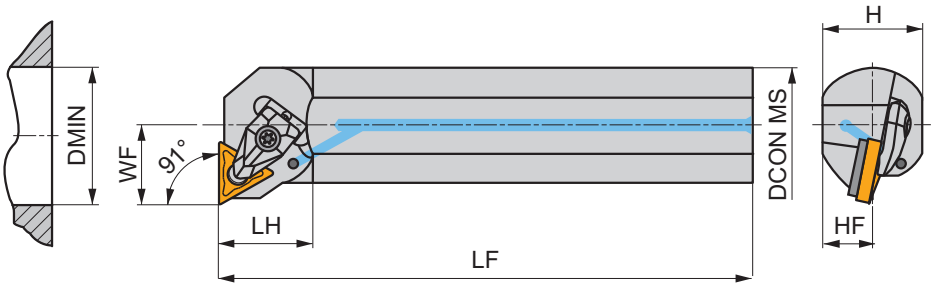
PRAMET

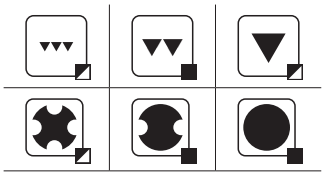
D

Internal Double Clamp Holder with 91° Cutting Angle for TN.. Inserts

Internal Right/Left hand double clamp boring bar, through coolant, 91° cutting angle for TN.. inserts. For internal taper and longitudinal turning with shoulder and chamfer turning. Body treated for longer tool life.







	Product	DCON MS (inch)	DMIN (inch)	WF (inch)	H (inch)	HF (inch)	LF (inch)	LH (inch)	LAMS (°)	GAMO (°)		lbs			MID
R	A16T-DTFNR 3	1.000	1.201	.640	.906	.453	12.000	1.339	-12	-6	✓	1.54	GI024	DTI16	6788481
	A20T-DTFNR 3	1.250	1.468	.765	1.181	.591	12.000	1.417	-11	-6	✓	3.08	GI024	DTI16	6788497
	A24T-DTFNR 4	1.500	1.760	.890	1.374	.687	12.000	1.417	-15	-6	✓	8.25	GI025	DT22	6788511
L	A16T-DTFNL 3	1.000	1.201	.640	.906	.453	12.000	1.339	-12	-6	✓	1.54	GI024	DTI16	6788480
	A24T-DTFNL 4	1.500	1.760	.890	1.374	.687	12.000	1.417	-15	-6	✓	8.25	GI025	DT22	6788510

GI024	TN.. 33.. (TN.. 1604..)
GI025	TN.. 43.. (TN.. 2204..)

		Nm			
DT22	DCS 12	3.9	DTS 315-04	US 2002-T15P	FLAG T15P/3,5
DTI16	DCS 09	1.7	DTS 316-01	US 2004-T09P	FLAG T09P

PTFN(RL) INT

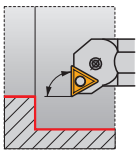
P M K N S H

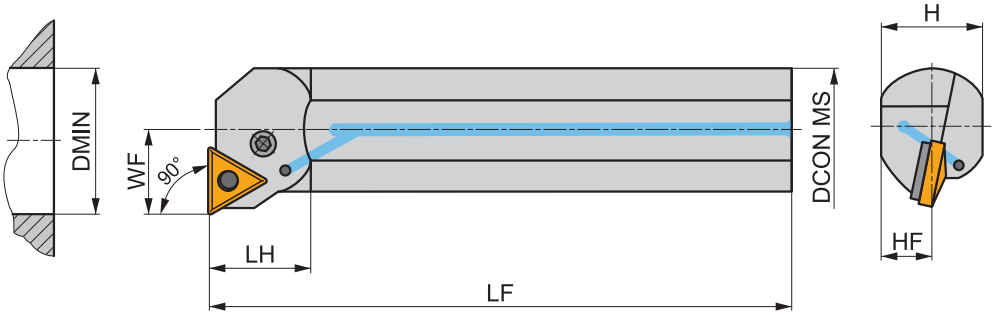
PRAMET

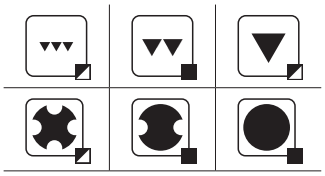
P

Internal Lever Lock Holder with 90° Cutting Angle for TN.. Inserts

Internal Right/Left hand lever lock boring bar, through coolant available, 90° cutting angle for TN.. inserts. For internal taper and longitudinal turning with shoulder and chamfer turning. Body treated for longer tool life.







	Product	DCON MS (mm)	DMIN (mm)	WF (mm)	H (mm)	B (mm)	LF (mm)	LAMS (°)	GAMO (°)		lbs			MID
R	**A25R-PTFNR 16**	25	31	17	23	23.01	200	-13	-6	–	1.58	GI024	PT04	6757386
	A32S-PTFNR 16	32	39	22	30	30	250	-12	-6	✓	3.20	GI024	PT01	6757339
L	**A25R-PTFNL 16**	25	31	17	23	23.01	200	-13	-6	–	1.58	GI024	PT04	6757153

GI024	TN.. 33.. (TN.. 1604..)

				Nm					
PT01	PTS 416	CL 009	CS 606	2.0	M 6x1	0.657	TR 09	MT 04	HXK 2.5
PT04	–	CL 216	CS 605	1.4	M 5x1	0.472	–	–	HXK 2

C.-DTFN(RL) INT

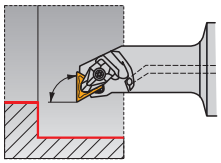
P M K N S H

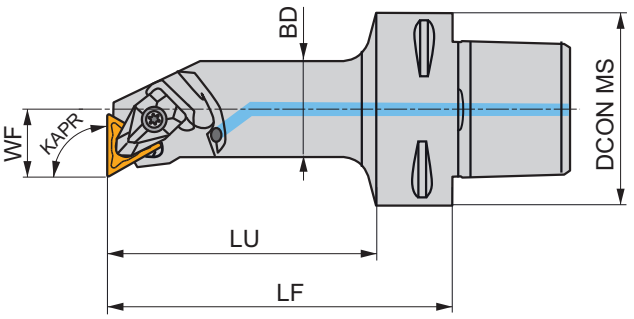
PRAMET

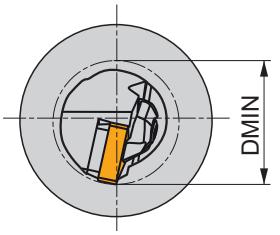
D

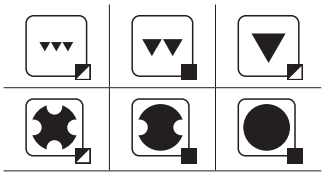
Internal PSC Quick Change Tool, Double Clamp, 91° Cutting Angle, TN.. Inserts

Internal Right/Left hand double clamp tool, through coolant, with 91° cutting angle for a wide range of internal turning applications with TN.. inserts. Polygon Shank Coupling. Body treated for longer tool life.









	Product	DCON MS (mm)	DMIN (mm)	WF (mm)	LF (mm)	LU (mm)	BD (mm)	KAPR (°)	LAMS (°)	GAMO (°)		lbs			MID
R	C4-DTFNR-17090-16	40	32	17	90	68	25	91	-12	-6	✓	1.12	GI024	DTI16	7809870

GI024	TN.. 33.. (TN.. 1604..)

DTI16	DCS 09	1.7 Nm	DTS 316-01	US 2004-T09P	FLAG T09P

DVJN(RL) EXT

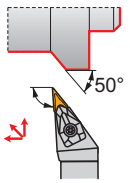
P M K N S H

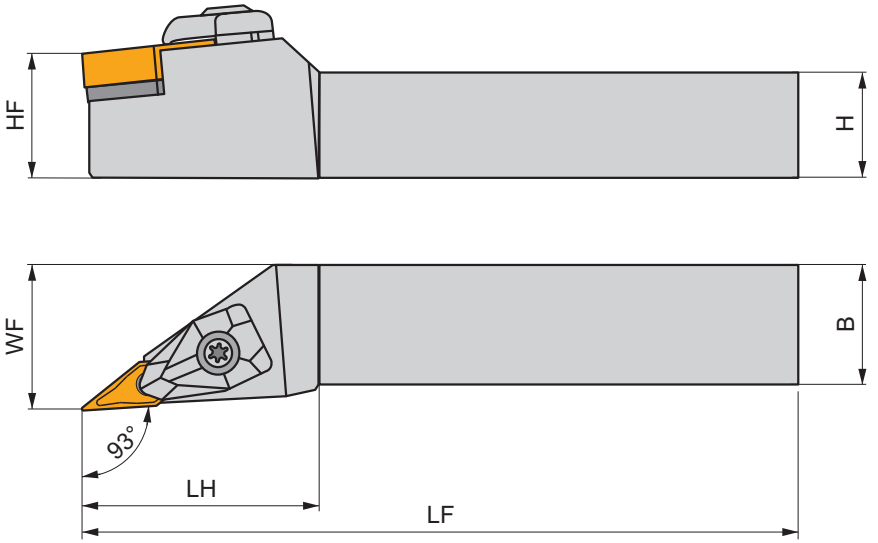
PRAMET

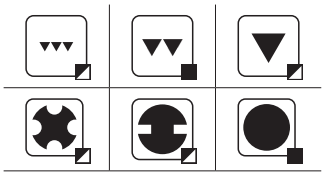
D

External Double Clamp Holder with 93° Cutting Angle for VN.. Inserts

External Right/Left hand double clamp tool holder with 93° cutting angle. Suited for longitudinal turning with shoulder, copy and taper turning and chamfering with negative VN.. inserts. Body treated for longer tool life.







	Product	H (mm)	B (mm)	HF (mm)	WF (mm)	LF (mm)	LH (mm)	LAMS (°)	GAMO (°)	lbs			MID
R	DVJNR 2020 K 16	20	20	20	25	125	46.4	-13	-4	.95	GI048	DV16	7028466
	DVJNR 2525 M 16	25	25	25	32	150	46.4	-13	-4	1.64	GI048	DV16	7028467
	DVJNR 3225 P 16	32	25	32	32	170	46.4	-13	-4	2.33	GI048	DV16	7028468
L	DVJNL 2020 K 16	20	20	20	25	125	46.4	-13	-4	.95	GI048	DV16	7028463
	DVJNL 2525 M 16	25	25	25	32	150	46.4	-13	-4	1.65	GI048	DV16	7028464
	DVJNL 3225 P 16	32	25	32	32	170	46.4	-13	-4	2.33	GI048	DV16	7028465

GI048	VN.. 33.. (VN.. 1604..)

DV16	DCS 16V	3.0	DVS 269-01	US 2009-T15P	FLAG T15P/3,5

IDVJN(RL) EXT

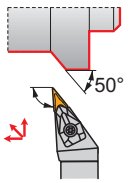
P M K N S H

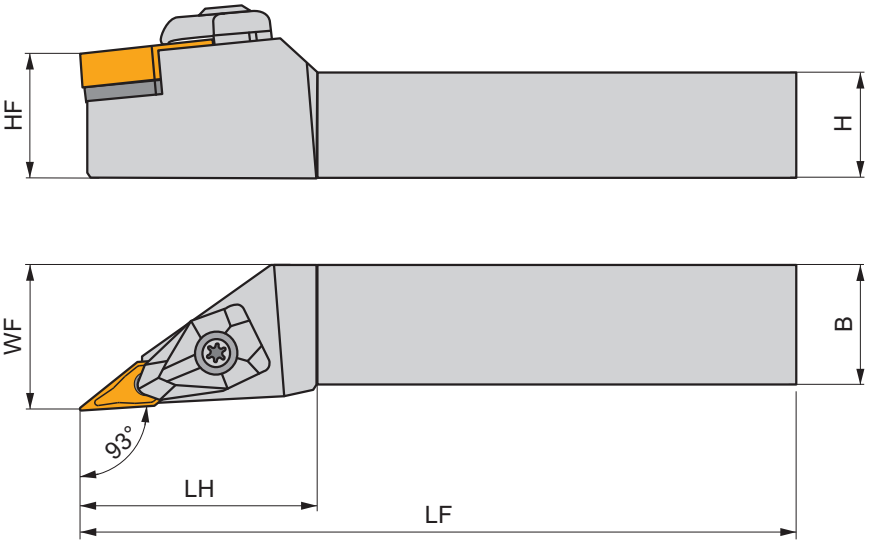
PRAMET

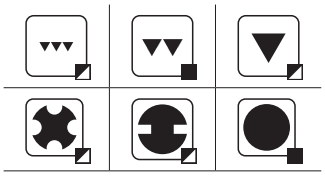
D

External Double Clamp Holder with 93° Cutting Angle for VN.. Inserts

External Right/Left hand double clamp tool holder with 93° cutting angle. Suited for longitudinal turning with shoulder, copy and taper turning and chamfering with negative VN.. inserts. Body treated for longer tool life.







	Product	H (inch)	B (inch)	HF (inch)	WF (inch)	LF (inch)	LH (inch)	LAMS (°)	GAMO (°)	lbs			MID
R	DVJNR 12 3B	.750	.750	.750	1.000	4.500	1.830	-13	-4	.88	GI048	DV16	6788529
	DVJNR 16 3D	1.000	1.000	1.000	1.250	6.000	1.830	-13	-4	1.54	GI048	DV16	6788530
	DVJNR 20 3D	1.250	1.250	1.250	1.500	6.000	1.830	-13	-4	2.47	GI048	DV16	6788531
L	DVJNL 12 3B	.750	.750	.750	1.000	4.500	1.830	-13	-4	.66	GI048	DV16	6788526
	DVJNL 16 3D	1.000	1.000	1.000	1.250	6.000	1.830	-13	-4	1.54	GI048	DV16	6788527
	DVJNL 20 3D	1.250	1.250	1.250	1.500	6.000	1.830	-13	-4	2.43	GI048	DV16	6788528

GI048	VN.. 33.. (VN.. 1604..)

DV16	DCS 16V	3.0	DVS 269-01	US 2009-T15P	FLAG T15P/3,5

DVPN(RL) EXT

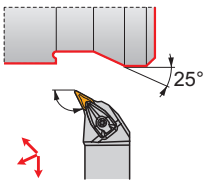
P M K N S H

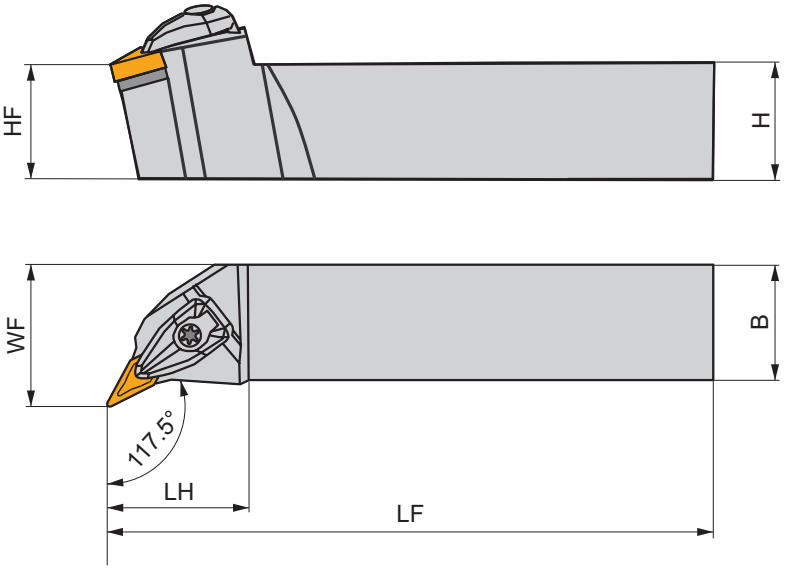
PRAMET

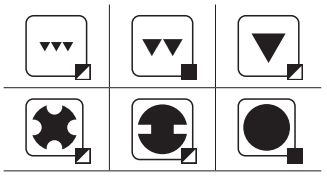
D

External Double Clamp Holder with 117.5° Cutting Angle for VN.. Inserts

External Right/Left hand double clamp tool holder with 117.5° cutting angle. Suited for longitudinal and face turning with shoulder, copy and taper turning and chamfering with negative VN.. inserts. Body treated for longer tool life.







	Product	H (mm)	B (mm)	HF (mm)	WF (mm)	LF (mm)	LH (mm)	LAMS (°)	GAMO (°)	lbs			MID
R	**DVPNR 2525 M 16**	25	25	25	32	150	39.2	-13	-4	1.65	GI048	DV16	7028471
L	**DVPNL 2525 M 16**	25	25	25	32	150	39.2	-13	-4	1.64	GI048	DV16	7028469

GI048	VN.. 33.. (VN.. 1604..)

DV16	DCS 16V	3.0	DVS 269-01	US 2009-T15P	FLAG T15P/3,5

MVJN(RL) EXT

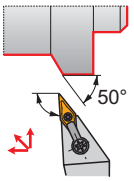
P M K N S H

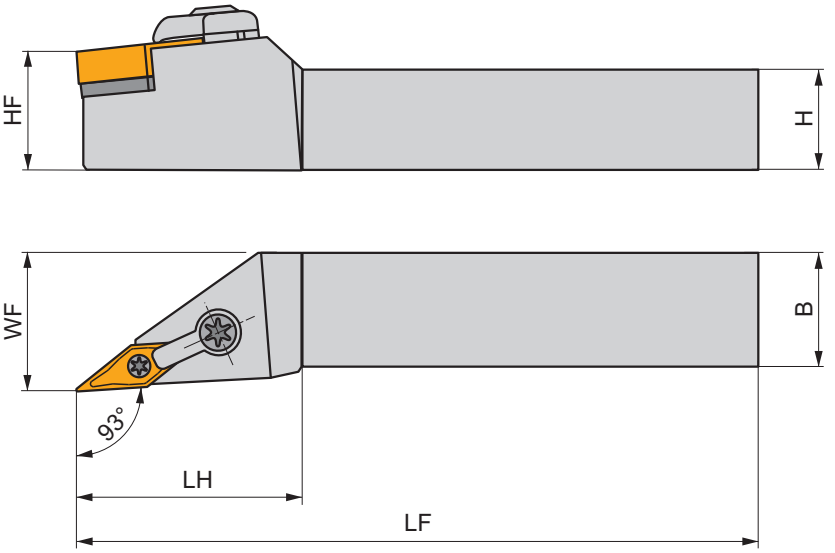
PRAMET

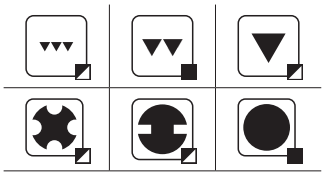
M

External Multi-Clamp Holder with 93° Cutting Angle for VN.. Inserts

External Right/Left hand multi-clamp turning holder with 93° cutting angle. Suited for longitudinal turning with shoulder, copy turning up to 50°, taper and chamfer turning with negative VN.. insert. Body treated for longer tool life.







	Product	H (mm)	B (mm)	HF (mm)	WF (mm)	LF (mm)	LH (mm)	LAMS (°)	GAMO (°)	lbs			MID
R	MVJNR 2020 K 16-A	20	20	20	25	125	41.0	-4.5	-13.5	.87	GI048	MV2	6756763
	MVJNR 2525 M 16-A	25	25	25	32	150	41.0	-4.5	-13.5	1.54	GI048	MV2	6756764
	MVJNR 3225 P 16-A	32	25	32	32	170	41.0	-4.5	-13.5	2.16	GI048	MV2	6756765
L	MVJNL 2020 K 16-A	20	20	20	25	125	41.0	-4.5	-13.5	.88	GI048	MV2	6756761
	MVJNL 2525 M 16-A	25	25	25	32	150	41.0	-4.5	-13.5	1.54	GI048	MV2	6756762
	MVJNL 3225 P 16-A	32	25	32	32	170	41.0	-4.5	-13.5	2.18	GI048	MV2	6757319

GI048	VN.. 33.. (VN.. 1604..)

				Nm		Nm	
MV2	UPC 22	MVN 160316	UP 0909-T09P	2.0	PS 6026-T09P	2.0	FLAG T09P

C.-DVJN(RL) EXT

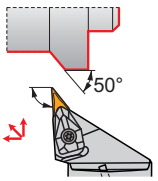
P M K N S H

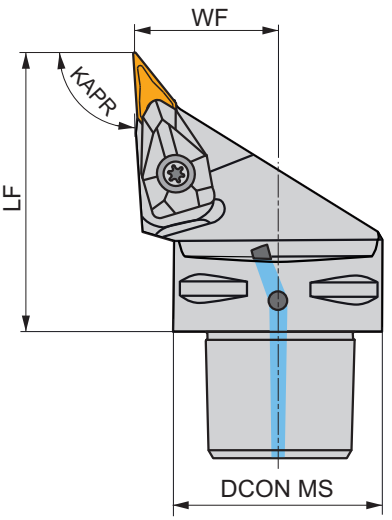
PRAMET

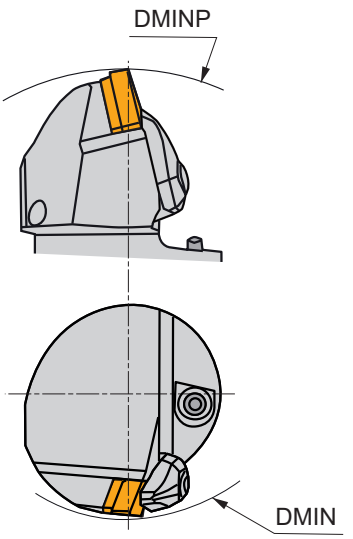
D

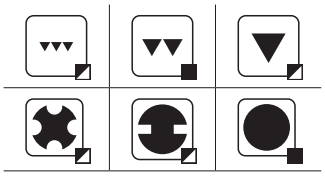
External PSC Quick Change Tool, Double Clamp, 93° Cutting Angle, VN.. Inserts

External Right/Left hand double clamp tool, through coolant, with 93° cutting angle for longitudinal turning with shoulder, copy and taper turning and chamfering with negative VN.. inserts. Polygon Shank Coupling. Body treated for longer tool life.









	Product	DCON MS (mm)	DMIN (mm)	DMINP (mm)	WF (mm)	LF (mm)	KAPR (°)	LAMS (°)	GAMO (°)		lbs			MID
R	C4-DVJNR-27062-16	40	60	152	27	62	93	-13	-4	✓	.98	GI048	C-DV16-1	7809813
	C5-DVJNR-35065-16	50	65	170	35	65	93	-13	-4	✓	1.04	GI048	C-DV16-2	7809815
	C6-DVJNR-45065-16	63	81	190	45	65	93	-13	-4	✓	2.50	GI048	C-DV16-2	7809817
L	C4-DVJNL-27062-16	40	60	152	27	62	93	-13	-4	✓	.98	GI048	C-DV16-1	7809812
	C5-DVJNL-35065-16	50	65	170	35	65	93	-13	-4	✓	1.58	GI048	C-DV16-2	7809814
	C6-DVJNL-45065-16	63	81	190	45	65	93	-13	-4	✓	2.50	GI048	C-DV16-2	7809816

GI048	VN.. 33.. (VN.. 1604..)

		Nm				
C-DV16-1	DCS 16V	3.0	DVS 269-01	US 2009-T15P	FLAG T15P/3,5	CN 034-01
C-DV16-2	DCS 16V	3.0	DVS 269-01	US 2009-T15P	FLAG T15P/3,5	CN 034-02

DVUN(RL) INT

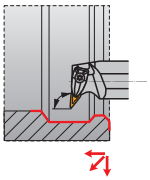
P M K N S H

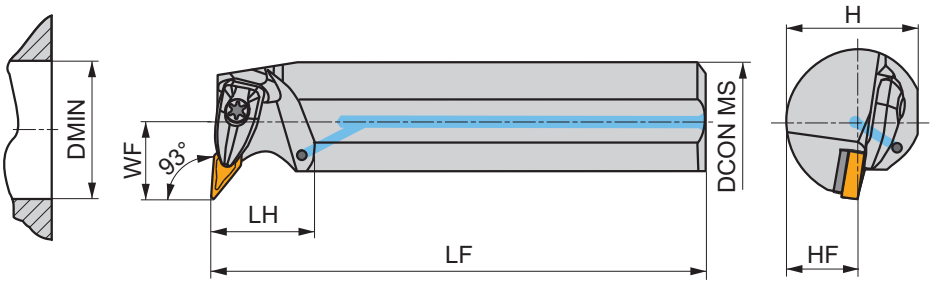
PRAMET

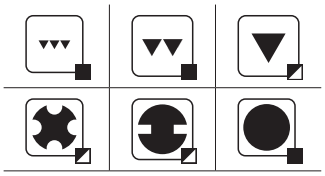
D

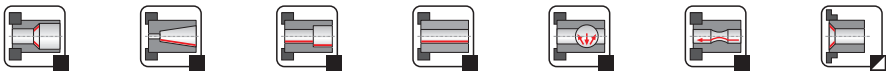
Internal Double Clamp Boring Bar with 93° Cutting Angle for VN.. Inserts

Internal Right/Left hand double clamp boring bar, through coolant, with 93° cutting angle for VN.. inserts. Suited for internal taper, longitudinal turning with shoulder, copying and chamfer turning. Body treated for longer tool life.









	Product	DCON MS (mm)	DMIN (mm)	WF (mm)	H (mm)	HF (mm)	LF (mm)	LH (mm)	LAMS (°)	GAMO (°)		lbs			MID
R	A40T-DVUNR 16	40	50	27	37	18.5	300	36.0	-9	-6	✓	5.70	GI048	DV16	7028498
L	A40T-DVUNL 16	40	50	27	37	18.5	300	36.0	-9	-6	✓	5.70	GI048	DV16	7028497

GI048	VN.. 33.. (VN.. 1604..)

DV16	DCS 16V	3.0 Nm	DVS 269-01	US 2009-T15P	FLAG T15P/3,5

DWLN(RL) EXT

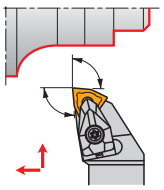
P M K N S H

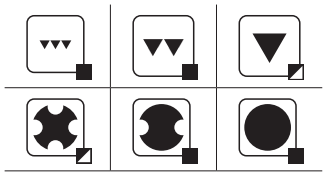
PRAMET

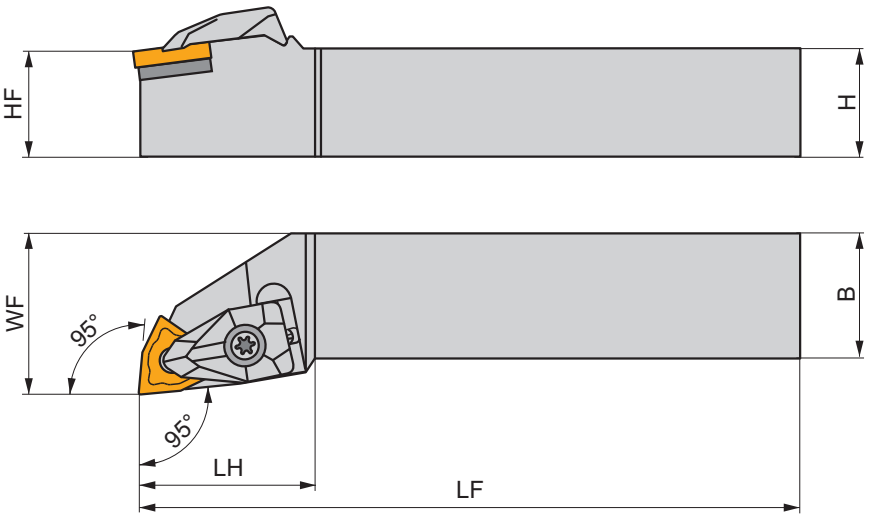
D

External Double Clamp Holder with 95° Cutting Angle for WN.. Inserts

External Right/Left hand double clamp turning holder with 95° cutting angle. Suited for longitudinal turning with shoulder, face, taper and chamfer turning with negative WN.. inserts. Body treated for longer tool life.







	Product	H (mm)	B (mm)	HF (mm)	WF (mm)	LF (mm)	LH (mm)	LAMS (°)	GAMO (°)	lbs				MID
R	DWLNR 1616 H 06	16	16	16	20	100	26.4	-6	-6	.48	GI028	DW06	–	7028476
	DWLNR 2020 K 06	20	20	20	25	125	27.1	-6	-6	.91	GI028	DW06	–	7028477
	DWLNR 2525 M 06	25	25	25	32	150	27.1	-6	-6	1.64	GI028	DW06	–	7028478
	DWLNR 2020 K 08	20	20	20	25	125	34.3	-6	-6	.95	GI072	DW08	AT004	6758079
	DWLNR 2525 M 08	25	25	25	32	150	35.0	-6	-6	1.65	GI072	DW08	AT004	6758091
	DWLNR 3225 P 08	32	25	32	32	170	35.0	-6	-6	2.23	GI072	DW08	AT004	6758093
	DWLNR 3225 P 10	32	25	32	32	170	38.0	-6	-6	2.34	GI166	DW10	–	6758520
	DWLNR 3232 P 13	32	32	32	40	170	40.0	-6	-6	3.08	GI167	DW13	–	6758521
	DWLNR 4040 S 13	40	40	40	50	250	41.0	-6	-6	7.03	GI167	DW13	–	6758522
L	DWLNL 1616 H 06	16	16	16	20	100	26.4	-6	-6	.48	GI028	DW06	–	7028473
	DWLNL 2020 K 06	20	20	20	25	125	27.1	-6	-6	.91	GI028	DW06	–	7028474
	DWLNL 2525 M 06	25	25	25	32	150	27.1	-6	-6	1.67	GI028	DW06	–	7028475
	DWLNL 2020 K 08	20	20	20	25	125	34.3	-6	-6	.96	GI072	DW08	AT004	6758090
	DWLNL 2525 M 08	25	25	25	32	150	35.0	-6	-6	1.63	GI072	DW08	AT004	6758092
	DWLNL 3225 P 08	32	25	32	32	170	35.0	-6	-6	2.43	GI072	DW08	AT004	6758094
	DWLNL 3225 P 10	32	25	32	32	170	38.0	-6	-6	2.51	GI166	DW10	–	6758517
	DWLNL 3232 P 13	32	32	32	40	170	40.0	-6	-6	3.16	GI167	DW13	–	6758518
	DWLNL 4040 S 13	40	40	40	50	250	41.0	-6	-6	6.99	GI167	DW13	–	6758519

GI028	WN.. 33.. (WN.. 0604..)
GI072	WN.. 43.. (WN.. 0804..)

GI166	WN.. 52.. (WN.. 1006..)
GI167	WN.. 64.. (WN.. 1306..)

DW06	DCS 09	1.7	DWS 328-01	US 2004-T09P	FLAG T09P	–
DW08	DCS 12	3.9	DWS 331-12	US 2002-T15P	FLAG T15P/3,5	–
DW10	DCS 16	6.4	DWN 100612	US 5018-T20P	–	LK T20P
DW13	DCS 19	6.4	DWN 130612	US 6013-T20P	–	LK T20P

AT004a	CER WN.N 0804..	DCS 12C4
AT004b	CER WN.A 0804..	DCS 12C2

IDWLN(RL) EXT

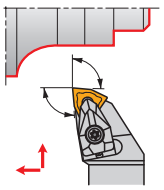
P M K N S H

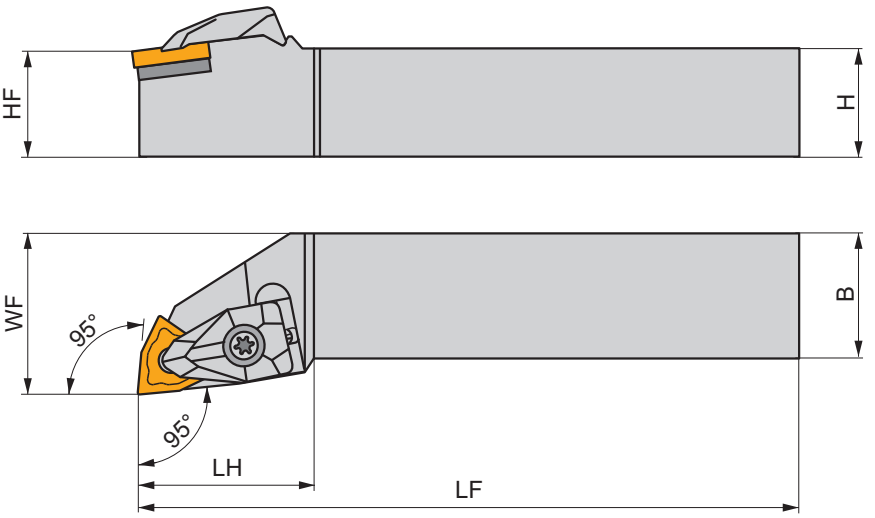
PRAMET

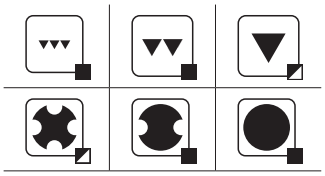
D

External Double Clamp Holder with 95° Cutting Angle for WN.. Inserts

External Right/Left hand double clamp turning holder with 95° cutting angle. Suited for longitudinal turning with shoulder, face, taper and chamfer turning with negative WN.. inserts. Body treated for longer tool life.







	Product	H (inch)	B (inch)	HF (inch)	WF (inch)	LF (inch)	LH (inch)	LAMS (°)	GAMO (°)	lbs			MID
R	DWLNR 10 3B	.625	.625	.625	.875	4.500	1.070	-6	-6	.60	GI028	DW06	6788629
	DWLNR 12 3C	.750	.750	.750	1.000	5.000	1.950	-6	-6	1.05	GI028	DW06	6788630
	DWLNR 16 3D	1.000	1.000	1.000	1.250	6.000	1.950	-6	-6	1.54	GI028	DW06	6788632
	DWLNR 12 4C	.750	.750	.750	1.000	5.000	1.378	-6	-6	1.05	GI072	DW08	6788631
	DWLNR 16 4D	1.000	1.000	1.000	1.250	6.000	1.350	-6	-6	1.54	GI072	DW08	6788633
	DWLNR 20 4D	1.250	1.250	1.250	1.500	6.000	1.378	-6	-6	2.76	GI072	DW08	6788634
L	DWLNL 10 3B	.625	.625	.625	.875	4.500	1.070	-6	-6	.60	GI028	DW06	6788623
	DWLNL 12 3C	.750	.750	.750	1.000	5.000	1.950	-6	-6	1.05	GI028	DW06	6788624
	DWLNL 16 3D	1.000	1.000	1.000	1.250	6.000	1.950	-6	-6	1.54	GI028	DW06	6788626
	DWLNL 12 4C	.750	.750	.750	1.000	5.000	1.378	-6	-6	1.05	GI072	DW08	6788625
	DWLNL 16 4D	1.000	1.000	1.000	1.250	6.000	1.350	-6	-6	1.54	GI072	DW08	6788627
	DWLNL 20 4D	1.250	1.250	1.250	1.500	6.000	1.378	-6	-6	2.76	GI072	DW08	6788628

GI028	WN.. 33.. (WN.. 0604..)
GI072	WN.. 43.. (WN.. 0804..)

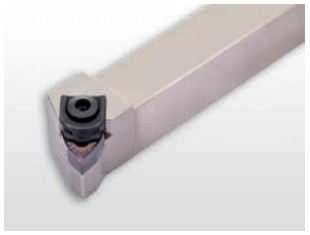
		Nm			
DW06	DCS 09	1.7	DWS 328-01	US 2004-T09P	FLAG T09P
DW08	DCS 12	3.9	DWS 331-12	US 2002-T15P	FLAG T15P/3,5

MWLN(RL) EXT

P M K N S H

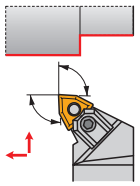
PRAMET

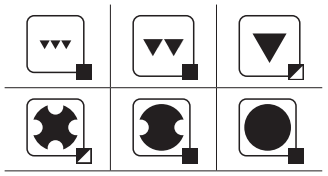
M

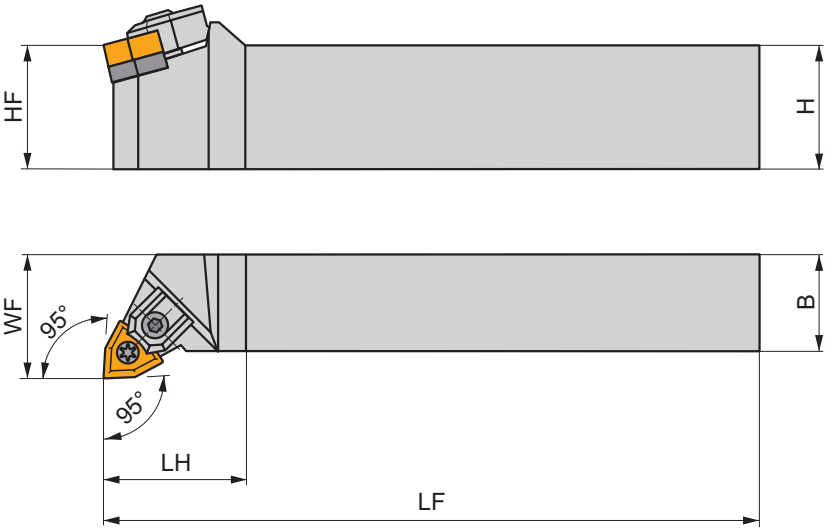


External Multi-Clamp Holder with 95° Cutting Angle for WN.. Inserts

External Right/Left hand multi-clamp turning holder with 95° cutting angle. Suited for longitudinal turning with shoulder, face, taper and chamfer turning with negative WN.. inserts. Body treated for longer tool life.







	Product	H (mm)	B (mm)	HF (mm)	WF (mm)	LF (mm)	LH (mm)	LAMS (°)	GAMO (°)	lbs			MID
R	**MWLNR 2525 M 08**	25	25	25	32	150	34.0	-6	-6	1.61	GI072	MW02	6756955
	MWLNR 3225 P 08	32	25	32	32	170	34.0	-6	-6	2.40	GI072	MW02	6757198
	MWLNR 4040 S 08	40	40	40	50	250	45.0	-6	-6	6.92	GI072	MW02	8268906
L	**MWLNL 2525 M 08**	25	25	25	32	150	34.0	-6	-6	1.72	GI072	MW02	6757244
	MWLNL 3225 P 08	32	25	32	32	170	34.0	-6	-6	2.25	GI072	MW02	6757154
	MWLNL 4040 S 08	40	40	40	50	250	45.0	-6	-6	6.91	GI072	MW02	8268905

GI072	WN.. 43.. (WN.. 0804..)

MW02	UE 11	4.0 Nm	MWS 433	UC 61	HS 94	HXK 5

PWLN(RL) EXT

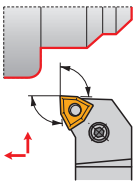
P M K N S H

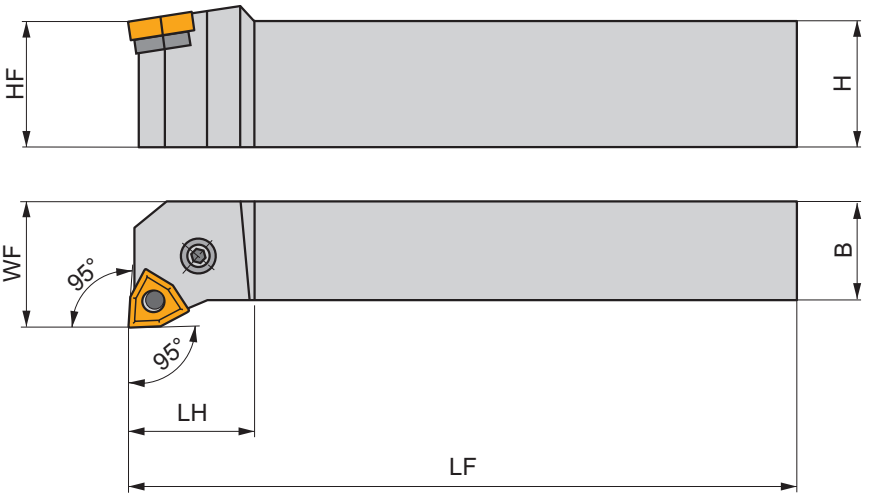
PRAMET

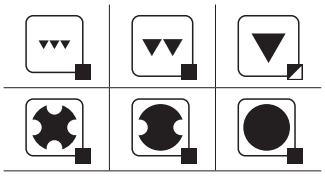
P

External Lever Lock Holder with 95° Cutting Angle for WN.. Inserts

External Right/Left hand lever lock turning holder with 95° cutting angle. Suited for longitudinal turning with shoulder, face, taper and chamfer turning with negative WN.. inserts. Body treated for longer tool life.







	Product	H (mm)	B (mm)	HF (mm)	WF (mm)	LF (mm)	LH (mm)	LAMS (°)	GAMO (°)	lbs			MID
R	PWLNR 1616 H 0604	16	16	16	20	100	22.0	-6	-6	.49	GI028	PW01	6757194
	PWLNR 2020 K 0604	20	20	20	25	125	22.0	-6	-6	.89	GI028	PW01	6756687
	PWLNR 2525 M 0604	25	25	25	32	150	25.0	-6	-6	1.65	GI028	PW01	6759722
	PWLNR 2020 K 08	20	20	20	25	125	28.0	-6	-6	.91	GI072	PW02	6757070
	PWLNR 2525 M 08	25	25	25	32	150	28.0	-6	-6	1.66	GI072	PW02	6756937
	PWLNR 3225 P 08	32	25	32	32	170	34.0	-6	-6	2.31	GI072	PW02	6756924
L	PWLNL 1616 H 0604	16	16	16	20	100	22.0	-6	-6	.46	GI028	PW01	6757062
	PWLNL 2020 K 0604	20	20	20	25	125	22.0	-6	-6	.90	GI028	PW01	6757063
	PWLNL 2525 M 0604	25	25	25	32	150	25.0	-6	-6	1.65	GI028	PW01	6759721
	PWLNL 2020 K 08	20	20	20	25	125	28.0	-6	-6	.88	GI072	PW02	6757068
	PWLNL 2525 M 08	25	25	25	32	150	28.0	-6	-6	1.63	GI072	PW02	6756952
	PWLNL 3225 P 08	32	25	32	32	170	34.0	-6	-6	2.31	GI072	PW02	6757135

	WN.. 33.. (WN.. 0604..)
GI028	
GI072	WN.. 43.. (WN.. 0804..)

				Nm					
PW01	PWS 007	CL 009	CS 606	2.0	M 6x1	0.657	TR 09	MT 04	HXK 2.5
PW02	PWS 008	CL 012	CS 608	3.0	M 8x1	0.815	TR 12	MT 05	HXK 3

C.-DWLN(RL) EXT

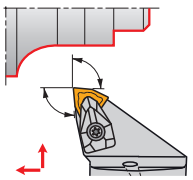
P M K N S H

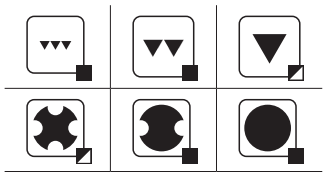
PRAMET

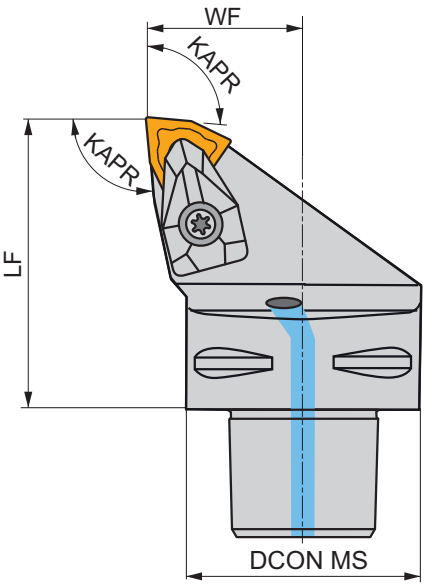
D

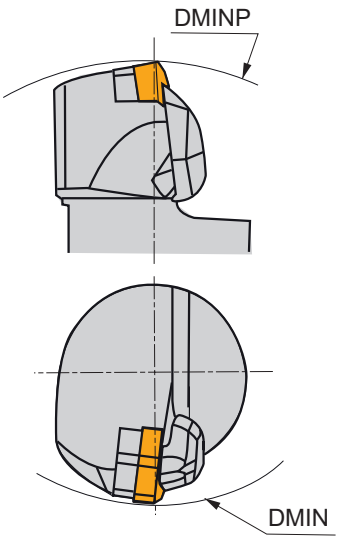
External PSC Quick Change Tool, Double Clamp, 95° Cutting Angle, WN.. Inserts

External Right/Left hand double clamp tool, through coolant, with 95° cutting angle for face and longitudinal turning with shoulder, taper and chamfering with negative WN.. inserts. Polygon Shank Coupling. Body treated for longer tool life.









	Product	DCON MS (mm)	DMIN (mm)	DMINP (mm)	WF (mm)	LF (mm)	KAPR (°)	LAMS (°)	GAMO (°)		lbs				MID
R	C4-DWLNR-27050-06	40	60	140	27	50	95	-6	-6	✓	.93	GI028	C-DW06	–	7809819
	C4-DWLNR-27050-08	40	110	140	27	50	95	-6	-6	✓	.92	GI072	C-DW08-1	AT004	7809821
	C5-DWLNR-35060-08	50	110	165	35	60	95	-6	-6	✓	1.63	GI072	C-DW08-2	AT004	7809823
	C6-DWLNR-45065-08	63	110	190	45	65	95	-6	-6	✓	2.95	GI072	C-DW08-2	AT004	7809825
L	C4-DWLNL-27050-06	40	60	140	27	50	95	-6	-6	✓	.94	GI028	C-DW06	–	7809818
	C4-DWLNL-27050-08	40	110	140	27	50	95	-6	-6	✓	.92	GI072	C-DW08-1	AT004	7809820
	C5-DWLNL-35060-08	50	110	165	35	60	95	-6	-6	✓	1.67	GI072	C-DW08-2	AT004	7809822
	C6-DWLNL-45065-08	63	110	190	45	65	95	-6	-6	✓	2.95	GI072	C-DW08-2	AT004	7809824

GI028	WN.. 33.. (WN.. 0604..)
GI072	WN.. 43.. (WN.. 0804..)

		Nm				
C-DW06	DCS 09	1.7	DWS 328-01	US 2004-T09P	FLAG T09P	CN 034-01
C-DW08-1	DCS 12	3.9	DWS 331-12	US 2002-T15P	FLAG T15P/3,5	CN 034-01
C-DW08-2	DCS 12	3.9	DWS 331-12	US 2002-T15P	FLAG T15P/3,5	CN 045-01

AT004a	CER WN.N 0804..	DCS 12C4
AT004b	CER WN.A 0804..	DCS 12C2

DWLN(RL) INT

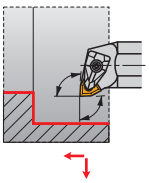
P M K N S H

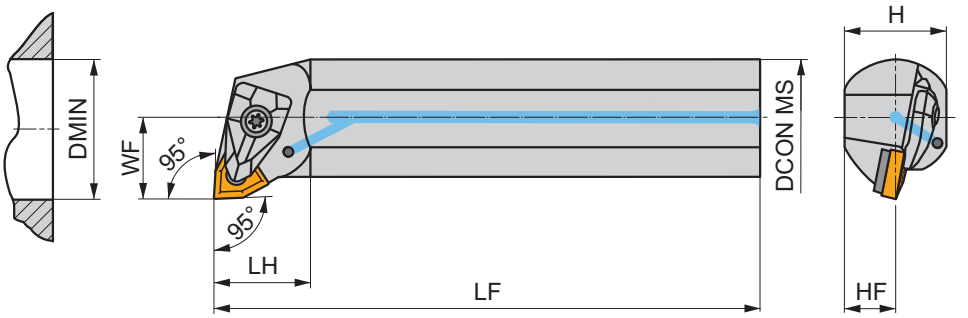
PRAMET

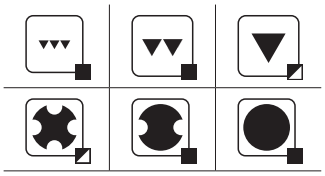
D

Internal Double Clamp Boring Bar with 95° Cutting Angle for WN.. Inserts

Internal Right/Left hand double clamp boring bar, through coolant, 95° cutting angle for negative WN.. inserts. For internal taper, longitudinal turning with shoulder and chamfer turning. Body treated for longer tool life.







	Product	DCON MS (mm)	DMIN (mm)	WF (mm)	H (mm)	HF (mm)	LF (mm)	LH (mm)	LAMS (°)	GAMO (°)		lbs			MID
R	A25T-DWLNR 06	25	32	17	23	11.5	300	31.0	-14	-6	✓	2.13	GI028	DW06	7028484
	A25T-DWLNR 08	25	33	17	23	11.5	300	31.0	-12	-6	✓	2.07	GI072	DWI08	7028486
	A32T-DWLNR 08	32	40	22	30	15	300	33.0	-10	-6	✓	3.76	GI072	DWI08	7028490
	A40T-DWLNR 08	40	50	27	37	18.5	300	36.0	-13	-6	✓	5.71	GI072	DW08	7028500
	A50U-DWLNR 08	50	63	35	47	23.5	350	39.0	-11	-6	✓	11.55	GI072	DW08	7028508
L	A25T-DWLNL 06	25	32	17	23	11.5	300	31.0	-14	-6	✓	2.14	GI028	DW06	7028483
	A25T-DWLNL 08	25	33	17	23	11.5	300	31.0	-12	-6	✓	2.16	GI072	DWI08	7028485
	A32T-DWLNL 08	32	40	22	30	15	300	33.0	-10	-6	✓	3.31	GI072	DWI08	7028489
	A40T-DWLNL 08	40	50	27	37	18.5	300	36.0	-13	-6	✓	5.72	GI072	DW08	7028499
	A50U-DWLNL 08	50	63	35	47	23.5	350	39.0	-11	-6	✓	11.58	GI072	DW08	7028507

GI028	WN.. 33.. (WN.. 0604..)
GI072	WN.. 43.. (WN.. 0804..)

		Nm			
DW06	DCS 09	1.7	DWS 328-01	US 2004-T09P	FLAG T09P
DW08	DCS 12	3.9	DWS 331-12	US 2002-T15P	FLAG T15P/3,5
DWI08	DCS 12	3.9	DWS 328-02	US 2002-T15P	FLAG T15P/3,5

IDWLN(RL) INT

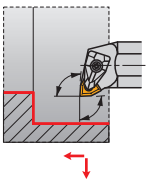
P M K N S H

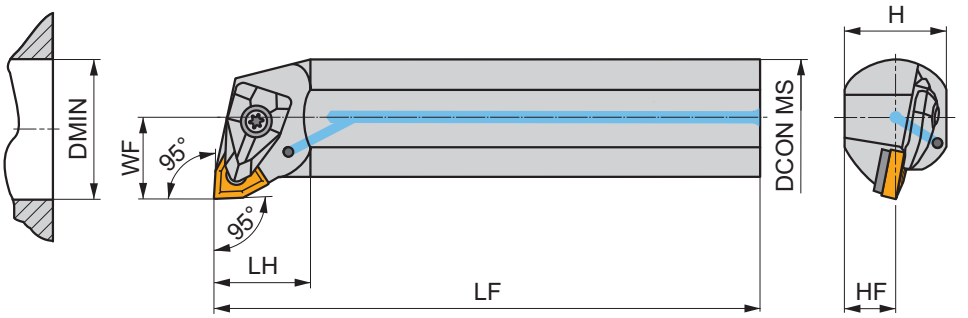
PRAMET

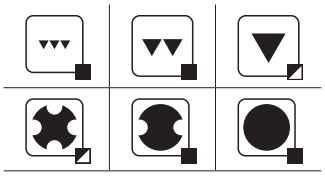
D

Internal Double Clamp Boring Bar with 95° Cutting Angle for WN.. Inserts

Internal Right/Left hand double clamp boring bar, through coolant, 95° cutting angle for negative WN.. inserts. For internal taper, longitudinal turning with shoulder and chamfer turning. Body treated for longer tool life.







	Product	DCON MS (inch)	DMIN (inch)	WF (inch)	H (inch)	HF (inch)	LF (inch)	LH (inch)	LAMS (°)	GAMO (°)		lbs			MID
R	A16T-DWLNR 4	1.000	1.299	.750	.906	.453	12.000	1.339	-12	-6	✓	1.54	GI072	DWI08	6788483
	A20T-DWLNR 4	1.250	1.705	1.000	1.181	.591	12.000	1.339	-15	-6	✓	3.08	GI072	DWI08	6788499
	A24T-DWLNR 4	1.500	2.000	1.000	1.374	.687	12.000	1.339	-13	-6	✓	8.25	GI072	DW08	6788513
L	A20T-DWLNL 4	1.250	1.705	1.000	1.181	.591	12.000	1.339	-15	-6	✓	3.08	GI072	DWI08	6788498

GI072	WN.. 43.. (WN.. 0804..)

DW08	DCS 12	3.9	DWS 331-12	US 2002-T15P	FLAG T15P/3,5
DWI08	DCS 12	3.9	DWS 328-02	US 2002-T15P	FLAG T15P/3,5

PWLN(RL) INT

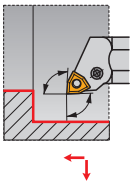
P M K N S H

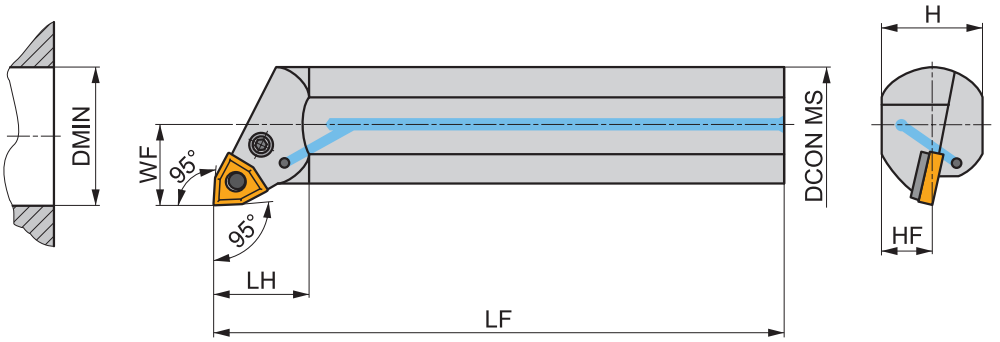
PRAMET

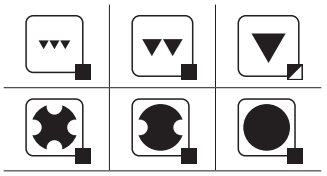
P

Internal Lever Lock Boring Bar with 95° Cutting Angle for WN.. Inserts

Internal Right/Left hand lever lock boring bar, through coolant available, 95° cutting angle for WN.. inserts. For internal taper and longitudinal turning with shoulder and chamfer turning. Body treated for longer tool life.







	Product	DCON MS (mm)	DMIN (mm)	WF (mm)	H (mm)	B (mm)	LF (mm)	LAMS (°)	GAMO (°)		lbs			MID
R	A16M-PWLNR 0604	16	20	11	15	15.01	150	-18	-4	✓	.53	GI028	PT04	6761034
	A20Q-PWLNR 0604	20	27	13	18	18.01	180	-18	-4	✓	.80	GI028	PT04	6761036
	A25R-PWLNR 0604	25	31	17	23	–	200	-14	-4	✓	1.58	GI028	PW01	8281409
	A32S-PWLNR 0604	32	39	22	30	30	250	-12	-4	✓	2.87	GI028	PW01	6757111
	A25R-PWLNR 08	25	31	17	23	23.01	200	-14	-4	✓	1.46	GI072	PC06	6758464
	A32S-PWLNR 08	32	39	22	30	30	250	-12	-4	✓	3.15	GI072	PW02	6758466
	A40T-PWLNR 08	40	48	27	37	38	300	-12	-4	✓	5.29	GI072	PW02	6757113
	A50U-PWLNR 08	50	61	35	47	48.49	350	-12	-4	✓	10.77	GI072	PW02	6757124
	A60V-PWLNR 08	60	80	43	57	58.5	400	-12	-4	–	17.86	GI072	PW02	6757367
L	A16M-PWLNL 0604	16	20	11	15	15.01	150	-18	-4	✓	.49	GI028	PT04	6761033
	A20Q-PWLNL 0604	20	27	13	18	18.01	180	-18	-4	✓	.80	GI028	PT04	6761035
	A25R-PWLNL 0604	25	31	17	23	–	200	-14	-4	✓	1.57	GI028	PW01	8281408
	A25R-PWLNL 08	25	31	17	23	23.01	200	-14	-4	✓	1.57	GI072	PC06	6758465
	A32S-PWLNL 08	32	39	22	30	30	250	-12	-4	✓	3.15	GI072	PW02	6758467
	A40T-PWLNL 08	40	48	27	37	38	300	-12	-4	–	5.96	GI072	PW02	6757368
	A50U-PWLNL 08	50	61	35	47	48.49	350	-12	-4	✓	10.76	GI072	PW02	6757369

GI028	WN.. 33.. (WN.. 0604..)
GI072	WN.. 43.. (WN.. 0804..)

				Nm					
PW01	PWS 007	CL 009	CS 606	2.0	M 6x1	0.657	TR 09	MT 04	HXK 2.5
PW02	PWS 008	CL 012	CS 608	3.0	M 8x1	0.815	TR 12	MT 05	HXK 3
PT04	–	CL 216	CS 605	1.4	M 5x1	0.472	–	–	HXK 2
PC06	–	CL 212	CS 626	2.0	M 6x1	0.528	–	–	HXK 2.5

C.-DWLN(RL) INT

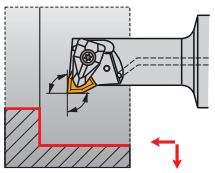
P M K N S H

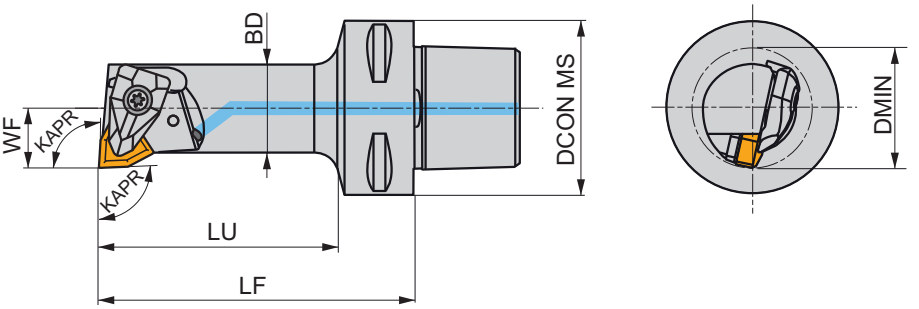
PRAMET

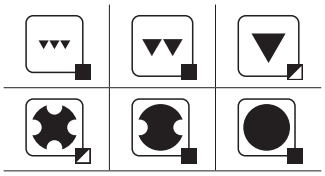
D

Internal PSC Quick Change Tool, Double Clamp, 95° Cutting Angle, WN.. Inserts

Internal Right/Left hand double clamp tool, through coolant, with 95° cutting angle for internal taper and longitudinal turning with shoulder and chamfering with WN.. inserts. Polygon Shank Coupling. Body treated for longer tool life.





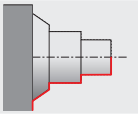


	Product	DCON MS (mm)	DMIN (mm)	WF (mm)	LF (mm)	LU (mm)	BD (mm)	KAPR (°)	LAMS (°)	GAMO (°)		lbs			MID
R	C4-DWLNR-13075-06	40	27	13	75	52	20	95	-17	-6	✓	.92	GI028	DW06	7809872
	C4-DWLNR-17090-08	40	33	17	90	68	25	95	-12	-6	✓	1.17	GI072	DWI08	7809874
L	C4-DWLNL-13075-06	40	27	13	75	52	20	95	-17	-6	✓	.92	GI028	DW06	7809871
	C4-DWLNL-17090-08	40	33	17	90	68	25	95	-12	-6	✓	1.17	GI072	DWI08	7809873

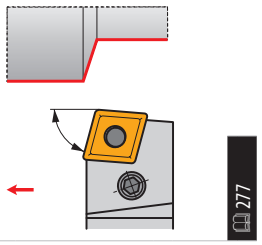
GI028	WN.. 33.. (WN.. 0604..)
GI072	WN.. 43.. (WN.. 0804..)

DW06	DCS 09	1.7	DWS 328-01	US 2004-T09P	FLAG T09P
DWI08	DCS 12	3.9	DWS 328-02	US 2002-T15P	FLAG T15P/3,5

ISO TURNING – EXTERNAL
SHORT AND STABLE COMPONENTS (negative inserts)

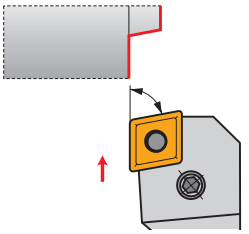


PCBN(RL) EXT 75°
CN..



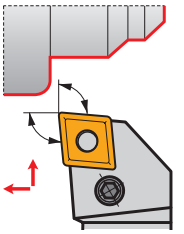
277

PCKN(RL) EXT 75°
CN..



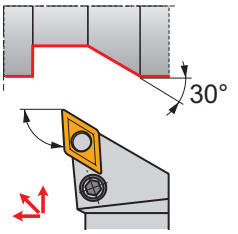
279

PCLN(RL) EXT 95°
CN..



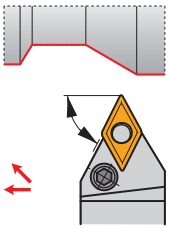
280

PDJN(RL) EXT 93°
DN..



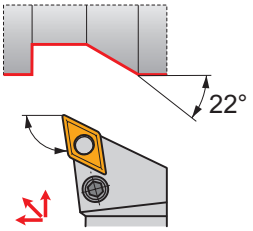
296

PDNN(RL) EXT 62°30´
DN..



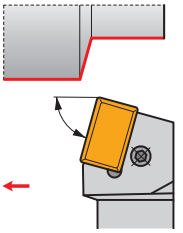
297

PDXN(RL) EXT 98°
DN..



298

PLBN(RL) EXT 75°
LN..



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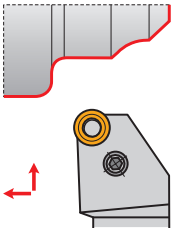
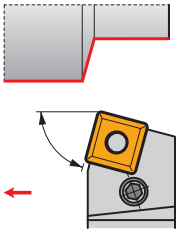
PRSN(RL) EXT
RN..



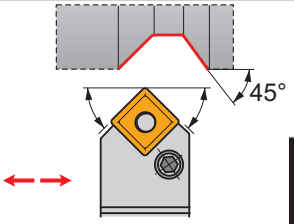
310

PSBN(RL) EXT 75°
SN..



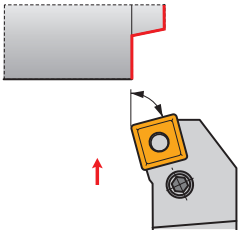
324

PSDNN EXT 45°
SN..



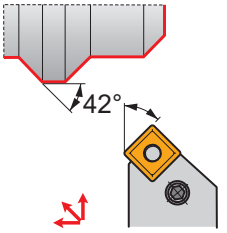
326

PSKN(RL) EXT 75°
SN..



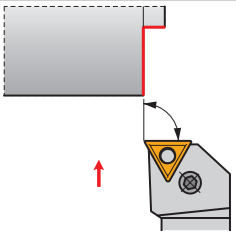
327

PSSN(RL) EXT 45°
SN..



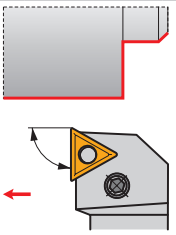
329

PTFN(RL) EXT 90°
TN..



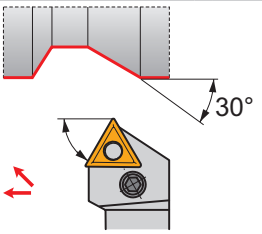
344

PTGN(RL) EXT 90°
TN..



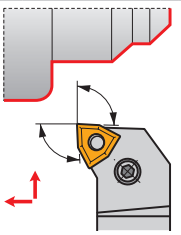
345

PTTN(RL) EXT 60°
TN..



346

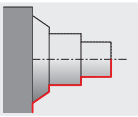
PWLN(RL) EXT 95°
WN..



362

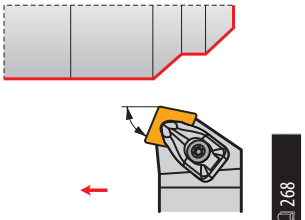
ISO TURNING – EXTERNAL

SHORT AND STABLE COMPONENTS (negative inserts)



DCBN(RL) EXT 75°

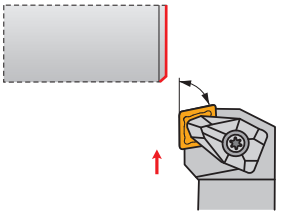
CN..



268

DCKN(RL) EXT 75°

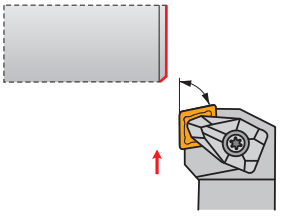
CN..



270

IDCKN(RL) EXT 75°

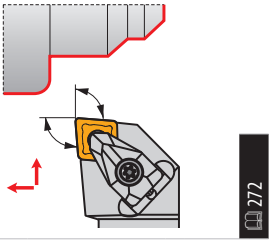
CN..



271

DCLN(RL) EXT 95°

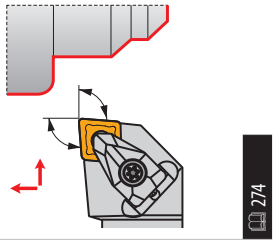
CN..



272

IDCLN(RL) EXT 95°

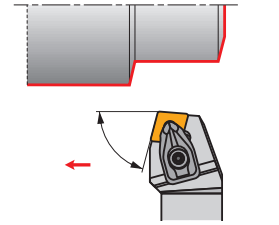
CN..



274

IDCRN(RL) EXT 75°

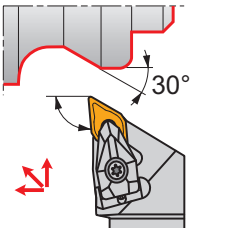
CN..



276

DDJN(RL) EXT 93°

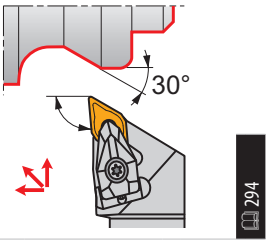
DN..



292

IDDJN(RL) EXT 93°

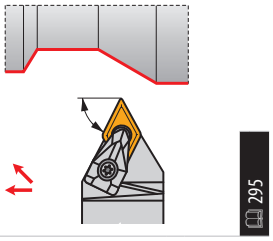
DN..



294

IDDPNN EXT 62,5°

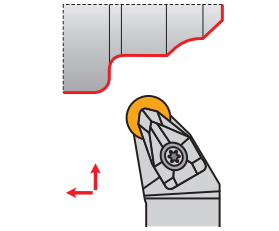
DN..



295

DRSN(RL) EXT

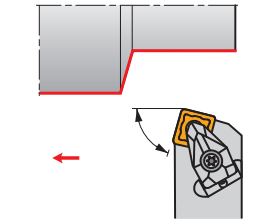
RN..



309

DSBN(RL) EXT 45°

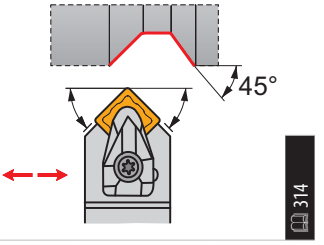
SN..



312

DSDNN EXT 45°

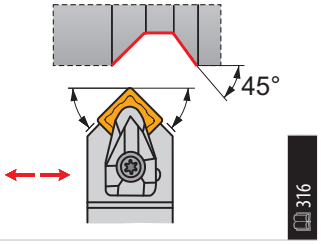
SN..



314

IDSDNN EXT 45°

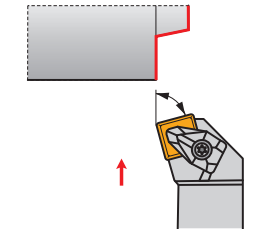
SN..



316

DSKN(RL) EXT 75°

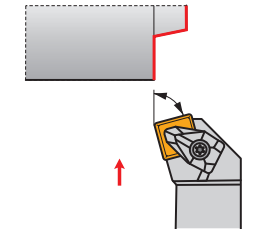
SN..



317

IDSKN(RL) EXT 75°

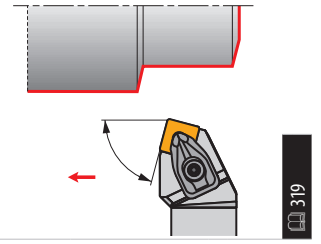
SN..



318

IDSRN(RL) EXT 75°

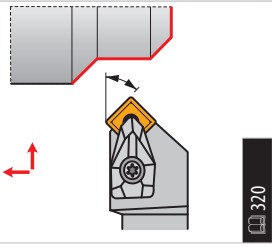
RN..



319

DSSN(RL) EXT 45°

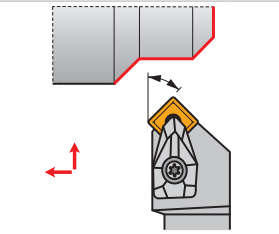
SN..



320

IDSSN(RL) EXT 45°

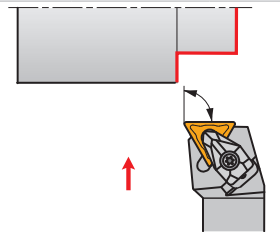
SN..



322

DTFN(RL) EXT 90°

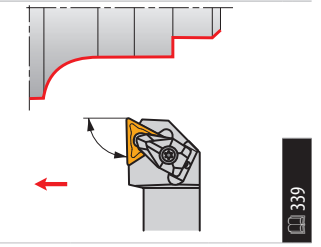
TN..



338

DTGN(RL) EXT 90°

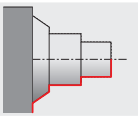
TN..



339

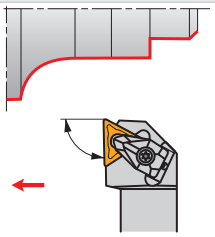
ISO TURNING – EXTERNAL

SHORT AND STABLE COMPONENTS (negative inserts)



IDTGN(RL) EXT 90°

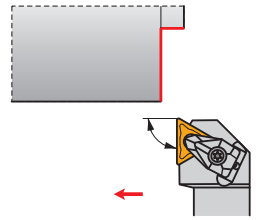
TN..



340

IDTJN(RL) EXT 93°

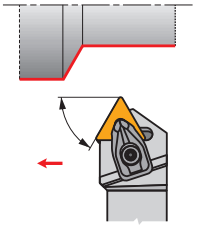
TN..



341

IDTTN(RL) EXT 60°

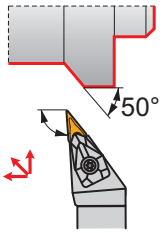
TN..



342

DVJN(RL) EXT 93°

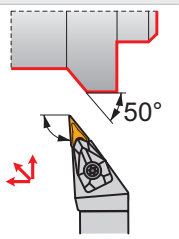
VN..



352

IDVJN(RL) EXT 93°

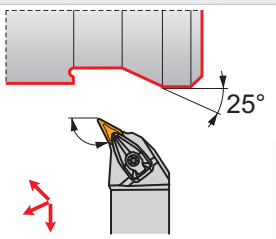
VN..



353

DVPN(RL) EXT 62°30´

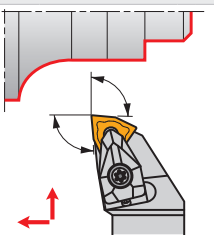
VN..



354

DWLN(RL) EXT 95°

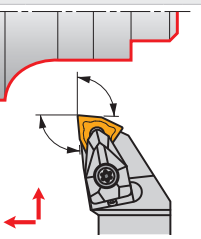
WN..



358

IDWLN(RL) EXT 95°

WN..

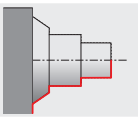


360

KHP / DKH CLAMPING DESIGNATION

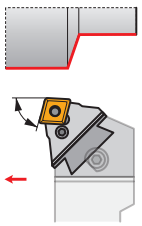
ISO TURNING – HEAVY ROUGHING – EXTERNAL

HEAD (KH)



KHP-CBNR 75°

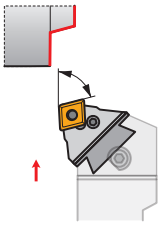
CN..



284

KHP-CBNL 75°

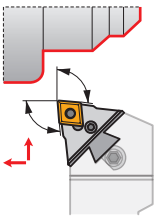
CN..



284

KHP-CLNR/L 95°

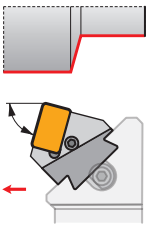
CN..



285

KHP-LBNR 75°

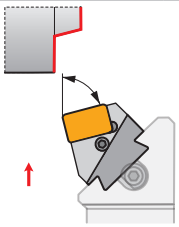
LN..



308

KHP-LBNL 75°

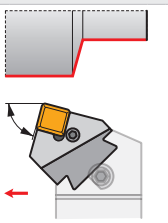
LN..



308

KHP-SBNR 75°

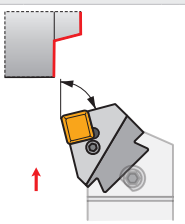
SN..



335

KHP-SBNL 75°

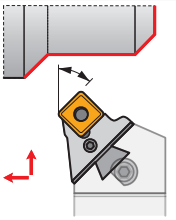
SN..



335

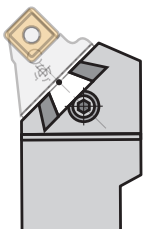
KHP-SSNR/L 45°

SN..



336

DKH(RL)

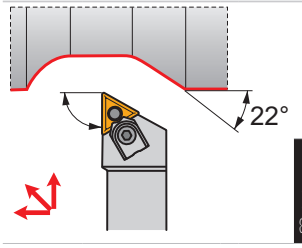


286

M CLAMPING DESIGNATION

MTJN(RL) EXT 93°

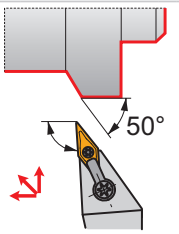
TN..



343

MVJN(RL) EXT 93°

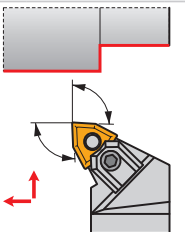
VN..



355

MWLN(RL) EXT 95°

WN..

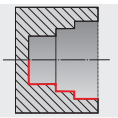


361

P CLAMPING DESIGNATION

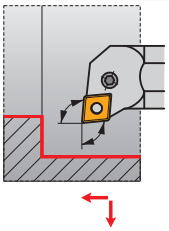
ISO TURNING – INTERNAL

SHORT AND STABLE COMPONENTS (negative inserts)



PCLN(RL) INT 95°

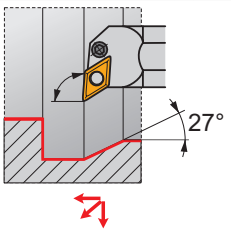
CN..



289

PDUN(RL) INT 93°

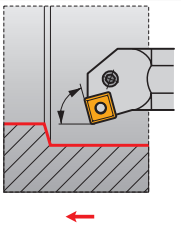
DN..



304

PSKN(RL) INT 93°

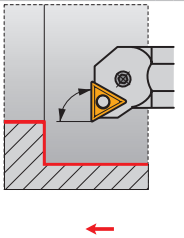
SN..



337

PTFN(RL) INT 90°

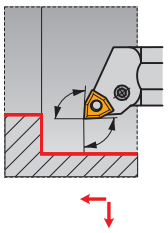
TN..



350

P CLAMPING DESIGNATION — TOOLS – NAVIGATOR

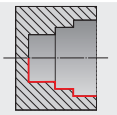
PWLN(RL) INT 95°
WN..



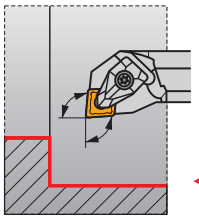
366

D CLAMPING DESIGNATION — TOOLS – NAVIGATOR

ISO TURNING – INTERNAL
SHORT AND STABLE COMPONENTS (negative inserts)

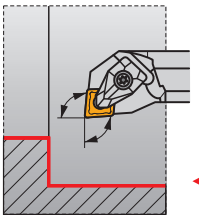


DCLN(RL) INT 95°
CN..



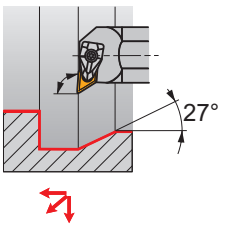
287

IDCLN(RL) INT 95°
CN..



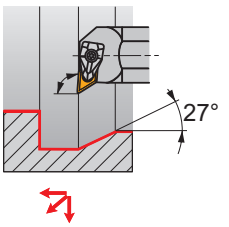
288

DDUN(RL) INT 93°
DN..



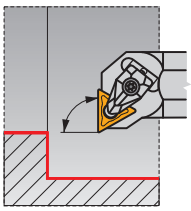
302

IDDUN(RL) INT 93°
DN..



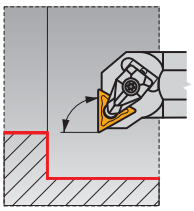
303

DTFN(RL) INT 90°
TN..



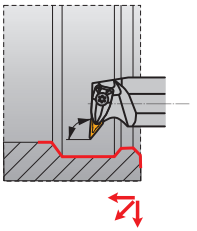
348

IDTFN(RL) INT 90°
TN..



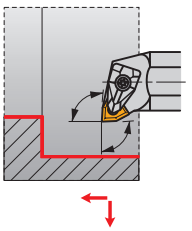
349

DVUN(RL) INT
VN..



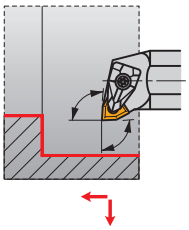
357

DWLN(RL) INT 95°
WN..



364

IDWLN(RL) INT 95°
WN..



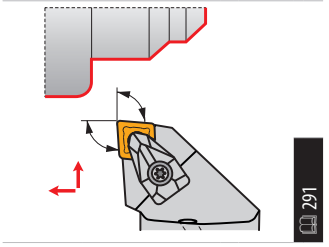
365

ISO TURNING – EXTERNAL PSC

SHORT AND STABLE COMPONENTS (negative inserts)

C.-DCLN(RL) EXT 95°

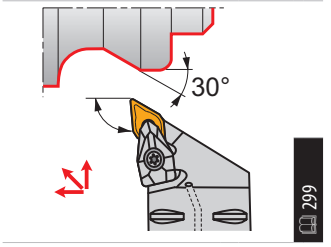
CN..



291

C.-DDJN(RL) EXT 93°

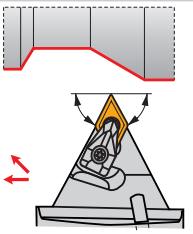
DN..



299

C.-DDNNN EXT 62.5°

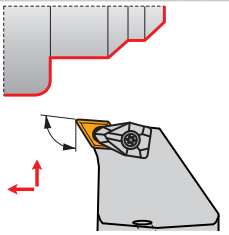
DN..



300

C.-DDUN(RL) EXT 93°

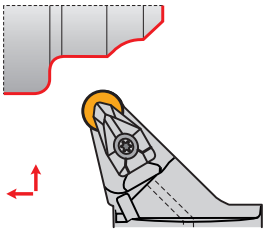
DN..



301

C.-DRSN(RL) EXT

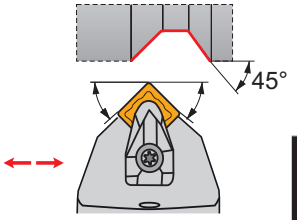
RN..



311

C.-DSDNN EXT 45°

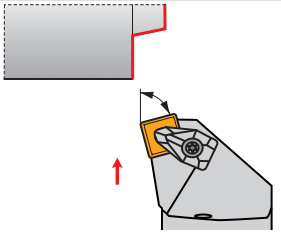
SN..



331

C.-DSKN(RL) EXT 75°

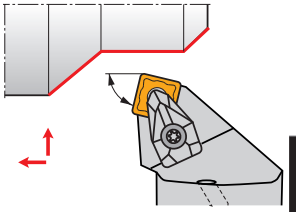
SN..



332

C.-DSRN(RL) EXT 75°

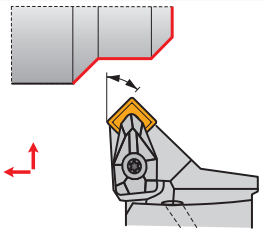
SN..



333

C.-DSSN(RL) EXT 45°

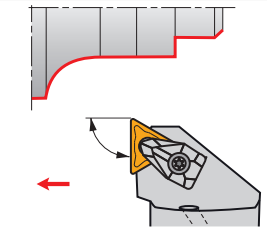
SN..



334

C.-DTJN(RL) EXT 93°

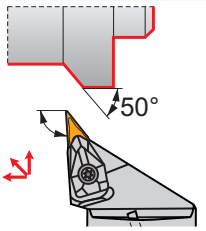
TN..



347

C.-DVJN(RL) EXT 93°

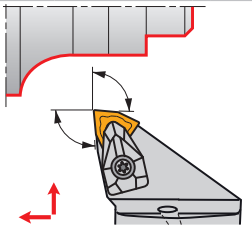
VN..



356

C.-DWLN(RL) EXT 95°

WN..



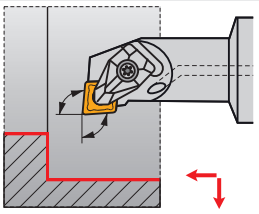
363

ISO TURNING – INTERNAL PSC

SHORT AND STABLE COMPONENTS (negative inserts)

C.-DCLN(RL) INT 95°

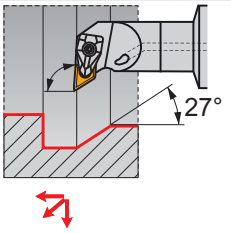
CN..



291

C.-DDUN(RL) INT 93°

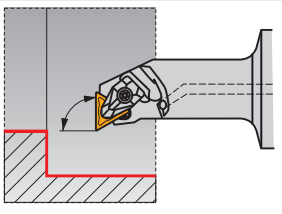
DN..



304

C.-DTFN(RL) INT 91°

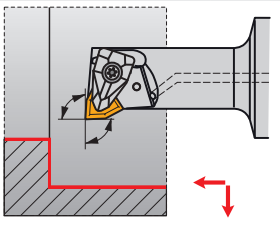
TN..



351

C.-DWLN(RL) INT 95°

WN..



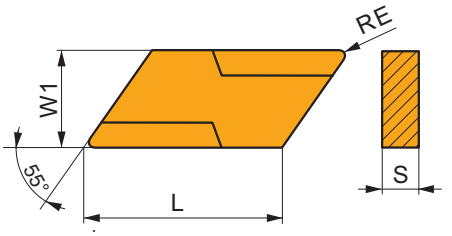
368

OTHER CARBIDE & CERMET INSERTS

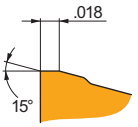
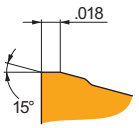
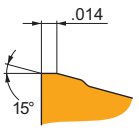
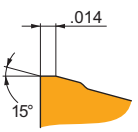
KNUX

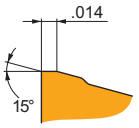
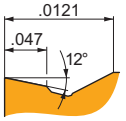
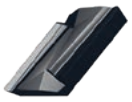
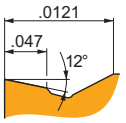
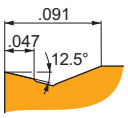
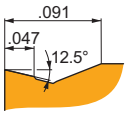
PRAMET

	W1	L	S
	(inch)	(inch)	(inch)
1604	.375	.768	.187



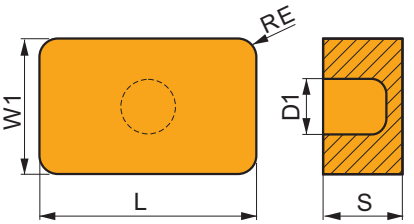
Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our cutting conditions app for further options.

Product		RE	P			M			K			N			S			H			MID
			vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	
		(inch)	(ft/min)	(in/rev)	(inch)	(ft/min)	(in/rev)	(inch)	(ft/min)	(in/rev)	(inch)	(ft/min)	(in/rev)	(inch)	(ft/min)	(in/rev)	(inch)	(ft/min)	(in/rev)	(inch)	
																					
L-22 geometry with left-handed design for finish to semi-rough machining, and continuous cuts.																					
KNUX 160405L-22	**T7325**	.020	427	.0098	.106	328	.0098	.106	–	–	–	–	–	–	–	–	–	–	–	–	7455480
	T7335	.020	410	.0098	.106	312	.0098	.106	–	–	–	–	–	–	–	–	–	–	–	–	7455429
	T9325	.020	509	.0098	.106	295	.0098	.106	476	.0098	.106	–	–	–	–	–	–	–	–	–	7455427
	T9335	.020	443	.0098	.106	262	.0098	.106	–	–	–	–	–	–	–	–	–	–	–	–	7455428
KNUX 160410L-22	**T9335**	.039	509	.0126	.106	295	.0114	.106	–	–	–	–	–	–	–	–	–	–	–	–	7455496
																					
R-22 geometry with right-handed design for finish to semi-rough machining, and continuous cuts.																					
KNUX 160405R-22	**T7325**	.020	427	.0098	.106	328	.0098	.106	–	–	–	–	–	–	–	–	–	–	–	–	7455490
	T7335	.020	410	.0098	.106	312	.0098	.106	–	–	–	–	–	–	–	–	–	–	–	–	7455489
	T9325	.020	509	.0098	.106	295	.0098	.106	476	.0098	.106	–	–	–	–	–	–	–	–	–	7455487
	T9335	.020	443	.0098	.106	262	.0098	.106	–	–	–	–	–	–	–	–	–	–	–	–	7455488
KNUX 160410R-22	**T9335**	.039	509	.0126	.106	295	.0114	.106	–	–	–	–	–	–	–	–	–	–	–	–	7455499
																					
L-32 geometry with left-handed design for finish to semi-rough machining, and continuous cuts.																					
KNUX 160405L-32	**T5315**	.020	623	.0098	.106	–	–	–	591	.0098	.106	–	–	–	–	–	–	–	–	–	7455481
	T7325	.020	427	.0098	.106	328	.0098	.106	–	–	–	–	–	–	–	–	–	–	–	–	7455485
	T7335	.020	410	.0098	.106	312	.0098	.106	–	–	–	–	–	–	–	–	–	–	–	–	7455484
	T9325	.020	509	.0098	.106	295	.0098	.106	476	.0098	.106	–	–	–	–	–	–	–	–	–	7455482
	T9335	.020	443	.0098	.106	262	.0098	.106	–	–	–	–	–	–	–	–	–	–	–	–	7455483
KNUX 160410L-32	**T9325**	.039	574	.0126	.106	344	.0114	.106	541	.0126	.106	–	–	–	–	–	–	–	–	–	7455497
	T9335	.039	509	.0126	.106	295	.0114	.106	–	–	–	–	–	–	–	–	–	–	–	–	7455498
																					
R-32 geometry with right-handed design for finish to semi-rough machining, and continuous cuts.																					
KNUX 160405R-32	**T5315**	.020	623	.0098	.106	–	–	–	591	.0098	.106	–	–	–	–	–	–	–	–	–	7455491
	T7325	.020	427	.0098	.106	328	.0098	.106	–	–	–	–	–	–	–	–	–	–	–	–	7455495
	T7335	.020	410	.0098	.106	312	.0098	.106	–	–	–	–	–	–	–	–	–	–	–	–	7455494
	T9325	.020	509	.0098	.106	295	.0098	.106	476	.0098	.106	–	–	–	–	–	–	–	–	–	7455492
	T9335	.020	443	.0098	.106	262	.0098	.106	–	–	–	–	–	–	–	–	–	–	–	–	7455493

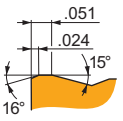
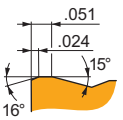
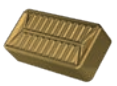
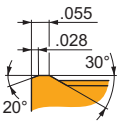
Product		RE	P			M			K			N			S			H			MID
		(inch)	vc (ft/min)	f (in/rev)	ap (inch)	vc (ft/min)	f (in/rev)	ap (inch)	vc (ft/min)	f (in/rev)	ap (inch)	vc (ft/min)	f (in/rev)	ap (inch)	vc (ft/min)	f (in/rev)	ap (inch)	vc (ft/min)	f (in/rev)	ap (inch)	
																					
			U E																		
R-32 geometry with right-handed design for finish to semi-rough machining, and continuous cuts.																					
KNUX 160410R-32	**T9325**	.039	574	.0126	.106	344	.0114	.106	541	.0126	.106	–	–	–	–	–	–	–	–	–	7455500
	T9335	.039	509	.0126	.106	295	.0114	.106	–	–	–	–	–	–	–	–	–	–	–	–	7455501
																					
			E																		
ER-72 geometry with right-handed design for fine to finish machining, and continuous cuts.																					
KNUX 160405ER-72	**T5315**	.020	820	.0079	.079	–	–	–	771	.0079	.079	–	–	–	–	–	–	–	–	–	6755760
	T9325	.020	705	.0079	.079	410	.0071	.079	656	.0079	.079	–	–	–	148	.0063	.063	–	–	–	6753829
	T9335	.020	607	.0079	.079	361	.0071	.079	–	–	–	–	–	–	131	.0063	.063	–	–	–	6754914
																					
			E																		
EL-72 geometry with left-handed design for fine to finish machining, and continuous cuts.																					
KNUX 160405EL-72	**T9325**	.020	705	.0079	.079	410	.0071	.079	656	.0079	.079	–	–	–	148	.0063	.063	–	–	–	6753978
	T9335	.020	607	.0079	.079	361	.0071	.079	–	–	–	–	–	–	131	.0063	.063	–	–	–	6754913
																					
			E																		
ER-73 geometry with right-handed design for finish to semi-rough machining, and continuous cuts.																					
KNUX 160405SR-73	**6640**	.020	492	.0098	.118	295	.0091	.118	459	.0098	.118	–	–	–	–	–	–	–	–	–	6751686
KNUX 160410SR-73	**6640**	.039	492	.0157	.118	295	.0142	.118	459	.0157	.118	–	–	–	–	–	–	–	–	–	6751726
	T5315	.039	771	.0157	.118	–	–	–	722	.0157	.118	–	–	–	–	–	–	–	–	–	6755764
																					
			E																		
EL-73 geometry with left-handed design for finish to semi-rough machining, and continuous cuts.																					
KNUX 160405SL-73	**6640**	.020	492	.0098	.118	295	.0091	.118	459	.0098	.118	–	–	–	–	–	–	–	–	–	6751685
KNUX 160410SL-73	**6640**	.039	492	.0157	.118	295	.0142	.118	459	.0157	.118	–	–	–	–	–	–	–	–	–	6751725

LNUX 40, LN.X 50

	W1	D1	L	S
	(inch)	(inch)	(inch)	(inch)
40-1	.992	.366	1.575	.551
50-1	1.000	.366	2.000	.551
5014	1.000	.250	2.000	.551



Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our cutting conditions app for further options.

Product		RE	P			M			K			N			S			H			MID
			vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	
		(inch)	(ft/min)	(in/rev)	(inch)	(ft/min)	(in/rev)	(inch)	(ft/min)	(in/rev)	(inch)	(ft/min)	(in/rev)	(inch)	(ft/min)	(in/rev)	(inch)	(ft/min)	(in/rev)	(inch)	
																					
LNUX 40-1129003	**6630**	.126	■ 148	.0531	.984	–	–	–	◪ 131	.0531	.984	–	–	–	–	–	–	–	–	–	6752120
	T9325	.126	■ 180	.0531	.984	–	–	–	◪ 164	.0531	.984	–	–	–	–	–	–	–	–	–	6753981
	T9335	.126	■ 131	.0531	.984	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	6754917
																					
LNUX 50-1275000	**6630**	.126	■ 148	.0531	.984	–	–	–	◪ 131	.0531	.984	–	–	–	–	–	–	–	–	–	6752126
	T9325	.126	■ 180	.0531	.984	–	–	–	◪ 164	.0531	.984	–	–	–	–	–	–	–	–	–	6753982
																					
LNMX 501432E	**T9335**	.126	■ 148	.0591	.984	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	6754915

LN.X for heavy rough machining and continuous to interrupted cuts.

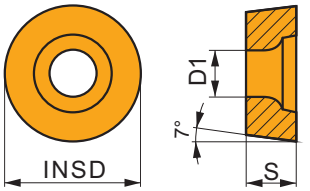
LN.X for heavy rough machining and continuous to interrupted cuts.

LN.X design for heavy rough machining and continuous to heavy interrupted cuts.

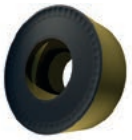
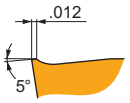
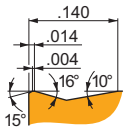
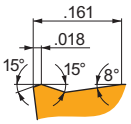
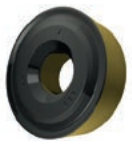
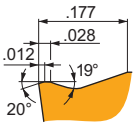
RCMT

PRAMET

	INSD	D1	S
	(inch)	(inch)	(inch)
1606	.630	.217	.250
2006	.787	.256	.250
2507	.984	.339	.313
3009	1.181	.394	.375

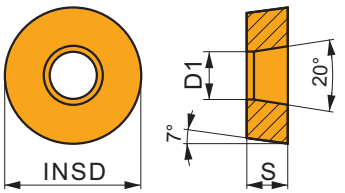


Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our cutting conditions app for further options.

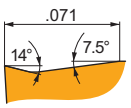
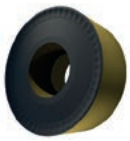
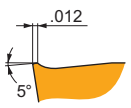
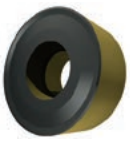
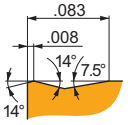
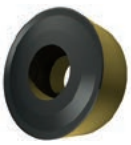
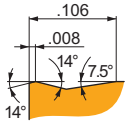
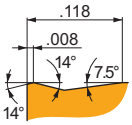
Product		RE (inch)	P vc (ft/min)	P f (in/rev)	P ap (inch)	M vc (ft/min)	M f (in/rev)	M ap (inch)	K vc (ft/min)	K f (in/rev)	K ap (inch)	N vc (ft/min)	N f (in/rev)	N ap (inch)	S vc (ft/min)	S f (in/rev)	S ap (inch)	H vc (ft/min)	H f (in/rev)	H ap (inch)	MID
																					
			HFC S																		
			37 geometry for semi-rough to heavy-rough machining, and continuous to interrupted cuts.																		
RCMT 1606MOS-37	**T9325**	–	■ 476	.0236	.118	–	–	–	◪ 443	.0236	.118	–	–	–	–	–	–	–	–	–	6753831
	T9415	–	■ 656	.0236	.118	–	–	–	◪ 623	.0236	.118	–	–	–	–	–	–	–	–	–	8183847
																					
			HFC P																		
			371 geometry for semi-rough to heavy-rough machining, and continuous to interrupted cuts.																		
RCMT 2006MOS-371	**T9325**	–	■ 410	.0315	.118	–	–	–	◪ 377	.0315	.118	–	–	–	–	–	–	–	–	–	6753987
	T9415	–	■ 607	.0315	.118	–	–	–	◪ 574	.0315	.118	–	–	–	–	–	–	–	–	–	8366640
																					
			HFC S																		
			372 geometry for semi-rough to heavy-rough machining, continuous to interrupted cuts.																		
RCMT 2507MOS-372	**T9325**	–	■ 295	.0315	.118	–	–	–	◪ 279	.0315	.118	–	–	–	–	–	–	–	–	–	6753988
																					
			HFC P																		
			RR4 geometry for heavy rough machining, and continuous to heavy interrupted cuts.																		
RCMT 3009MO-RR4	**T9310**	–	■ 295	.0433	.157	–	–	–	◪ 279	.0433	.157	–	–	–	–	–	–	–	–	–	6755593
	T9315	–	■ 279	.0433	.157	–	–	–	◪ 262	.0433	.157	–	–	–	–	–	–	–	–	–	6755594
	T9415	–	■ 312	.0433	.157	–	–	–	◪ 295	.0433	.157	–	–	–	–	–	–	–	–	–	8183848

RCMX

	INSD (inch)	D1 (inch)	S (inch)
1003	.394	.142	.125
1204	.472	.165	.187
1606	.630	.205	.250
2006	.787	.256	.250
2507	.984	.283	.313
3209	1.260	.374	.375



Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our cutting conditions app for further options.

Product		RE (inch)	P vc (ft/min)	P f (in/rev)	P ap (inch)	M vc (ft/min)	M f (in/rev)	M ap (inch)	K vc (ft/min)	K f (in/rev)	K ap (inch)	N vc (ft/min)	N f (in/rev)	N ap (inch)	S vc (ft/min)	S f (in/rev)	S ap (inch)	H vc (ft/min)	H f (in/rev)	H ap (inch)	MID
																					
RCMX 1003MOS-31	**T9325**	–	541	.0197	.079	312	.0177	.079	509	.0197	.079	–	–	–	–	–	–	–	–	–	6753989
																					
RCMX 1606MOS-37	**T9325**	–	476	.0236	.118	–	–	–	443	.0236	.118	–	–	–	–	–	–	–	–	–	6753991
	T9415	–	656	.0236	.118	–	–	–	623	.0236	.118	–	–	–	–	–	–	–	–	–	8239166
RCMX 2006MOS-37	**6630**	–	443	.0236	.118	–	–	–	410	.0236	.118	–	–	–	–	–	–	–	–	–	6752008
RCMX 2507MOS-37	**6630**	–	295	.0236	.118	–	–	–	279	.0236	.118	–	–	–	–	–	–	–	–	–	6751666
																					
RCMX 1204MOS-321	**T9325**	–	394	.0394	.118	–	–	–	361	.0394	.118	–	–	–	–	–	–	–	–	–	6753990
	T9415	–	558	.0394	.118	–	–	–	525	.0394	.118	–	–	–	–	–	–	–	–	–	8345955
																					
RCMX 1606MOS-331	**6630**	–	328	.0472	.138	–	–	–	312	.0472	.138	–	–	–	–	–	–	–	–	–	6751660
	T9325	–	344	.0472	.138	–	–	–	312	.0472	.138	–	–	–	–	–	–	–	–	–	6753832
	T9335	–	361	.0315	.138	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	6754920
	T9415	–	509	.0472	.138	–	–	–	476	.0472	.138	–	–	–	–	–	–	–	–	–	8239167
																					
RCMX 2006MOS-341	**6630**	–	344	.0394	.138	–	–	–	312	.0394	.138	–	–	–	–	–	–	–	–	–	6751662
	6640	–	295	.0394	.138	–	–	–	279	.0394	.138	–	–	–	–	–	–	–	–	–	6751663

31 geometry for finish to semi-rough machining, and continuous to interrupted cuts.

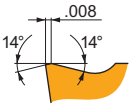
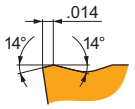
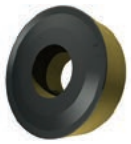
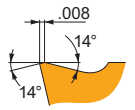
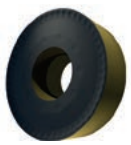
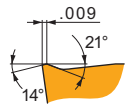
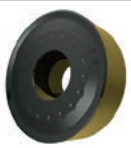
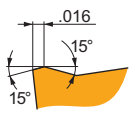
37 geometry for semi-rough to heavy-rough machining, and continuous to interrupted cuts.

321 geometry for semi-rough to heavy-rough machining, and continuous to interrupted cuts.

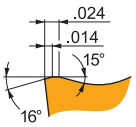
331 geometry for semi-rough to heavy-rough machining, and continuous to interrupted cuts.

341 geometry for semi-rough to heavy-rough machining, and continuous to interrupted cuts.

Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our cutting conditions app for further options.

Product		RE (inch)	P vc (ft/min)	P f (in/rev)	P ap (inch)	M vc (ft/min)	M f (in/rev)	M ap (inch)	K vc (ft/min)	K f (in/rev)	K ap (inch)	N vc (ft/min)	N f (in/rev)	N ap (inch)	S vc (ft/min)	S f (in/rev)	S ap (inch)	H vc (ft/min)	H f (in/rev)	H ap (inch)	MID
			**351** geometry for semi-rough to heavy-rough machining, and continuous to interrupted cuts.																		
RCMX 2507M0S-351	**6630**	–	■ 230	.0394	.138	–	–	–	◪ 213	.0394	.138	–	–	–	–	–	–	–	–	–	6751664
	6640	–	■ 197	.0394	.138	–	–	–	■ 180	.0394	.138	–	–	–	–	–	–	–	–	–	6751665
			**361** geometry for rough to heavy-rough machining and continuous to heavy interrupted cuts.																		
RCMX 3209M0S-361	**6640**	–	■ 164	.0551	.177	–	–	–	■ 148	.0551	.177	–	–	–	–	–	–	–	–	–	6751668
			**RF1** geometry for finish to semi-rough machining, and continuous to interrupted cuts.																		
RCMX 2006M0-RF1	**T5305**	–	◪ 344	.0315	.138	–	–	–	◪ 312	.0315	.138	–	–	–	–	–	–	–	–	–	6755844
	T9310	–	■ 344	.0315	.138	–	–	–	◪ 312	.0315	.138	–	–	–	–	–	–	–	–	–	6755576
	T9315	–	■ 328	.0315	.138	–	–	–	◪ 312	.0315	.138	–	–	–	–	–	–	–	–	–	6755577
	T9325	–	■ 295	.0315	.138	–	–	–	◪ 279	.0315	.138	–	–	–	–	–	–	–	–	–	6755578
	T9415	–	■ 344	.0315	.138	–	–	–	◪ 312	.0315	.138	–	–	–	–	–	–	–	–	–	8239168
RCMX 2507M0-RF1	**T8345**	–	■ 148	.0394	.138	–	–	–	◪ 131	.0394	.138	–	–	–	–	–	–	–	–	–	6754447
	T9310	–	■ 312	.0394	.138	–	–	–	◪ 295	.0394	.138	–	–	–	–	–	–	–	–	–	6755582
	T9335	–	■ 213	.0394	.138	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	6754923
	T9415	–	■ 328	.0394	.138	–	–	–	◪ 312	.0394	.138	–	–	–	–	–	–	–	–	–	8366641
			**RM1** geometry for finish to rough machining, and continuous to interrupted cuts.																		
RCMX 2006M0-RM1	**T9310**	–	■ 312	.0394	.138	–	–	–	◪ 295	.0394	.138	–	–	–	–	–	–	–	–	–	6755579
	T9315	–	■ 295	.0394	.138	–	–	–	◪ 279	.0394	.138	–	–	–	–	–	–	–	–	–	6755580
	T9325	–	■ 262	.0394	.138	–	–	–	◪ 246	.0394	.138	–	–	–	–	–	–	–	–	–	6755581
	T9335	–	■ 410	.0236	.118	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	6754922
	T9415	–	■ 328	.0394	.138	–	–	–	◪ 312	.0394	.138	–	–	–	–	–	–	–	–	–	8183849
RCMX 2507M0-RM1	**T9310**	–	■ 312	.0394	.138	–	–	–	◪ 295	.0394	.138	–	–	–	–	–	–	–	–	–	6755585
	T9315	–	■ 295	.0394	.138	–	–	–	◪ 279	.0394	.138	–	–	–	–	–	–	–	–	–	6755586
	T9335	–	■ 262	.0236	.118	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	6754924
	T9415	–	■ 328	.0394	.138	–	–	–	◪ 312	.0394	.138	–	–	–	–	–	–	–	–	–	8183900
			**RM2** geometry for semi-rough to rough machining, and continuous to interrupted cuts.																		
RCMX 2507M0-RM2	**T9310**	–	■ 295	.0433	.138	–	–	–	◪ 279	.0433	.138	–	–	–	–	–	–	–	–	–	6755588
	T9325	–	■ 246	.0433	.138	–	–	–	◪ 230	.0433	.138	–	–	–	–	–	–	–	–	–	6755590
	T9415	–	■ 312	.0433	.138	–	–	–	◪ 295	.0433	.138	–	–	–	–	–	–	–	–	–	8239169
RCMX 3209M0-RM2	**T5315**	–	◪ 312	.0394	.177	–	–	–	◪ 295	.0394	.177	–	–	–	–	–	–	–	–	–	6802056
	T9310	–	■ 295	.0394	.177	–	–	–	◪ 279	.0394	.177	–	–	–	–	–	–	–	–	–	6755595
	T9315	–	■ 279	.0394	.177	–	–	–	◪ 262	.0394	.177	–	–	–	–	–	–	–	–	–	6755596
	T9325	–	■ 246	.0394	.177	–	–	–	◪ 230	.0394	.177	–	–	–	–	–	–	–	–	–	6755597
	T9335	–	■ 180	.0551	.177	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	6754925
	T9415	–	■ 312	.0394	.177	–	–	–	◪ 295	.0394	.177	–	–	–	–	–	–	–	–	–	8183901

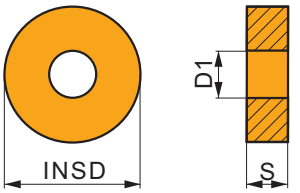
Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our cutting conditions app for further options.

Product		RE (inch)	P vc (ft/min)	P f (in/rev)	P ap (inch)	M vc (ft/min)	M f (in/rev)	M ap (inch)	K vc (ft/min)	K f (in/rev)	K ap (inch)	N vc (ft/min)	N f (in/rev)	N ap (inch)	S vc (ft/min)	S f (in/rev)	S ap (inch)	H vc (ft/min)	H f (in/rev)	H ap (inch)	MID
																					
			HFC	P																	
RR2 geometry for heavy rough machining, and continuous to interrupted cuts.																					
RCMX 3209M0-RR2	**T9315**	–	■ 197	.0551	.177	–	–	–	◪ 180	.0551	.177	–	–	–	–	–	–	◪ 33	.0276	.079	6755605
	T9415	–	■ 230	.0551	.177	–	–	–	◪ 213	.0551	.177	–	–	–	–	–	–	◪ 33	.0276	.079	8239170

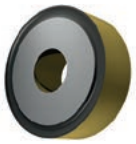
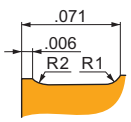
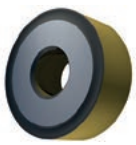
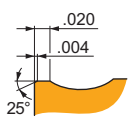
RNMG

PRAMET

	INSD (inch)	D1 (inch)	S (inch)
43	.500	.203	.187
54	.625	.250	.250
64	.750	.313	.250
86	1.000	.359	.375



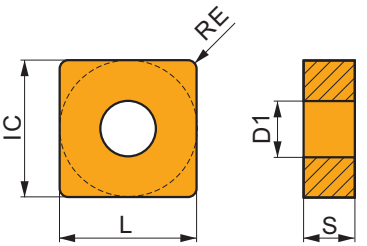
Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our cutting conditions app for further options.

Product		RE (inch)	P vc (ft/min)	P f (in/rev)	P ap (inch)	M vc (ft/min)	M f (in/rev)	M ap (inch)	K vc (ft/min)	K f (in/rev)	K ap (inch)	N vc (ft/min)	N f (in/rev)	N ap (inch)	S vc (ft/min)	S f (in/rev)	S ap (inch)	H vc (ft/min)	H f (in/rev)	H ap (inch)	MID
																					
			HFC	S																	
08 geometry for semi-rough to heavy-rough machining, and continuous to interrupted cuts.																					
RNMG 43-08	**T5305**	–	◪ 640	.0276	.118	–	–	–	◪ 607	.0276	.118	–	–	–	–	–	–	◪ 115	.0138	.031	6755850
	T9325	–	◪ 443	.0276	.118	–	–	–	◪ 410	.0276	.118	–	–	–	–	–	–	–	–	–	6753994
	T9415	–	◪ 623	.0276	.118	–	–	–	◪ 591	.0276	.118	–	–	–	–	–	–	◪ 115	.0138	.031	8345564
RNMG 54-08	**T5305**	–	◪ 640	.0276	.118	–	–	–	◪ 607	.0276	.118	–	–	–	–	–	–	◪ 115	.0138	.039	6755851
	T9325	–	◪ 673	.0276	.118	–	–	–	◪ 623	.0276	.118	–	–	–	–	–	–	–	–	–	6753995
	T9415	–	◪ 623	.0276	.118	–	–	–	◪ 591	.0276	.118	–	–	–	–	–	–	◪ 115	.0138	.039	8345565
RNMG 64-08	**T9325**	–	◪ 443	.0276	.118	–	–	–	◪ 410	.0276	.118	–	–	–	–	–	–	–	–	–	6753996
	T9415	–	◪ 623	.0276	.118	–	–	–	◪ 591	.0276	.118	–	–	–	–	–	–	◪ 115	.0138	.051	8345566
																					
			HFC	P																	
081 geometry for rough to heavy-rough machining, and continuous to interrupted cuts.																					
RNMG 86-081	**T9325**	–	◪ 427	.0354	.197	–	–	–	◪ 394	.0354	.197	–	–	–	–	–	–	–	–	–	6753997
	T9415	–	◪ 328	.0354	.197	–	–	–	◪ 312	.0354	.197	–	–	–	–	–	–	◪ 66	.0177	.067	8345567

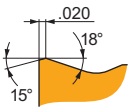
SNMM

PRAMET

	IC	D1	L	S
	(inch)	(inch)	(inch)	(inch)
85	1.000	.359	1.000	.313
86	1.000	.359	1.000	.375



Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our cutting conditions app for further options.

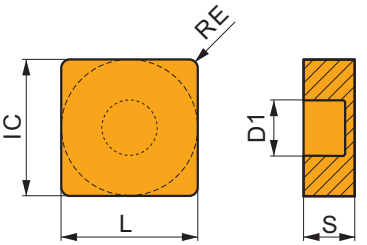
Product		RE	P			M			K			N			S			H			MID
			vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	
		(inch)	(ft/min)	(in/rev)	(inch)	(ft/min)	(in/rev)	(inch)	(ft/min)	(in/rev)	(inch)	(ft/min)	(in/rev)	(inch)	(ft/min)	(in/rev)	(inch)	(ft/min)	(in/rev)	(inch)	
																					
SNMM 856-SR	**T9325**	.094	262	.0394	.472	148	.0354	.472	246	.0394	.472	–	–	–	–	–	–	–	–	–	6754152
SNMM 866-SR	**6630**	.094	213	.0394	.551	115	.0354	.551	197	.0394	.551	–	–	–	–	–	–	–	–	–	6752129
	T9335	.094	213	.0394	.551	115	.0354	.551	–	–	–	–	–	–	–	–	–	–	–	–	6754970

SR geometry for rough to heavy-rough machining, and continuous to interrupted cuts.

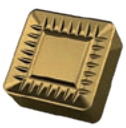
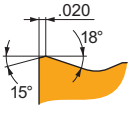
SNMX

PRAMET

	IC	D1	L	S
	(inch)	(inch)	(inch)	(inch)
2512	1.000	.361	1.000	.472



Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our cutting conditions app for further options.

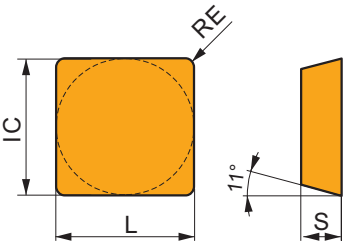
Product		RE	P			M			K			N			S			H			MID
			vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	
		(inch)	(ft/min)	(in/rev)	(inch)	(ft/min)	(in/rev)	(inch)	(ft/min)	(in/rev)	(inch)	(ft/min)	(in/rev)	(inch)	(ft/min)	(in/rev)	(inch)	(ft/min)	(in/rev)	(inch)	
																					
SNMX 251224S-SR	**6630**	.094	213	.0394	.551	115	.0354	.551	197	.0394	.551	–	–	–	–	–	–	–	–	–	6751659
	T8345	.094	148	.0394	.551	82	.0354	.551	131	.0394	.551	–	–	–	–	–	–	–	–	–	6753687
	T9325	.094	262	.0394	.551	148	.0354	.551	246	.0394	.551	–	–	–	–	–	–	–	–	–	6754158
	T9335	.094	213	.0394	.551	115	.0354	.551	–	–	–	–	–	–	–	–	–	–	–	–	6754972

SR geometry for rough to heavy-rough machining, and continuous to interrupted cuts.

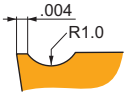
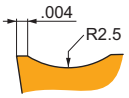
SPMR

PRAMET

	IC (inch)	L (inch)	S (inch)
32	.375	.375	.125
42	.500	.500	.125



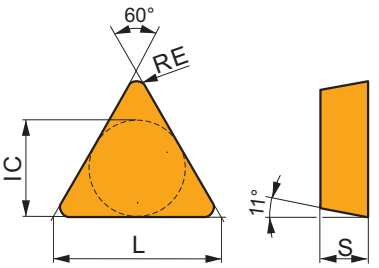
Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our cutting conditions app for further options.

Product		RE (inch)	P vc (ft/min)	P f (in/rev)	P ap (inch)	M vc (ft/min)	M f (in/rev)	M ap (inch)	K vc (ft/min)	K f (in/rev)	K ap (inch)	N vc (ft/min)	N f (in/rev)	N ap (inch)	S vc (ft/min)	S f (in/rev)	S ap (inch)	H vc (ft/min)	H f (in/rev)	H ap (inch)	MID
																					
			46 geometry for fine to finish machining, and continuous to interrupted cuts.																		
SPMR 322-46	**T9325**	.031	837	.0059	.039	492	.0059	.039	787	.0059	.039	–	–	–	–	–	–	–	–	–	6754160
																					
			48 geometry for finish to semi-rough machining, and continuous to interrupted cuts.																		
SPMR 421-48	**T9325**	.016	558	.0087	.087	328	.0087	.087	525	.0087	.087	–	–	–	–	–	–	–	–	–	6754161
	T9335	.016	476	.0087	.087	279	.0087	.087	–	–	–	–	–	–	–	–	–	–	–	–	6754973
SPMR 422-48	**6640**	.031	525	.0087	.087	312	.0087	.087	492	.0087	.087	–	–	–	–	–	–	–	–	–	6751690
	T9325	.031	673	.0087	.087	394	.0087	.087	623	.0087	.087	–	–	–	–	–	–	–	–	–	6754162
	T9335	.031	574	.0087	.087	344	.0087	.087	–	–	–	–	–	–	–	–	–	–	–	–	6754974
SPMR 423-48	**T9325**	.047	705	.0087	.087	410	.0087	.087	656	.0087	.087	–	–	–	–	–	–	–	–	–	6754163

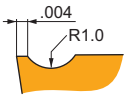
TPMR

PRAMET

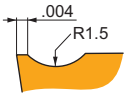
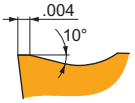
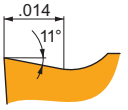
	IC (inch)	L (inch)	S (inch)
22	.250	.433	.125
32	.375	.650	.125



Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our cutting conditions app for further options.

Product		RE (inch)	P vc (ft/min)	P f (in/rev)	P ap (inch)	M vc (ft/min)	M f (in/rev)	M ap (inch)	K vc (ft/min)	K f (in/rev)	K ap (inch)	N vc (ft/min)	N f (in/rev)	N ap (inch)	S vc (ft/min)	S f (in/rev)	S ap (inch)	H vc (ft/min)	H f (in/rev)	H ap (inch)	MID
																					
			46 geometry for fine to finish machining, and continuous to interrupted cuts.																		
TPMR 221-46	**6640**	.016	459	.0059	.039	262	.0055	.039	427	.0059	.039	–	–	–	–	–	–	–	–	–	6751745
	T9325	.016	574	.0059	.039	344	.0059	.039	541	.0059	.039	–	–	–	–	–	–	–	–	–	6754404
	T9335	.016	492	.0059	.039	295	.0059	.039	–	–	–	–	–	–	–	–	–	–	–	–	6755002
TPMR 222-46	**6640**	.031	558	.0059	.039	328	.0055	.039	525	.0059	.039	–	–	–	–	–	–	–	–	–	6751746
	T9325	.031	673	.0059	.039	394	.0059	.039	623	.0059	.039	–	–	–	–	–	–	–	–	–	6754405

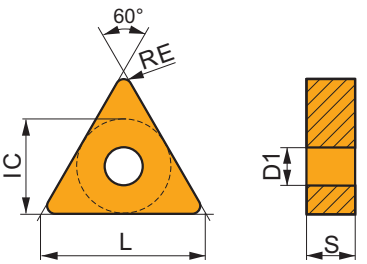
Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our cutting conditions app for further options.

Product		RE	P			M			K			N			S			H			MID
			vc (ft/min)	f (in/rev)	ap (inch)	vc (ft/min)	f (in/rev)	ap (inch)	vc (ft/min)	f (in/rev)	ap (inch)	vc (ft/min)	f (in/rev)	ap (inch)	vc (ft/min)	f (in/rev)	ap (inch)	vc (ft/min)	f (in/rev)	ap (inch)	
			**47** geometry for finish to semi-rough machining, and continuous to interrupted cuts.																		
TPMR 321-47	**6640**	.016	394	.0079	.059	230	.0071	.059	361	.0079	.059	–	–	–	–	–	–	–	–	–	6751692
	T9325	.016	492	.0079	.059	295	.0071	.059	459	.0079	.059	–	–	–	–	–	–	–	–	–	6753851
	T9335	.016	410	.0079	.059	246	.0071	.059	–	–	–	–	–	–	–	–	–	–	–	–	6755004
TPMR 322-47	**6640**	.031	459	.0079	.059	262	.0071	.059	427	.0079	.059	–	–	–	–	–	–	–	–	–	6751694
	T9325	.031	574	.0079	.059	344	.0071	.059	541	.0079	.059	–	–	–	–	–	–	–	–	–	6753852
	T9335	.031	492	.0079	.059	295	.0071	.059	–	–	–	–	–	–	–	–	–	–	–	–	6755005
TPMR 323-47	**T9325**	.047	607	.0079	.059	361	.0071	.059	574	.0079	.059	–	–	–	–	–	–	–	–	–	6754407
	T9335	.047	525	.0079	.059	312	.0071	.059	–	–	–	–	–	–	–	–	–	–	–	–	6755007
			**61** geometry for finish machining with moderate feeds and depths of cut, and continuous to interrupted cuts.																		
TPMR 322-61	**T9325**	.031	443	.0138	.071	262	.0126	.071	410	.0138	.071	–	–	–	–	–	–	–	–	–	6754406
	T9335	.031	394	.0138	.071	230	.0126	.071	–	–	–	–	–	–	–	–	–	–	–	–	6755006
			**PF2** geometry for fine to finish machining, and continuous cuts.																		
TPMR 221-PF2	**TT010**	.016	837	.0039	.020	492	.0039	.020	–	–	–	–	–	–	–	–	–	–	–	–	7168745
TPMR 321-PF2	**TT010**	.016	837	.0039	.020	492	.0039	.020	–	–	–	–	–	–	–	–	–	–	–	–	7168746

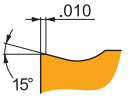
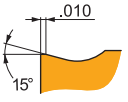
TNMM

PRAMET

	IC (inch)	D1 (inch)	L (inch)	S (inch)
43	.500	.203	.866	.187



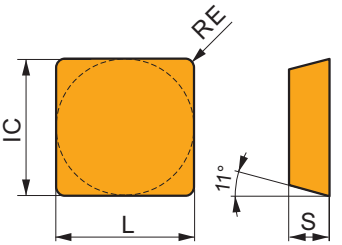
Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our cutting conditions app for further options.

Product		RE	P			M			K			N			S			H			MID
			vc (ft/min)	f (in/rev)	ap (inch)	vc (ft/min)	f (in/rev)	ap (inch)	vc (ft/min)	f (in/rev)	ap (inch)	vc (ft/min)	f (in/rev)	ap (inch)	vc (ft/min)	f (in/rev)	ap (inch)	vc (ft/min)	f (in/rev)	ap (inch)	
			**ER** geometry with right-handed design for medium to semi-rough machining, and continuous cuts.																		
TNMM 433R	**T9335**	.047	623	.0138	.083	361	.0126	.083	–	–	–	–	–	–	131	.0098	.067	–	–	–	6754996
			**EL** geometry with left handed design for medium to semi-rough machining, and continuous cuts.																		
TNMM 433L	**T9335**	.047	623	.0138	.083	361	.0126	.083	–	–	–	–	–	–	131	.0098	.067	–	–	–	6754994

SPU

PRAMET

	IC (inch)	L (inch)	M (inch)	S (inch)
42	.500	.500	.091	.125
53	.625	.625	.110	.187
63	.750	.750	.136	.187
84	1.000	1.000	.174	.250



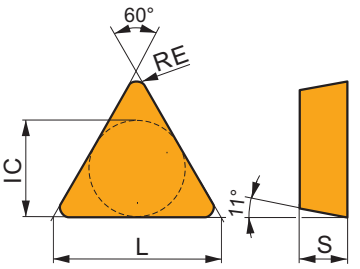
Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our cutting conditions app for further options.

Product		RE (inch)	P vc (ft/min)	P f (in/rev)	P ap (inch)	M vc (ft/min)	M f (in/rev)	M ap (inch)	K vc (ft/min)	K f (in/rev)	K ap (inch)	N vc (ft/min)	N f (in/rev)	N ap (inch)	S vc (ft/min)	S f (in/rev)	S ap (inch)	H vc (ft/min)	H f (in/rev)	H ap (inch)	MID
SPUN for fine-finish to semi-rough machining, and continuous to slightly interrupted cuts.																					
SPU 422	**6640**	.031	591	.0059	.157	–	–	–	558	.0059	.157	–	–	–	–	–	–	–	–	–	6751607
SPUN for fine-finish to semi-rough machining, and continuous to slightly interrupted cuts.																					
SPU 423	**6640**	.047	623	.0059	.157	–	–	–	591	.0059	.157	–	–	–	–	–	–	–	–	–	6751608
SPU 532	**6640**	.031	509	.0079	.197	–	–	–	476	.0079	.197	–	–	–	–	–	–	–	–	–	6751609
SPU 533	**6640**	.047	541	.0079	.197	–	–	–	509	.0079	.197	–	–	–	–	–	–	–	–	–	6751610
SPU 632	**6640**	.031	492	.0079	.236	–	–	–	459	.0079	.236	–	–	–	–	–	–	–	–	–	6752052
SPU 633	**6640**	.047	525	.0079	.236	–	–	–	492	.0079	.236	–	–	–	–	–	–	–	–	–	6751611
SPU 634	**6640**	.063	541	.0079	.236	–	–	–	509	.0079	.236	–	–	–	–	–	–	–	–	–	6751612
SPUN..S for fine-finish to semi-rough machining, and continuous to slightly interrupted cuts.																					
SPU 845S	**6640**	.079	262	.0157	.472	–	–	–	246	.0157	.472	–	–	–	–	–	–	–	–	–	6751618

TPU

PRAMET

	IC (inch)	L (inch)	S (inch)
22	.250	.433	.125
32	.375	.650	.125
43	.500	.866	.187
54	.625	1.083	.250
64	.750	1.299	.250



Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our cutting conditions app for further options.

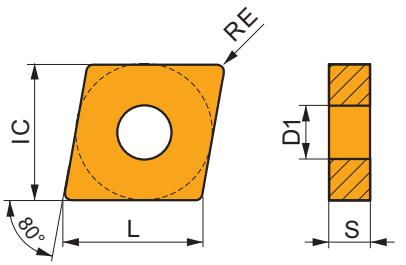
Product		RE (inch)	P vc (ft/min)	P f (in/rev)	P ap (inch)	M vc (ft/min)	M f (in/rev)	M ap (inch)	K vc (ft/min)	K f (in/rev)	K ap (inch)	N vc (ft/min)	N f (in/rev)	N ap (inch)	S vc (ft/min)	S f (in/rev)	S ap (inch)	H vc (ft/min)	H f (in/rev)	H ap (inch)	MID
TPUN for fine-finish to semi-rough machining, and continuous to slightly interrupted cuts.																					
TPU 221	**6640**	.016	443	.0039	.047	–	–	–	410	.0039	.047	–	–	–	–	–	–	–	–	–	6751554
TPU 222	**6640**	.031	410	.0071	.047	–	–	–	377	.0071	.047	–	–	–	–	–	–	–	–	–	6751555
TPU 321	**6640**	.016	443	.0039	.059	–	–	–	410	.0039	.059	–	–	–	–	–	–	–	–	–	6751560
TPU 322	**6640**	.031	410	.0071	.059	–	–	–	377	.0071	.059	–	–	–	–	–	–	–	–	–	6751583
TPU 323	**6640**	.047	410	.0079	.059	–	–	–	377	.0079	.059	–	–	–	–	–	–	–	–	–	6751567
TPU 432	**6640**	.031	394	.0071	.079	–	–	–	361	.0071	.079	–	–	–	–	–	–	–	–	–	6751571
TPU 433	**6640**	.047	394	.0079	.079	–	–	–	361	.0079	.079	–	–	–	–	–	–	–	–	–	6751572
TPUN..S for fine-finish to semi-rough machining, and continuous to slightly interrupted cuts.																					
TPU 544S	**6640**	.063	213	.0118	.197	–	–	–	197	.0118	.197	–	–	–	–	–	–	–	–	–	6751573
TPU 645S	**6640**	.079	213	.0118	.197	–	–	–	197	.0118	.197	–	–	–	–	–	–	–	–	–	6751574

ADVANCED MATERIALS INSERTS

CNGA CER

PRAMET

	IC	D1	L	S
	(inch)	(inch)	(inch)	(inch)
43	.500	.203	.508	.187



Product		RE	P			M			K			N			S			H			MID
			vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	
		(inch)	(ft/min)	(in/rev)	(inch)	(ft/min)	(in/rev)	(inch)	(ft/min)	(in/rev)	(inch)	(ft/min)	(in/rev)	(inch)	(ft/min)	(in/rev)	(inch)	(ft/min)	(in/rev)	(inch)	

HSC T

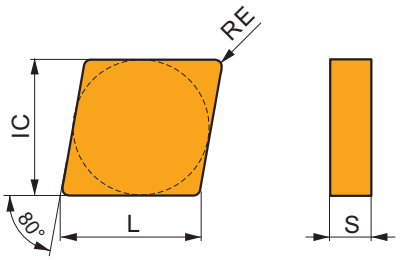
CER for machining with high speeds and continuous cuts.

CNGA 431 T00820	**TC100**	.016	–	–	–	–	–	–	■	1936	.0039	.079	–	–	–	–	–	–	–	–	–	6755458
CNGA 432 T00420	**TC100**	.031	–	–	–	–	–	–	■	1804	.0079	.079	–	–	–	–	–	–	–	–	–	6755427
CNGA 433 T00420	**TC100**	.047	–	–	–	–	–	–	■	1772	.0098	.079	–	–	–	–	–	–	–	–	–	6755428

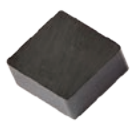
CNGN CER

PRAMET

	IC	L	S
	(inch)	(inch)	(inch)
43	.500	.508	.187
45	.500	.508	.313



Product		RE	P			M			K			N			S			H			MID
			vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	
		(inch)	(ft/min)	(in/rev)	(inch)	(ft/min)	(in/rev)	(inch)	(ft/min)	(in/rev)	(inch)	(ft/min)	(in/rev)	(inch)	(ft/min)	(in/rev)	(inch)	(ft/min)	(in/rev)	(inch)	



HSC T

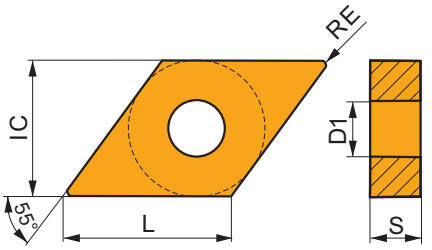
CER for machining with high speeds and continuous cuts.

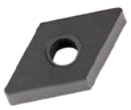
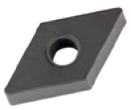
CNG 432 T00420	**TC100**	.031	–	–	–	–	–	–	■	1804	.0079	.079	–	–	–	–	–	–	–	–	–	6755429
CNG 452 T00420	**TC100**	.031	–	–	–	–	–	–	■	1804	.0079	.079	–	–	–	–	–	–	–	–	–	6755413
CNG 453 T00420	**TC100**	.047	–	–	–	–	–	–	■	1772	.0098	.079	–	–	–	–	–	–	–	–	–	6755430

DNGA CER

PRAMET

	IC (inch)	D1 (inch)	L (inch)	S (inch)
43	.500	.203	.610	.187

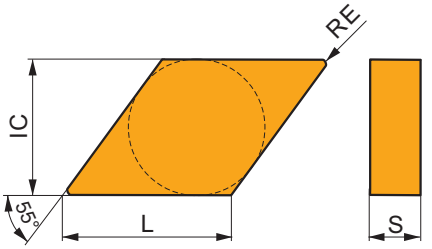


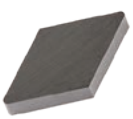
Product		RE (inch)	P vc (ft/min)	P f (in/rev)	P ap (inch)	M vc (ft/min)	M f (in/rev)	M ap (inch)	K vc (ft/min)	K f (in/rev)	K ap (inch)	N vc (ft/min)	N f (in/rev)	N ap (inch)	S vc (ft/min)	S f (in/rev)	S ap (inch)	H vc (ft/min)	H f (in/rev)	H ap (inch)	MID
			HSC S																		
CER for machining with high speeds and continuous cuts.																					
DNGA 431 S00820	**TC100**	.031	–	–	–	–	–	–	1476	.0079	.059	–	–	–	–	–	–	–	–	–	6755433
			HSC T																		
CER for machining with high speeds and continuous cuts.																					
DNGA 431 T00420	**TC100**	.016	–	–	–	–	–	–	1558	.0039	.059	–	–	–	–	–	–	–	–	–	6755431
DNGA 432 T00520	**TC100**	.031	–	–	–	–	–	–	1476	.0079	.059	–	–	–	–	–	–	–	–	–	6755432

DNGN CER

PRAMET

	IC (inch)	L (inch)	S (inch)
43	.500	.610	.187

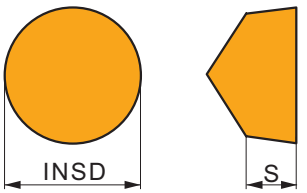


Product		RE (inch)	P vc (ft/min)	P f (in/rev)	P ap (inch)	M vc (ft/min)	M f (in/rev)	M ap (inch)	K vc (ft/min)	K f (in/rev)	K ap (inch)	N vc (ft/min)	N f (in/rev)	N ap (inch)	S vc (ft/min)	S f (in/rev)	S ap (inch)	H vc (ft/min)	H f (in/rev)	H ap (inch)	MID
			HSC T																		
CER for machining with high speeds and continuous cuts.																					
DNG 432 T00420	**TC100**	.031	–	–	–	–	–	–	1476	.0079	.059	–	–	–	–	–	–	–	–	–	6755414

RCGX CER

PRAMET

	INSD (inch)	S (inch)
0606	.250	.250
0907	.375	.313
1207	.500	.313

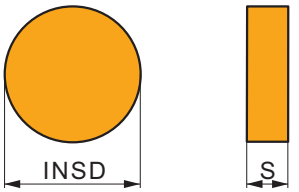


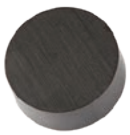
Product		RE (inch)	P vc (ft/min)	P f (in/rev)	P ap (inch)	M vc (ft/min)	M f (in/rev)	M ap (inch)	K vc (ft/min)	K f (in/rev)	K ap (inch)	N vc (ft/min)	N f (in/rev)	N ap (inch)	S vc (ft/min)	S f (in/rev)	S ap (inch)	H vc (ft/min)	H f (in/rev)	H ap (inch)	MID
			HSC K																		
CER for machining with high speeds and continuous cuts.																					
RCGX 060600 K15015	**TC100**	–	–	–	–	–	–	–	■ 1198	.0118	.031	–	–	–	–	–	–	–	–	–	6755435
RCGX 090700 K15015	**TC100**	–	–	–	–	–	–	–	■ 1345	.0079	.047	–	–	–	–	–	–	–	–	–	6755436
RCGX 120700 K15015	**TC100**	–	–	–	–	–	–	–	■ 1329	.0079	.059	–	–	–	–	–	–	–	–	–	6755437

RNGN CER

PRAMET

	INSD (inch)	S (inch)
32	.375	.125
43	.500	.187
45	.500	.313

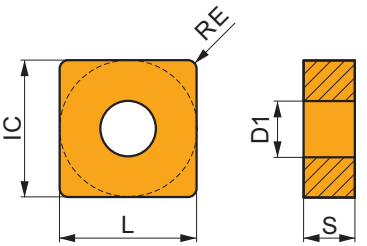


Product		RE (inch)	P vc (ft/min)	P f (in/rev)	P ap (inch)	M vc (ft/min)	M f (in/rev)	M ap (inch)	K vc (ft/min)	K f (in/rev)	K ap (inch)	N vc (ft/min)	N f (in/rev)	N ap (inch)	S vc (ft/min)	S f (in/rev)	S ap (inch)	H vc (ft/min)	H f (in/rev)	H ap (inch)	MID
			HSC T																		
CER for machining with high speeds and continuous cuts.																					
RNG 32 T00420	**TC100**	–	–	–	–	–	–	–	■ 1509	.0079	.047	–	–	–	–	–	–	–	–	–	6755415
RNG 43 T00420	**TC100**	–	–	–	–	–	–	–	■ 1493	.0079	.059	–	–	–	–	–	–	–	–	–	6755416
RNG 45 T00420	**TC100**	–	–	–	–	–	–	–	■ 1493	.0079	.059	–	–	–	–	–	–	–	–	–	6755417
RNG 45 T06015	**TC100**	–	–	–	–	–	–	–	■ 1493	.0079	.059	–	–	–	–	–	–	–	–	–	6755418

SNGA CER

PRAMET

	IC	D1	L	S
	(inch)	(inch)	(inch)	(inch)
43	.500	.203	.500	.187

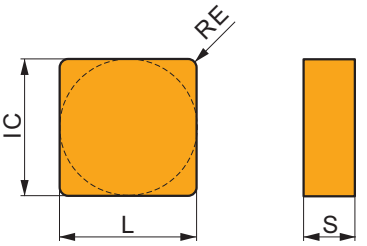


Product		RE	P			M			K			N			S			H			MID
			vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	
		(inch)	(ft/min)	(in/rev)	(inch)	(ft/min)	(in/rev)	(inch)	(ft/min)	(in/rev)	(inch)	(ft/min)	(in/rev)	(inch)	(ft/min)	(in/rev)	(inch)	(ft/min)	(in/rev)	(inch)	
			HSC		T	**CER** for machining with high speeds and continuous cuts.															
SNGA 432 T00425	**TC100**	.031	–	–	–	–	–	–	■ 1886	.0079	.079	–	–	–	–	–	–	–	–	–	6755474
SNGA 433 T00420	**TC100**	.047	–	–	–	–	–	–	■ 1854	.0098	.079	–	–	–	–	–	–	–	–	–	6755419

SNGN CER

PRAMET

	IC	L	S
	(inch)	(inch)	(inch)
32	.375	.375	.125
43	.500	.500	.187
45	.500	.500	.313

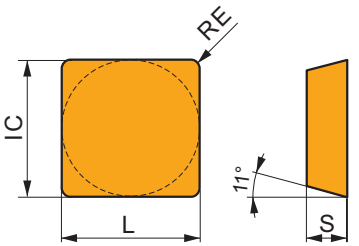


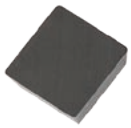
Product		RE	P			M			K			N			S			H			MID
			vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	
		(inch)	(ft/min)	(in/rev)	(inch)	(ft/min)	(in/rev)	(inch)	(ft/min)	(in/rev)	(inch)	(ft/min)	(in/rev)	(inch)	(ft/min)	(in/rev)	(inch)	(ft/min)	(in/rev)	(inch)	
			HSC		T	**CER** for machining with high speeds and continuous cuts.															
SNG 322 T00420	**TC100**	.031	–	–	–	–	–	–	■ 1903	.0079	.071	–	–	–	–	–	–	–	–	–	6755439
SNG 323 T00420	**TC100**	.047	–	–	–	–	–	–	■ 1854	.0098	.071	–	–	–	–	–	–	–	–	–	6755473
SNG 431 T00420	**TC100**	.016	–	–	–	–	–	–	■ 2034	.0039	.079	–	–	–	–	–	–	–	–	–	6755440
SNG 432 T00420	**TC100**	.031	–	–	–	–	–	–	■ 1886	.0079	.079	–	–	–	–	–	–	–	–	–	6755441
SNG 452 T00420	**TC100**	.031	–	–	–	–	–	–	■ 1886	.0079	.079	–	–	–	–	–	–	–	–	–	6755442
SNG 453 T00420	**TC100**	.047	–	–	–	–	–	–	■ 1854	.0098	.079	–	–	–	–	–	–	–	–	–	6755443

SPGN CER

PRAMET

	IC (inch)	L (inch)	S (inch)
42	.500	.500	.125



Product		RE (inch)	P vc (ft/min)	P f (in/rev)	P ap (inch)	M vc (ft/min)	M f (in/rev)	M ap (inch)	K vc (ft/min)	K f (in/rev)	K ap (inch)	N vc (ft/min)	N f (in/rev)	N ap (inch)	S vc (ft/min)	S f (in/rev)	S ap (inch)	H vc (ft/min)	H f (in/rev)	H ap (inch)	MID
																					
SPG 422 T00420	**TC100**	.031	–	–	–	–	–	–	■ 1739	.0079	.059	–	–	–	–	–	–	–	–	–	6755444

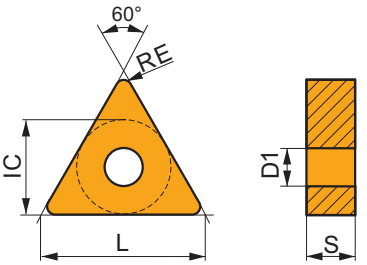
HSC T

CER for machining with high speeds and continuous cuts.

TNGA CER

PRAMET

	IC (inch)	D1 (inch)	L (inch)	S (inch)
33	.375	.150	.650	.187



Product		RE (inch)	P vc (ft/min)	P f (in/rev)	P ap (inch)	M vc (ft/min)	M f (in/rev)	M ap (inch)	K vc (ft/min)	K f (in/rev)	K ap (inch)	N vc (ft/min)	N f (in/rev)	N ap (inch)	S vc (ft/min)	S f (in/rev)	S ap (inch)	H vc (ft/min)	H f (in/rev)	H ap (inch)	MID
TNGA 332 T00420	**TC100**	.031	–	–	–	–	–	–	■ 1558	.0079	.059	–	–	–	–	–	–	–	–	–	6755446
TNGA 333 T00420	**TC100**	.047	–	–	–	–	–	–	■ 1640	.0079	.059	–	–	–	–	–	–	–	–	–	6755421

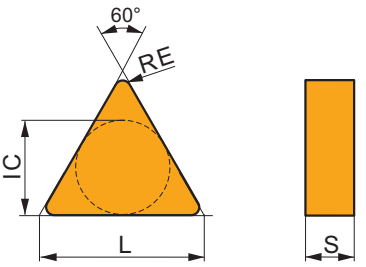
HSC T

CER for machining with high speeds and continuous cuts.

TNGN CER

PRAMET

	IC (inch)	L (inch)	S (inch)
33	.375	.650	.187
35	.375	.650	.313



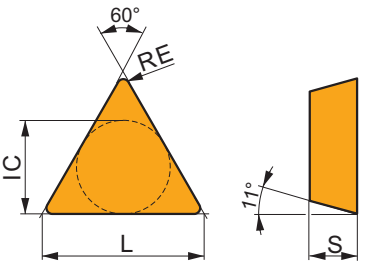
--- Product		RE (inch)	P vc (ft/min)	P f (in/rev)	P ap (inch)	M vc (ft/min)	M f (in/rev)	M ap (inch)	K vc (ft/min)	K f (in/rev)	K ap (inch)	N vc (ft/min)	N f (in/rev)	N ap (inch)	S vc (ft/min)	S f (in/rev)	S ap (inch)	H vc (ft/min)	H f (in/rev)	H ap (inch)	MID
TNG 332 T00420	**TC100**	.031	–	–	–	–	–	–	■	1558	.0079	.059	–	–	–	–	–	–	–	–	–	6755422
TNG 333 T00420	**TC100**	.047	–	–	–	–	–	–	■	1640	.0079	.059	–	–	–	–	–	–	–	–	–	6755411
TNG 352 T00820	**TC100**	.031	–	–	–	–	–	–	■	1558	.0079	.059	–	–	–	–	–	–	–	–	–	6755449

CER for machining with high speeds and continuous cuts.

TPGN CER

PRAMET

	IC (inch)	L (inch)	S (inch)
22	.250	.433	.125
32	.375	.650	.125



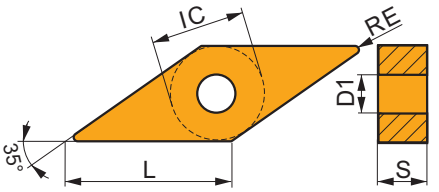
Product		RE (inch)	P vc (ft/min)	P f (in/rev)	P ap (inch)	M vc (ft/min)	M f (in/rev)	M ap (inch)	K vc (ft/min)	K f (in/rev)	K ap (inch)	N vc (ft/min)	N f (in/rev)	N ap (inch)	S vc (ft/min)	S f (in/rev)	S ap (inch)	H vc (ft/min)	H f (in/rev)	H ap (inch)	MID
TPG 221 T00420	**TC100**	.016	–	–	–	–	–	–	■	1509	.0039	.059	–	–	–	–	–	–	–	–	–	6755450
TPG 222 T00420	**TC100**	.031	–	–	–	–	–	–	■	1394	.0079	.059	–	–	–	–	–	–	–	–	–	6755423
TPG 321 T00420	**TC100**	.016	–	–	–	–	–	–	■	1509	.0039	.059	–	–	–	–	–	–	–	–	–	6755424
TPG 322 T00420	**TC100**	.031	–	–	–	–	–	–	■	1394	.0079	.059	–	–	–	–	–	–	–	–	–	6755425
TPG 323 T00420	**TC100**	.047	–	–	–	–	–	–	■	1476	.0079	.059	–	–	–	–	–	–	–	–	–	6755426

CER for machining with high speeds and continuous cuts.

VNGA CER

PRAMET

	IC (inch)	D1 (inch)	L (inch)	S (inch)
33	.375	.150	.654	.187

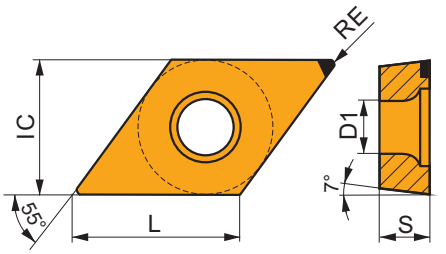


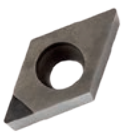
Product		RE (inch)	P vc (ft/min)	P f (in/rev)	P ap (inch)	M vc (ft/min)	M f (in/rev)	M ap (inch)	K vc (ft/min)	K f (in/rev)	K ap (inch)	N vc (ft/min)	N f (in/rev)	N ap (inch)	S vc (ft/min)	S f (in/rev)	S ap (inch)	H vc (ft/min)	H f (in/rev)	H ap (inch)	MID
			HSC T																		
CER for machining with high speeds and continuous cuts.																					
VNGA 331 T00420	**TC100**	.016	–	–	–	–	–	–	■ 1394	.0039	.039	–	–	–	–	–	–	–	–	–	6755451
VNGA 332 T00420	**TC100**	.031	–	–	–	–	–	–	■ 1296	.0079	.039	–	–	–	–	–	–	–	–	–	6755452

DCMW PCD

PRAMET

	IC (inch)	D1 (inch)	L (inch)	S (inch)
32.5	.375	.173	.457	.156

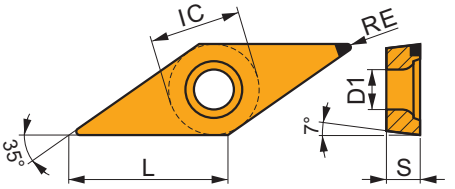


Product		RE (inch)	P vc (ft/min)	P f (in/rev)	P ap (inch)	M vc (ft/min)	M f (in/rev)	M ap (inch)	K vc (ft/min)	K f (in/rev)	K ap (inch)	N vc (ft/min)	N f (in/rev)	N ap (inch)	S vc (ft/min)	S f (in/rev)	S ap (inch)	H vc (ft/min)	H f (in/rev)	H ap (inch)	MID
			HSC F																		
PCD for finish machining, high speeds and stable cutting conditions.																					
DCMW 32.51FN	**PD1**	.016	–	–	–	–	–	–	–	–	–	■ 3396	.0047	.020	–	–	–	–	–	–	6751869
DCMW 32.52FN	**PD1**	.031	–	–	–	–	–	–	–	–	–	■ 3937	.0047	.039	–	–	–	–	–	–	6751821

VCMW PCD

PRAMET

	IC (inch)	D1 (inch)	L (inch)	S (inch)
33	.375	.173	.654	.187

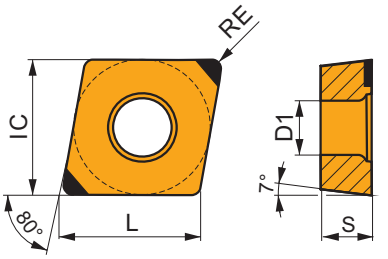


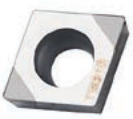
--- Product		RE (inch)	P vc (ft/min)	P f (in/rev)	P ap (inch)	M vc (ft/min)	M f (in/rev)	M ap (inch)	K vc (ft/min)	K f (in/rev)	K ap (inch)	N vc (ft/min)	N f (in/rev)	N ap (inch)	S vc (ft/min)	S f (in/rev)	S ap (inch)	H vc (ft/min)	H f (in/rev)	H ap (inch)	MID
	HSC F																				
PCD tipped for finish to semi-rough machining, high speeds and stable cutting conditions.																					
VCMW 331FN	**PD1**	.016	–	–	–	–	–	–	–	–	–	■ 2953	.0047	.020	–	–	–	–	–	–	6751824
VCMW 332FN	**PD1**	.031	–	–	–	–	–	–	–	–	–	■ 3445	.0047	.039	–	–	–	–	–	–	6751865

CCGW CBN

PRAMET

	IC (inch)	D1 (inch)	L (inch)	S (inch)
21.5	.250	.110	.256	.094
32.5	.375	.177	.382	.156

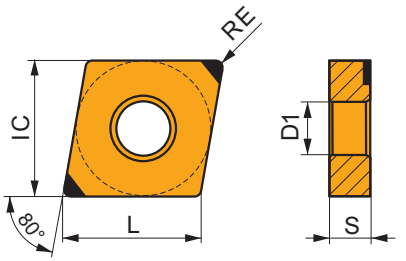


Product		RE (inch)	P vc (ft/min)	P f (in/rev)	P ap (inch)	M vc (ft/min)	M f (in/rev)	M ap (inch)	K vc (ft/min)	K f (in/rev)	K ap (inch)	N vc (ft/min)	N f (in/rev)	N ap (inch)	S vc (ft/min)	S f (in/rev)	S ap (inch)	H vc (ft/min)	H f (in/rev)	H ap (inch)	MID
	HSC E																				
CBN for finish machining.																					
CCGW 21.51E	**TB310**	.016	–	–	–	–	–	–	◪ 1509	.0039	.016	–	–	–	◪ 394	.0028	.012	■ 312	.0028	.012	6755919
CCGW 32.51E	**TB310**	.016	–	–	–	–	–	–	◪ 1509	.0039	.016	–	–	–	◪ 394	.0028	.012	■ 312	.0028	.012	6755920
	HSC S																				
CBN for finish machining.																					
CCGW 21.51S00420	**TB310**	.016	–	–	–	–	–	–	◪ 1509	.0039	.016	–	–	–	◪ 394	.0028	.012	■ 312	.0028	.012	6755685
CCGW 32.51S00420	**TB310**	.016	–	–	–	–	–	–	◪ 1509	.0039	.016	–	–	–	◪ 394	.0028	.012	■ 312	.0028	.012	6755921

CNGA CBN

PRAMET

	IC (inch)	D1 (inch)	L (inch)	S (inch)
43	.500	.203	.508	.187

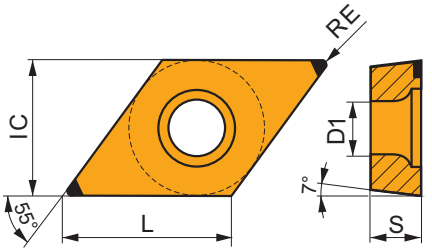


Product		RE (inch)	P vc (ft/min)	P f (in/rev)	P ap (inch)	M vc (ft/min)	M f (in/rev)	M ap (inch)	K vc (ft/min)	K f (in/rev)	K ap (inch)	N vc (ft/min)	N f (in/rev)	N ap (inch)	S vc (ft/min)	S f (in/rev)	S ap (inch)	H vc (ft/min)	H f (in/rev)	H ap (inch)	MID
			HSC		S	**CBN** for finish machining and continuous cuts.																
CNGA 431S00420	**TB310**	.016	–	–	–	–	–	–	◪ 1673	.0039	.016	–	–	–	◪ 443	.0028	.012	■ 344	.0028	.012	6755923
CNGA 432S00420	**TB310**	.031	–	–	–	–	–	–	◪ 1739	.0059	.024	–	–	–	◪ 459	.0043	.020	■ 361	.0031	.028	6755688

DCGW CBN

PRAMET

	IC (inch)	D1 (inch)	L (inch)	S (inch)
32.5	.375	.177	.457	.156

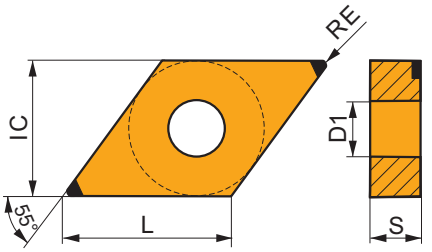


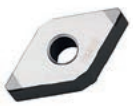
Product		RE (inch)	P vc (ft/min)	P f (in/rev)	P ap (inch)	M vc (ft/min)	M f (in/rev)	M ap (inch)	K vc (ft/min)	K f (in/rev)	K ap (inch)	N vc (ft/min)	N f (in/rev)	N ap (inch)	S vc (ft/min)	S f (in/rev)	S ap (inch)	H vc (ft/min)	H f (in/rev)	H ap (inch)	MID
			HSC		S	**CBN** for finish machining.																
DCGW 32.51S00420	**TB310**	.016	–	–	–	–	–	–	◪ 1214	.0039	.016	–	–	–	◪ 312	.0028	.012	■ 246	.0028	.012	6755686
DCGW 32.52S00420	**TB310**	.031	–	–	–	–	–	–	◪ 1247	.0059	.024	–	–	–	◪ 328	.0043	.020	■ 262	.0031	.028	6755924

DNGA CBN

PRAMET

	IC (inch)	D1 (inch)	L (inch)	S (inch)
44	.500	.203	.610	.250

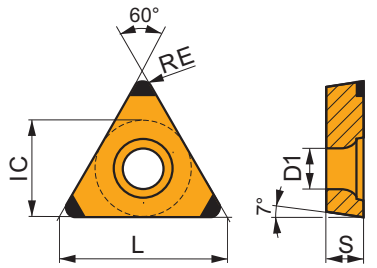


Product		RE (inch)	P vc (ft/min)	P f (in/rev)	P ap (inch)	M vc (ft/min)	M f (in/rev)	M ap (inch)	K vc (ft/min)	K f (in/rev)	K ap (inch)	N vc (ft/min)	N f (in/rev)	N ap (inch)	S vc (ft/min)	S f (in/rev)	S ap (inch)	H vc (ft/min)	H f (in/rev)	H ap (inch)	MID
			HSC S																		
CBN for finish machining and continuous cuts.																					
DNGA 442S00420	**TB310**	.031	–	–	–	–	–	–	1378	.0059	.024	–	–	–	361	.0043	.020	279	.0031	.028	6755925

TCGW CBN

PRAMET

	IC (inch)	D1 (inch)	L (inch)	S (inch)
21.5	.250	.114	.433	.094

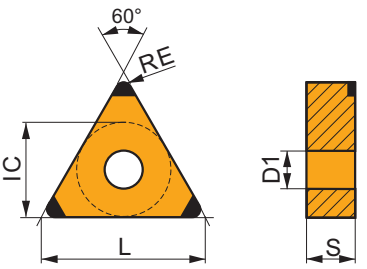


Product		RE (inch)	P vc (ft/min)	P f (in/rev)	P ap (inch)	M vc (ft/min)	M f (in/rev)	M ap (inch)	K vc (ft/min)	K f (in/rev)	K ap (inch)	N vc (ft/min)	N f (in/rev)	N ap (inch)	S vc (ft/min)	S f (in/rev)	S ap (inch)	H vc (ft/min)	H f (in/rev)	H ap (inch)	MID
			HSC E																		
CBN for finish machining, and continuous cuts.																					
TCGW 21.51E	**TB310**	.016	–	–	–	–	–	–	1280	.0039	.016	–	–	–	328	.0028	.012	262	.0028	.012	6755926
			HSC S																		
CBN for finish machining, and continuous cuts.																					
TCGW 21.51S00420	**TB310**	.016	–	–	–	–	–	–	1280	.0039	.016	–	–	–	328	.0028	.012	262	.0028	.012	6755687
TCGW 21.52S00420	**TB310**	.031	–	–	–	–	–	–	1312	.0059	.024	–	–	–	344	.0043	.020	279	.0031	.028	6755927

TNGA CBN

PRAMET

	IC (inch)	D1 (inch)	L (inch)	S (inch)
33	.375	.150	.650	.187

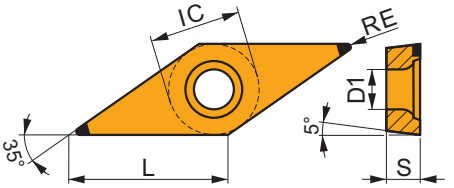


Product		RE (inch)	P vc (ft/min)	P f (in/rev)	P ap (inch)	M vc (ft/min)	M f (in/rev)	M ap (inch)	K vc (ft/min)	K f (in/rev)	K ap (inch)	N vc (ft/min)	N f (in/rev)	N ap (inch)	S vc (ft/min)	S f (in/rev)	S ap (inch)	H vc (ft/min)	H f (in/rev)	H ap (inch)	MID
			HSC		S	**CBN** for finish machining and continuous cuts.																
TNGA 332S00420	**TB310**	.031	–	–	–	–	–	–	◪ 1476	.0059	.024	–	–	–	◪ 377	.0043	.020	■ 312	.0031	.028	6755928

VBGW CBN

PRAMET

	IC (inch)	D1 (inch)	L (inch)	S (inch)
33	.375	.177	.630	.187

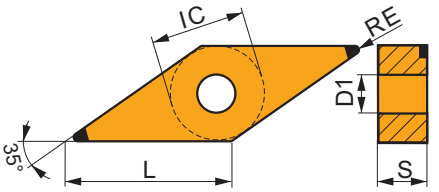


Product		RE (inch)	P vc (ft/min)	P f (in/rev)	P ap (inch)	M vc (ft/min)	M f (in/rev)	M ap (inch)	K vc (ft/min)	K f (in/rev)	K ap (inch)	N vc (ft/min)	N f (in/rev)	N ap (inch)	S vc (ft/min)	S f (in/rev)	S ap (inch)	H vc (ft/min)	H f (in/rev)	H ap (inch)	MID
			HSC		S	**CBN** for finish machining and continuous cuts.																
VBGW 331S00420	**TB310**	.016	–	–	–	–	–	–	◪ 1115	.0039	.016	–	–	–	◪ 295	.0028	.012	■ 230	.0028	.012	6755929
VBGW 332S00420	**TB310**	.031	–	–	–	–	–	–	◪ 1148	.0059	.024	–	–	–	◪ 295	.0043	.020	■ 230	.0031	.028	6755930

VNGA CBN

PRAMET

	IC (inch)	D1 (inch)	L (inch)	S (inch)
33	.375	.150	.630	.187

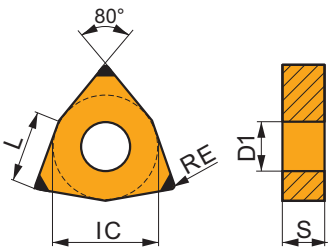


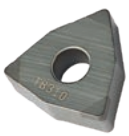
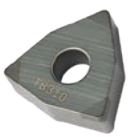
Product		RE (inch)	P vc (ft/min)	P f (in/rev)	P ap (inch)	M vc (ft/min)	M f (in/rev)	M ap (inch)	K vc (ft/min)	K f (in/rev)	K ap (inch)	N vc (ft/min)	N f (in/rev)	N ap (inch)	S vc (ft/min)	S f (in/rev)	S ap (inch)	H vc (ft/min)	H f (in/rev)	H ap (inch)	MID
			CBN for finish machining and continuous cuts.																		
VNGA 331S00420	**TB310**	.016	–	–	–	–	–	–	1181	.0039	.016	–	–	–	312	.0028	.012	246	.0028	.012	6755931
VNGA 332S00420	**TB310**	.031	–	–	–	–	–	–	1214	.0059	.024	–	–	–	312	.0043	.020	246	.0031	.028	6755689

WNGA CBN

PRAMET

	IC (inch)	D1 (inch)	L (inch)	S (inch)
43	.500	.203	.343	.187



Product		RE (inch)	P vc (ft/min)	P f (in/rev)	P ap (inch)	M vc (ft/min)	M f (in/rev)	M ap (inch)	K vc (ft/min)	K f (in/rev)	K ap (inch)	N vc (ft/min)	N f (in/rev)	N ap (inch)	S vc (ft/min)	S f (in/rev)	S ap (inch)	H vc (ft/min)	H f (in/rev)	H ap (inch)	MID
																					
			CBN for finish machining and continuous cuts.																		
WNGA 432S00420	**TB310**	.031	–	–	–	–	–	–	1739	.0059	.024	–	–	–	459	.0043	.020	361	.0031	.028	6755690
																					
			CBN for finish machining and continuous cuts.																		
WNGA 432S00420W	**TB310**	.031	–	–	–	–	–	–	1739	.0059	.024	–	–	–	459	.0043	.020	361	.0031	.028	6755691

PARTING-OFF & GROOVING

GL – EXTERNAL TOOLS NAVIGATOR

INSERT SEAT	GL1	GL2	GL3	GL4	GL5	GL6
NEW GLAF(RL)EXT 20×20 25×25		COX 20 mm	COX 20 – 40 mm	COX 20 – 32 mm	COX 24 – 32 mm	COX 24 – 32 mm
NEW IGLAF(RL)EXT 0.750"×0.750" 1.000"×1.000"		COX . 79"	COX . 790" – 1.570"	COX . 790" – 1.260"	COX . 940" – 1.00"	COX . 75" – 1.00"
NEW GLAF(RL)EXT-S 12×12 16×16		COX 12 – 16 mm	COX 12 – 16 mm	COX 16 mm		
NEW IGLAF(RL)EXT-S 0.500"×0.500" 0.625"×0.625"		COX . 470" – .630"	COX . 470" – .630"	COX . 630"		
GLSF(RL)EXT 20×20 25×25	COX 16 mm NEW	COX 20 – 24 mm	COX 20 – 32 mm	COX 20 – 32 mm	COX 20 – 32 mm	COX 20 – 32 mm
IGLSF(RL)EXT 0.750"×0.750" 1.000"×1.000"		COX . 790" – .940"	COX . 790" – 1.260"	COX 0790" – 1.260"	COX . 790" – 1.260"	COX . 790" – 1.260"
GLSF(RL)EXT-S 12×12 16×16	COX 12 – 16 mm NEW	COX 12 – 16 mm	COX 12 – 16 mm	COX 16 mm		
IGLSF(RL)EXT-S 0.500"×0.500" 0.625"×0.625"		COX . 470" – .630"	COX . 470" – .630"	COX . 630"		
NEW GLSF(RL)EXT-G 20×20 32×32		COX 10 mm	COX 10 – 20 mm	COX 12 – 24 mm	COX 12 – 32 mm	COX 12 – 32 mm
NEW IGLSF(RL)EXT-G 0.750"×0.750" 1.250"×1.250"		COX .390"	COX .390" – .790"	COX .470" – .940"	COX .470" – 1.200"	COX .470" – 1.200"
Cutting width (mm) CW	**1.5**	**2**	**3 (2.5)**	**4**	**5**	**6**	**8**
Deep parting-off (single sided insert) NEW			PM PR	PM PR			
Parting-off (tube / full bar)	NEW PM	PM PR	CW=2.5/3 PM PR	PM PR	PM PR	PM PR	
Grooving (deep / shallow)		PR GM	PR GM	PR GM	PR GM	GM	NEW GM
Turning (longitudinal)		GM	GM	GM	GM	GM	NEW GM
Profiling (multiaxial)		MM	MM	MM	MM	MM	

GLAF(RL) EXT

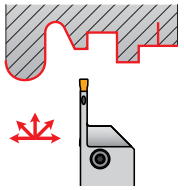
P M K N S H

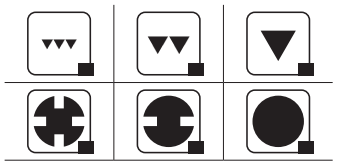
PRAMET

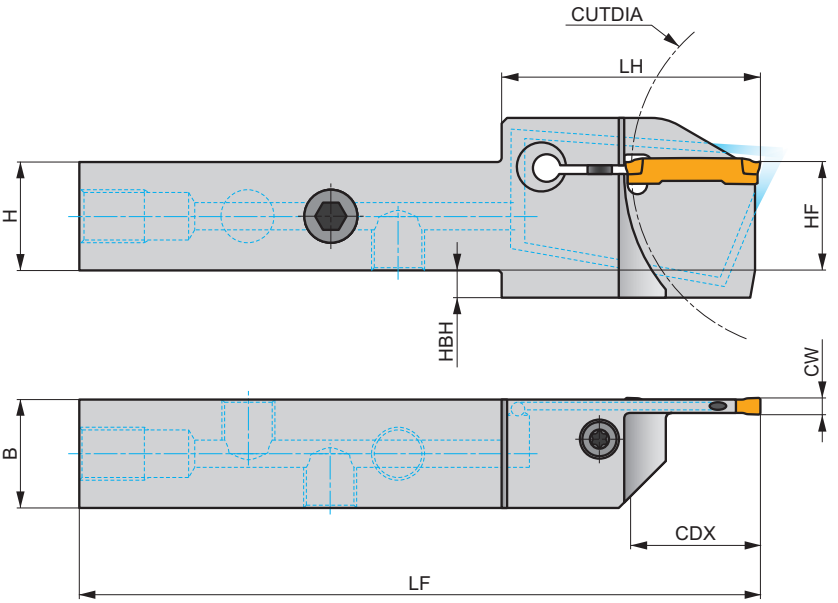
G

Grooving and Parting-Off tool with internal coolant for GL Inserts

External Right/Left handed tool holder with internal coolant for GL inserts. Suited for radial grooving, parting-off, turning and profiling applications. Reinforced body design for longer tool life and low vibrations. Body treated for longer tool life.







	Product	HF (mm)	HBH (mm)	H (mm)	B (mm)	LF (mm)	LH (mm)	CW (mm)	CDX (mm)	CUTDIA (mm)		lbs				MID
R	GL2-A2020KFR-20-80	20	5	20	20	125	43.5	2.00	20	80	✓	.72	GI334	GL11	CC01	8180514
	GL2-A2525MFR-20-80	25	–	25	25	150	43.5	2.00	20	80	✓	1.43	GI334	GL11	CC01	8180516
	GL3-A2020KFR-20-80	20	5	20	20	125	43.5	3.00	20	80	✓	.73	GI335	GL11	CC01	8180522
	GL3-A2020KFR-24-80	20	5	20	20	125	47.5	3.00	24	80	✓	.71	GI335	GL11	CC01	8180524
	GL3-A2525MFR-20-80	25	–	25	25	150	43.5	3.00	20	80	✓	1.45	GI335	GL11	CC01	8180526
	GL3-A2525PFR-32-80	25	5	25	25	170	55.5	3.00	32	80	✓	1.61	GI335	GL11	CC01	8180528
	GL3-A2525PFR-40-100	25	7	25	25	170	63.5	3.00	40	100	✓	1.55	GI335	GL11	CC01	8180530
	GL4-A2020KFR-20-80	20	5	20	20	125	43.6	4.00	20	80	✓	.83	GI336	GL11	CC01	8180539
	GL4-A2020KFR-24-80	20	5	20	20	125	47.6	4.00	24	80	✓	.81	GI336	GL11	CC01	8180593
	GL4-A2525MFR-20-80	25	–	25	25	150	43.6	4.00	20	80	✓	1.27	GI336	GL11	CC01	8180591
	GL4-A2525PFR-32-80	25	5	25	25	170	55.6	4.00	32	80	✓	1.48	GI336	GL11	CC01	8180595
	GL5-A2020KFR-24-80	20	5	20	20	125	47.6	5.00	24	80	✓	.72	GI337	GL11	CC01	8180597
	GL5-A2525PFR-32-100	25	5	25	25	170	55.6	5.00	32	100	✓	1.49	GI337	GL11	CC01	8180599
	GL6-A2020KFR-24-80	20	5	20	20	125	47.6	6.00	24	80	✓	.82	GI338	GL11	CC01	8180601
	GL6-A2525PFR-32-100	25	5	25	25	170	55.6	6.00	32	100	✓	1.50	GI338	GL11	CC01	8180603
L	GL2-A2020KFL-20-80	20	5	20	20	125	43.5	2.00	20	80	✓	.72	GI334	GL11	CC01	8180513
	GL2-A2525MFL-20-80	25	–	25	25	150	43.5	2.00	20	80	✓	1.46	GI334	GL11	CC01	8180515
	GL3-A2020KFL-20-80	20	5	20	20	125	43.5	3.00	20	80	✓	.73	GI335	GL11	CC01	8180521
	GL3-A2020KFL-24-80	20	5	20	20	125	47.5	3.00	24	80	✓	.79	GI335	GL11	CC01	8180523
	GL3-A2525MFL-20-80	25	–	25	25	150	43.5	3.00	20	80	✓	1.44	GI335	GL11	CC01	8180525
	GL3-A2525PFL-32-80	25	5	25	25	170	55.5	3.00	32	80	✓	1.47	GI335	GL11	CC01	8180527
	GL3-A2525PFL-40-100	25	7	25	25	170	63.5	3.00	40	100	✓	1.54	GI335	GL11	CC01	8180529
	GL4-A2020KFL-20-80	20	5	20	20	125	43.6	4.00	20	80	✓	.73	GI336	GL11	CC01	8180538
	GL4-A2020KFL-24-80	20	5	20	20	125	47.6	4.00	24	80	✓	.81	GI336	GL11	CC01	8180592
	GL4-A2525MFL-20-80	25	–	25	25	150	43.6	4.00	20	80	✓	1.44	GI336	GL11	CC01	8180590
	GL4-A2525PFL-32-80	25	5	25	25	170	55.6	4.00	32	80	✓	1.60	GI336	GL11	CC01	8180594

	Product	HF (mm)	HBH (mm)	H (mm)	B (mm)	LF (mm)	LH (mm)	CW (mm)	CDX (mm)	CUTDIA (mm)		lbs				MID
L	**GL5-A2020KFL-24-80**	20	5	20	20	125	47.6	5.00	24	80	✓	.72	GI337	GL11	CC01	8180596
	GL5-A2525PFL-32-100	25	5	25	25	170	55.6	5.00	32	100	✓	1.49	GI337	GL11	CC01	8180598
	GL6-A2020KFL-24-80	20	5	20	20	125	47.6	6.00	24	80	✓	.72	GI338	GL11	CC01	8180600
	GL6-A2525PFL-32-100	25	5	25	25	170	55.6	6.00	32	100	✓	1.50	GI338	GL11	CC01	8180602

GI334	GL2..	–
GI335	GL3..	–
GI336	GL4..	–
GI337	GL5..	–
GI338	GL6-D600..	GL6-D800..

Cutting depths on machined diameter on page 422.

GL11	US 5018-T20P	5.0	M 5	18.2	LKT20P

CC01	CHP-P1/8	G1/8″	HXK 4

Coolant accessories can be found on page 424.

IGLAF(RL) EXT

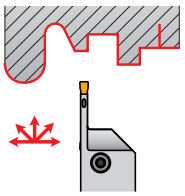
P M K N S H

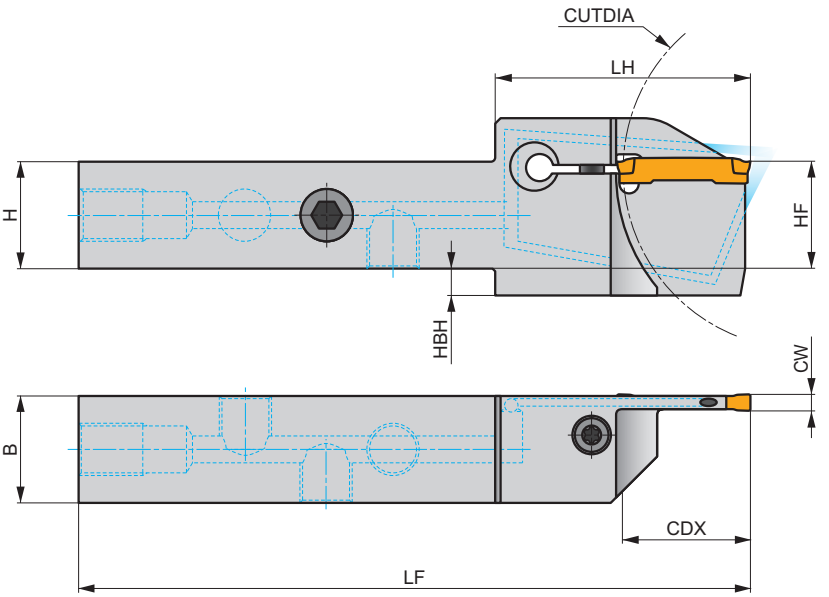
PRAMET

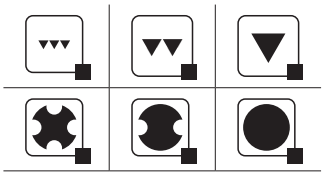
G

Grooving and Parting-Off tool with internal coolant for GL Inserts

External Right/Left handed tool holder with internal coolant for GL inserts. Suited for radial grooving, parting-off, turning and profiling applications. Reinforced body design for longer tool life and low vibrations. Body treated for longer tool life.







	Product	HF (inch)	HBH (inch)	H (inch)	B (inch)	LF (inch)	LH (inch)	CW (inch)	CDX (inch)	CUTDIA (inch)		lbs				MID
R	GL2-A12CFR-.79-3.15	.750	.197	.750	.750	5.000	1.713	.079	.790	3.150	✓	.66	GI334	GL11	CC01	8180694
	GL2-A16DFR-.79-3.15	1.000	–	1.000	1.000	6.000	1.713	.079	.790	3.150	✓	1.51	GI334	GL11	CC01	8180696
	GL3-A12CFR-.79-3.15	.750	.197	.750	.750	5.000	1.713	.118	.790	3.150	✓	.77	GI335	GL11	CC01	8180702
	GL3-A12CFR-.94-3.15	.750	.197	.750	.750	5.000	1.870	.118	.940	3.150	✓	.75	GI335	GL11	CC01	8180704
	GL3-A16DFR-.79-3.15	1.000	–	1.000	1.000	6.000	1.713	.118	.790	3.150	✓	1.50	GI335	GL11	CC01	8180706
	GL3-A16EFR-1.26-3.15	1.000	.197	1.000	1.000	7.000	2.185	.118	1.260	3.150	✓	1.60	GI335	GL11	CC01	8180708
	GL3-A16EFR-1.57-3.94	1.000	.276	1.000	1.000	7.000	2.500	.118	1.570	3.940	✓	1.55	GI335	GL11	CC01	8180710
	GL4-A12CFR-.79-3.15	.750	.197	.750	.750	5.000	1.717	.157	.790	3.150	✓	.67	GI336	GL11	CC01	8180716
	GL4-A12CFR-.94-3.15	.750	.197	.750	.750	5.000	1.874	.157	.940	3.150	✓	.75	GI336	GL11	CC01	8180730
	GL4-A16DFR-.79-3.15	1.000	–	1.000	1.000	6.000	1.717	.157	.790	3.150	✓	1.50	GI336	GL11	CC01	8180718
	GL4-A16EFR-1.26-3.15	1.000	.197	1.000	1.000	7.000	2.189	.157	1.260	3.150	✓	1.61	GI336	GL11	CC01	8180732
	GL5-A12CFR-.94-3.15	.750	.197	.750	.750	5.000	1.874	.197	.940	3.150	✓	.77	GI337	GL11	CC01	8180734
	GL5-A16EFR-1.26-3.94	1.000	.197	1.000	1.000	7.000	2.189	.197	1.260	3.940	✓	1.74	GI337	GL11	CC01	8180736
	GL6-A12CFR-.94-3.15	.750	.197	.750	.750	5.000	1.874	.236	.940	3.150	✓	.76	GI338	GL11	CC01	8180738
	GL6-A16EFR-1.26-3.94	1.000	.197	1.000	1.000	7.000	2.189	.236	1.260	3.940	✓	1.75	GI338	GL11	CC01	8180740
L	GL2-A12CFL-.79-3.15	.750	.197	.750	.750	5.000	1.713	.079	.790	3.150	✓	.66	GI334	GL11	CC01	8180693
	GL2-A16DFL-.79-3.15	1.000	–	1.000	1.000	6.000	1.713	.079	.790	3.150	✓	1.52	GI334	GL11	CC01	8180695
	GL3-A12CFL-.79-3.15	.750	.197	.750	.750	5.000	1.713	.118	.790	3.150	✓	.78	GI335	GL11	CC01	8180701
	GL3-A12CFL-.94-3.15	.750	.197	.750	.750	5.000	1.870	.118	.940	3.150	✓	.75	GI335	GL11	CC01	8180703
	GL3-A16DFL-.79-3.15	1.000	–	1.000	1.000	6.000	1.713	.118	.790	3.150	✓	1.50	GI335	GL11	CC01	8180705
	GL3-A16EFL-1.26-3.15	1.000	.197	1.000	1.000	7.000	2.185	.118	1.260	3.150	✓	1.60	GI335	GL11	CC01	8180707
	GL3-A16EFL-1.57-3.94	1.000	.276	1.000	1.000	7.000	2.500	.118	1.570	3.940	✓	1.55	GI335	GL11	CC01	8180709
	GL4-A12CFL-.79-3.15	.750	.197	.750	.750	5.000	1.717	.157	.790	3.150	✓	.77	GI336	GL11	CC01	8180715

	Product	HF (inch)	HBH (inch)	H (inch)	B (inch)	LF (inch)	LH (inch)	CW (inch)	CDX (inch)	CUTDIA (inch)		lbs				MID
L	**GL4-A12CFL-.94-3.15**	.750	.197	.750	.750	5.000	1.874	.157	.940	3.150	✓	.76	GI336	GL11	CC01	8180719
	GL4-A16DFL-.79-3.15	1.000	–	1.000	1.000	6.000	1.717	.157	.790	3.150	✓	1.50	GI336	GL11	CC01	8180717
	GL4-A16EFL-1.26-3.15	1.000	.197	1.000	1.000	7.000	2.189	.157	1.260	3.150	✓	1.61	GI336	GL11	CC01	8180731
	GL5-A12CFL-.94-3.15	.750	.197	.750	.750	5.000	1.874	.197	.940	3.150	✓	.76	GI337	GL11	CC01	8180733
	GL5-A16EFL-1.26-3.94	1.000	.197	1.000	1.000	7.000	2.189	.197	1.260	3.940	✓	1.73	GI337	GL11	CC01	8180735
	GL6-A12CFL-.94-3.15	.750	.197	.750	.750	5.000	1.874	.236	.940	3.150	✓	.77	GI338	GL11	CC01	8180737
	GL6-A16EFL-1.26-3.94	1.000	.197	1.000	1.000	7.000	2.189	.236	1.260	3.940	✓	1.75	GI338	GL11	CC01	8180739

GI334	GL2..	–
GI335	GL3..	–
GI336	GL4..	–
GI337	GL5..	–
GI338	GL6-D600..	GL6-D800..

Cutting depths on machined diameter on page 522.

GL11	US 5018-T20P	5.0	M 5	.717	LKT20P

CC01	CHP-P1/8	G1/8″	HXK 4

Coolant accessories can be found on page 424.

GLAF(RL) EXT-S

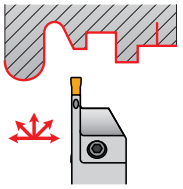
P M K N S H

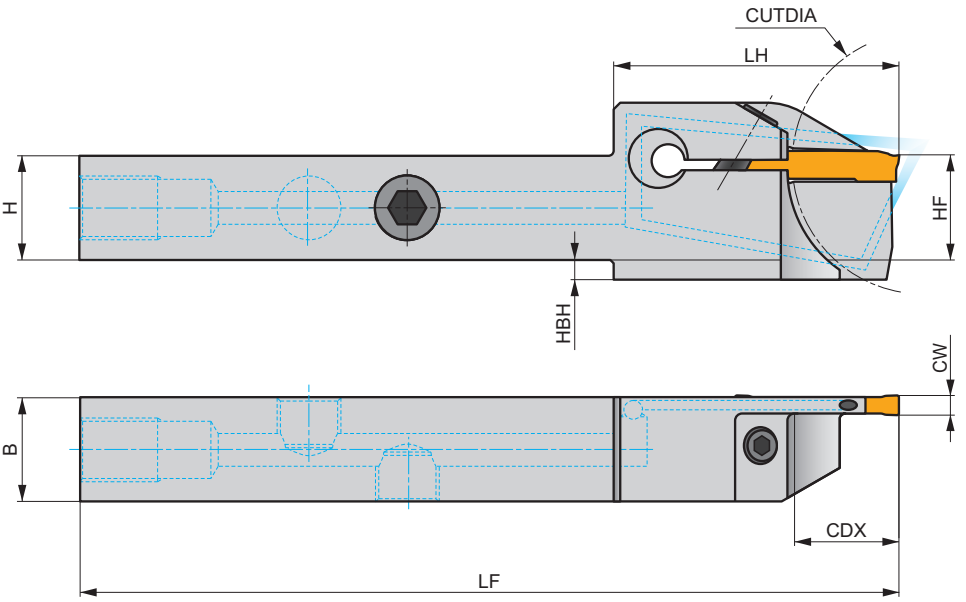
PRAMET

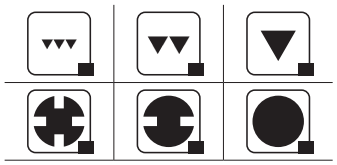
G

Grooving tool with internal coolant for GL Inserts, for Sliding head machines

External Right/Left handed tool holder with internal coolant for GL inserts, designed for sliding head machines and easy access to insert clamping. Suited for radial grooving, parting-off, turning and profiling applications. Body treated for longer tool life.







	Product	HF (mm)	HBH (mm)	H (mm)	B (mm)	LF (mm)	LH (mm)	CW (mm)	CDX (mm)	CUTDIA (mm)		lbs				MID
R	GL2-A1212HFR-12-40	12	3	12	12	100	33.0	2.00	12	40	✓	.27	GI334	GL13	CC02	8180510
	GL2-A1616KFR-16-45	16	3	16	16	125	43.5	2.00	16	45	✓	.47	GI334	GL12	CC01	8180512
	GL3-A1212HFR-12-40	12	3	12	12	100	33.0	3.00	12	40	✓	.27	GI335	GL13	CC02	8180518
	GL3-A1616KFR-16-45	16	3	16	16	125	43.5	3.00	16	45	✓	.47	GI335	GL12	CC01	8180520
	GL4-A1616KFR-16-45	16	4	16	16	125	43.6	4.00	16	45	✓	.47	GI336	GL12	CC01	8180537
L	GL2-A1212HFL-12-40	12	3	12	12	100	33.0	2.00	12	40	✓	.25	GI334	GL13	CC02	8180419
	GL2-A1616KFL-16-45	16	3	16	16	125	43.5	2.00	16	45	✓	.59	GI334	GL12	CC01	8180511
	GL3-A1212HFL-12-40	12	3	12	12	100	33.0	3.00	12	40	✓	.26	GI335	GL13	CC02	8180517
	GL3-A1616KFL-16-45	16	3	16	16	125	43.5	3.00	16	45	✓	.55	GI335	GL12	CC01	8180519
	GL4-A1616KFL-16-45	16	4	16	16	125	43.6	4.00	16	45	✓	.47	GI336	GL12	CC01	8180536

GI334	GL2..
GI335	GL3..
GI336	GL4..

Cutting depths on machined diameter on page 422.

		Nm			
GL12	HS 0516	5.0	M 5	16	HXK 4
GL13	HS 0412	5.0	M 4	12	HXK 3

CC01	CHP-P1/8	–	G1/8″	HXK 4	–	–
CC02	–	CHP-P6	M6	HXK 3	CHP-G06	CHP-R1/8-6

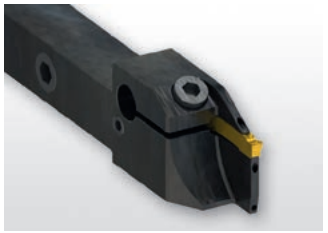
Coolant accessories can be found on page 424.

IGLAF(RL) EXT-S

P M K N S H

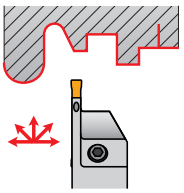
PRAMET

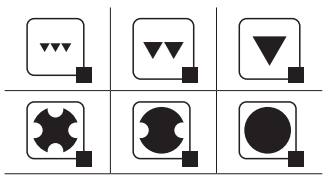
G

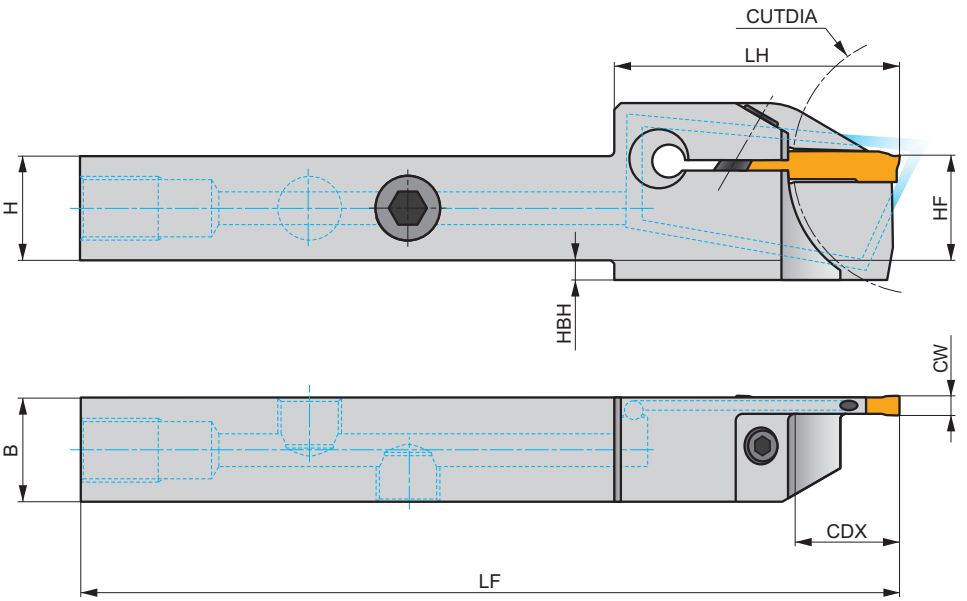


Grooving tool with internal coolant for GL Inserts, for Sliding head machines

External Right/Left handed tool holder with internal coolant for GL inserts, designed for sliding head machines and easy access to insert clamping. Suited for radial grooving, parting-off, turning and profiling applications. Body treated for longer tool life.







	Product	HF (inch)	HBH (inch)	H (inch)	B (inch)	LF (inch)	LH (inch)	CW (inch)	CDX (inch)	CUTDIA (inch)		lbs					MID
R	GL2-A08AFR-.47-1.57	.500	.118	.500	.500	4.000	1.299	.079	.470	1.570	✓	.24	GI334	GL13	CC02	8180690
	GL2-A10CFR-.63-1.78	.625	.118	.625	.625	5.000	1.713	.079	.630	1.780	✓	.47	GI334	GL12	CC01	8180692
	GL3-A08AFR-.47-1.57	.500	.118	.500	.500	4.000	1.299	.118	.470	1.570	✓	.29	GI335	GL13	CC02	8180698
	GL3-A10CFR-.63-1.78	.625	.118	.625	.625	5.000	1.713	.118	.630	1.780	✓	.57	GI335	GL12	CC01	8180700
	GL4-A10CFR-.63-1.78	.625	.157	.625	.625	5.000	1.717	.157	.630	1.780	✓	.61	GI336	GL12	CC01	8180714
L	GL2-A08AFL-.47-1.57	.500	.118	.500	.500	4.000	1.299	.079	.470	1.570	✓	.24	GI334	GL13	CC02	8180609
	GL2-A10CFL-.63-1.78	.625	.118	.625	.625	5.000	1.713	.079	.630	1.780	✓	.47	GI334	GL12	CC01	8180691
	GL3-A08AFL-.47-1.57	.500	.118	.500	.500	4.000	1.299	.118	.470	1.570	✓	.29	GI335	GL13	CC02	8180697
	GL3-A10CFL-.63-1.78	.625	.118	.625	.625	5.000	1.713	.118	.630	1.780	✓	.57	GI335	GL12	CC01	8180699
	GL4-A10CFL-.63-1.78	.625	.157	.625	.625	5.000	1.717	.157	.630	1.780	✓	.58	GI336	GL12	CC01	8180713

GI334	GL2..
GI335	GL3..
GI336	GL4..

Cutting depths on machined diameter on page 422.

		Nm			
GL12	HS 0516	5.0	M 5	.630	HXK 4
GL13	HS 0412	5.0	M 4	.472	HXK 3

CC01	CHP-P1/8	–	G1/8″	HXK 4	–	–
CC02	–	CHP-P6	M6	HXK 3	CHP-G06	CHP-R1/8-6

Coolant accessories can be found on page 424.

GLSF(RL) EXT

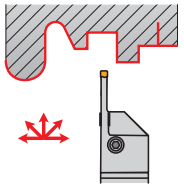
P M K N S H

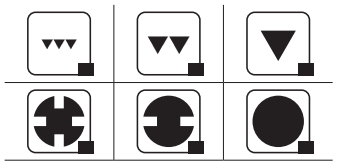
PRAMET

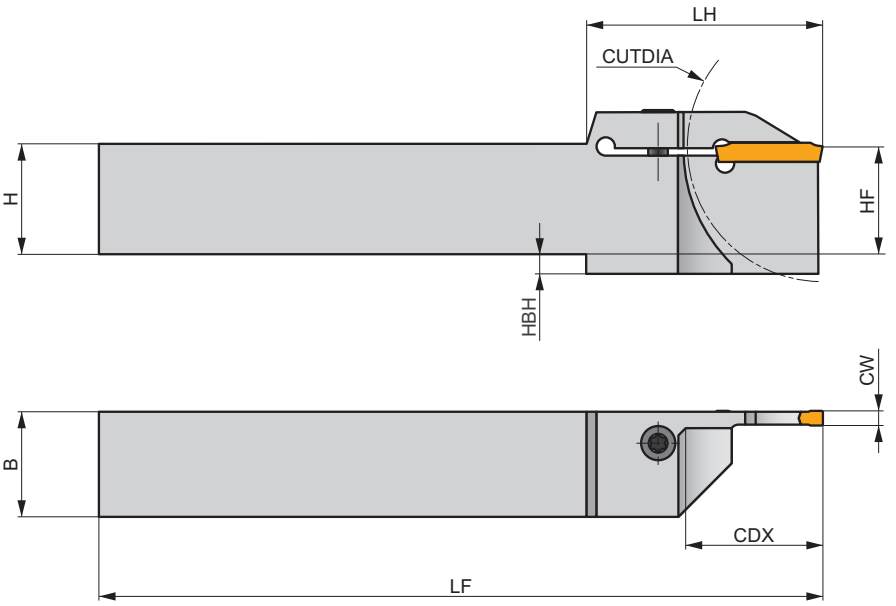
G

Grooving and Parting-Off tool for GL Inserts

External Right/Left handed tool holder for GL inserts. Suited for radial grooving, parting-off, turning and profiling applications. Reinforced body design for longer tool life and low vibrations. Body treated for longer tool life.







	Product	HF (mm)	HBH (mm)	H (mm)	B (mm)	LF (mm)	LH (mm)	CW (mm)	CDX (mm)	CUTDIA (mm)	lbs			MID
R	GL1-S2020KFR-16-60	20	–	20	20	125	34.2	1.50	16	60	.77	GI333	GL11	8462752
	GL2-S2020KFR-20-80	20	–	20	20	125	43.5	2.00	20	80	.83	GI334	GL11	7803127
	GL2-S2020KFR-24-80	20	5	20	20	125	48.5	2.00	24	80	.84	GI334	GL11	7983491
	GL2-S2525MFR-20-80	25	–	25	25	150	43.5	2.00	20	80	1.53	GI334	GL11	7803129
	GL2-S2525MFR-24-80	25	–	25	25	150	47.5	2.00	24	80	1.50	GI334	GL11	7983493
	GL3-S2020KFR-20-80	20	–	20	20	125	43.5	3.00	20	80	.84	GI335	GL11	7803235
	GL3-S2020KFR-24-80	20	5	20	20	125	47.5	3.00	24	80	.79	GI335	GL11	7983495
	GL3-S2525MFR-20-80	25	–	25	25	150	43.5	3.00	20	80	1.54	GI335	GL11	7803237
	GL3-S2525MFR-24-80	25	–	25	25	150	47.5	3.00	24	80	1.42	GI335	GL11	7983497
	GL3-S2525PFR-32-80	25	5	25	25	170	55.5	3.00	32	80	1.71	GI335	GL11	7803239
	GL4-S2020KFR-20-80	20	–	20	20	125	43.5	4.00	20	80	.84	GI336	GL11	7803243
	GL4-S2020KFR-24-80	20	5	20	20	125	47.5	4.00	24	80	.82	GI336	GL11	7983499
	GL4-S2525MFR-20-80	25	–	25	25	150	43.5	4.00	20	80	1.50	GI336	GL11	7803245
	GL4-S2525MFR-24-80	25	–	25	25	150	47.5	4.00	24	80	1.52	GI336	GL11	7983501
	GL4-S2525PFR-32-80	25	5	25	25	170	55.5	4.00	32	80	1.73	GI336	GL11	7803247
	GL5-S2020KFR-20-80	20	–	20	20	125	43.5	5.00	20	80	.85	GI337	GL11	7803250
	GL5-S2525MFR-20-80	25	–	25	25	150	43.5	5.00	20	80	1.50	GI337	GL11	7803252
	GL5-S2525PFR-32-100	25	5	25	25	170	55.5	5.00	32	100	1.73	GI337	GL11	7983503
	GL6-S2020KFR-20-80	20	–	20	20	125	43.5	6.00	20	80	.85	GI338-1	GL11	7803255
	GL6-S2525MFR-20-80	25	–	25	25	150	43.5	6.00	20	80	1.50	GI338-1	GL11	7803257
	GL6-S2525PFR-32-100	25	5	25	25	170	55.5	6.00	32	100	1.66	GI338	GL11	7983505

	Product	HF (mm)	HBH (mm)	H (mm)	B (mm)	LF (mm)	LH (mm)	CW (mm)	CDX (mm)	CUTDIA (mm)	lbs			MID
L	**GL1-S2020KFL-16-60**	20	–	20	20	125	34.2	1.50	16	60	.77	GI333	GL11	8462751
	GL2-S2020KFL-20-80	20	–	20	20	125	43.5	2.00	20	80	.83	GI334	GL11	7803126
	GL2-S2020KFL-24-80	20	5	20	20	125	47.5	2.00	24	80	.86	GI334	GL11	7983490
	GL2-S2525MFL-20-80	25	–	25	25	150	43.5	2.00	20	80	1.54	GI334	GL11	7803128
	GL2-S2525MFL-24-80	25	–	25	25	150	47.5	2.00	24	80	1.42	GI334	GL11	7983492
	GL3-S2020KFL-20-80	20	–	20	20	125	43.5	3.00	20	80	.84	GI335	GL11	7803234
	GL3-S2020KFL-24-80	20	5	20	20	125	47.5	3.00	24	80	.85	GI335	GL11	7983494
	GL3-S2525MFL-20-80	25	–	25	25	150	43.5	3.00	20	80	1.50	GI335	GL11	7803236
	GL3-S2525MFL-24-80	25	–	25	25	150	47.5	3.00	24	80	1.51	GI335	GL11	7983496
	GL3-S2525PFL-32-80	25	5	25	25	170	55.5	3.00	32	80	1.71	GI335	GL11	7803238
	GL4-S2020KFL-20-80	20	–	20	20	125	43.5	4.00	20	80	.83	GI336	GL11	7803242
	GL4-S2020KFL-24-80	20	5	20	20	125	47.5	4.00	24	80	.86	GI336	GL11	7983498
	GL4-S2525MFL-20-80	25	–	25	25	150	43.5	4.00	20	80	1.50	GI336	GL11	7803244
	GL4-S2525MFL-24-80	25	–	25	25	150	47.5	4.00	24	80	1.43	GI336	GL11	7983500
	GL4-S2525PFL-32-80	25	5	25	25	170	55.5	4.00	32	80	1.72	GI336	GL11	7803246
	GL5-S2020KFL-20-80	20	–	20	20	125	43.5	5.00	20	80	.84	GI337	GL11	7803249
	GL5-S2525MFL-20-80	25	–	25	25	150	43.5	5.00	20	80	1.56	GI337	GL11	7803251
	GL5-S2525PFL-32-100	25	5	25	25	170	55.5	5.00	32	100	1.74	GI337	GL11	7983502
	GL6-S2020KFL-20-80	20	–	20	20	125	43.5	6.00	20	80	.85	GI338-1	GL11	7803254
	GL6-S2525MFL-20-80	25	–	25	25	150	43.5	6.00	20	80	1.56	GI338-1	GL11	7803256
	GL6-S2525PFL-32-100	25	5	25	25	170	55.5	6.00	32	100	1.66	GI338	GL11	7983504

GI333	GL1..	–
GI334	GL2..	–
GI335	GL3..	–
GI336	GL4..	–
GI337	GL5..	–
GI338	GL6-D600..	GL6-D800..
GI338_1	GL6-D600..	–

Cutting depths on machined diameter on page 422.

GL11	US 5018-T20P	5.0	M 5	18.2	LKT20P

IGLSF(RL) EXT

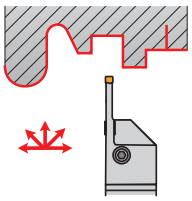
P M K N S H

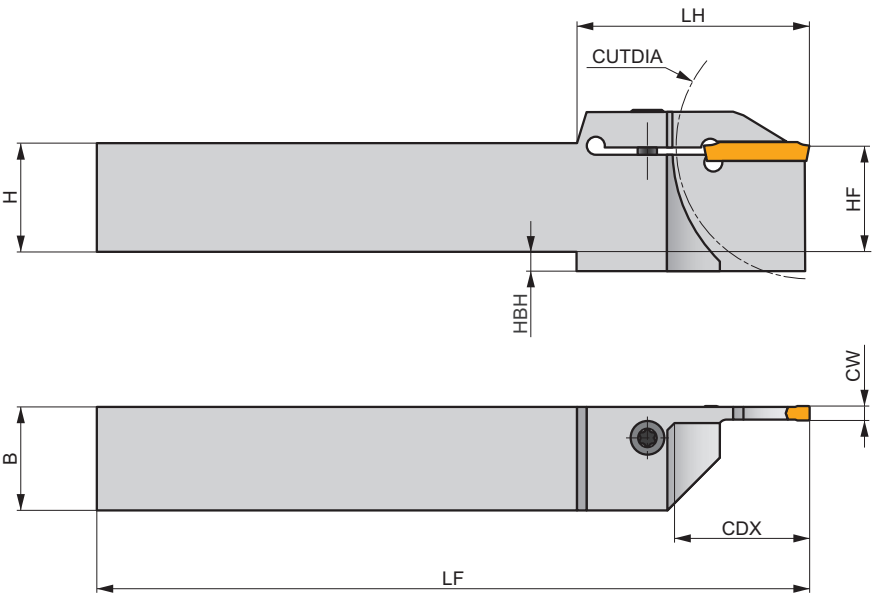
PRAMET

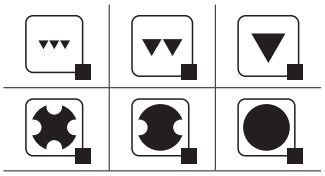
G

Grooving and Parting-Off tool for GL Inserts

External Right/Left handed tool holder for GL inserts. Suited for radial grooving, parting-off, turning and profiling applications. Reinforced body design for longer tool life and low vibrations. Body treated for longer tool life.







	Product	HF (inch)	HBH (inch)	H (inch)	B (inch)	LF (inch)	LH (inch)	CW (inch)	CDX (inch)	CUTDIA (inch)	lbs			MID
R	GL2-S12CFR-.79-3.15	.750	–	.750	.750	5.000	1.700	.079	.790	3.150	.78	GI334	GL11	7804078
	GL2-S12CFR-.94-3.15	.750	.197	.750	.750	5.000	1.870	.079	.940	3.150	.73	GI334	GL11	8015986
	GL2-S16DFR-.79-3.15	1.000	–	1.000	1.000	6.000	1.700	.079	.790	3.150	.15	GI334	GL11	7804140
	GL2-S16DFR-.94-3.15	1.000	–	1.000	1.000	6.000	1.870	.079	.940	3.150	1.49	GI334	GL11	8015990
	GL3-S12CFR-.79-3.15	.750	–	.750	.750	5.000	1.700	.118	.790	3.150	.78	GI335	GL11	7804144
	GL3-S12CFR-.94-3.15	.750	.197	.750	.750	5.000	1.870	.118	.940	3.150	.73	GI335	GL11	8015996
	GL3-S16DFR-.79-3.15	1.000	–	1.000	1.000	6.000	1.700	.118	.790	3.150	1.50	GI335	GL11	7804146
	GL3-S16DFR-.94-3.15	1.000	–	1.000	1.000	6.000	1.870	.118	.940	3.150	1.49	GI335	GL11	8016000
	GL3-S16EFR-1.26-3.15	1.000	.197	1.000	1.000	7.000	2.180	.118	1.260	3.150	1.50	GI335	GL11	7804148
	GL4-S12CFR-.79-3.15	.750	–	.750	.750	5.000	1.700	.157	.790	3.150	.78	GI336	GL11	7804150
	GL4-S12CFR-.94-3.15	.750	.197	.750	.750	5.000	1.870	.157	.940	3.150	.74	GI336	GL11	8016007
	GL4-S16DFR-.79-3.15	1.000	–	1.000	1.000	6.000	1.700	.157	.790	3.150	1.50	GI336	GL11	7804152
	GL4-S16DFR-.94-3.15	1.000	–	1.000	1.000	6.000	1.870	.157	.940	3.150	1.50	GI336	GL11	8016041
	GL4-S16EFR-1.26-3.15	1.000	.197	1.000	1.000	7.000	2.180	.157	1.260	3.150	1.50	GI336	GL11	7804154
	GL5-S12CFR-.79-3.15	.750	–	.750	.750	5.000	1.700	.197	.790	3.150	.79	GI337	GL11	7804156
	GL5-S16DFR-.79-3.15	1.000	–	1.000	1.000	6.000	1.700	.197	.790	3.150	1.50	GI337	GL11	7804158
	GL5-S16EFR-1.26-3.94	1.000	.197	1.000	1.000	7.000	2.180	.197	1.260	3.940	1.79	GI337	GL11	8016047
	GL6-S12CFR-.79-3.15	.750	–	.750	.750	5.000	1.700	.236	.790	3.150	.78	GI338	GL11	7804160
	GL6-S16DFR-.79-3.15	1.000	–	1.000	1.000	6.000	1.700	.236	.790	3.150	1.50	GI338	GL11	7804162
	GL6-S16EFR-1.26-3.94	1.000	.197	1.000	1.000	7.000	2.180	.236	1.260	3.940	1.80	GI338	GL11	8016053
L	GL2-S12CFL-.79-3.15	.750	–	.750	.750	5.000	1.700	.079	.790	3.150	.08	GI334	GL11	7804077
	GL2-S12CFL-.94-3.15	.750	.197	.750	.750	5.000	1.870	.079	.940	3.150	.73	GI334	GL11	8015985
	GL2-S16DFL-.79-3.15	1.000	–	1.000	1.000	6.000	1.700	.079	.790	3.150	1.50	GI334	GL11	7804079

	Product	HF (inch)	HBH (inch)	H (inch)	B (inch)	LF (inch)	LH (inch)	CW (inch)	CDX (inch)	CUTDIA (inch)	lbs			MID
L	**GL2-S16DFL-.94-3.15**	1.000	–	1.000	1.000	6.000	1.870	.079	.940	3.150	1.49	GI334	GL11	8015989
	GL3-S12CFL-.79-3.15	.750	–	.750	.750	5.000	1.700	.118	.790	3.150	.78	GI335	GL11	7804143
	GL3-S12CFL-.94-3.15	.750	.197	.750	.750	5.000	1.870	.118	.940	3.150	.73	GI335	GL11	8015995
	GL3-S16DFL-.79-3.15	1.000	–	1.000	1.000	6.000	1.700	.118	.790	3.150	1.50	GI335	GL11	7804145
	GL3-S16DFL-.94-3.15	1.000	–	1.000	1.000	6.000	1.870	.118	.940	3.150	1.49	GI335	GL11	8015999
	GL3-S16EFL-1.26-3.15	1.000	.197	1.000	1.000	7.000	2.180	.118	1.260	3.150	1.50	GI335	GL11	7804147
	GL4-S12CFL-.79-3.15	.750	–	.750	.750	5.000	1.700	.157	.790	3.150	.79	GI336	GL11	7804149
	GL4-S12CFL-.94-3.15	.750	.197	.750	.750	5.000	1.870	.157	.940	3.150	.74	GI336	GL11	8016006
	GL4-S16DFL-.79-3.15	1.000	–	1.000	1.000	6.000	1.700	.157	.790	3.150	1.50	GI336	GL11	7804151
	GL4-S16DFL-.94-3.15	1.000	–	1.000	1.000	6.000	1.870	.157	.940	3.150	1.50	GI336	GL11	8016040
	GL4-S16EFL-1.26-3.15	1.000	.197	1.000	1.000	7.000	2.180	.157	1.260	3.150	1.50	GI336	GL11	7804153
	GL5-S12CFL-.79-3.15	.750	–	.750	.750	5.000	1.700	.197	.790	3.150	.79	GI337	GL11	7804155
	GL5-S16DFL-.79-3.15	1.000	–	1.000	1.000	6.000	1.700	.197	.790	3.150	1.50	GI337	GL11	7804157
	GL5-S16EFL-1.26-3.94	1.000	.197	1.000	1.000	7.000	2.180	.197	1.260	3.940	1.79	GI337	GL11	8016046
	GL6-S12CFL-.79-3.15	.750	–	.750	.750	5.000	1.700	.236	.790	3.150	.79	GI338	GL11	7804159
	GL6-S16DFL-.79-3.15	1.000	–	1.000	1.000	6.000	1.700	.236	.790	3.150	1.50	GI338	GL11	7804161
	GL6-S16EFL-1.26-3.94	1.000	.197	1.000	1.000	7.000	2.180	.236	1.260	3.940	1.80	GI338	GL11	8016052

GI334	GL2..	–
GI335	GL3..	–
GI336	GL4..	–
GI337	GL5..	–
GI338	GL6-D600..	GL6-D800..

Cutting depths on machined diameter on page 422.

		Nm			
GL11	US 5018-T20P	5.0	M 5	.717	LKT20P

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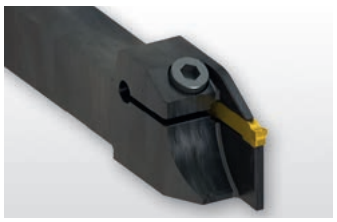
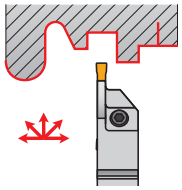
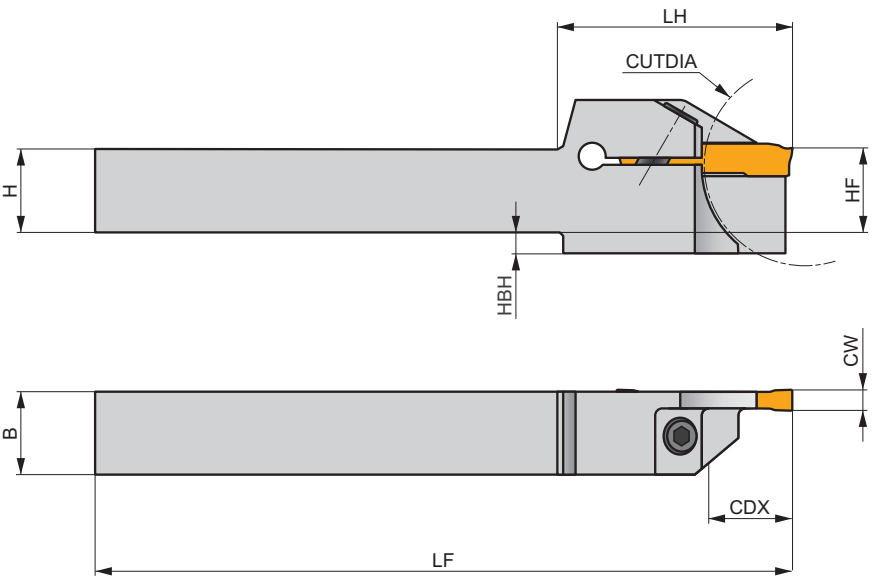
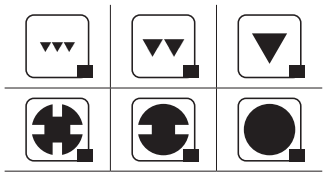


Grooving and Parting-Off tool for GL Inserts, for Sliding head machines

External Right/Left handed tool holder for GL inserts, designed for sliding head machines and easy access to insert clamping. Suited for radial grooving, parting-off, turning and profiling applications. Body treated for longer tool life.







	Product	HF (mm)	HBH (mm)	H (mm)	B (mm)	LF (mm)	LH (mm)	CW (mm)	CDX (mm)	CUTDIA (mm)	lbs			MID
R	GL1-S1212HFR-12-40	12	–	12	12	100	30.2	1.50	12	40	.22	GI333	GL13	8462468
	GL1-S1616KFR-16-45	16	–	16	16	125	34.2	1.50	16	45	.51	GI333	GL12	8462750
	GL2-S1212HFR-12-40	12	3	12	12	100	33.0	2.00	12	40	.30	GI334	GL13	7983507
	GL2-S1616KFR-16-45	16	3	16	16	125	39.5	2.00	16	45	.51	GI334	GL12	7803125
	GL3-S1212HFR-12-40	12	3	12	12	100	33.0	3.00	12	40	.24	GI335	GL13	7983523
	GL3-S1616KFR-16-45	16	3	16	16	125	39.5	3.00	16	45	.51	GI335	GL12	7803233
	GL4-S1616KFR-16-45	16	4	16	16	125	39.5	4.00	16	45	.61	GI336	GL12	7983529
L	GL1-S1212HFL-12-40	12	–	12	12	100	30.2	1.50	12	40	.22	GI333	GL13	8462467
	GL1-S1616KFL-16-45	16	–	16	16	125	34.2	1.50	16	45	.51	GI333	GL12	8462469
	GL2-S1212HFL-12-40	12	3	12	12	100	33.0	2.00	12	40	.24	GI334	GL13	7983506
	GL2-S1616KFL-16-45	16	3	16	16	125	39.5	2.00	16	45	.51	GI334	GL12	7803124
	GL3-S1212HFL-12-40	12	3	12	12	100	33.0	3.00	12	40	.24	GI335	GL13	7983522
	GL3-S1616KFL-16-45	16	3	16	16	125	39.5	3.00	16	45	.51	GI335	GL12	7803232
	GL4-S1616KFL-16-45	16	4	16	16	125	39.5	4.00	16	45	.54	GI336	GL12	7983528

GI333	GL1..
GI334	GL2..
GI335	GL3..
GI336	GL4..

Cutting depths on machined diameter on page 422.

		Nm			
GL12	HS 0516	5.0	M 5	16	HXK 4
GL13	HS 0412	5.0	M 4	12	HXK 3

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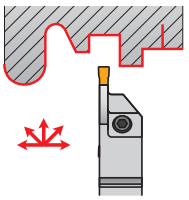
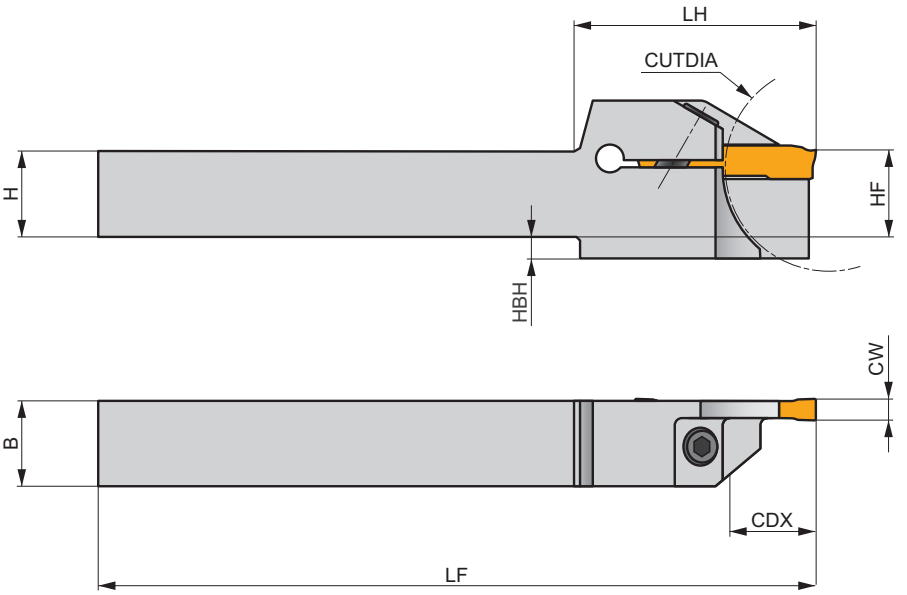
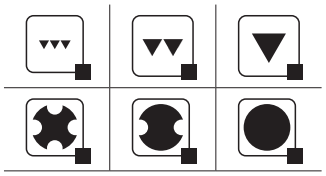
Grooving and Parting-Off tool for GL Inserts, for Sliding head machines

External Right/Left handed tool holder for GL inserts, designed for sliding head machines and easy access to insert clamping. Suited for radial grooving, parting-off, turning and profiling applications. Body treated for longer tool life.







	Product	HF (inch)	H (inch)	B (inch)	LF (inch)	LH (inch)	CW (inch)	CDX (inch)	HBH (inch)	CUTDIA (inch)	lbs			MID
R	GL2-S08AFR-.47-1.57	.500	.500	.500	4.000	1.300	.079	.470	.118	1.570	.27	GI334	GL13	8015982
	GL2-S10CFR-.63-1.78	.625	.625	.625	5.000	1.550	.079	.630	.118	1.780	.51	GI334	GL12	7804076
	GL3-S08AFR-.47-1.57	.500	.500	.500	4.000	1.290	.118	.470	.118	1.570	.28	GI335	GL13	8015992
	GL3-S10CFR-.63-1.78	.625	.625	.625	5.000	1.550	.118	.630	.118	1.780	.51	GI335	GL12	7804142
	GL4-S10CFR-.63-1.78	.625	.625	.625	5.000	1.550	.157	.630	.157	1.780	.54	GI336	GL12	8016003
L	GL2-S08AFL-.47-1.57	.500	.500	.500	4.000	1.290	.079	.470	.118	1.570	.27	GI334	GL13	8015981
	GL2-S10CFL-.63-1.78	.625	.625	.625	5.000	1.550	.079	.630	.118	1.780	.51	GI334	GL12	7804075
	GL3-S08AFL-.47-1.57	.500	.500	.500	4.000	1.290	.118	.470	.118	1.570	.28	GI335	GL13	8015991
	GL3-S10CFL-.63-1.78	.625	.625	.625	5.000	1.550	.118	.630	.118	1.780	.51	GI335	GL12	7804141
	GL4-S10CFL-.63-1.78	.625	.625	.625	5.000	1.550	.157	.630	.157	1.780	.54	GI336	GL12	8016002

GI334	GL2..
GI335	GL3..
GI336	GL4..

Cutting depths on machined diameter on page 422.

		Nm			
GL12	HS 0516	5.0	M 5	.630	HXK 4
GL13	HS 0412	5.0	M 4	.472	HXK 3

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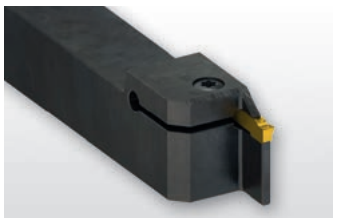
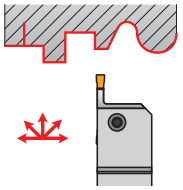
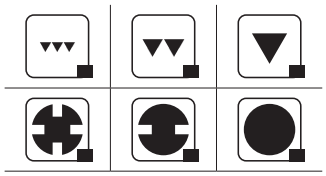
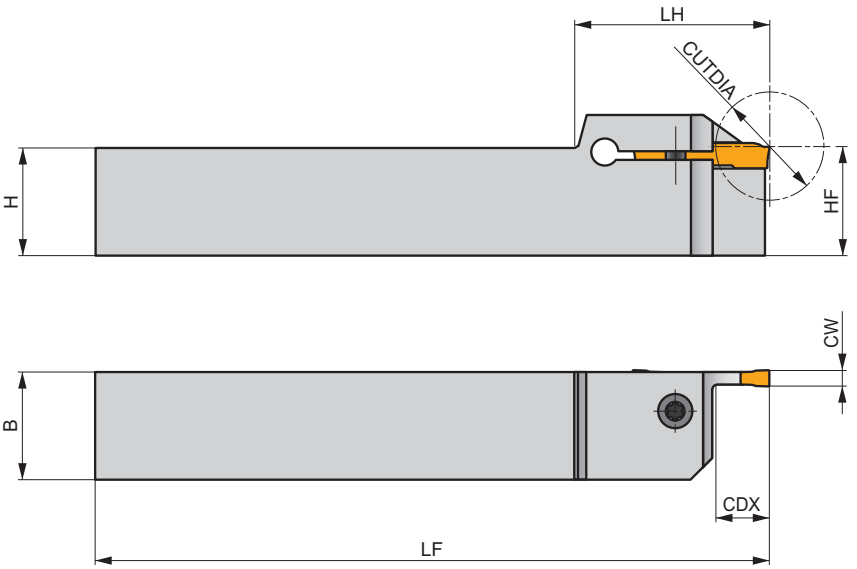


Grooving and Turning tool for GL Inserts

External Right/Left handed tool holder for GL inserts. Best suited for longitudinal turning and profiling applications, usable also for grooving and parting-off. Body treated for longer tool life.







	Product	HF (mm)	H (mm)	B (mm)	LF (mm)	LH (mm)	CW (mm)	CDX (mm)	CUTDIA (mm)	kg			MID
R	GL2-S2020KFR-10	20	20	20	125	36.0	2.00	10	20	0.38	GI334	GL11	7983509
	GL2-S2525MFR-10	25	25	25	150	36.0	2.00	10	20	0.69	GI334	GL11	7983521
	GL3-S2020KFR-10	20	20	20	125	36.0	3.00	10	20	0.36	GI335	GL11	7983525
	GL3-S2525MFR-10	25	25	25	150	36.0	3.00	10	20	0.69	GI335	GL11	7983527
	GL3-S3232MFR-20	32	32	32	150	46.0	3.00	20	40	1.06	GI335	GL15	8178808
	GL4-S2020KFR-12	20	20	20	125	36.0	4.00	12	24	0.37	GI336	GL11	7983531
	GL4-S2525MFR-12	25	25	25	150	36.0	4.00	12	24	0.69	GI336	GL11	7983533
	GL4-S3232MFR-24	32	32	32	150	50.0	4.00	24	48	1.04	GI336	GL15	8178820
	GL5-S2020KFR-12	20	20	20	125	36.0	5.00	12	24	0.36	GI337	GL11	7983535
	GL5-S2525MFR-12	25	25	25	150	36.0	5.00	12	24	0.70	GI337	GL11	7983537
	GL5-S3232PFR-32	32	32	32	170	58.0	5.00	32	64	1.15	GI337	GL15	8178822
	GL6-S2020KFR-12	20	20	20	125	36.0	6.00	12	24	0.36	GI338-1	GL11	7983539
	GL6-S2525MFR-12	25	25	25	150	36.0	6.00	12	24	0.68	GI338-1	GL11	7983541
	GL6-S3232PFR-32	32	32	32	170	58.0	6.00	32	64	1.15	GI338	GL15	8178824
L	GL2-S2020KFL-10	20	20	20	125	36.0	2.00	10	20	0.37	GI334	GL11	7983508
	GL2-S2525MFL-10	25	25	25	150	36.0	2.00	10	20	0.70	GI334	GL11	7983520
	GL3-S2020KFL-10	20	20	20	125	36.0	3.00	10	20	0.36	GI335	GL11	7983524
	GL3-S2525MFL-10	25	25	25	150	36.0	3.00	10	20	0.70	GI335	GL11	7983526
	GL3-S3232MFL-20	32	32	32	150	46.0	3.00	20	40	1.06	GI335	GL15	8178807
	GL4-S2020KFL-12	20	20	20	125	36.0	4.00	12	24	0.37	GI336	GL11	7983530
	GL4-S2525MFL-12	25	25	25	150	36.0	4.00	12	24	0.69	GI336	GL11	7983532
	GL4-S3232MFL-24	32	32	32	150	50.0	4.00	24	48	1.04	GI336	GL15	8178809
	GL5-S2020KFL-12	20	20	20	125	36.0	5.00	12	24	0.36	GI337	GL11	7983534
	GL5-S2525MFL-12	25	25	25	150	36.0	5.00	12	24	0.69	GI337	GL11	7983536
	GL5-S3232PFL-32	32	32	32	170	58.0	5.00	32	64	1.15	GI337	GL15	8178821
	GL6-S2020KFL-12	20	20	20	125	36.0	6.00	12	24	0.36	GI338-1	GL11	7983538
	GL6-S2525MFL-12	25	25	25	150	36.0	6.00	12	24	0.68	GI338-1	GL11	7983540
	GL6-S3232PFL-32	32	32	32	170	58.0	6.00	32	64	1.15	GI338	GL15	8178823

GI334	GL2..	–
GI335	GL3..	–
GI336	GL4..	–
GI337	GL5..	–
GI338	GL6-D600..	GL6-D800..
GI338_1	GL6-D600..	–

GL11	US 5018-T20P	5.0	M 5	18.2	LK T20P
GL15	SR 88026-T30P	5.0	M8	26	LK T30P

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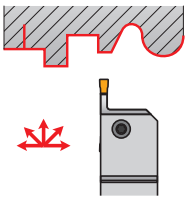
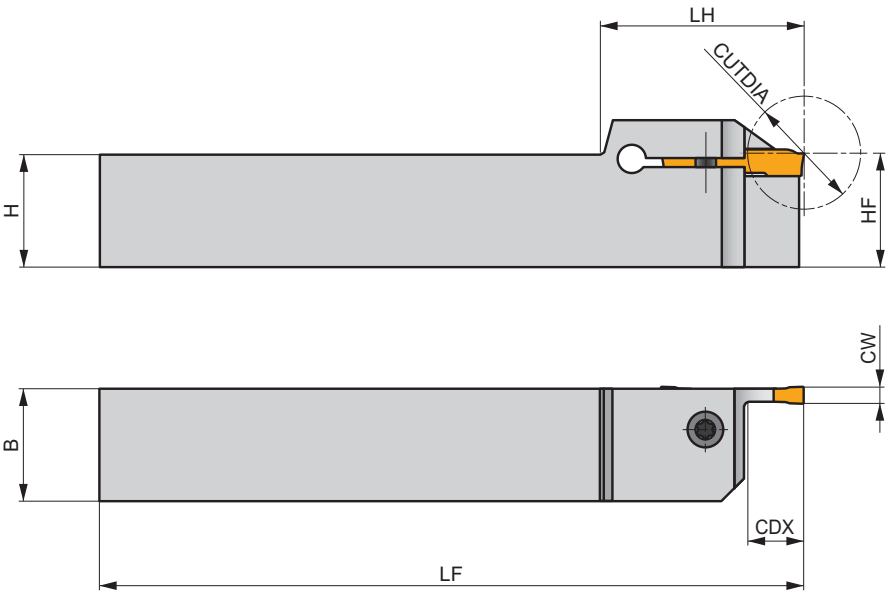
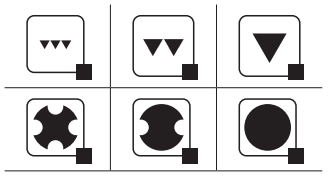
Grooving and Turning tool for GL Inserts

External Right/Left handed tool holder for GL inserts. Best suited for longitudinal turning and profiling applications, usable also for grooving and parting-off. Body treated for longer tool life.







	Product	HF (inch)	H (inch)	B (inch)	LF (inch)	LH (inch)	CW (inch)	CDX (inch)	CUTDIA (inch)	lbs			MID
R	GL2-S12CFR-.39	.750	.750	.750	5.000	1.390	.079	.390	.780	.74	GI334	GL11	8015984
	GL2-S16DFR-.39	1.000	1.000	1.000	6.000	1.390	.079	.390	.780	1.59	GI334	GL11	8015988
	GL3-S12CFR-.39	.750	.750	.750	5.000	1.390	.118	.390	.780	.74	GI335	GL11	8015994
	GL3-S16DFR-.39	1.000	1.000	1.000	6.000	1.390	.118	.390	.780	1.59	GI335	GL11	8015998
	GL3-S20DFR-.79	1.250	1.250	1.250	6.000	1.811	.118	.790	1.580	2.34	GI335	GL15	8178860
	GL4-S12CFR-.47	.750	.750	.750	5.000	1.390	.157	.470	.940	.72	GI336	GL11	8016005
	GL4-S16DFR-.47	1.000	1.000	1.000	6.000	1.390	.157	.470	.940	1.57	GI336	GL11	8016009
	GL4-S20DFR-.94	1.250	1.250	1.250	6.000	1.890	.157	.940	1.880	2.28	GI336	GL15	8178862
	GL5-S12CFR-.47	.750	.750	.750	5.000	1.390	.197	.470	.940	.72	GI337	GL11	8016043
	GL5-S16DFR-.47	1.000	1.000	1.000	6.000	1.390	.197	.470	.940	1.57	GI337	GL11	8016045
	GL5-S20EFR-1.26	1.250	1.250	1.250	7.000	2.205	.197	1.200	2.400	2.61	GI337	GL15	8178864
	GL6-S12CFR-.47	.750	.750	.750	5.000	1.390	.236	.470	.940	.73	GI338	GL11	8016049
	GL6-S16DFR-.47	1.000	1.000	1.000	6.000	1.390	.236	.470	.940	1.57	GI338	GL11	8016051
	GL6-S20EFR-1.26	1.250	1.250	1.250	7.000	2.205	.236	1.200	2.400	2.62	GI338	GL15	8178866
L	GL2-S12CFL-.39	.750	.750	.750	5.000	1.390	.079	.390	.780	.74	GI334	GL11	8015983
	GL2-S16DFL-.39	1.000	1.000	1.000	6.000	1.390	.079	.390	.780	1.59	GI334	GL11	8015987
	GL3-S12CFL-.39	.750	.750	.750	5.000	1.390	.118	.390	.780	.74	GI335	GL11	8015993
	GL3-S16DFL-.39	1.000	1.000	1.000	6.000	1.390	.118	.390	.780	1.59	GI335	GL11	8015997
	GL3-S20DFL-.79	1.250	1.250	1.250	6.000	1.811	.118	.790	1.580	2.34	GI335	GL15	8178829
	GL4-S12CFL-.47	.750	.750	.750	5.000	1.390	.157	.470	.940	.72	GI336	GL11	8016004
	GL4-S16DFL-.47	1.000	1.000	1.000	6.000	1.390	.157	.470	.940	1.57	GI336	GL11	8016008
	GL4-S20DFL-.94	1.250	1.250	1.250	6.000	1.890	.157	.940	1.880	2.28	GI336	GL15	8178861
	GL5-S12CFL-.47	.750	.750	.750	5.000	1.390	.197	.470	.940	.72	GI337	GL11	8016042

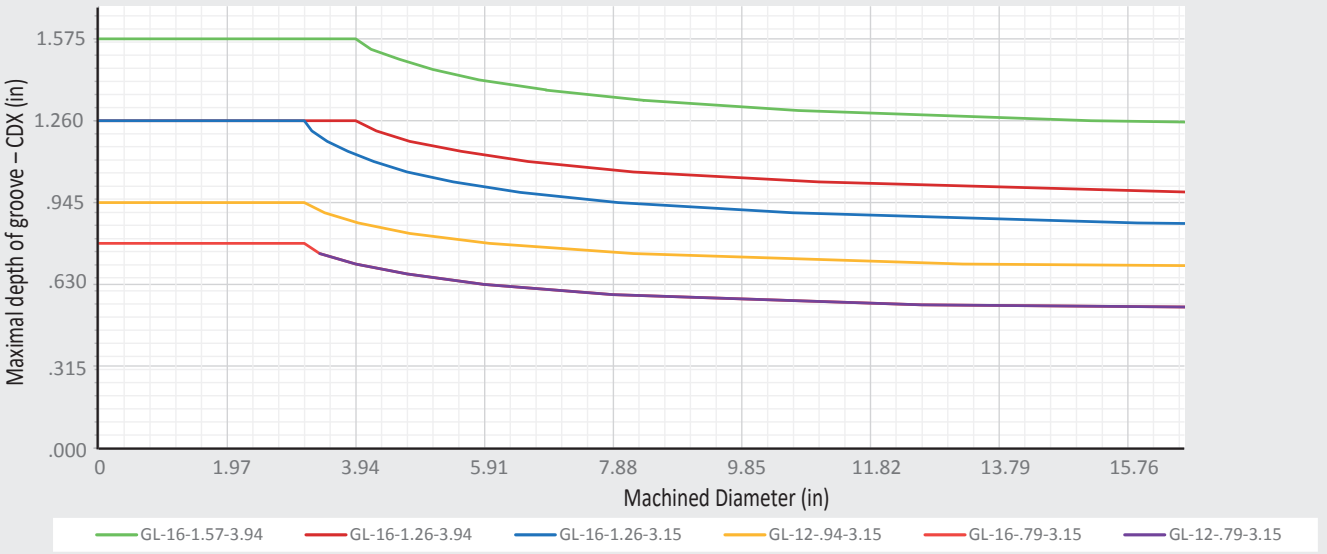
	Product	HF (inch)	H (inch)	B (inch)	LF (inch)	LH (inch)	CW (inch)	CDX (inch)	CUTDIA (inch)	lbs			MID
L	**GL5-S16DFL-.47**	1.000	1.000	1.000	6.000	1.390	.197	.470	.940	1.57	GI337	GL11	8016044
	GL5-S20EFL-1.26	1.250	1.250	1.250	7.000	2.205	.197	1.200	2.400	2.61	GI337	GL15	8178863
	GL6-S12CFL-.47	.750	.750	.750	5.000	1.390	.236	.470	.940	.73	GI338	GL11	8016048
	GL6-S16DFL-.47	1.000	1.000	1.000	6.000	1.390	.236	.470	.940	1.57	GI338	GL11	8016050
	GL6-S20EFL-1.26	1.250	1.250	1.250	7.000	2.205	.236	1.200	2.400	2.62	GI338	GL15	8178865

GI334	GL2..	–
GI335	GL3..	–
GI336	GL4..	–
GI337	GL5..	–
GI338	GL6-D600..	GL6-D800..

		Nm			
GL11	US 5018-T20P	5.0	M 5	.717	LKT20P
GL15	SR 88026-T30P	5.0	M8	1.024	LKT30P

CUTTING DEPTHS DEPENDING ON MACHINED DIAMETER

IGLAF(RL) EXT



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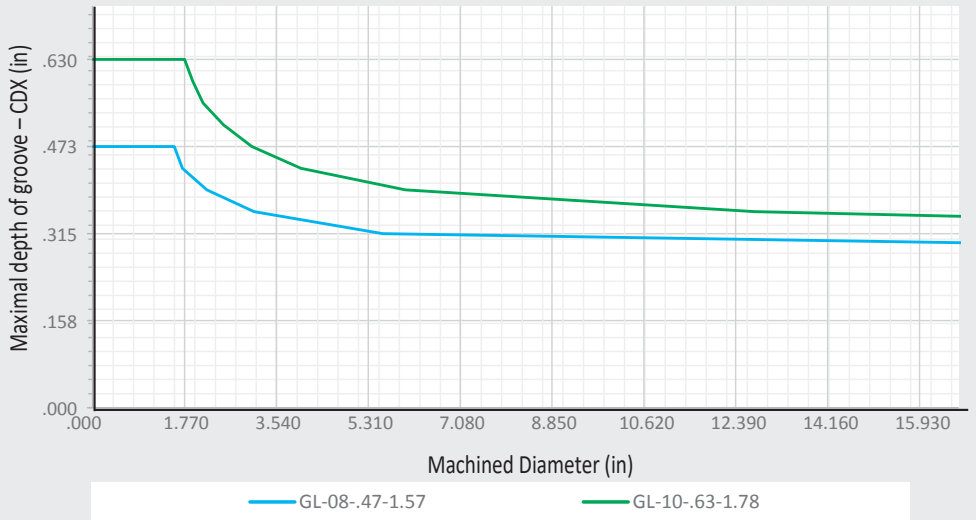
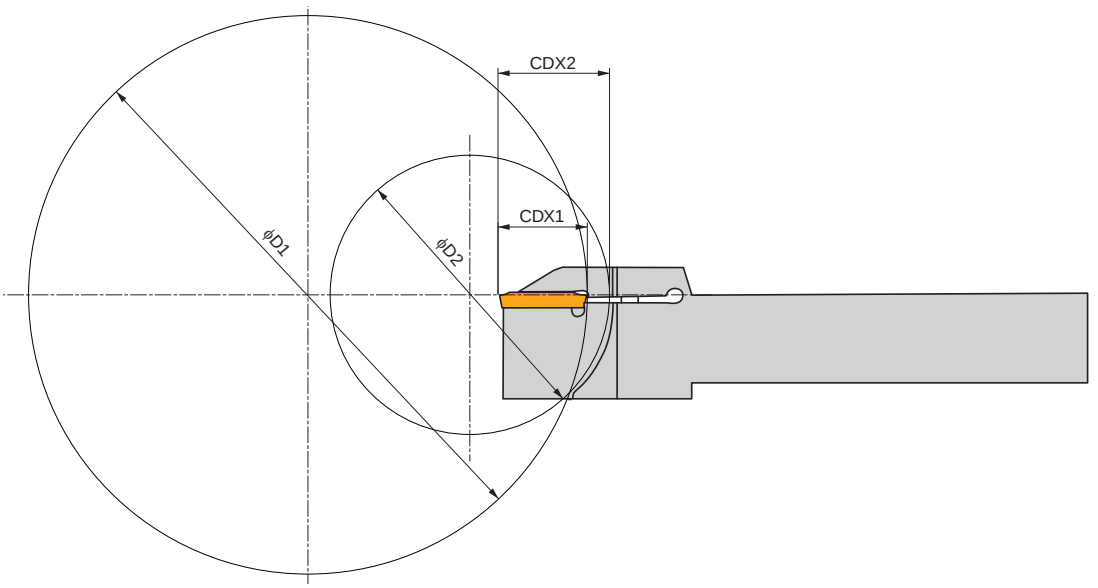
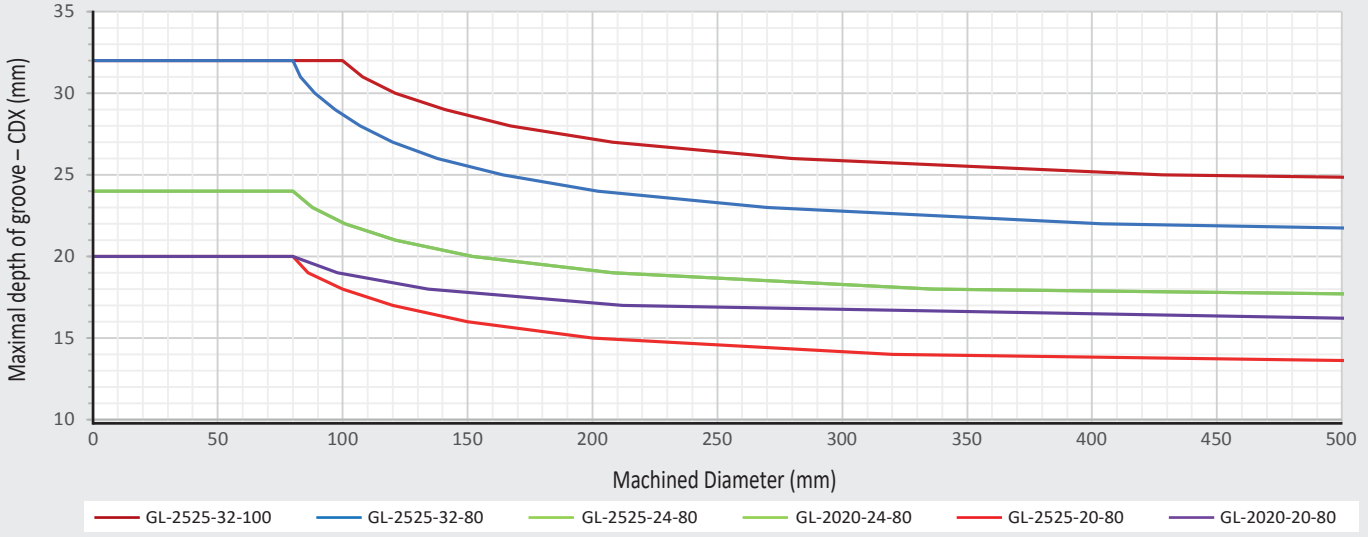


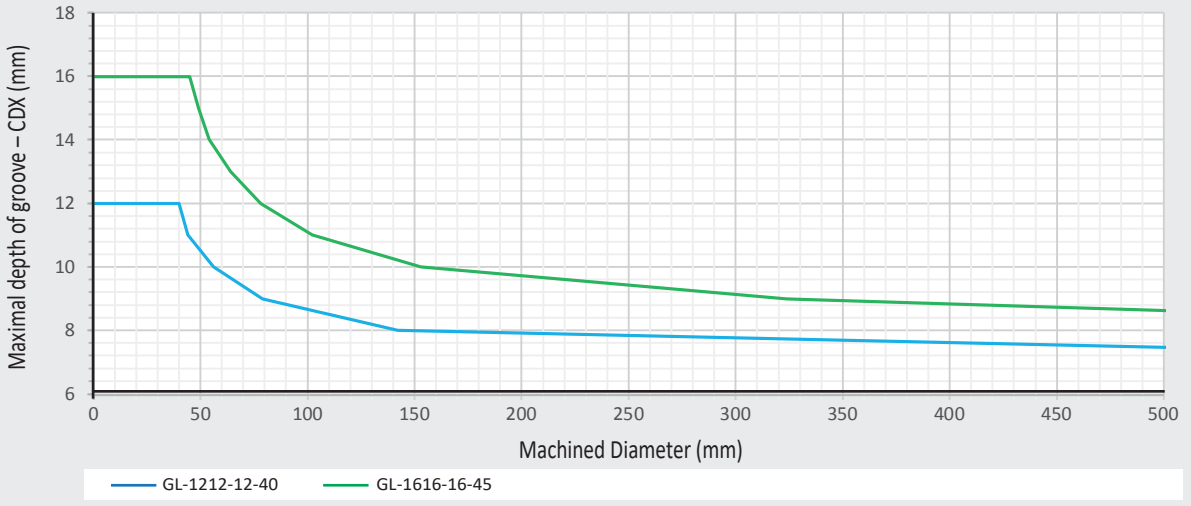


CUTTING DEPTHS DEPENDING ON MACHINED DIAMETER

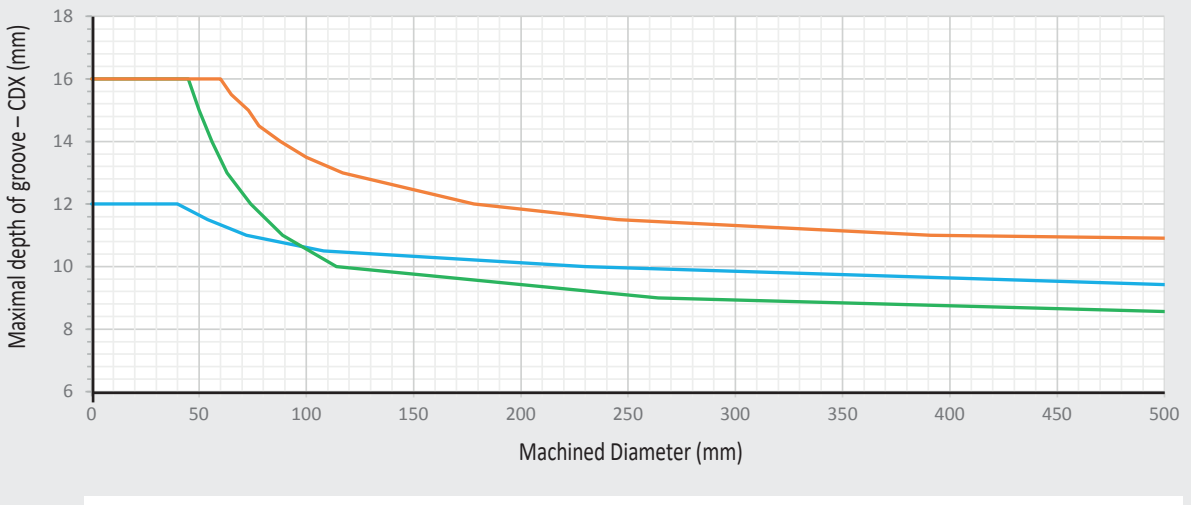
GLSF (RL) EXT



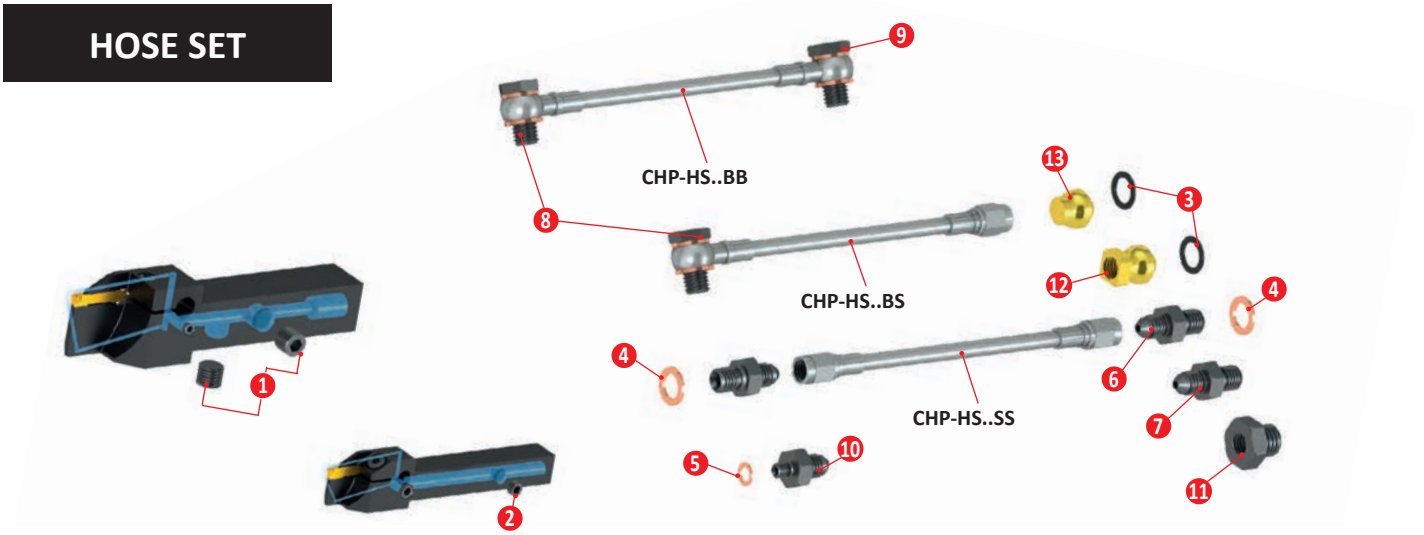
GLSF (RL) EXT-S

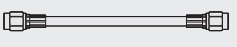
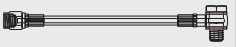


GL1



HOSE SET



Hose Sets							
							
	Ordering Code	Designation	**Ordering Code**	Designation	**Ordering Code**	Designation	**length**
	8180744	CHP-HS150 SS	**8180745**	CHP-HS150 BS	**8180746**	CHP-HS150 BB	150 mm
	8180747	CHP-HS250 SS	**8180748**	CHP-HS250 BS	**8180749**	CHP-HS250 BB	250 mm
	8180750	CHP-HS300 SS	**8180751**	CHP-HS300 BS	**8180752**	CHP-HS300 BB	300 mm

	Hose Set Components		Designation	Number of Components		
1		Plug G⅛“	CHP-P1/8	1 x	1 x	1 x
2		Plug 6*	CHP-P6	–	–	–
3		O-ring	CHP-O10×1	2 x	2 x	2 x
4		Copper gasket	CHP-G10	2 x	3 x	4 x
5		Copper gasket*	CHP-G06	–	–	–
6		Conector straight G⅛“	CHP-CS1/8	2 x	1 x	–
7		Conector straight M10	CHP-CS10	1 x	–	–
8		Conector banjo G⅛“	CHP-CB1/8	–	1 x	2 x
9		Conector banjo M10	CHP-CB10	–	1 x	1 x
10		Reduction G⅛“ to M6*	CHP-R1/8-6	–	–	–
11		Reduction G¼" to G⅛“	CHP-R1/4-1/8	–	1 x	1 x
12		Coolant nozzle G⅛“	CHP-PV1/8-12	1 x	1 x	1 x
13		Coolant nozzle plug	CHP-PV14	1 x	1 x	1 x

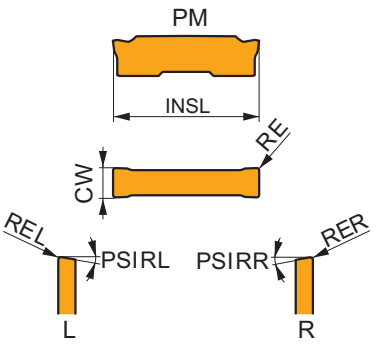
* included in tool shank 12 × 12 delivery

More information in the package leaflet

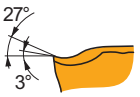
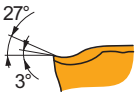
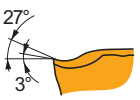
GL. D - PM

PRAMET

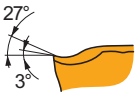
	CW	CWTOLL	CWTOLU	INSL
	(inch)	(inch)	(inch)	(inch)
150	.059	-.002	.002	.65
200	.079	-.002	.002	.984
250	.100	-.002	.002	.984
300	.118	-.002	.002	.984
400	.157	-.002	.002	.984
500	.197	-.002	.002	.984
600	.236	-.002	.002	.984



Suitability and starting values for cutting speed (vc) and feed (f). Refer to our Machining Calculator app for further calculations.

Product		RE	P		M		K		N		S		H		PSIRR	PSIRL	MID
			vc (ft/min)	f (in/rev)	vc (ft/min)	f (in/rev)	vc (ft/min)	f (in/rev)	vc (ft/min)	f (in/rev)	vc (ft/min)	f (in/rev)	vc (ft/min)	f (in/rev)	(°)	(°)	
																	
PM geometry with highly positive rake, first choice for parting-off, and continuous to slightly interrupted cuts.																	
GL1-D150M015-PM	**G8330**	.006	427	.002	246	.002	394	.002	1280	.0024	98	.0016	–	–	–	–	8463342
GL2-D200M02-PM	**G8330**	.008	427	.0031	246	.0028	394	.0031	1280	.0039	98	.0024	–	–	–	–	7802882
	T7325	.008	492	.0031	377	.0028	459	.0031	–	–	148	.0024	–	–	–	–	7802883
GL3-D250G02-PM	**G8330**	.008	427	.0039	246	.0035	394	.0039	1280	.0047	98	.0028	–	–	–	–	7802916
GL3-D300M02-PM	**G8330**	.008	427	.0039	246	.0035	394	.0039	1280	.0047	98	.0028	–	–	–	–	7802917
	T7325	.008	492	.0039	377	.0035	459	.0039	–	–	148	.0028	–	–	–	–	7802918
GL4-D400M02-PM	**G8330**	.008	427	.0047	246	.0043	394	.0047	1280	.0055	98	.0039	–	–	–	–	7802931
	T7325	.008	492	.0047	377	.0043	459	.0047	–	–	148	.0039	–	–	–	–	7802932
GL5-D500M03-PM	**G8330**	.012	427	.0059	246	.0055	394	.0059	1280	.0071	98	.0047	–	–	–	–	7802945
GL6-D600M03-PM	**G8330**	.012	427	.0059	246	.0055	394	.0059	1280	.0071	98	.0047	–	–	–	–	7802947
																	
R-PM right-handed geometry with highly positive rake, first choice for tubes parting-off, and continuous cuts.																	
GL1-D150G015R06-PM	**G8330**	.006	427	.002	246	.002	394	.002	1280	.0024	98	.0016	–	–	6	–	8463344
GL1-D150G015R12-PM	**G8330**	.006	427	.002	246	.002	394	.002	1280	.0024	98	.0016	–	–	12	–	8463346
GL2-D200G02R06-PM	**G8330**	.008	427	.0031	246	.0028	394	.0031	1280	.0039	98	.0024	–	–	6	–	7802887
	T7325	.008	492	.0031	377	.0028	459	.0031	–	–	148	.0024	–	–	6	–	7802889
GL2-D200G02R12-PM	**G8330**	.008	427	.0031	246	.0028	394	.0031	1280	.0039	98	.0024	–	–	12	–	7802885
GL3-D300G02R06-PM	**G8330**	.008	427	.0039	246	.0035	394	.0039	1280	.0047	98	.0028	–	–	6	–	7802922
	T7325	.008	492	.0039	377	.0035	459	.0039	–	–	148	.0028	–	–	6	–	7802924
GL3-D300G02R12-PM	**G8330**	.008	427	.0039	246	.0035	394	.0039	1280	.0047	98	.0028	–	–	12	–	7802920
GL4-D400G02R06-PM	**G8330**	.008	427	.0047	246	.0043	394	.0047	1280	.0055	98	.0039	–	–	6	–	7802936
	T7325	.008	492	.0047	377	.0043	459	.0047	–	–	148	.0039	–	–	6	–	7802938
GL4-D400G02R12-PM	**G8330**	.008	427	.0047	246	.0043	394	.0047	1280	.0055	98	.0039	–	–	12	–	7802934
																	
L-PM left-handed geometry with highly positive rake, first choice for tubes parting-off, and continuous cuts.																	
GL1-D150G015L06-PM	**G8330**	.006	427	.002	246	.002	394	.002	1280	.0024	98	.0016	–	–	–	6	8463343
GL1-D150G015L12-PM	**G8330**	.006	427	.002	246	.002	394	.002	1280	.0024	98	.0016	–	–	–	12	8463345
GL2-D200G02L06-PM	**G8330**	.008	427	.0031	246	.0028	394	.0031	1280	.0039	98	.0024	–	–	–	6	7802886
	T7325	.008	492	.0031	377	.0028	459	.0031	–	–	148	.0024	–	–	–	6	7802888
GL2-D200G02L12-PM	**G8330**	.008	427	.0031	246	.0028	394	.0031	1280	.0039	98	.0024	–	–	–	12	7802884

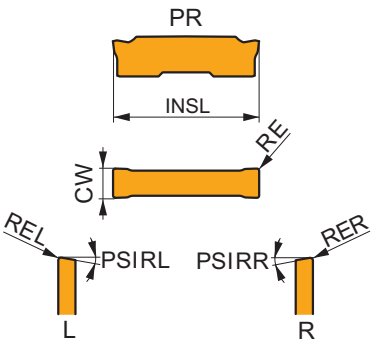
Suitability and starting values for cutting speed (vc) and feed (f). Refer to our Machining Calculator app for further calculations.

Product		RE (inch)	P vc (ft/min)	P f (in/rev)	M vc (ft/min)	M f (in/rev)	K vc (ft/min)	K f (in/rev)	N vc (ft/min)	N f (in/rev)	S vc (ft/min)	S f (in/rev)	H vc (ft/min)	H f (in/rev)	PSIRR (°)	PSIRL (°)	MID
																	
L-PM left-handed geometry with highly positive rake, first choice for tubes parting-off, and continuous cuts.																	
GL3-D300G02L06-PM	**G8330**	.008	427	.0039	246	.0035	394	.0039	1280	.0047	98	.0028	–	–	–	6	7802921
	T7325	.008	492	.0039	377	.0035	459	.0039	–	–	148	.0028	–	–	–	6	7802923
GL3-D300G02L12-PM	**G8330**	.008	427	.0039	246	.0035	394	.0039	1280	.0047	98	.0028	–	–	–	12	7802919
GL4-D400G02L06-PM	**G8330**	.008	427	.0047	246	.0043	394	.0047	1280	.0055	98	.0039	–	–	–	6	7802935
	T7325	.008	492	.0047	377	.0043	459	.0047	–	–	148	.0039	–	–	–	6	7802937
GL4-D400G02L12-PM	**G8330**	.008	427	.0047	246	.0043	394	.0047	1280	.0055	98	.0039	–	–	–	12	7802933

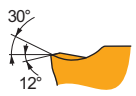
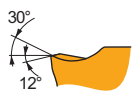
GL. D - PR

PRAMET

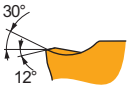
	CW (inch)	CWTOLL (inch)	CWTOLU (inch)	INSL (inch)
200	.079	-.002	.002	.984
300	.118	-.002	.002	.984
400	.157	-.002	.002	.984
500	.197	-.002	.002	.984
600	.236	-.002	.002	.984



Suitability and starting values for cutting speed (vc) and feed (f). Refer to our Machining Calculator app for further calculations.

Product		RE (inch)	P vc (ft/min)	P f (in/rev)	M vc (ft/min)	M f (in/rev)	K vc (ft/min)	K f (in/rev)	N vc (ft/min)	N f (in/rev)	S vc (ft/min)	S f (in/rev)	H vc (ft/min)	H f (in/rev)	PSIRR (°)	PSIRL (°)	MID
																	
PR geometry with negative T-land, first choice for difficult grooving and parting-off, and continuous to interrupted cuts.																	
GL2-D200M02-PR	**G8330**	.008	427	.0039	246	.0035	394	.0039	–	–	–	–	–	–	–	–	7802910
	T7325	.008	492	.0039	377	.0035	459	.0039	–	–	–	–	–	–	–	–	7802911
GL3-D300M02-PR	**G8330**	.008	427	.0047	246	.0043	394	.0047	–	–	–	–	–	–	–	–	7802925
	T7325	.008	492	.0047	377	.0043	459	.0047	–	–	–	–	–	–	–	–	7802926
GL4-D400M02-PR	**G8330**	.008	427	.0059	246	.0055	394	.0059	–	–	–	–	–	–	–	–	7802939
	T7325	.008	492	.0059	377	.0055	459	.0059	–	–	–	–	–	–	–	–	7802940
GL5-D500M04-PR	**G8330**	.016	427	.0071	246	.0063	394	.0071	–	–	–	–	–	–	–	–	7802946
GL6-D600M04-PR	**G8330**	.016	427	.0071	246	.0063	394	.0071	–	–	–	–	–	–	–	–	7802948
																	
R-PR right-handed geometry with negative T-land, first choice for difficult bars parting-off, and continuous to interrupted cuts.																	
GL2-D200G02R06-PR	**G8330**	.008	427	.0039	246	.0035	394	.0039	–	–	–	–	–	–	6	–	7802913
GL2-D200G02R12-PR	**G8330**	.008	427	.0039	246	.0035	394	.0039	–	–	–	–	–	–	12	–	7802915
GL3-D300G02R06-PR	**G8330**	.008	427	.0047	246	.0043	394	.0047	–	–	–	–	–	–	6	–	7802928
GL3-D300G02R12-PR	**G8330**	.008	427	.0047	246	.0043	394	.0047	–	–	–	–	–	–	12	–	7802930
GL4-D400G02R06-PR	**G8330**	.008	427	.0059	246	.0055	394	.0059	–	–	–	–	–	–	6	–	7802942
GL4-D400G02R12-PR	**G8330**	.008	427	.0059	246	.0055	394	.0059	–	–	–	–	–	–	12	–	7802944

Suitability and starting values for cutting speed (vc) and feed (f). Refer to our Machining Calculator app for further calculations.

Product		RE	P		M		K		N		S		H		PSIRR	PSIRL	MID
			vc (ft/min)	f (in/rev)	vc (ft/min)	f (in/rev)	vc (ft/min)	f (in/rev)	vc (ft/min)	f (in/rev)	vc (ft/min)	f (in/rev)	vc (ft/min)	f (in/rev)	(°)	(°)	
																	

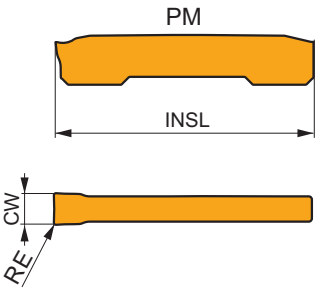
L-PR left-handed geometry with negative T-land, first choice for difficult bars parting-off, and continuous to interrupted cuts.

GL2-D200G02L06-PR	**G8330**	.008	■	427	.0039	◪	246	.0035	■	394	.0039	–	–	–	–	–	–	–	6	7802912
GL2-D200G02L12-PR	**G8330**	.008	■	427	.0039	◪	246	.0035	■	394	.0039	–	–	–	–	–	–	–	12	7802914
GL3-D300G02L06-PR	**G8330**	.008	■	427	.0047	◪	246	.0043	■	394	.0047	–	–	–	–	–	–	–	6	7802927
GL3-D300G02L12-PR	**G8330**	.008	■	427	.0047	◪	246	.0043	■	394	.0047	–	–	–	–	–	–	–	12	7802929
GL4-D400G02L06-PR	**G8330**	.008	■	427	.0059	◪	246	.0055	■	394	.0059	–	–	–	–	–	–	–	6	7802941
GL4-D400G02L12-PR	**G8330**	.008	■	427	.0059	◪	246	.0055	■	394	.0059	–	–	–	–	–	–	–	12	7802943

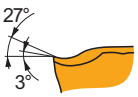
GL. S - PM

PRAMET

	CW (inch)	CWTOLL (inch)	CWTOLU (inch)	INSL (inch)
300	.118	-.002	.002	.965
400	.157	-.002	.002	.957



Suitability and starting values for cutting speed (vc) and feed (f). Refer to our Machining Calculator app for further calculations.

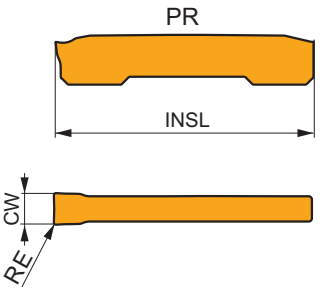
Product		RE	P		M		K		N		S		H		PSIRR	PSIRL	MID
			vc (ft/min)	f (in/rev)	vc (ft/min)	f (in/rev)	vc (ft/min)	f (in/rev)	vc (ft/min)	f (in/rev)	vc (ft/min)	f (in/rev)	vc (ft/min)	f (in/rev)	(°)	(°)	
																	

PM geometry with highly positive rake on single sided insert, first choice for deep parting-off, and continuous to slightly interrupted cuts.

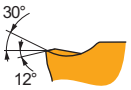
GL3-S300M02-PM	**G8330**	.008	■	427	.0039	■	246	.0035	◪	394	.0039	◪	1280	.0047	◪	98	.0028	–	–	–	–	8178695
GL4-S400M02-PM	**G8330**	.008	■	427	.0047	■	246	.0043	◪	394	.0047	◪	1280	.0055	◪	98	.0039	–	–	–	–	8178697

GL. S - PR

	CW	CWTOLL	CWTOLU	INSL
	(inch)	(inch)	(inch)	(inch)
300	.118	-.002	.002	.965
400	.157	-.002	.002	.957



Suitability and starting values for cutting speed (vc) and feed (f). Refer to our Machining Calculator app for further calculations.

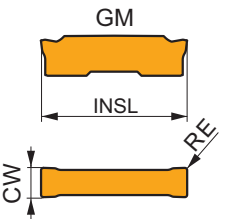
Product		RE	P		M		K		N		S		H		PSIRR	PSIRL	MID
			vc (ft/min)	f (in/rev)	vc (ft/min)	f (in/rev)	vc (ft/min)	f (in/rev)	vc (ft/min)	f (in/rev)	vc (ft/min)	f (in/rev)	vc (ft/min)	f (in/rev)	(°)	(°)	
		(inch)															
																	

PR geometry with negative T-land on single sided insert, first choice for difficult deep grooving and parting-off, and continuous to interrupted cuts.

GL3-S300M02-PR	**G8330**	.008	427	.0047	246	.0043	394	.0047	–	–	–	–	–	–	–	–	8178696
GL4-S400M02-PR	**G8330**	.008	427	.0059	246	.0055	394	.0059	–	–	–	–	–	–	–	–	8178698

GL. D - GM

	CW	CWTOLL	CWTOLU	INSL
	(inch)	(inch)	(inch)	(inch)
200	.079	-.002	.002	.984
300	.118	-.002	.002	.984
400	.157	-.002	.002	.984
500	.197	-.002	.002	.984
600	.236	-.002	.002	.984
800	.315	-.002	.002	.984



Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

Product		RE	P			M			K			N			S			H			MID
			vc (ft/min)	f (in/rev)	ap (inch)	vc (ft/min)	f (in/rev)	ap (inch)	vc (ft/min)	f (in/rev)	ap (inch)	vc (ft/min)	f (in/rev)	ap (inch)	vc (ft/min)	f (in/rev)	ap (inch)	vc (ft/min)	f (in/rev)	ap (inch)	
		(inch)																			

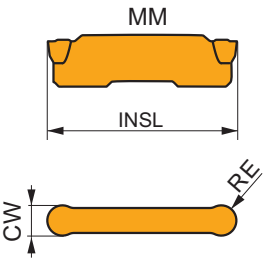
GM versatile geometry for grooving and longitudinal turning, and continuous to interrupted cuts.

GL2-D200M02-GM	**G8330**	.008	623	.0039	.031	361	.0035	.031	591	.0039	.031	–	–	–	148	.0031	.024	–	–	–	8023038
	T7325	.008	722	.0039	.031	558	.0035	.031	673	.0039	.031	–	–	–	230	.0031	.024	–	–	–	8023039
GL3-D300M02-GM	**G8330**	.008	492	.0079	.039	295	.0071	.039	459	.0079	.039	–	–	–	115	.0055	.031	–	–	–	8022955
	T7325	.008	574	.0079	.039	443	.0071	.039	541	.0079	.039	–	–	–	180	.0055	.031	–	–	–	8022956
GL3-D300M04-GM	**G8330**	.016	525	.0079	.039	312	.0071	.039	492	.0079	.039	–	–	–	131	.0055	.031	–	–	–	7983471
	T7325	.016	607	.0079	.039	459	.0071	.039	574	.0079	.039	–	–	–	197	.0055	.031	–	–	–	7983472
GL4-D400M04-GM	**G8330**	.016	492	.0098	.047	295	.0091	.047	459	.0098	.047	–	–	–	115	.0071	.039	–	–	–	7983475
	T7325	.016	558	.0098	.047	427	.0091	.047	525	.0098	.047	–	–	–	180	.0071	.039	–	–	–	7983476
GL4-D400M08-GM	**G8330**	.031	591	.0098	.047	344	.0091	.047	558	.0098	.047	–	–	–	148	.0071	.039	–	–	–	8022957
	T7325	.031	656	.0098	.047	509	.0091	.047	623	.0098	.047	–	–	–	213	.0071	.039	–	–	–	8022958
GL5-D500M08-GM	**G8330**	.031	558	.0118	.047	328	.0106	.047	525	.0118	.047	–	–	–	131	.0083	.039	–	–	–	8023030
	T7325	.031	623	.0118	.047	476	.0106	.047	591	.0118	.047	–	–	–	197	.0083	.039	–	–	–	8023031
GL6-D600M08-GM	**G8330**	.031	558	.0118	.047	328	.0106	.047	525	.0118	.047	–	–	–	131	.0083	.039	–	–	–	8023034
	T7325	.031	623	.0118	.047	476	.0106	.047	591	.0118	.047	–	–	–	197	.0083	.039	–	–	–	8023035
GL6-D800M08-GM	**G8330** [1)]	.031	558	.0118	.047	328	.0106	.047	525	.0118	.047	–	–	–	131	.0083	.047	–	–	–	8463347

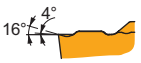
[1)] Usable only in holders with CDX ≥ 24.

GL. D - MM

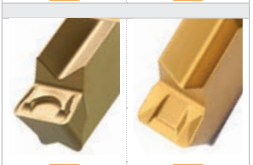
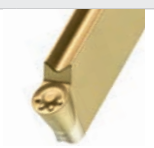
	CW	CWTOLL	CWTOLU	INSL
	(inch)	(inch)	(inch)	(inch)
200	.079	-.002	.002	.984
300	.118	-.002	.002	.984
400	.157	-.002	.002	.984
500	.197	-.002	.002	1.024
600	.236	-.002	.002	1.024



Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

Product		RE	P			M			K			N			S			H			MID
			vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	
		(inch)	(ft/min)	(in/rev)	(inch)	(ft/min)	(in/rev)	(inch)	(ft/min)	(in/rev)	(inch)	(ft/min)	(in/rev)	(inch)	(ft/min)	(in/rev)	(inch)	(ft/min)	(in/rev)	(inch)	
			**MM** geometry, with full radius shape for copy profiling and longitudinal turning, and continuous to interrupted cuts.																		
GL2-D200MM0-MM	**G8330**	.039	■ 820	.0039	.039	■ 492	.0035	.039	■ 771	.0039	.039	–	–	–	◪ 197	.0031	.031	–	–	–	8023060
	T7325	.039	◪ 935	.0039	.039	■ 722	.0035	.039	■ 886	.0039	.039	–	–	–	◪ 295	.0031	.031	–	–	–	8023061
GL3-D300MM0-MM	**G8330**	.059	■ 689	.0079	.047	■ 410	.0071	.047	■ 640	.0079	.047	–	–	–	◪ 164	.0055	.039	–	–	–	7983473
	T7325	.059	◪ 787	.0079	.047	■ 607	.0071	.047	■ 738	.0079	.047	–	–	–	◪ 246	.0055	.039	–	–	–	7983474
GL4-D400MM0-MM	**G8330**	.079	■ 722	.0079	.047	■ 427	.0071	.047	■ 673	.0079	.047	–	–	–	◪ 180	.0055	.039	–	–	–	7983477
	T7325	.079	◪ 820	.0079	.047	■ 640	.0071	.047	■ 771	.0079	.047	–	–	–	◪ 262	.0055	.039	–	–	–	7983478
GL5-D500MM0-MM	**G8330**	.098	■ 673	.0098	.047	■ 394	.0091	.047	■ 623	.0098	.047	–	–	–	◪ 164	.0071	.039	–	–	–	8023032
	T7325	.098	◪ 771	.0098	.047	■ 591	.0091	.047	■ 722	.0098	.047	–	–	–	◪ 246	.0071	.039	–	–	–	8023033
GL6-D600MM0-MM	**G8330**	.118	■ 640	.0118	.047	■ 377	.0106	.047	■ 607	.0118	.047	–	–	–	◪ 148	.0083	.039	–	–	–	8023036
	T7325	.118	◪ 722	.0118	.047	■ 558	.0106	.047	■ 673	.0118	.047	–	–	–	◪ 230	.0083	.039	–	–	–	8023037

LCM. – EXTERNAL TOOLS NAVIGATOR

INSERT SEAT	0316	0416	0516	0616	0830
GFI(RL) EXT 16×16 32×25					
GFM(RL) EXT 20×20 32×25					
Cutting width (mm) CW	3	4	5	6	8
Deep parting-off (single sided insert)	LCMR CM	LCMR CM			
Parting-off (tube / full bar)	CM F	CM F	CM F	CM F	F
Grooving (deep / shallow)	F M	F M	F M	 F M	F
Turning (longitudinal)	F M	F M	F M	F M	F
Profiling (multiaxial)	 MP	MP	MP	MP	MP

GFI(RL) EXT

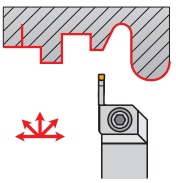
P M K N S H

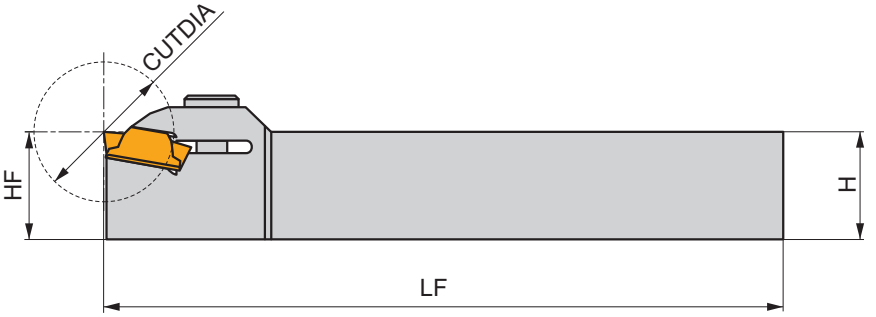
PRAMET

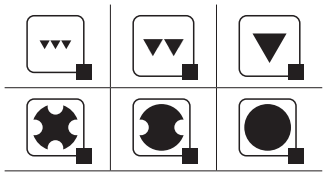
G

External V-Groove Top Clamp Grooving and Turning Tool for LCM. Inserts

External Right/Left hand tool holder for grooving with LCM. inserts. Suited for parting-off, grooving, profiling and longitudinal turning applications. Body treated for longer tool life.







	Product	HF (mm)	H (mm)	B (mm)	LF (mm)	CW (mm)	CUTDIA (mm)	lbs			MID
R	**GFIR 1616 H 03**	16	16	16	100	3.00	18	.48	GI136	GL03	6757963
	GFIR 2020 K 03	20	20	20	125	3.00	18	.87	GI136	GL04	6757965
	GFIR 2525 M 03	25	25	25	150	3.00	18	1.61	GI136	GL05	6757967
	GFIR 1616 H 04	16	16	16	100	4.00	24	.47	GI137	GL03	6757969
	GFIR 2020 K 04	20	20	20	125	4.00	24	.85	GI137	GL04	6757971
	GFIR 2525 M 04	25	25	25	150	4.00	24	1.56	GI137	GL05	6757973
	GFIR 2020 K 05	20	20	20	125	5.00	28	.84	GI138	GL04	6757975
	GFIR 2525 M 05	25	25	25	150	5.00	28	1.54	GI138	GL05	6757977
	GFIR 2020 K 06	20	20	20	125	6.00	28	.83	GI139	GL04	6757979
	GFIR 2525 M 06	25	25	25	150	6.00	28	1.55	GI139	GL05	6757981
	GFIR 2525 M 08	25	25	25	150	8.00	48	1.63	GI193	GL09	6759687
	GFIR 3225 P 08	32	32	25	170	8.00	48	2.24	GI193	GL09	6759692
L	**GFIL 1616 H 03**	16	16	16	100	3.00	18	.48	GI136	GL03	6757964
	GFIL 2020 K 03	20	20	20	125	3.00	18	.87	GI136	GL04	6757966
	GFIL 2525 M 03	25	25	25	150	3.00	18	1.60	GI136	GL05	6757968
	GFIL 2020 K 04	20	20	20	125	4.00	24	.84	GI137	GL04	6757972
	GFIL 2525 M 04	25	25	25	150	4.00	24	1.56	GI137	GL05	6757974
	GFIL 2525 M 05	25	25	25	150	5.00	28	1.57	GI138	GL05	6757978
	GFIL 2020 K 06	20	20	20	125	6.00	28	.88	GI139	GL04	6757980
	GFIL 2525 M 06	25	25	25	150	6.00	28	1.54	GI139	GL05	6757982
	GFIL 2525 M 08	25	25	25	150	8.00	48	1.63	GI193	GL09	6759691
	GFIL 3225 P 08	32	32	25	170	8.00	48	2.24	GI193	GL09	6759693

GI136	LCM. 0316..
GI137	LCM. 0416..
GI138	LCM. 0516..
GI139	LCM. 0616..
GI193	LCM. 0830..

		Nm			
GL03	HS 0616C	6.0	M 6	0.63	HXK 5
GL04	HS 0620C	6.0	M 6	0.787	HXK 5
GL05	HS 0625C	6.0	M 6	0.984	HXK 5
GL09	HSI 1020	8.0	M 10	0.787	HXK 8

GFM(RL) EXT

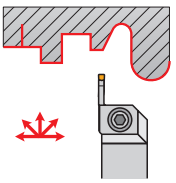
P M K N S H

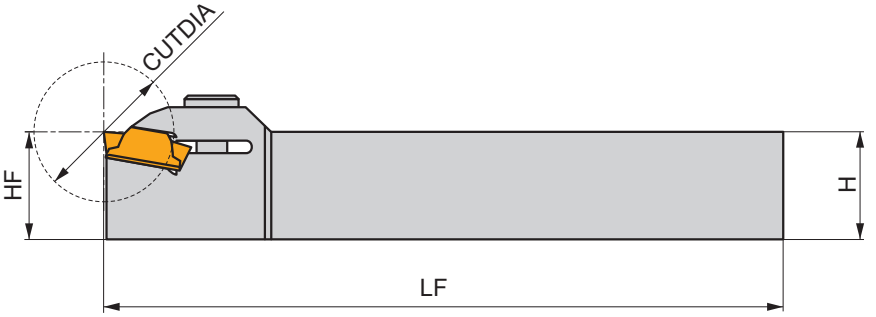
PRAMET

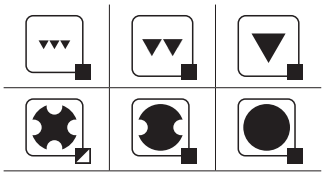
G

External V-Groove Top Clamp Grooving and Turning Tool for LCM. Inserts

External Right/Left hand tool holder for grooving with LCM. inserts. Suited for parting-off, grooving, profiling and longitudinal turning applications. Body treated for longer tool life.







	Product	HF (mm)	H (mm)	B (mm)	LF (mm)	CW (mm)	CUTDIA (mm)	lbs			MID
R	GFMR 2020 K 0316	20	20	20	125	3.00	30	.82	GI136	GL04	6760374
	GFMR 2525 M 0316	25	25	25	150	3.00	30	1.50	GI136	GL04	6760376
	GFMR 2020 K 0416	20	20	20	125	4.00	40	.81	GI137	GL04	6760375
	GFMR 2525 M 0416	25	25	25	150	4.00	40	1.48	GI137	GL04	6760377
	GFMR 2525 M 0516	25	25	25	150	5.00	50	1.44	GI138	GL04	6760378
	GFMR 3225 P 0516	32	32	25	170	5.00	50	2.11	GI138	GL04	6760380
	GFMR 2525 M 0616	25	25	25	150	6.00	60	1.44	GI139	GL04	6760379
	GFMR 3225 P 0616	32	32	25	170	6.00	60	2.10	GI139	GL04	6760381
	GFMR 3225 P 0830	32	32	25	170	8.00	80	2.13	GI193	GL10	6760382
L	GFML 2020 K 0316	20	20	20	125	3.00	30	.80	GI136	GL04	6760365
	GFML 2525 M 0316	25	25	25	150	3.00	30	1.53	GI136	GL04	6760367
	GFML 2525 M 0416	25	25	25	150	4.00	40	1.47	GI137	GL04	6760368
	GFML 2525 M 0516	25	25	25	150	5.00	50	1.45	GI138	GL04	6760369
	GFML 3225 P 0516	32	32	25	170	5.00	50	2.12	GI138	GL04	6760371
	GFML 3225 P 0616	32	32	25	170	6.00	60	2.09	GI139	GL04	6760372
	GFML 3225 P 0830	32	32	25	170	8.00	80	2.14	GI193	GL10	6760373

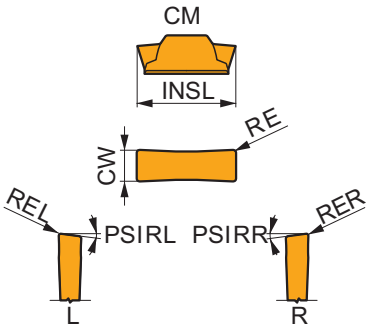
GI136	LCM. 0316..
GI137	LCM. 0416..
GI138	LCM. 0516..
GI139	LCM. 0616..

GI193	LCM. 0830..

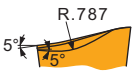
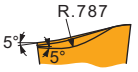
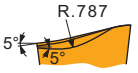
		Nm			
GL04	HS 0620C	6.0	M 6	0.787	HXK 5
GL10	HSI 1020	8.0	M 10	0.787	HXK 8

LCMF 16 - CM

	CW	CWTOLL	CWTOLU	INSL
	(inch)	(inch)	(inch)	(inch)
0316	.118	-.002	.002	.646
0416	.157	-.002	.002	.646
0516	.197	-.002	.002	.646
0616	.236	-.002	.002	.646



Suitability and starting values for cutting speed (vc) and feed (f). Refer to our Machining Calculator app for further calculations.

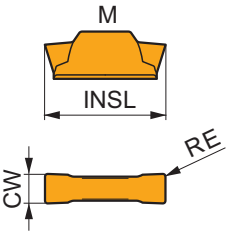
Product		RE	P		M		K		N		S		H		PSIRR	PSIRL	MID
			vc	f	vc	f	vc	f	vc	f	vc	f	vc	f			
		(inch)	(ft/min)	(in/rev)	(ft/min)	(in/rev)	(ft/min)	(in/rev)	(ft/min)	(in/rev)	(ft/min)	(in/rev)	(ft/min)	(in/rev)	(°)	(°)	
																	
CM geometry, first choice for parting-off and grooving, and continuous to slightly interrupted cuts.																	
LCMF 031602-CM	**T8330**	.008	427	.0043	246	.0039	394	.0043	–	–	–	–	–	–	–	–	6754706
LCMF 031604-CM	**T8330**	.016	427	.0043	246	.0039	394	.0043	–	–	–	–	–	–	–	–	6754707
LCMF 041602-CM	**T8330**	.008	427	.0043	246	.0039	394	.0043	–	–	–	–	–	–	–	–	6754709
LCMF 041604-CM	**T8330**	.016	427	.0043	246	.0039	394	.0043	–	–	–	–	–	–	–	–	6754710
LCMF 051604-CM	**T8330**	.016	427	.0043	246	.0043	394	.0043	–	–	–	–	–	–	–	–	6754711
LCMF 061604-CM	**T8330**	.016	427	.0043	246	.0043	394	.0043	–	–	–	–	–	–	–	–	6754712
																	
R-CM geometry, right-handed design, first choice for parting-off and continuous to slightly interrupted cuts.																	
LCMF 031602R15-CM	**T8330** [1]	.008	427	.0043	246	.0039	394	.0043	–	–	–	–	–	–	15	–	6755650
LCMF 031602R6-CM	**T8330**	.008	427	.0043	246	.0039	394	.0043	–	–	–	–	–	–	6	–	6755649
																	
L-CM geometry, left-handed design, first choice for parting-off and continuous to slightly interrupted cuts.																	
LCMF 031602L6-CM	**T8330**	.008	427	.0043	246	.0039	394	.0043	–	–	–	–	–	–	–	6	6755651
LCMF 041602L6-CM	**T8330**	.008	427	.0043	246	.0039	394	.0043	–	–	–	–	–	–	–	6	6755655

[1] Toolholders have to be modified.

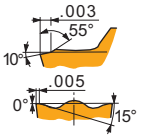
LCMF 16 - M

PRAMET

	CW	CWTOLL	CWTOLU	INSL
	(inch)	(inch)	(inch)	(inch)
0316	.118	-.002	.002	.646
0416	.157	-.002	.002	.646
0516	.197	-.002	.002	.646
0616	.236	-.002	.002	.646



Suitability and starting values for cutting speed (vc) and feed (f). Refer to our Machining Calculator app for further calculations.

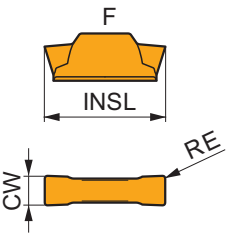
Product		RE	P			M			K			N			S			H			MID
			vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	
		(inch)	(ft/min)	(in/rev)	(inch)	(ft/min)	(in/rev)	(inch)	(ft/min)	(in/rev)	(inch)	(ft/min)	(in/rev)	(inch)	(ft/min)	(in/rev)	(inch)	(ft/min)	(in/rev)	(inch)	
																					
LCMF 031602-M	**T8330**	.008	525	.0051	.039	312	.0047	.039	492	.0051	.039	–	–	–	–	–	–	98	.0039	.028	6754267
LCMF 031604-M	**T8330**	.016	558	.0051	.039	328	.0047	.039	525	.0051	.039	–	–	–	–	–	–	98	.0039	.028	6754269
LCMF 041604-M	**T8330**	.016	509	.0071	.039	295	.0063	.039	476	.0071	.039	–	–	–	–	–	–	98	.0047	.031	6754274
	T9325	.016	738	.0071	.039	443	.0063	.039	689	.0071	.039	–	–	–	–	–	–	–	–	–	6754671
LCMF 041608-M	**T8330**	.031	607	.0071	.039	361	.0063	.039	574	.0071	.039	–	–	–	–	–	–	115	.0047	.031	6754308
	T9325	.031	869	.0071	.039	509	.0063	.039	820	.0071	.039	–	–	–	–	–	–	–	–	–	6754678
LCMF 051608-M	**T8330**	.031	591	.0079	.039	344	.0071	.039	558	.0079	.039	–	–	–	–	–	–	115	.0051	.039	6754311
	T9325	.031	837	.0079	.039	492	.0071	.039	787	.0079	.039	–	–	–	–	–	–	–	–	–	6754684
LCMF 061608-M	**T8330**	.031	574	.0098	.039	344	.0091	.039	541	.0098	.039	–	–	–	–	–	–	115	.0051	.039	6754314
	T9325	.031	755	.0098	.039	443	.0091	.039	705	.0098	.039	–	–	–	–	–	–	–	–	–	6754687

M geometry for grooving and longitudinal turning, and continuous to interrupted cuts.

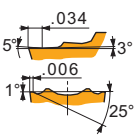
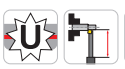
LCMF 16, LCMF 30 - F

PRAMET

	CW	CWTOLL	CWTOLU	INSL
	(inch)	(inch)	(inch)	(inch)
0316	.118	-.002	.002	.646
0416	.157	-.002	.002	.646
0516	.197	-.002	.002	.646
0616	.236	-.002	.002	.646
0830	.315	-.002	.002	1.181

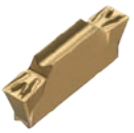
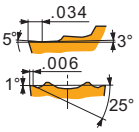


Suitability and starting values for cutting speed (vc) and feed (f). Refer to our Machining Calculator app for further calculations.

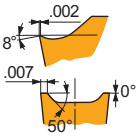
Product		RE	P			M			K			N			S			H			MID
			vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	
		(inch)	(ft/min)	(in/rev)	(inch)	(ft/min)	(in/rev)	(inch)	(ft/min)	(in/rev)	(inch)	(ft/min)	(in/rev)	(inch)	(ft/min)	(in/rev)	(inch)	(ft/min)	(in/rev)	(inch)	
																					
LCMF 031602-F	**T8330**	.008	640	.0039	.012	377	.0035	.012	607	.0039	.012	–	–	–	–	–	–	–	–	–	6754266

F geometry for parting-off, grooving and axial turning, fine and finish machining, and continuous to slightly interrupted cuts.

Suitability and starting values for cutting speed (vc) and feed (f). Refer to our Machining Calculator app for further calculations.

Product	RE (inch)	P vc (ft/min)	P f (in/rev)	P ap (inch)	M vc (ft/min)	M f (in/rev)	M ap (inch)	K vc (ft/min)	K f (in/rev)	K ap (inch)	N vc (ft/min)	N f (in/rev)	N ap (inch)	S vc (ft/min)	S f (in/rev)	S ap (inch)	H vc (ft/min)	H f (in/rev)	H ap (inch)	MID
 																				
LCMF 031604-F	**T8330**	.016	656	.0039	.020	394	.0035	.020	623	.0039	.020	–	–	–	–	–	–	–	–	–	6754268
LCMF 041604-F	**T8330**	.016	607	.0051	.020	361	.0047	.020	574	.0051	.020	–	–	–	–	–	–	–	–	–	6754273
	T9325	.016	902	.0051	.020	541	.0047	.020	853	.0051	.020	–	–	–	–	–	–	–	–	–	6754669
LCMF 041608-F	**T8330**	.031	673	.0051	.039	394	.0047	.039	623	.0051	.039	–	–	–	–	–	–	–	–	–	6754307
	T9325	.031	1001	.0051	.039	591	.0047	.039	935	.0051	.039	–	–	–	–	–	–	–	–	–	6754672
LCMF 051608-F	**T8330**	.031	640	.0059	.039	377	.0055	.039	607	.0059	.039	–	–	–	–	–	–	–	–	–	6754310
	T9325	.031	935	.0059	.039	558	.0055	.039	886	.0059	.039	–	–	–	–	–	–	–	–	–	6754681
LCMF 061608-F	**T8330**	.031	623	.0067	.039	361	.0059	.039	591	.0067	.039	–	–	–	–	–	–	–	–	–	6754313
	T9325	.031	886	.0067	.039	525	.0059	.039	837	.0067	.039	–	–	–	–	–	–	–	–	–	6754686

F geometry for parting-off, grooving and axial turning, fine and finish machining, and continuous to slightly interrupted cuts.



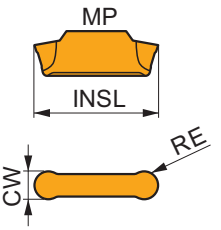
LCMF 083008-F	**T8330**	.031	574	.0098	.039	344	.0091	.039	541	.0098	.039	–	–	–	–	–	–	–	–	–	6755609
LCMF 083012-F	**T8330**	.047	558	.0098	.059	328	.0091	.059	525	.0098	.059	–	–	–	–	–	–	–	–	–	6754256

F geometry for parting-off, grooving and axial turning, fine and finish machining, and continuous to slightly interrupted cuts.

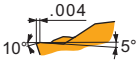
LCMF 16, LCMF 30 - MP

PRAMET

	CW (inch)	CWTOLL (inch)	CWTOLU (inch)	INSL (inch)
0316	.118	-.002	.002	.689
0416	.157	-.002	.002	.693
0516	.197	-.002	.002	.72
0616	.236	-.002	.002	.728
0830	.315	-.002	.002	1.217



Suitability and starting values for cutting speed (vc) and feed (f). Refer to our Machining Calculator app for further calculations.

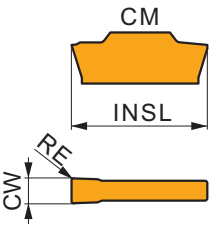
Product	RE (inch)	P vc (ft/min)	P f (in/rev)	P ap (inch)	M vc (ft/min)	M f (in/rev)	M ap (inch)	K vc (ft/min)	K f (in/rev)	K ap (inch)	N vc (ft/min)	N f (in/rev)	N ap (inch)	S vc (ft/min)	S f (in/rev)	S ap (inch)	H vc (ft/min)	H f (in/rev)	H ap (inch)	MID
																				
LCMF 0316MO-MP	**T8330**	.059	623	.0118	.031	361	.0106	.031	591	.0118	.031	–	–	–	–	–	–	–	–	–	6754270
LCMF 0416MO-MP	**T8330**	.079	574	.0157	.039	344	.0142	.039	541	.0157	.039	–	–	–	–	–	–	–	–	–	6754309
	T9325	.079	722	.0157	.039	427	.0142	.039	673	.0157	.039	–	–	–	–	–	–	–	–	–	6754680
LCMF 0516MO-MP	**T8330**	.098	558	.0177	.039	328	.0161	.039	525	.0177	.039	–	–	–	–	–	–	–	–	–	6754312
	T9325	.098	673	.0177	.039	394	.0161	.039	623	.0177	.039	–	–	–	–	–	–	–	–	–	6754685
LCMF 0616MO-MP	**T8330**	.118	541	.0197	.039	312	.0177	.039	509	.0197	.039	–	–	–	–	–	–	–	–	–	6754315
	T9325	.118	656	.0197	.039	394	.0177	.039	623	.0197	.039	–	–	–	–	–	–	–	–	–	6754689
LCMF 0830MO-MP	**T8330**	.157	492	.0236	.047	295	.0213	.047	459	.0236	.047	–	–	–	–	–	–	–	–	–	6755613

MP geometry for longitudinal turning and copy profiling, and continuous to interrupted cuts.

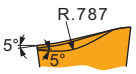
LCMR 16 - CM

PRAMET

	CW	CWTOLL	CWTOLU	INSL
	(inch)	(inch)	(inch)	(inch)
0316	.118	-.002	.002	.646
0416	.157	-.002	.002	.646



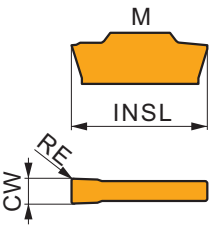
Suitability and starting values for cutting speed (vc) and feed (f). Refer to our Machining Calculator app for further calculations.

Product		RE	P		M		K		N		S		H		PSIRR	PSIRL	MID
			vc (ft/min)	f (in/rev)	vc (ft/min)	f (in/rev)	vc (ft/min)	f (in/rev)	vc (ft/min)	f (in/rev)	vc (ft/min)	f (in/rev)	vc (ft/min)	f (in/rev)	(°)	(°)	
																	
CM geometry, first choice for parting-off and grooving, and continuous to slightly interrupted cuts.																	
LCMR 031602-CM	**T8330**	.008	427	.0043	246	.0039	394	.0043	–	–	–	–	–	–	–	–	6754725
LCMR 041604-CM	**T8330**	.016	427	.0043	246	.0039	394	.0043	–	–	–	–	–	–	–	–	6754726

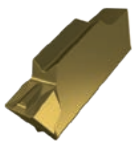
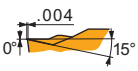
LCMR 16 - M

PRAMET

	CW	CWTOLL	CWTOLU	INSL
	(inch)	(inch)	(inch)	(inch)
0316	.118	-.002	.002	.646
0416	.157	-.002	.002	.646
0516	.197	-.002	.002	.646
0616	.236	-.002	.002	.646



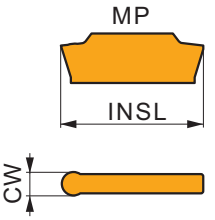
Suitability and starting values for cutting speed (vc) and feed (f). Refer to our Machining Calculator app for further calculations.

Product		RE	P			M			K			N			S			H			MID
			vc (ft/min)	f (in/rev)	ap (inch)	vc (ft/min)	f (in/rev)	ap (inch)	vc (ft/min)	f (in/rev)	ap (inch)	vc (ft/min)	f (in/rev)	ap (inch)	vc (ft/min)	f (in/rev)	ap (inch)	vc (ft/min)	f (in/rev)	ap (inch)	
																					
M geometry for grooving and longitudinal turning, and continuous to interrupted cuts.																					
LCMR 031604-M	**T8330**	.016	558	.0051	.039	328	.0047	.039	525	.0051	.039	–	–	–	–	–	–	98	.0039	.028	6754721
LCMR 041604-M	**T8330**	.016	509	.0071	.039	295	.0063	.039	476	.0071	.039	–	–	–	–	–	–	98	.0047	.031	6754722
LCMR 051604-M	**T8330**	.016	492	.0079	.039	295	.0071	.039	459	.0079	.039	–	–	–	–	–	–	98	.0051	.039	6754723
LCMR 061608-M	**T8330**	.031	574	.0098	.039	344	.0091	.039	541	.0098	.039	–	–	–	–	–	–	115	.0051	.039	6754724

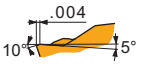
LCMR 16 - MP

PRAMET

	CW	CWTOLL	CWTOLU	INSL
	(inch)	(inch)	(inch)	(inch)
0416	.157	-.002	.002	.689
0616	.236	-.002	.002	.72



Suitability and starting values for cutting speed (vc) and feed (f). Refer to our Machining Calculator app for further calculations.

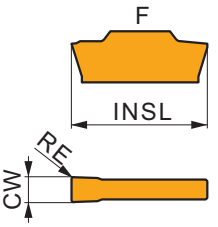
Product		RE	P			M			K			N			S			H			MID
			vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	
		(inch)	(ft/min)	(in/rev)	(inch)	(ft/min)	(in/rev)	(inch)	(ft/min)	(in/rev)	(inch)	(ft/min)	(in/rev)	(inch)	(ft/min)	(in/rev)	(inch)	(ft/min)	(in/rev)	(inch)	
																					
LCMR 0416MO-MP	**T8330**	.079	■	574	.0157	.039	◪	344	.0142	.039	■	541	.0157	.039	–	–	–	–	–	–	–	–	–	6754728
LCMR 0616MO-MP	**T8330**	.118	■	541	.0197	.039	◪	312	.0177	.039	■	509	.0197	.039	–	–	–	–	–	–	–	–	–	6754730

MP geometry for longitudinal turning and copy profiling, and continuous to interrupted cuts.

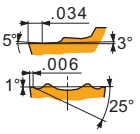
LCMR 16, LCMR 30 - F

PRAMET

	CW	CWTOLL	CWTOLU	INSL
	(inch)	(inch)	(inch)	(inch)
0316	.118	-.002	.002	.646
0416	.157	-.002	.002	.646
0516	.197	-.002	.002	.646
0616	.236	-.002	.002	.646



Suitability and starting values for cutting speed (vc) and feed (f). Refer to our Machining Calculator app for further calculations.

Product		RE	P			M			K			N			S			H			MID
			vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	
		(inch)	(ft/min)	(in/rev)	(inch)	(ft/min)	(in/rev)	(inch)	(ft/min)	(in/rev)	(inch)	(ft/min)	(in/rev)	(inch)	(ft/min)	(in/rev)	(inch)	(ft/min)	(in/rev)	(inch)	
																					
LCMR 031604-F	**T8330**	.016	■	656	.0039	.020	◪	394	.0035	.020	◪	623	.0039	.020	–	–	–	–	–	–	–	–	–	6754717
LCMR 041604-F	**T8330**	.016	■	607	.0051	.020	◪	361	.0047	.020	◪	574	.0051	.020	–	–	–	–	–	–	–	–	–	6754718
LCMR 051604-F	**T8330**	.016	■	591	.0059	.020	◪	344	.0055	.020	◪	558	.0059	.020	–	–	–	–	–	–	–	–	–	6754719
LCMR 061608-F	**T8330**	.031	■	623	.0067	.039	◪	361	.0059	.039	◪	591	.0067	.039	–	–	–	–	–	–	–	–	–	6754720

F geometry for parting-off, grooving and longitudinal turning, fine and finish machining, and continuous to slightly interrupted cuts.

GL – BLADES & ACCESSORIES NAVIGATOR

INSERT SEAT	GL1	GL2	GL3	GL4	GL5	GL6	
Blades H = 1.023; 1.259 in	CDX 16 mm NEW	CDX 35–50 mm	CDX 35–50 mm	CDX 50 mm	CDX 60 mm	CDX 60 mm	
NEW MS Blades		CDX 24 mm	CDX 24 mm	CDX 24 mm	CDX 24 mm	CDX 24 mm	
Cutting width (mm) CW	1.5	2	3 (2.5)	4	5	6	8
NEW **Deep parting-off** (single sided insert)			SINGLE SIDED INSERT PM 1 PR	SINGLE SIDED INSERT PM 1 PR			
Parting-off (tube / full bar)	NEW PM	PM 1 PR	CW = 2.5 / 3 PM 1 PR	PM 1 PR	PM 1 PR	PM 1 PR	
Grooving (deep / shallow)		PR GM	PR GM	PR GM	PR GM	NEW PR GM	GM

MS-EN

IMS-EN

- Modular Tool Holder
- Shank sizes:
  20 × 20, 25 × 25, 32 × 32 mm
  .787 × .787, .984 × .984, 1.259 × 1.259 in

DU, D

IDU, D

- Tool Holder Block
- Shank sizes:
  20 × 20, 25 × 23, 25 × 32, 32 × 29, 25 × 30 mm
  .787 × .787, .984 × .905 , .984 × 1.259, 1.259 × 1.141,
  .984 × 1.181 in

GLS B

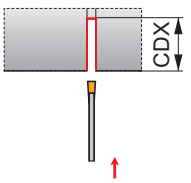
P M K N S H

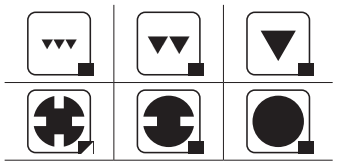
PRAMET

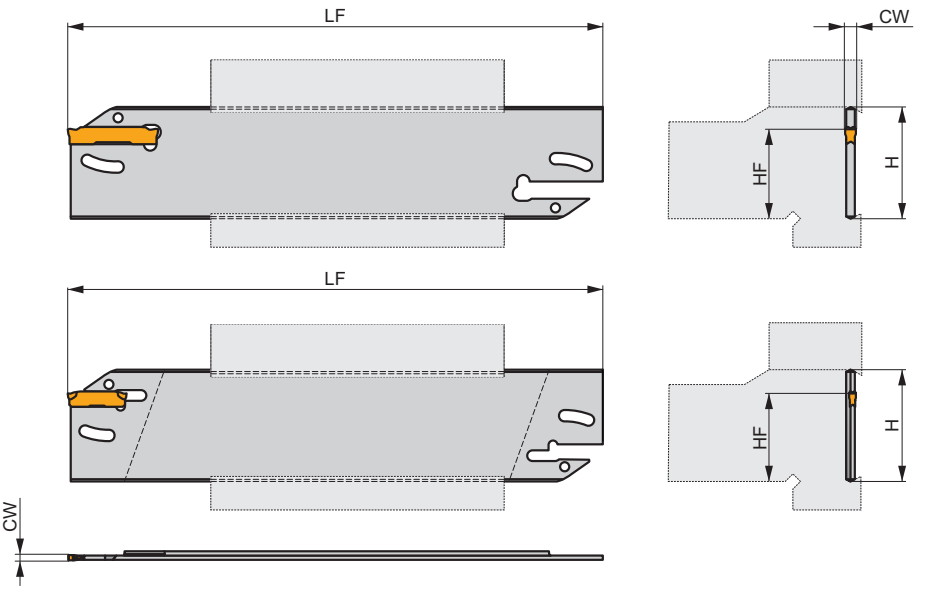
X

Double-Ended Parting-off and Grooving Blade for GL Inserts

Blade for GL inserts, suited for parting-off and grooving applications. Easy inserts replacement by specific key (included in package). Can be fitted into the DU, D tool holder block. Body treated for longer tool life.







	Product	HF (mm)	HF (inch)	H (mm)	H (inch)	LF (mm)	LF (inch)	CW (mm)	CW (inch)	CDX (mm)	CDX (inch)	lbs			MID
R	GL1-S26KBR-16	21.4	.843	26	1.024	125	4.921	1.50	.059	16	.630	.10	GI333	KV2	8462754
	GL1-S32MBR-16	32	1.260	32	1.260	150	5.906	1.50	.059	16	.630	.16	GI333	KV2	8462756
L	GL1-S26KBL-16	21.4	.843	26	1.024	125	4.921	1.50	.059	16	.630	.10	GI333	KV2	8462753
	GL1-S32MBL-16	32	1.260	32	1.260	150	5.906	1.50	.059	16	.630	.16	GI333	KV2	8462755
N	GL2-S26KB	21.4	.843	26	1.024	125	4.921	2.00	.079	35	1.378	.28	GI334	KV2	7803230
	GL2-S32MB	25	.984	32	1.260	150	5.906	2.00	.079	50	1.969	.32	GI334	KV2	7803231
	GL3-S26KB	21.4	.843	26	1.024	125	4.921	3.00	.118	35	1.378	.32	GI335	KV2	7829089
	GL3-S32MB	25	.984	32	1.260	150	5.906	3.00	.118	50	1.969	.33	GI335	KV2	7803241
	GL4-S32MB	25	.984	32	1.260	150	5.906	4.00	.157	50	1.969	.42	GI336	KV2	7803248
	GL5-S32MB	25	.984	32	1.260	150	5.906	5.00	.197	60	2.362	.48	GI337	KV2	7803253
	GL6-S32MB	25	.984	32	1.260	150	5.906	6.00	.236	60	2.362	.55	GI338	KV2	7803258

GI333	GL1..	–
GI334	GL2..	–
GI335	GL3..	–
GI336	GL4..	–
GI337	GL5..	–
GI338	GL6-D600..	GL6-D800..

KV2	KV 15x150

GLS BS

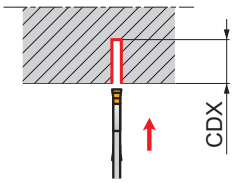
P M K N S H

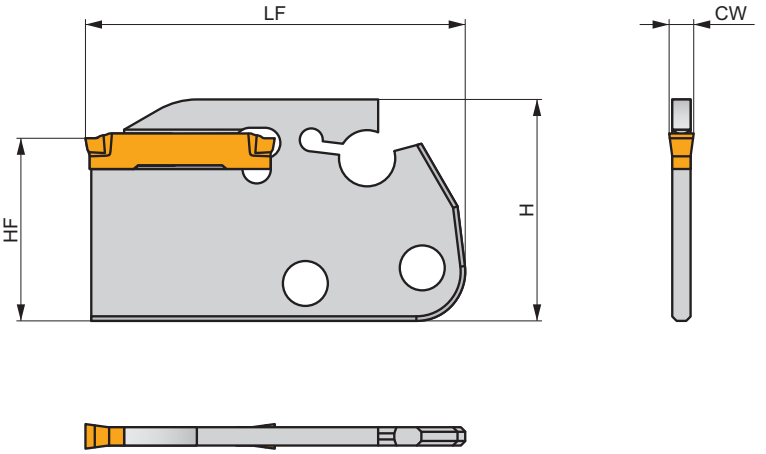
PRAMET

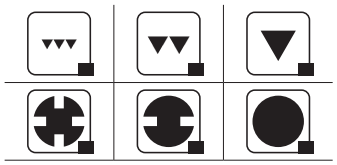
G

Grooving and Parting-off Blade for GL Inserts, for MS-EN Tool Holder

Blade for modular tool holder MS-EN, designed for GL inserts. Suited for grooving and parting-off applications. Blades treated for longer tool life.







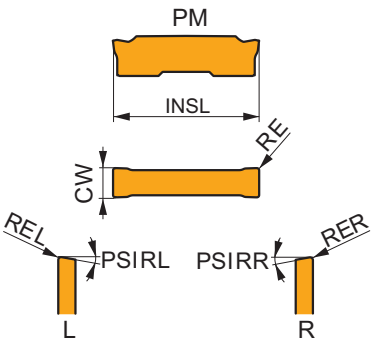
Product	HF (mm)	HF (inch)	H (mm)	H (inch)	LF (mm)	LF (inch)	CW (mm)	CW (inch)	CDX (mm)	CDX (inch)	lbs		MID
GL2-S29CBS	24	.945	29	1.142	50	1.969	2.00	.079	24	.945	.03	GI334	8178802
GL3-S29CBS	24	.945	29	1.142	50	1.969	3.00	.118	24	.945	.04	GI335	8178803
GL4-S29CBS	24	.945	29	1.142	50	1.969	4.00	.157	24	.945	.05	GI336	8178804
GL5-S29CBS	24	.945	29	1.142	50	1.969	5.00	.197	24	.945	.07	GI337	8178805
GL6-S29CBS	24	.945	29	1.142	50	1.969	6.00	.236	24	.945	.09	GI338	8178806

GI334	GL2..	–
GI335	GL3..	–
GI336	GL4..	–
GI337	GL5..	–
GI338	GL6-D600..	GL6-D800..

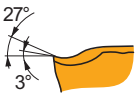
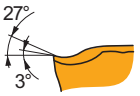
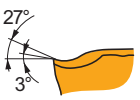
GL. D - PM

PRAMET

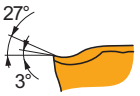
	CW	CWTOLL	CWTOLU	INSL
	(inch)	(inch)	(inch)	(inch)
150	.059	-.002	.002	.65
200	.079	-.002	.002	.984
250	.100	-.002	.002	.984
300	.118	-.002	.002	.984
400	.157	-.002	.002	.984
500	.197	-.002	.002	.984
600	.236	-.002	.002	.984



Suitability and starting values for cutting speed (vc) and feed (f). Refer to our Machining Calculator app for further calculations.

Product		RE	P		M		K		N		S		H		PSIRR	PSIRL	MID
			vc (ft/min)	f (in/rev)	vc (ft/min)	f (in/rev)	vc (ft/min)	f (in/rev)	vc (ft/min)	f (in/rev)	vc (ft/min)	f (in/rev)	vc (ft/min)	f (in/rev)	(°)	(°)	
																	
PM geometry with highly positive rake, first choice for parting-off, and continuous to slightly interrupted cuts.																	
GL1-D150M015-PM	**G8330**	.006	427	.002	246	.002	394	.002	1280	.0024	98	.0016	–	–	–	–	8463342
GL2-D200M02-PM	**G8330**	.008	427	.0031	246	.0028	394	.0031	1280	.0039	98	.0024	–	–	–	–	7802882
	T7325	.008	492	.0031	377	.0028	459	.0031	–	–	148	.0024	–	–	–	–	7802883
GL3-D250G02-PM	**G8330**	.008	427	.0039	246	.0035	394	.0039	1280	.0047	98	.0028	–	–	–	–	7802916
GL3-D300M02-PM	**G8330**	.008	427	.0039	246	.0035	394	.0039	1280	.0047	98	.0028	–	–	–	–	7802917
	T7325	.008	492	.0039	377	.0035	459	.0039	–	–	148	.0028	–	–	–	–	7802918
GL4-D400M02-PM	**G8330**	.008	427	.0047	246	.0043	394	.0047	1280	.0055	98	.0039	–	–	–	–	7802931
	T7325	.008	492	.0047	377	.0043	459	.0047	–	–	148	.0039	–	–	–	–	7802932
GL5-D500M03-PM	**G8330**	.012	427	.0059	246	.0055	394	.0059	1280	.0071	98	.0047	–	–	–	–	7802945
GL6-D600M03-PM	**G8330**	.012	427	.0059	246	.0055	394	.0059	1280	.0071	98	.0047	–	–	–	–	7802947
																	
R-PM right-handed geometry with highly positive rake, first choice for tubes parting-off, and continuous cuts.																	
GL1-D150G015R06-PM	**G8330**	.006	427	.002	246	.002	394	.002	1280	.0024	98	.0016	–	–	6	–	8463344
GL1-D150G015R12-PM	**G8330**	.006	427	.002	246	.002	394	.002	1280	.0024	98	.0016	–	–	12	–	8463346
GL2-D200G02R06-PM	**G8330**	.008	427	.0031	246	.0028	394	.0031	1280	.0039	98	.0024	–	–	6	–	7802887
	T7325	.008	492	.0031	377	.0028	459	.0031	–	–	148	.0024	–	–	6	–	7802889
GL2-D200G02R12-PM	**G8330**	.008	427	.0031	246	.0028	394	.0031	1280	.0039	98	.0024	–	–	12	–	7802885
GL3-D300G02R06-PM	**G8330**	.008	427	.0039	246	.0035	394	.0039	1280	.0047	98	.0028	–	–	6	–	7802922
	T7325	.008	492	.0039	377	.0035	459	.0039	–	–	148	.0028	–	–	6	–	7802924
GL3-D300G02R12-PM	**G8330**	.008	427	.0039	246	.0035	394	.0039	1280	.0047	98	.0028	–	–	12	–	7802920
GL4-D400G02R06-PM	**G8330**	.008	427	.0047	246	.0043	394	.0047	1280	.0055	98	.0039	–	–	6	–	7802936
	T7325	.008	492	.0047	377	.0043	459	.0047	–	–	148	.0039	–	–	6	–	7802938
GL4-D400G02R12-PM	**G8330**	.008	427	.0047	246	.0043	394	.0047	1280	.0055	98	.0039	–	–	12	–	7802934
																	
L-PM left-handed geometry with highly positive rake, first choice for tubes parting-off, and continuous cuts.																	
GL1-D150G015L06-PM	**G8330**	.006	427	.002	246	.002	394	.002	1280	.0024	98	.0016	–	–	–	6	8463343
GL1-D150G015L12-PM	**G8330**	.006	427	.002	246	.002	394	.002	1280	.0024	98	.0016	–	–	–	12	8463345
GL2-D200G02L06-PM	**G8330**	.008	427	.0031	246	.0028	394	.0031	1280	.0039	98	.0024	–	–	–	6	7802886
	T7325	.008	492	.0031	377	.0028	459	.0031	–	–	148	.0024	–	–	–	6	7802888
GL2-D200G02L12-PM	**G8330**	.008	427	.0031	246	.0028	394	.0031	1280	.0039	98	.0024	–	–	–	12	7802884

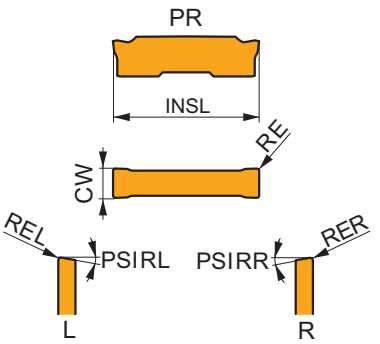
Suitability and starting values for cutting speed (vc) and feed (f). Refer to our Machining Calculator app for further calculations.

Product		RE	P		M		K		N		S		H		PSIRR	PSIRL	MID
			vc (ft/min)	f (in/rev)	vc (ft/min)	f (in/rev)	vc (ft/min)	f (in/rev)	vc (ft/min)	f (in/rev)	vc (ft/min)	f (in/rev)	vc (ft/min)	f (in/rev)	(°)	(°)	
																	
L-PM left-handed geometry with highly positive rake, first choice for tubes parting-off, and continuous cuts.																	
GL3-D300G02L06-PM	**G8330**	.008	■ 427	.0039	■ 246	.0035	◪ 394	.0039	◪ 1280	.0047	◪ 98	.0028	–	–	–	6	7802921
	T7325	.008	◪ 492	.0039	■ 377	.0035	◪ 459	.0039	–	–	◪ 148	.0028	–	–	–	6	7802923
GL3-D300G02L12-PM	**G8330**	.008	■ 427	.0039	■ 246	.0035	◪ 394	.0039	◪ 1280	.0047	◪ 98	.0028	–	–	–	12	7802919
GL4-D400G02L06-PM	**G8330**	.008	■ 427	.0047	■ 246	.0043	◪ 394	.0047	◪ 1280	.0055	◪ 98	.0039	–	–	–	6	7802935
	T7325	.008	◪ 492	.0047	■ 377	.0043	◪ 459	.0047	–	–	◪ 148	.0039	–	–	–	6	7802937
GL4-D400G02L12-PM	**G8330**	.008	■ 427	.0047	■ 246	.0043	◪ 394	.0047	◪ 1280	.0055	◪ 98	.0039	–	–	–	12	7802933

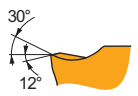
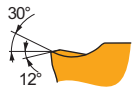
GL. D - PR

PRAMET

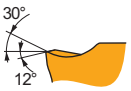
	CW (inch)	CWTOLL (inch)	CWTOLU (inch)	INSL (inch)
200	.079	-.002	.002	.984
300	.118	-.002	.002	.984
400	.157	-.002	.002	.984
500	.197	-.002	.002	.984
600	.236	-.002	.002	.984



Suitability and starting values for cutting speed (vc) and feed (f). Refer to our Machining Calculator app for further calculations.

Product		RE	P		M		K		N		S		H		PSIRR	PSIRL	MID
			vc (ft/min)	f (in/rev)	vc (ft/min)	f (in/rev)	vc (ft/min)	f (in/rev)	vc (ft/min)	f (in/rev)	vc (ft/min)	f (in/rev)	vc (ft/min)	f (in/rev)	(°)	(°)	
																	
PR geometry with negative T-land, first choice for difficult grooving and parting-off, and continuous to interrupted cuts.																	
GL2-D200M02-PR	**G8330**	.008	■ 427	.0039	◪ 246	.0035	■ 394	.0039	–	–	–	–	–	–	–	–	7802910
	T7325	.008	◪ 492	.0039	◪ 377	.0035	■ 459	.0039	–	–	–	–	–	–	–	–	7802911
GL3-D300M02-PR	**G8330**	.008	■ 427	.0047	◪ 246	.0043	■ 394	.0047	–	–	–	–	–	–	–	–	7802925
	T7325	.008	◪ 492	.0047	◪ 377	.0043	■ 459	.0047	–	–	–	–	–	–	–	–	7802926
GL4-D400M02-PR	**G8330**	.008	■ 427	.0059	◪ 246	.0055	■ 394	.0059	–	–	–	–	–	–	–	–	7802939
	T7325	.008	◪ 492	.0059	◪ 377	.0055	■ 459	.0059	–	–	–	–	–	–	–	–	7802940
GL5-D500M04-PR	**G8330**	.016	■ 427	.0071	◪ 246	.0063	■ 394	.0071	–	–	–	–	–	–	–	–	7802946
GL6-D600M04-PR	**G8330**	.016	■ 427	.0071	◪ 246	.0063	■ 394	.0071	–	–	–	–	–	–	–	–	7802948
																	
R-PR right-handed geometry with negative T-land, first choice for difficult bars parting-off, and continuous to interrupted cuts.																	
GL2-D200G02R06-PR	**G8330**	.008	■ 427	.0039	◪ 246	.0035	■ 394	.0039	–	–	–	–	–	–	6	–	7802913
GL2-D200G02R12-PR	**G8330**	.008	■ 427	.0039	◪ 246	.0035	■ 394	.0039	–	–	–	–	–	–	12	–	7802915
GL3-D300G02R06-PR	**G8330**	.008	■ 427	.0047	◪ 246	.0043	■ 394	.0047	–	–	–	–	–	–	6	–	7802928
GL3-D300G02R12-PR	**G8330**	.008	■ 427	.0047	◪ 246	.0043	■ 394	.0047	–	–	–	–	–	–	12	–	7802930
GL4-D400G02R06-PR	**G8330**	.008	■ 427	.0059	◪ 246	.0055	■ 394	.0059	–	–	–	–	–	–	6	–	7802942
GL4-D400G02R12-PR	**G8330**	.008	■ 427	.0059	◪ 246	.0055	■ 394	.0059	–	–	–	–	–	–	12	–	7802944

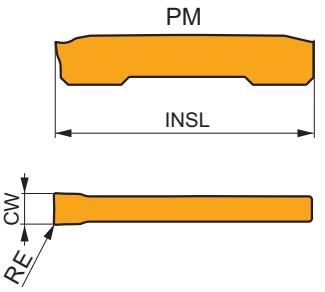
Suitability and starting values for cutting speed (vc) and feed (f). Refer to our Machining Calculator app for further calculations.

Product		RE	P		M		K		N		S		H		PSIRR	PSIRL	MID
			vc (ft/min)	f (in/rev)	vc (ft/min)	f (in/rev)	vc (ft/min)	f (in/rev)	vc (ft/min)	f (in/rev)	vc (ft/min)	f (in/rev)	vc (ft/min)	f (in/rev)	(°)	(°)	
		(inch)															
																	
L-PR left-handed geometry with negative T-land, first choice for difficult bars parting-off, and continuous to interrupted cuts.																	
GL2-D200G02L06-PR	**G8330**	.008	427	.0039	246	.0035	394	.0039	–	–	–	–	–	–	–	6	7802912
GL2-D200G02L12-PR	**G8330**	.008	427	.0039	246	.0035	394	.0039	–	–	–	–	–	–	–	12	7802914
GL3-D300G02L06-PR	**G8330**	.008	427	.0047	246	.0043	394	.0047	–	–	–	–	–	–	–	6	7802927
GL3-D300G02L12-PR	**G8330**	.008	427	.0047	246	.0043	394	.0047	–	–	–	–	–	–	–	12	7802929
GL4-D400G02L06-PR	**G8330**	.008	427	.0059	246	.0055	394	.0059	–	–	–	–	–	–	–	6	7802941
GL4-D400G02L12-PR	**G8330**	.008	427	.0059	246	.0055	394	.0059	–	–	–	–	–	–	–	12	7802943

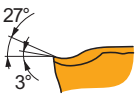
GL. S - PM

PRAMET

	CW	CWTOLL	CWTOLU	INSL
	(inch)	(inch)	(inch)	(inch)
300	.118	-.002	.002	.965
400	.157	-.002	.002	.957



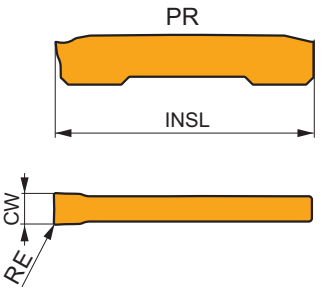
Suitability and starting values for cutting speed (vc) and feed (f). Refer to our Machining Calculator app for further calculations.

Product		RE	P		M		K		N		S		H		PSIRR	PSIRL	MID
			vc (ft/min)	f (in/rev)	vc (ft/min)	f (in/rev)	vc (ft/min)	f (in/rev)	vc (ft/min)	f (in/rev)	vc (ft/min)	f (in/rev)	vc (ft/min)	f (in/rev)	(°)	(°)	
		(inch)															
																	
PM geometry with highly positive rake on single sided insert, first choice for deep parting-off, and continuous to slightly interrupted cuts.																	
GL3-S300M02-PM	**G8330**	.008	427	.0039	246	.0035	394	.0039	1280	.0047	98	.0028	–	–	–	–	8178695
GL4-S400M02-PM	**G8330**	.008	427	.0047	246	.0043	394	.0047	1280	.0055	98	.0039	–	–	–	–	8178697

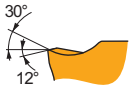
GL. S - PR

PRAMET

	CW	CWTOLL	CWTOLU	INSL
	(inch)	(inch)	(inch)	(inch)
300	.118	-.002	.002	.965
400	.157	-.002	.002	.957



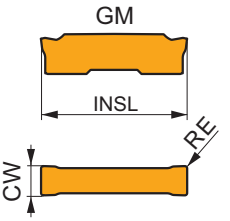
Suitability and starting values for cutting speed (vc) and feed (f). Refer to our Machining Calculator app for further calculations.

Product		RE	P		M		K		N		S		H		PSIRR	PSIRL	MID
			vc (ft/min)	f (in/rev)	vc (ft/min)	f (in/rev)	vc (ft/min)	f (in/rev)	vc (ft/min)	f (in/rev)	vc (ft/min)	f (in/rev)	vc (ft/min)	f (in/rev)	(°)	(°)	
		(inch)															
			**PR** geometry with negative T-land on single sided insert, first choice for difficult deep grooving and parting-off, and continuous to interrupted cuts.														
GL3-S300M02-PR	**G8330**	.008	427	.0047	246	.0043	394	.0047	–	–	–	–	–	–	–	–	8178696
GL4-S400M02-PR	**G8330**	.008	427	.0059	246	.0055	394	.0059	–	–	–	–	–	–	–	–	8178698

GL. D - GM

PRAMET

	CW	CWTOLL	CWTOLU	INSL
	(inch)	(inch)	(inch)	(inch)
200	.079	-.002	.002	.984
300	.118	-.002	.002	.984
400	.157	-.002	.002	.984
500	.197	-.002	.002	.984
600	.236	-.002	.002	.984
800	.315	-.002	.002	.984



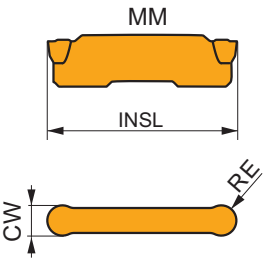
Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

Product		RE	P			M			K			N			S			H			MID
			vc (ft/min)	f (in/rev)	ap (inch)	vc (ft/min)	f (in/rev)	ap (inch)	vc (ft/min)	f (in/rev)	ap (inch)	vc (ft/min)	f (in/rev)	ap (inch)	vc (ft/min)	f (in/rev)	ap (inch)	vc (ft/min)	f (in/rev)	ap (inch)	
		(inch)																			
			GM versatile geometry for grooving and longitudinal turning, and continuous to interrupted cuts.																		
GL2-D200M02-GM	**G8330**	.008	623	.0039	.031	361	.0035	.031	591	.0039	.031	–	–	–	148	.0031	.024	–	–	–	8023038
	T7325	.008	722	.0039	.031	558	.0035	.031	673	.0039	.031	–	–	–	230	.0031	.024	–	–	–	8023039
GL3-D300M02-GM	**G8330**	.008	492	.0079	.039	295	.0071	.039	459	.0079	.039	–	–	–	115	.0055	.031	–	–	–	8022955
	T7325	.008	574	.0079	.039	443	.0071	.039	541	.0079	.039	–	–	–	180	.0055	.031	–	–	–	8022956
GL3-D300M04-GM	**G8330**	.016	525	.0079	.039	312	.0071	.039	492	.0079	.039	–	–	–	131	.0055	.031	–	–	–	7983471
	T7325	.016	607	.0079	.039	459	.0071	.039	574	.0079	.039	–	–	–	197	.0055	.031	–	–	–	7983472
GL4-D400M04-GM	**G8330**	.016	492	.0098	.047	295	.0091	.047	459	.0098	.047	–	–	–	115	.0071	.039	–	–	–	7983475
	T7325	.016	558	.0098	.047	427	.0091	.047	525	.0098	.047	–	–	–	180	.0071	.039	–	–	–	7983476
GL4-D400M08-GM	**G8330**	.031	591	.0098	.047	344	.0091	.047	558	.0098	.047	–	–	–	148	.0071	.039	–	–	–	8022957
	T7325	.031	656	.0098	.047	509	.0091	.047	623	.0098	.047	–	–	–	213	.0071	.039	–	–	–	8022958
GL5-D500M08-GM	**G8330**	.031	558	.0118	.047	328	.0106	.047	525	.0118	.047	–	–	–	131	.0083	.039	–	–	–	8023030
	T7325	.031	623	.0118	.047	476	.0106	.047	591	.0118	.047	–	–	–	197	.0083	.039	–	–	–	8023031
GL6-D600M08-GM	**G8330**	.031	558	.0118	.047	328	.0106	.047	525	.0118	.047	–	–	–	131	.0083	.039	–	–	–	8023034
	T7325	.031	623	.0118	.047	476	.0106	.047	591	.0118	.047	–	–	–	197	.0083	.039	–	–	–	8023035
GL6-D800M08-GM	**G8330** [1)]	.031	558	.0118	.047	328	.0106	.047	525	.0118	.047	–	–	–	131	.0083	.047	–	–	–	8463347

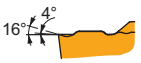
[1)] Usable only in holders with CDX ≥ 24.

GL. D - MM

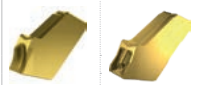
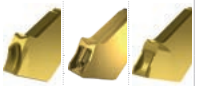
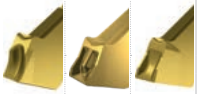
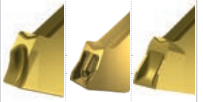
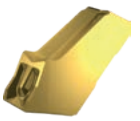
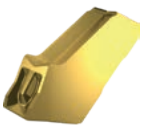
	CW	CWTOLL	CWTOLU	INSL
	(inch)	(inch)	(inch)	(inch)
200	.079	-.002	.002	.984
300	.118	-.002	.002	.984
400	.157	-.002	.002	.984
500	.197	-.002	.002	1.024
600	.236	-.002	.002	1.024

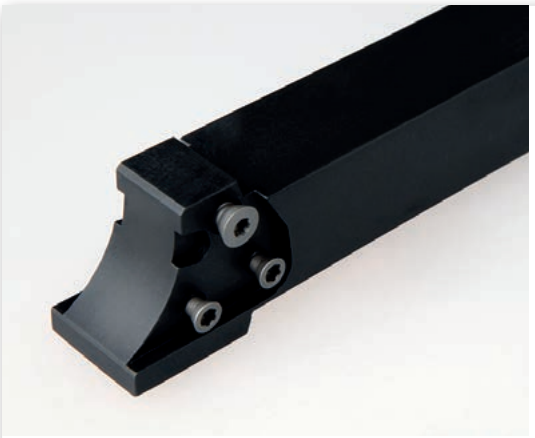


Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

Product		RE	P			M			K			N			S			H			MID
			vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	
		(inch)	(ft/min)	(in/rev)	(inch)	(ft/min)	(in/rev)	(inch)	(ft/min)	(in/rev)	(inch)	(ft/min)	(in/rev)	(inch)	(ft/min)	(in/rev)	(inch)	(ft/min)	(in/rev)	(inch)	
			**MM** geometry, with full radius shape for copy profiling and longitudinal turning, and continuous to interrupted cuts.																		
GL2-D200MM0-MM	**G8330**	.039	■ 820	.0039	.039	■ 492	.0035	.039	■ 771	.0039	.039	–	–	–	◪ 197	.0031	.031	–	–	–	8023060
	T7325	.039	◪ 935	.0039	.039	■ 722	.0035	.039	■ 886	.0039	.039	–	–	–	◪ 295	.0031	.031	–	–	–	8023061
GL3-D300MM0-MM	**G8330**	.059	■ 689	.0079	.047	■ 410	.0071	.047	■ 640	.0079	.047	–	–	–	◪ 164	.0055	.039	–	–	–	7983473
	T7325	.059	◪ 787	.0079	.047	■ 607	.0071	.047	■ 738	.0079	.047	–	–	–	◪ 246	.0055	.039	–	–	–	7983474
GL4-D400MM0-MM	**G8330**	.079	■ 722	.0079	.047	■ 427	.0071	.047	■ 673	.0079	.047	–	–	–	◪ 180	.0055	.039	–	–	–	7983477
	T7325	.079	◪ 820	.0079	.047	■ 640	.0071	.047	■ 771	.0079	.047	–	–	–	◪ 262	.0055	.039	–	–	–	7983478
GL5-D500MM0-MM	**G8330**	.098	■ 673	.0098	.047	■ 394	.0091	.047	■ 623	.0098	.047	–	–	–	◪ 164	.0071	.039	–	–	–	8023032
	T7325	.098	◪ 771	.0098	.047	■ 591	.0091	.047	■ 722	.0098	.047	–	–	–	◪ 246	.0071	.039	–	–	–	8023033
GL6-D600MM0-MM	**G8330**	.118	■ 640	.0118	.047	■ 377	.0106	.047	■ 607	.0118	.047	–	–	–	◪ 148	.0083	.039	–	–	–	8023036
	T7325	.118	◪ 722	.0118	.047	■ 558	.0106	.047	■ 673	.0118	.047	–	–	–	◪ 230	.0083	.039	–	–	–	8023037

LFMX – BLADES & ACCESSORIES NAVIGATOR

INSERT SEAT	1.60	2.00	3.00	4.00	5.00	6.35
XLCFN B Blades H = 26 mm H = 32; 45 mm						
XLCF(NRL) BS MS Blades						
Cutting width (mm) CW	1.5 / 1.6	2.0 / 2.2	3.1	4.1	5.1	6.35
Parting-off inserts (sharp / with T-land)	 F1 F2	 F1 F2 M2	 F1 F2 M2	 F1 F2 M2	 F2	 F2



MS-EN IMS-EN

- Modular Tool Holder
- Shank sizes:
  20 × 20, 25 × 25, 32 × 32 mm
  .787 × .787, .984 × .984, 1.259 × 1.259 in

DU, D IDU, D

- Tool Holder Block
- Shank sizes:
  20 × 20, 25 × 23, 25 × 32, 32 × 29, 25 × 30 mm
  .787 × .787, .984 × .905 , .984 × 1.259, 1.259 × 1.141,
  .984 × 1.181 in

XLCFN B

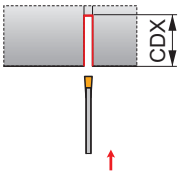
P M K N S H

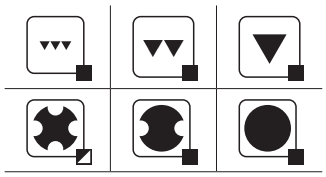
PRAMET

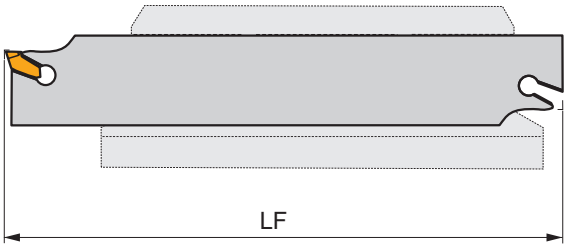
X

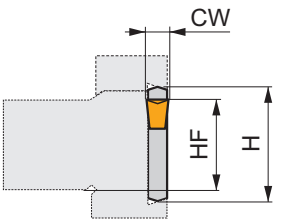
Double-Ended Parting-off Blade for LFMX Inserts

Blade for parting-off applications Suited for single-sided LFMX inserts. Can be fitted into the DU Pramet basic holders. Blade treated for longer tool life.









	Product	HF (mm)	H (mm)	LF (mm)	CW (mm)	CDX (mm)	lbs			MID
N	**XLCFN 2601 J 1.60**	21.4	26	110	1.50	15	.12	GI132	KV	6757901
	XLCFN 2601 J 2.00	21.4	26	110	2.00	25	.16	GI061	KV	6756839
	XLCFN 2602 J 3.00	21.4	26	110	3.10	37.5	.17	GI001	KV	6756324
	XLCFN 2603 J 4.00	21.4	26	110	4.10	40	.22	GI002	KV	6756325
	XLCFN 3201 M 1.60	25	32	150	1.50	15	.24	GI132	KV	6757902
	XLCFN 3201 M 2.00	25	32	150	2.00	25	.24	GI061	KV	6757081
	XLCFN 3202 M 3.00	25	32	150	3.10	50	.18	GI001	KV	6756326
	XLCFN 3203 M 4.00	25	32	150	4.10	50	.32	GI002	KV	6756327
	XLCFN 3204 M 5.00	25	32	150	5.10	60	.39	GI004	KV	6756333
	XLCFN 3205 M 6.35	25	32	150	6.35	60	.45	GI005	KV	6756334
	XLCFN 4502 S 3.00	32	45	250	3.10	80	.44	GI001	KV	6756568
	XLCFN 4503 S 4.00	32	45	250	4.10	80	.74	GI002	KV	6756569
	XLCFN 4504 S 5.00	32	45	250	5.10	80	.91	GI004	KV	6756570
	XLCFN 4505 S 6.35	32	45	250	6.35	80	1.06	GI005	KV	6756571

GI001	LFMX 3.1-.	–
GI002	LFMX 4.1-.	–
GI004	LFMX 5.1-.	–
GI005	LFMX 6.35-.	–
GI061	LFMX 2.0-.	LFMX 2.2-.
GI132	LFMX 1.5-.	LFMX 1.6-.

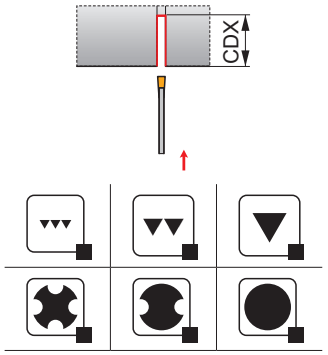
KV	KV 5x70

XLCF(NRL) BS

P M K N S H

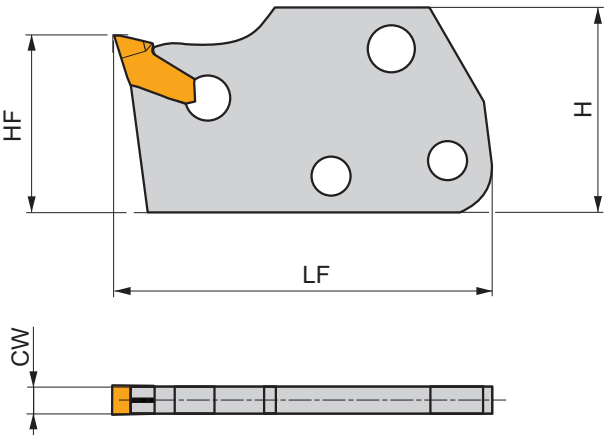
PRAMET

X



Radial Grooving Blade for Modular MS-EN Tool Holder for LFMX Inserts

Modular grooving blade for grooving with single-sided LFMX inserts. Suited for grooving or parting-off (max. 25 mm cutting depth) applications. Blades treated for longer tool life.



	Product	HF (mm)	H (mm)	LF (mm)	CW (mm)	CDX (mm)	lbs			MID
R	XLCFR 160115-1.60	12	25	35	1.50	15	.07	GI132	KV	6757897
	XLCFR 160115-2.00	12	25	35	2.00	15	.08	GI061	KV	6757077
	XLCFR 250115-1.60	24	29	40	1.50	15	.02	GI132	KV	6757899
	XLCFR 250115-2.00	24	29	40	2.00	15	.10	GI061	KV	6757079
L	XLCFL 160115-1.60	12	25	35	1.50	15	.07	GI132	KV	6757898
	XLCFL 160115-2.00	12	25	35	2.00	15	.08	GI061	KV	6757078
	XLCFL 250115-1.60	24	29	40	1.50	15	.09	GI132	KV	6757900
	XLCFL 250115-2.00	24	29	40	2.00	15	.10	GI061	KV	6757080
N	XLCFN 160215-3.00	12	25	35	3.10	15	.02	GI001	KV	6756565
	XLCFN 160220-3.00	12	25	40	3.10	20	.10	GI001	KV	6756337
	XLCFN 250215-3.00	24	29	40	3.10	15	.09	GI001	KV	6756566
	XLCFN 250225-3.00	24	29	50	3.10	25	.11	GI001	KV	6756322
	XLCFN 250315-4.00	24	29	40	4.10	15	.10	GI002	KV	6756567
	XLCFN 250325-4.00	24	29	50	4.10	25	.09	GI002	KV	6756323
	XLCFN 250425-5.00	24	29	50	5.10	25	.10	GI004	KV	6756331
	XLCFN 250525-6.35	24	29	50	6.35	25	.15	GI005	KV	6756332

GI001	LFMX 3.1-.	–
GI002	LFMX 4.1-.	–
GI004	LFMX 5.1-.	–
GI005	LFMX 6.35-.	–

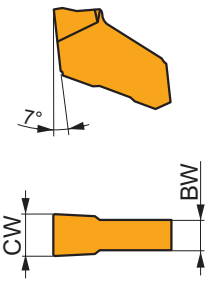
GI061	LFMX 2.0-.	LFMX 2.2-.
GI132	LFMX 1.5-.	LFMX 1.6-.

KV	KV 5x70

LFMX - F1

PRAMET

	CW	CWTOLL	CWTOLU	
	(inch)	(inch)	(inch)	
1.5	.059	-.001	.001	.051
1.6	.063	-.001	.001	.051
2.0	.079	-.001	.001	.063
3.1	.122	-.002	.002	.102
4.1	.161	-.002	.002	.142



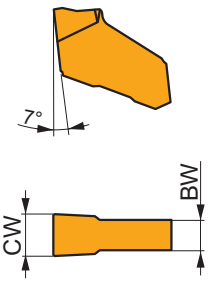
Suitability and starting values for cutting speed (vc) and feed (f). Refer to our Machining Calculator app for further calculations.

Product		RE	P		M		K		N		S		H		PSIRR	PSIRL	MID
			vc	f	vc	f	vc	f	vc	f	vc	f	vc	f			
		(inch)	(ft/min)	(in/rev)	(ft/min)	(in/rev)	(ft/min)	(in/rev)	(ft/min)	(in/rev)	(ft/min)	(in/rev)	(ft/min)	(in/rev)	(°)	(°)	
F1 eN-geometry for parting-off and grooving, and continuous cuts.																	
LFMX 1.5-.16ENF1	**T8330**	.006	427	.0031	246	.0028	394	.0031	–	–	–	–	–	–	–	–	6755607
LFMX 1.6-.16ENF1	**T8330**	.006	427	.0031	246	.0028	394	.0031	–	–	–	–	–	–	–	–	6755608
LFMX 2.0-.16ENF1	**T8330**	.006	427	.0031	246	.0028	394	.0031	–	–	–	–	–	–	–	–	6754321
LFMX 3.1-.20ENF1	**T8330**	.008	427	.0039	246	.0035	394	.0039	–	–	–	–	–	–	–	–	6754336
LFMX 4.1-.20ENF1	**T8330**	.008	427	.0039	246	.0035	394	.0039	–	–	–	–	–	–	–	–	6754343

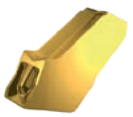
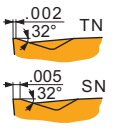
LFMX - F2

PRAMET

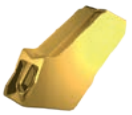
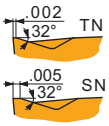
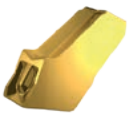
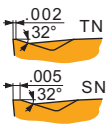
	CW	CWTOLL	CWTOLU	
	(inch)	(inch)	(inch)	
1.6	.063	-.001	.001	.051
2.0	.079	-.001	.001	.063
3.1	.122	-.002	.002	.102
4.1	.161	-.002	.002	.142
5.1	.201	-.002	.002	.181
6.35	.250	-.002	.002	.228



Suitability and starting values for cutting speed (vc) and feed (f). Refer to our Machining Calculator app for further calculations.

Product		RE	P		M		K		N		S		H		PSIRR	PSIRL	MID
			vc	f	vc	f	vc	f	vc	f	vc	f	vc	f			
		(inch)	(ft/min)	(in/rev)	(ft/min)	(in/rev)	(ft/min)	(in/rev)	(ft/min)	(in/rev)	(ft/min)	(in/rev)	(ft/min)	(in/rev)	(°)	(°)	
																	
SN-F2 geometry for parting-off and grooving, and continuous cuts.																	
LFMX 1.6-.16SNF2	**T8330**	.006	427	.0039	246	.0035	394	.0039	–	–	–	–	–	–	–	–	6754320
LFMX 2.0-.16SNF2	**6640**	.006	492	.0039	295	.0035	459	.0039	–	–	–	–	–	–	–	–	6752157
	T8330	.006	427	.0039	246	.0035	394	.0039	–	–	–	–	–	–	–	–	6754324
LFMX 3.1-.20SNF2	**6640**	.008	492	.0039	295	.0035	459	.0039	–	–	–	–	–	–	–	–	6752366
	T8330	.008	427	.0039	246	.0035	394	.0039	–	–	–	–	–	–	–	–	6754338
LFMX 4.1-.20SNF2	**T8330**	.008	427	.0047	246	.0043	394	.0047	–	–	–	–	–	–	–	–	6754345

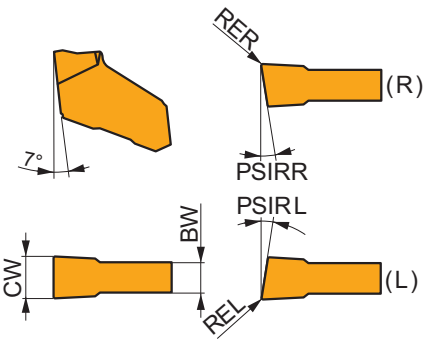
Suitability and starting values for cutting speed (vc) and feed (f). Refer to our Machining Calculator app for further calculations.

Product		RE	P vc (ft/min)	P f (in/rev)	M vc (ft/min)	M f (in/rev)	K vc (ft/min)	K f (in/rev)	N vc (ft/min)	N f (in/rev)	S vc (ft/min)	S f (in/rev)	H vc (ft/min)	H f (in/rev)	PSIRR (°)	PSIRL (°)	MID
																	
			SN-F2 geometry for parting-off and grooving, and continuous cuts.														
LFMX 5.1-.20SNF2	**T8330**	.008	427	.0047	246	.0043	394	.0047	–	–	–	–	–	–	–	–	6754350
LFMX 6.35-.20SNF2	**T8330**	.008	427	.0059	246	.0055	394	.0059	–	–	–	–	–	–	–	–	6754352
																	
			TN-F2 geometry for parting-off and grooving, and continuous cuts.														
LFMX 3.1-.20TNF2	**6640**	.008	492	.0039	295	.0035	459	.0039	–	–	–	–	–	–	–	–	6752368
	T8330	.008	427	.0039	246	.0035	394	.0039	–	–	–	–	–	–	–	–	6754341
LFMX 4.1-.20TNF2	**T8330**	.008	427	.0047	246	.0043	394	.0047	–	–	–	–	–	–	–	–	6754348

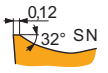
LFMX - M2

PRAMET

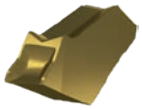
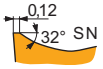
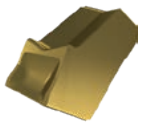
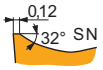
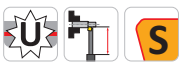
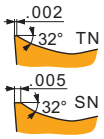
	CW (inch)	CWTOLL (inch)	CWTOLU (inch)	
2.0	.079	-.001	.001	.063
2.2	.087	-.001	.001	.063
3.1	.122	-.002	.002	.102
4.1	.161	-.002	.002	.142
5.1	.201	-.002	.002	.181
6.35	.250	-.002	.002	.228



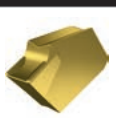
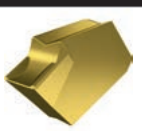
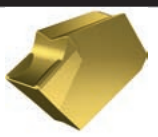
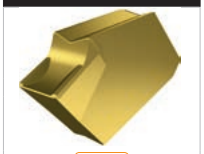
Suitability and starting values for cutting speed (vc) and feed (f). Refer to our Machining Calculator app for further calculations.

Product		RE	P vc (ft/min)	P f (in/rev)	M vc (ft/min)	M f (in/rev)	K vc (ft/min)	K f (in/rev)	N vc (ft/min)	N f (in/rev)	S vc (ft/min)	S f (in/rev)	H vc (ft/min)	H f (in/rev)	PSIRR (°)	PSIRL (°)	MID
																	
			SN-M2 geometry for parting-off and grooving, and continuous to slightly interrupted cuts.														
LFMX 2.0-.16SNM2	**6640**	.006	492	.0043	295	.0039	459	.0043	–	–	–	–	–	–	–	–	6752158
	T8330	.006	427	.0043	246	.0039	394	.0043	–	–	–	–	–	–	–	–	6754325
LFMX 2.2-.16SNM2	**6640**	.006	492	.0043	295	.0039	459	.0043	–	–	–	–	–	–	–	–	6752023
	T8330	.006	427	.0043	246	.0039	394	.0043	–	–	–	–	–	–	–	–	6754335
LFMX 3.1-.20SNM2	**6640**	.008	492	.0059	295	.0055	459	.0059	–	–	–	–	–	–	–	–	6752416
	T8330	.008	427	.0059	246	.0055	394	.0059	–	–	–	–	–	–	–	–	6754339
LFMX 4.1-.20SNM2	**6640**	.008	492	.0059	295	.0055	459	.0059	–	–	–	–	–	–	–	–	6752419
	T8330	.008	427	.0059	246	.0055	394	.0059	–	–	–	–	–	–	–	–	6754346
LFMX 5.1-.20SNM2	**6640**	.008	492	.0079	295	.0071	459	.0079	–	–	–	–	–	–	–	–	6752009
	T8330	.008	427	.0079	246	.0071	394	.0079	–	–	–	–	–	–	–	–	6754351
LFMX 6.35-.20SNM2	**6640**	.008	492	.0079	295	.0071	459	.0079	–	–	–	–	–	–	–	–	6752010
	T8330	.008	427	.0079	246	.0071	394	.0079	–	–	–	–	–	–	–	–	6754353

Suitability and starting values for cutting speed (vc) and feed (f). Refer to our Machining Calculator app for further calculations.

Product		RE	P		M		K		N		S		H		PSIRR	PSIRL	MID
			vc (ft/min)	f (in/rev)	vc (ft/min)	f (in/rev)	vc (ft/min)	f (in/rev)	vc (ft/min)	f (in/rev)	vc (ft/min)	f (in/rev)	vc (ft/min)	f (in/rev)	(°)	(°)	
																	
SR-M2 geometry, with right-handed design, for parting-off, and continuous to slightly interrupted cuts.																	
LFMX 2.0-.16SR12M2	**T8330**	.006	427	.0035	246	.0031	394	.0035	–	–	–	–	–	–	12	–	6754326
LFMX 2.0-.16SR6M2	**T8330**	.006	427	.0035	246	.0031	394	.0035	–	–	–	–	–	–	6	–	6754334
LFMX 3.1-.20SR8M2	**T8330**	.008	427	.0043	246	.0039	394	.0043	–	–	–	–	–	–	8	–	6754340
LFMX 4.1-.20SR8M2	**T8330**	.008	427	.0059	246	.0055	394	.0059	–	–	–	–	–	–	8	–	6754347
																	
SL-M2 geometry, with left-handed design, for parting-off, and continuous to slightly interrupted cuts.																	
LFMX 2.0-.16SL12M2	**T8330**	.006	427	.0035	246	.0031	394	.0035	–	–	–	–	–	–	–	12	6754322
LFMX 2.0-.16SL6M2	**T8330**	.006	427	.0035	246	.0031	394	.0035	–	–	–	–	–	–	–	6	6754323
LFMX 3.1-.20SL8M2	**T8330**	.008	427	.0043	246	.0039	394	.0043	–	–	–	–	–	–	–	8	6754337
LFMX 4.1-.20SL8M2	**T8330**	.008	427	.0059	246	.0055	394	.0059	–	–	–	–	–	–	–	8	6754344
																	
TN-M2 geometry for parting-off and grooving, and continuous to slightly interrupted cuts.																	
LFMX 3.1-.20TNM2	**6640**	.008	492	.0059	295	.0055	459	.0059	–	–	–	–	–	–	–	–	6752417
	T8330	.008	427	.0059	246	.0055	394	.0059	–	–	–	–	–	–	–	–	6754342
LFMX 4.1-.20TNM2	**6640**	.008	492	.0059	295	.0055	459	.0059	–	–	–	–	–	–	–	–	6752418
	T8330	.008	427	.0059	246	.0055	394	.0059	–	–	–	–	–	–	–	–	6754349

LFUX – BLADES & ACCESSORIES NAVIGATOR

INSERT SEAT	03	04	05	06		
XLCFN B LFUX Blades H = 26 mm H = 32; 47 mm						
Cutting width (mm) CW	3	4	5			
Parting-off inserts	 LFUX	 LFUX	 LFUX	 LFUX		

DU, D

IDU, D

- Tool Holder Block
- Shank sizes:
  20 × 20, 25 × 23, 25 × 32, 32 × 29, 25 × 30 mm
  .787 × .787, .984 × .905 , .984 × 1.259, 1.259 × 1.141,
  .984 × 1.181 in

XLCFN B LFUX

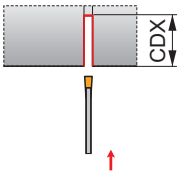
P M K N S H

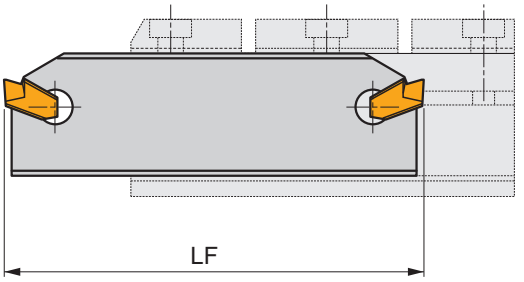
PRAMET

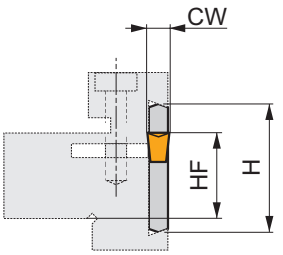
X

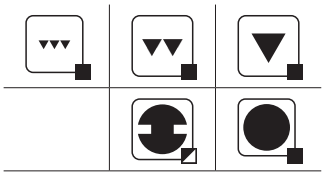
Double-Ended Parting-off Blade for LFUX Inserts

Blade for parting-off applications Suited for single sided LFUX inserts. Available in heights of 26, 32 or 47 mm. Can be fitted into the DU, D Pramet basic holders. Blade treated for longer tool life.









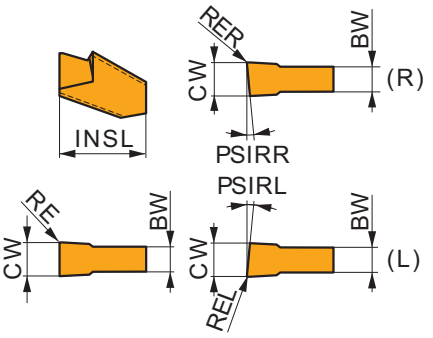
	Product	HF (mm)	H (mm)	LF (mm)	CW (mm)	CDX (mm)	lbs			MID
N	XLCFN 2603 J 03	21.4	26	110	3.10	37.5	.13	GI018	KV	6756935
	XLCFN 3202 M 03	25	32	150	3.10	50	.25	GI018	KV	6756910
	XLCFN 3203 M 04	25	32	150	4.10	50	.31	GI019	KV	6756964
	XLCFN 3204 M 05	25	32	150	5.10	60	.38	GI020	KV	6756931
	XLCFN 4704 S 05	38	47	270	5.10	100	1.02	GI020	KV	6757230
	XLCFN 4705 S 06	38	47	270	6.10	100	1.10	GI021	KV	6757140

GI018	LFUX 0308..
GI019	LFUX 0408..
GI020	LFUX 0508..
GI021	LFUX 0608..

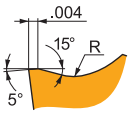
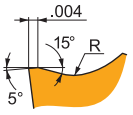
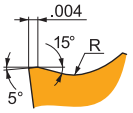
KV	KV 5x70

LFUX

	CW		INSL
	(inch)		(inch)
0308	.118	.099	.453
0408	.157	.135	.453
0508	.197	.169	.453
0608	.236	.209	.453



Suitability and starting values for cutting speed (vc) and feed (f). Refer to our Machining Calculator app for further calculations.

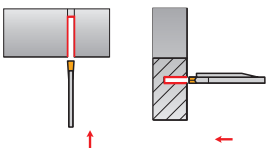
Product		RE	P		M		K		N		S		H		PSIRR	PSIRL	MID
			vc	f	vc	f	vc	f	vc	f	vc	f	vc	f			
		(inch)	(ft/min)	(in/rev)	(ft/min)	(in/rev)	(ft/min)	(in/rev)	(ft/min)	(in/rev)	(ft/min)	(in/rev)	(ft/min)	(in/rev)	(°)	(°)	
																	
			TN geometry for parting-off and grooving, and continuous to slightly interrupted cuts.														
LFUX 030802TN	**6640**	.008	492	.0039	–	–	459	.0039	–	–	–	–	–	–	–	–	6751687
	T8330	.008	427	.0039	–	–	394	.0039	–	–	–	–	–	–	–	–	6754328
LFUX 040802TN	**6640**	.008	492	.0047	–	–	459	.0047	–	–	–	–	–	–	–	–	6751688
	T8330	.008	427	.0047	–	–	394	.0047	–	–	–	–	–	–	–	–	6754331
LFUX 050802TN	**6640**	.008	492	.0059	–	–	459	.0059	–	–	–	–	–	–	–	–	6751689
	T8330	.008	427	.0059	–	–	394	.0059	–	–	–	–	–	–	–	–	6754332
LFUX 060802TN	**6640**	.008	492	.0079	–	–	459	.0079	–	–	–	–	–	–	–	–	6751723
	T8330	.008	427	.0079	–	–	394	.0079	–	–	–	–	–	–	–	–	6754333
																	
			TR geometry, right-handed, for parting-off and continuous to slightly interrupted cuts.														
LFUX 030800TR	**6640**	.008	492	.0039	–	–	459	.0039	–	–	–	–	–	–	5	–	6751721
	T8330	.008	427	.0039	–	–	394	.0039	–	–	–	–	–	–	5	–	6754327
LFUX 040800TR	**T8330**	.008	427	.0047	–	–	394	.0047	–	–	–	–	–	–	5	–	6754330
																	
			TL geometry, left-handed, for parting-off and continuous to slightly interrupted cuts.														
LFUX 030800TL	**T8330**	.008	427	.0039	–	–	394	.0039	–	–	–	–	–	–	–	5	6754329

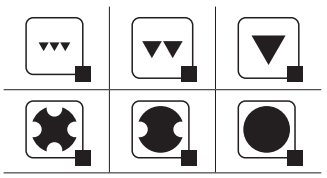
MS-EN

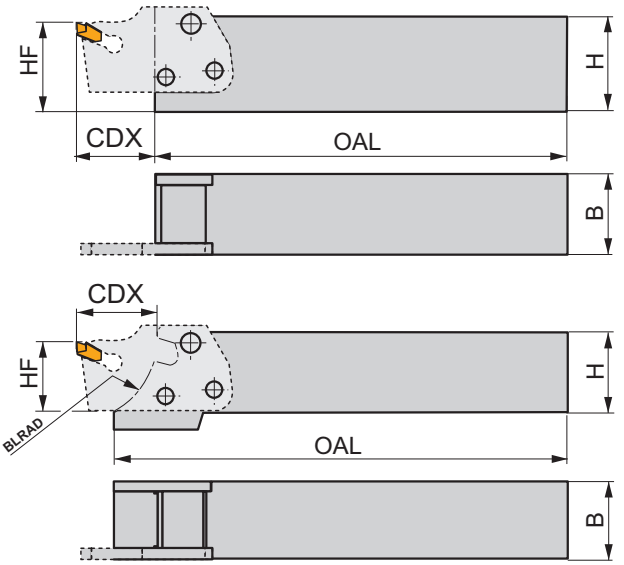
PRAMET

Modular Tool Holder for Grooving and Parting-off Blades

Modular tool holder for BS type grooving and parting-off blades. Body treated for longer tool life.







Product	HF (mm)	H (mm)	B (mm)	OAL (mm)	BLRAD (mm)	lbs			MID
MS-EN-1212 F	12	12	12	75	–	.26	GI006	ND4	6756564
MS-EN-1616 H	16	16	16	90	–	.45	GI006	ND4	6756338
MS-EN-2020 K	20	20	20	115	–	.51	GI003	ND5	6756328
MS-EN-2020 KS	20	20	20	129	25	.93	GI060	ND5	6756836
MS-EN-2525 M	25	25	25	140	–	1.43	GI003	ND5	6756329
MS-EN-2525 MS	25	25	25	153	25	1.62	GI060	ND5	6756837
MS-EN-3225 P	32	32	25	160	–	2.09	GI003	ND5	6756330
MS-EN-3225 PS	32	32	25	174	25	2.20	GI060	ND5	6756838

GI003	XLC.. 25..15...	XLC.. 25..25…	GL.BS	XLXFL 25…
GI006	XLCF. 16..15…	XLCF. 16..20…	–	–
GI060	XLC.. 25..15…	XLC.. 25..25…	GL.BS	–

		Nm				Nm			
ND4	US 4011-T15P	3.5	M 4	0.417	–	–	–	–	FLAG T15P
ND5	US 45013-T20P	5.0	M 5	0.512	US 46017-T20P	5.0	M6	0.669	FLAG T20P

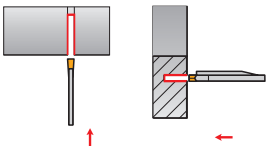
ND4 =3 x US 4011-T15P; ND5=2 x US 45013-T20P

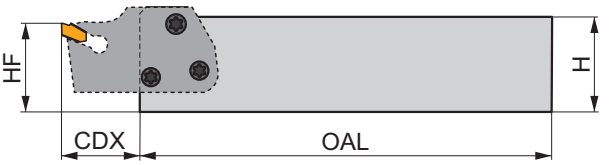
IMS-EN

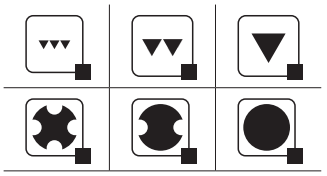
PRAMET

Modular Tool Holder for Grooving and Parting-off Blades

Modular tool holder for BS type grooving and parting-off blades. Body treated for longer tool life.







Product	HF (inch)	H (inch)	B (inch)	OAL (inch)	BLRAD (inch)	lbs			MID
MS-EN-08 A	.500	.500	.500	4.000	–	.29	GI006	ND4	6790612
MS-EN-10 A	.625	.625	.625	4.000	–	.50	GI006	ND4	6790613
MS-EN-12 C	.750	.750	.750	5.000	–	.82	GI003	ND5	6790614
MS-EN-16 D	1.000	1.000	1.000	6.000	–	1.65	GI003	ND5	6790615
MS-EN-85 E	1.250	1.250	1.000	7.000	–	2.40	GI003	ND5	6790616

GI003	XLC.. 25..15...	XLC.. 25..25…	GL.BS	XLXFL 25…
GI006	XLCF. 16..15…	XLCF. 16..20…	–	–

ND4	US 4011-T15P	3.5	M 4	0.417	–	–	–	–	FLAG T15P
ND5	US 45013-T20P	5.0	M 5	0.512	US 46017-T20P	5.0	M6	0.669	FLAG T20P

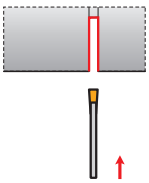
ND4 =3 x US 4011-T15P; ND5=2 x US 45013-T20P

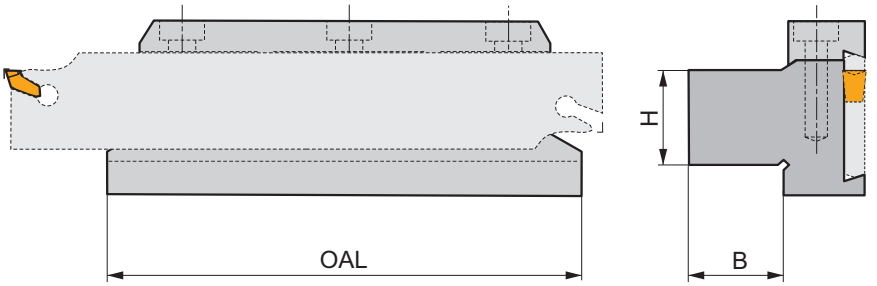
DU, D

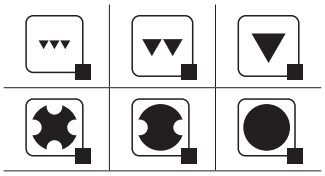
PRAMET

Tool Holder Block for Parting-off Blades

Tool holder to fit GL or XLC. blades for parting-off. Body treated for longer tool life.







Product	H (mm)	B (mm)	OAL (mm)	lbs			MID
26-DU 2020	20	20	90	1.68	GI007	ND2	6756339
26-D 2020	20	20	100	1.80	GI007	ND2	6756678
32-DU 2523	25	23	110	2.34	GI008	ND2	6756340
32-DU 2532	25	32	110	2.74	GI008	ND2	6756341
32-D 2530	25	30	115	2.83	GI008	ND2	6756669
32-DU 3229	32	29	110	2.76	GI008	ND2	6756342
45-DU 3229	32	29	110	3.31	GI009	ND7	6756572
45-DU 4036	40	36	110	4.52	GI009	ND7	6761296
47-D 4040	40	40	150	8.47	GI091	ND3	6757157

GI007	XLC.N 26..	GL.-S26.B.
GI008	XLC.N 32..	GL.-S32.B.
GI009	XLC.N 45..	–
GI091	XLC.N 47..	–

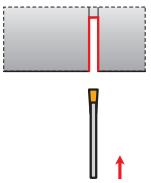
		Nm			
ND2	HS 0625	6.0	M 6	0.984	HXK 5
ND3	HS 1030	8.0	M 10	1.181	HXK 8
ND7	HS 0630	6.0	M 6	1.181	HXK 5

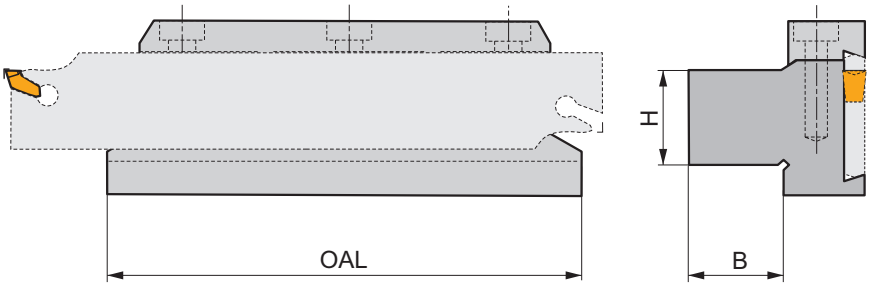
IDU, D

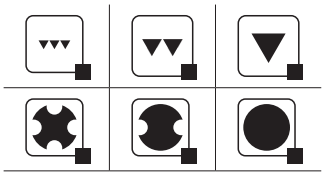
PRAMET

Tool Holder Block for Parting-off Blades

Tool holder to fit GL or XLC. blades for parting-off. Body treated for longer tool life.







Product	H (inch)	B (inch)	OAL (inch)	lbs			MID
26-DU 12	.750	.750	3.540	1.15	GI007	IND2	6790480
32-DU 74	1.000	.875	4.330	1.88	GI008	IND2	6790481
32-DU 104	1.000	1.250	4.330	2.32	GI008	IND2	6803685
32-DU 95	1.250	1.125	4.330	2.32	GI008	IND2	6790483
45-DU 95	1.250	1.125	4.330	2.98	GI009	IND7	6790485
45-DU 24	1.500	1.500	4.330	3.90	GI009	IND7	6790484

GI007	XLC.N 26..	GL.-S26.B.
GI008	XLC.N 32..	GL.-S32.B.
GI009	XLC.N 45..	–

		Nm			
IND2	HS 0625	6.0	M 6	0.984	HXK 5
IND7	HS 0630	6.0	M 6	1.181	HXK 5

INSERT SEAT	LNMX 3.00	GL3	GL4	GL5	GL6
NEW Face axial, Right 20×20 / 32×32		CDX 12 – 25 mm	CDX 20 – 25 mm	CDX 25 mm	CDX 25 – 32 mm
NEW Face axial, Left 25×25 / 32×32		CDX 12 – 25 mm	CDX 20 – 25 mm	CDX 25 mm	CDX 25 – 32 mm
NEW Face 90°, Right 25×25		CDX 15 – 25 mm	CDX 20 – 25 mm		
MS Blades	CDX 20 mm				
Cutting width (mm) CW	3.1	3	4	5	6 / 8
Face grooving	LFMX	GM	GM	GM	GM / GM
Face turning Face profiling		GM MM	GM MM	GM MM	GM MM / GM

GLSF L-R AXIAL

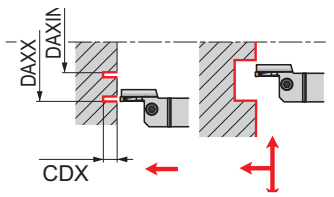
P M K N S H

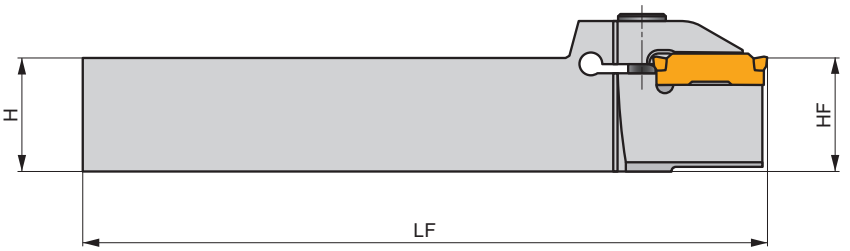
PRAMET

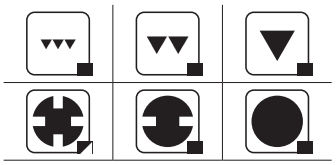
G

Axial Face Grooving tool for GL inserts

Left handed axial face grooving tool holder for GL inserts. Suited for face grooving, turning and profiling applications. Body treated for longer tool life.







	Product	HF (mm)	H (mm)	B (mm)	WF (mm)	LF (mm)	CW (mm)	CDX (mm)	DAXX (mm)	DAXIN (mm)	kg			MID
L	GL3-S2525MFL-12-R035027	25	25	25	26	150	3.00	12	35	27	0.69	GI361	GL16	8462156
	GL3-S2525MFL-15-R044033	25	25	25	26	150	3.00	15	44	33	0.68	GI361	GL16	8462157
	GL3-S2525MFL-15-R055040	25	25	25	26	150	3.00	15	55	40	0.68	GI361	GL16	8462158
	GL3-S2525MFL-20-R080051	25	25	25	26	150	3.00	20	80	51	0.65	GI361	GL16	8462159
	GL3-S2525MFL-25-R110076	25	25	25	26	150	3.00	25	110	76	0.63	GI361	GL16	8462230
	GL4-S2525MFL-20-R065050	25	25	25	26	150	4.00	20	65	50	0.71	GI362	GL16	8462231
	GL4-S2525MFL-20-R095060	25	25	25	26	150	4.00	20	95	60	0.65	GI362	GL16	8462232
	GL4-S2525MFL-25-R160090	25	25	25	26	150	4.00	25	160	90	0.63	GI362	GL16	8462233
	GL4-S2525MFL-25-R400150	25	25	25	25.7	150	4.00	25	400	150	0.63	GI362	GL16	8462234
	GL4-S2525MFL-25-R950380	25	25	25	25.7	150	4.00	25	950	380	0.63	GI362	GL16	8462235
	GL5-S2525MFL-25-R095060	25	25	25	25.3	150	5.00	25	95	60	0.63	GI363	GL16	8462236
	GL5-S2525MFL-25-R200090	25	25	25	25.3	150	5.00	25	200	90	0.63	GI363	GL16	8462237
	GL5-S2525MFL-25-R950180	25	25	25	25.3	150	5.00	25	950	180	0.63	GI363	GL16	8462238
	GL6-S2525MFL-25-R095060	25	25	25	25.4	150	6.00	25	95	60	0.64	GI364	GL16	8462239
	GL6-S2525MFL-25-R200090	25	25	25	25.4	150	6.00	25	200	90	0.64	GI364	GL16	8462240
	GL6-S2525MFL-25-R950180	25	25	25	25.4	150	6.00	25	950	180	0.64	GI364	GL16	8462241
	GL6-S3232PFL-32-R200090	32	32	32	32.4	170	6.00	32	200	90	1.20	GI364	GL17	8462242
	GL6-S3232PFL-32-R950180	32	32	32	32.4	170	6.00	32	950	180	1.20	GI364	GL17	8462243

GI361	GL3-GM	GL3-MM
GI362	GL4-GM	GL4-MM
GI363	GL5-GM	GL5-MM
GI364	GL6-GM	GL6-MM

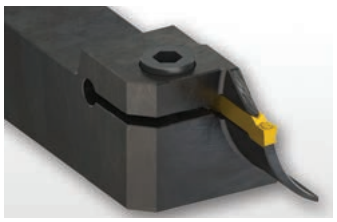
		Nm	
GL16	HS 0620	6.0	HXK 5
GL17	HS 0825	8.0	HXK 6

GLSF R-L AXIAL

P M K N S H

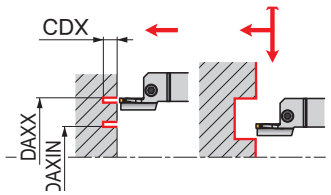
PRAMET

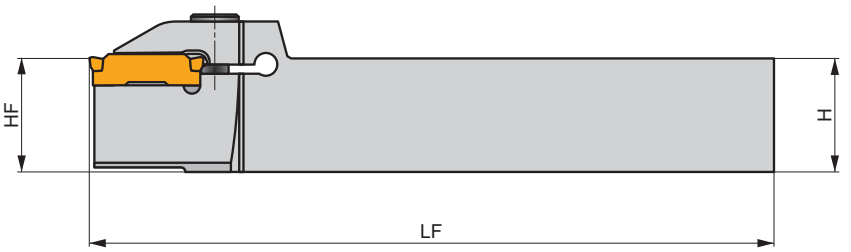
G

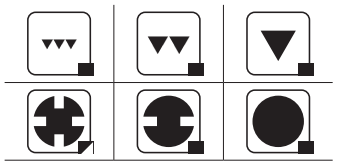


Axial Face Grooving tool for GL inserts

Right handed axial face grooving tool holder for GL inserts. Suited for face grooving, turning and profiling applications. Body treated for longer tool life.







	Product	HF (mm)	H (mm)	B (mm)	WF (mm)	LF (mm)	CW (mm)	CDX (mm)	DAXX (mm)	DAXIN (mm)	kg			MID
R	GL3-S2020KFR-12-L035027	20	20	20	20.5	125	3.00	12	35	27	0.40	GI361	GL16	8462352
	GL3-S2020KFR-15-L044033	20	20	20	20.5	125	3.00	15	44	33	0.40	GI361	GL16	8462353
	GL3-S2020KFR-15-L055040	20	20	20	20.5	125	3.00	15	55	40	0.40	GI361	GL16	8462354
	GL3-S2020KFR-20-L080051	20	20	20	20.5	125	3.00	20	80	51	0.40	GI361	GL16	8462355
	GL3-S2525MFR-12-L035027	25	25	25	26	150	3.00	12	35	27	0.69	GI361	GL16	8462247
	GL3-S2525MFR-15-L044033	25	25	25	26	150	3.00	15	44	33	0.68	GI361	GL16	8462248
	GL3-S2525MFR-15-L055040	25	25	25	26	150	3.00	15	55	40	0.68	GI361	GL16	8462249
	GL3-S2525MFR-20-L080051	25	25	25	26	150	3.00	20	80	51	0.65	GI361	GL16	8462350
	GL3-S2525MFR-25-L110076	25	25	25	26	150	3.00	25	110	76	0.63	GI361	GL16	8462351
	GL4-S2525MFR-20-L065050	25	25	25	26	150	4.00	20	65	50	0.66	GI362	GL16	8462356
	GL4-S2525MFR-20-L095060	25	25	25	26	150	4.00	20	95	60	0.65	GI362	GL16	8462357
	GL4-S2525MFR-25-L160090	25	25	25	26	150	4.00	25	160	90	0.63	GI362	GL16	8462358
	GL4-S2525MFR-25-L400150	25	25	25	25.7	150	4.00	25	400	150	0.63	GI362	GL16	8462359
	GL4-S2525MFR-25-L950380	25	25	25	25.7	150	4.00	25	950	380	0.63	GI362	GL16	8462360
	GL5-S2525MFR-25-L095060	25	25	25	25.3	150	5.00	25	95	60	0.63	GI363	GL16	8462361
	GL5-S2525MFR-25-L200090	25	25	25	25.3	150	5.00	25	200	90	0.63	GI363	GL16	8462362
	GL5-S2525MFR-25-L950180	25	25	25	25.3	150	5.00	25	950	180	0.63	GI363	GL16	8462363
	GL6-S2525MFR-25-L095060	25	25	25	25.4	150	6.00	25	95	60	0.64	GI364	GL16	8462364
	GL6-S2525MFR-25-L200090	25	25	25	25.4	150	6.00	25	200	90	0.64	GI364	GL16	8462365
	GL6-S2525MFR-25-L950180	25	25	25	25.4	150	6.00	25	950	180	0.64	GI364	GL16	8462366
	GL6-S3232PFR-32-L200090	32	32	32	32.4	170	6.00	32	200	90	1.20	GI364	GL17	8462367
	GL6-S3232PFR-32-L950180	32	32	32	32.4	170	6.00	32	950	180	1.20	GI364	GL17	8462368

GI361	GL3-GM	GL3-MM
GI362	GL4-GM	GL4-MM
GI363	GL5-GM	GL5-MM
GI364	GL6-GM	GL6-MM

GL16	HS 0620	6.0	HXK 5
GL17	HS 0825	8.0	HXK 6

GLSG R-R AXIAL

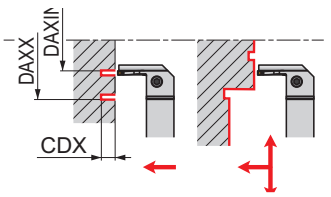
P M K N S H

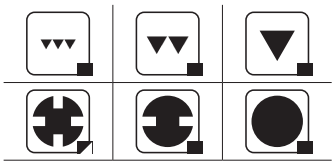
PRAMET

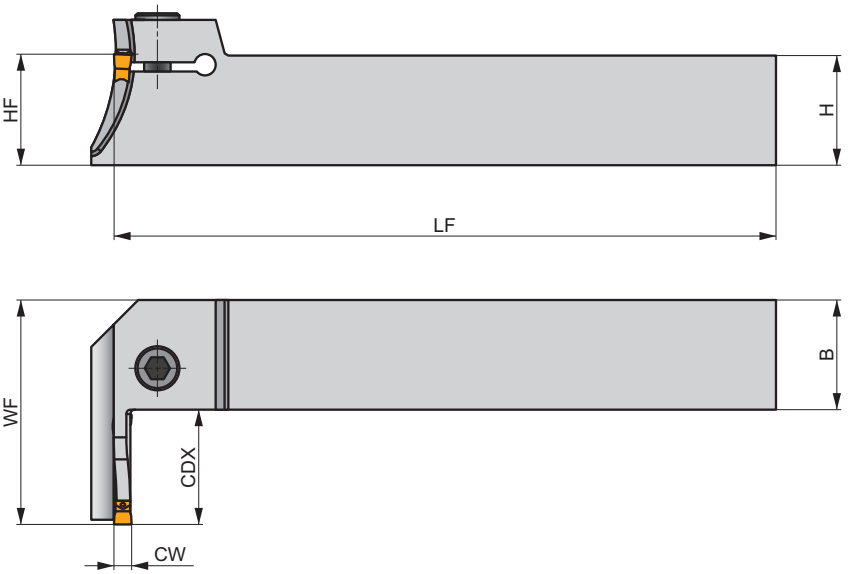
G

Radial Face Grooving tool for GL inserts

Right handed radial face grooving tool holder for GL inserts. Suited for face grooving, turning and profiling applications. Body treated for longer tool life.







Product	HF (mm)	H (mm)	B (mm)	WF (mm)	LF (mm)	CW (mm)	CDX (mm)	DAXX (mm)	DAXIN (mm)	kg			MID
GL3-S2525MGR-15-R044033	25	25	25	40.9	150	3.00	15	44	33	0.75	GI361	GL16	8462378
GL3-S2525MGR-15-R055040	25	25	25	40.9	150	3.00	15	55	40	0.75	GI361	GL16	8462379
GL3-S2525MGR-20-R080051	25	25	25	45.9	150	3.00	20	80	51	0.75	GI361	GL16	8462460
GL3-S2525MGR-25-R110076	25	25	25	50.9	150	3.00	25	110	76	0.75	GI361	GL16	8462461
GL4-S2525MGR-20-R065050	25	25	25	46	150	4.00	20	65	50	0.77	GI362	GL16	8462462
GL4-S2525MGR-25-R095060	25	25	25	51	150	4.00	25	95	60	0.76	GI362	GL16	8462463
GL4-S2525MGR-25-R160090	25	25	25	51	150	4.00	25	160	90	0.76	GI362	GL16	8462464
GL4-S2525MGR-25-R400150	25	25	25	51	150	4.00	25	400	150	0.75	GI362	GL16	8462465

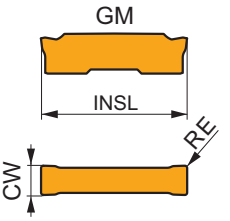
GI361	GL3-GM	GL3-MM
GI362	GL4-GM	GL4-MM

GL16	HS 0620	6.0	HXK 5

GL. D - GM

PRAMET

	CW	CWTOLL	CWTOLU	INSL
	(inch)	(inch)	(inch)	(inch)
200	.079	-.002	.002	.984
300	.118	-.002	.002	.984
400	.157	-.002	.002	.984
500	.197	-.002	.002	.984
600	.236	-.002	.002	.984
800	.315	-.002	.002	.984



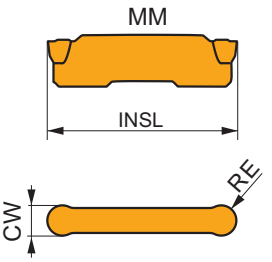
Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

Product		RE	P			M			K			N			S			H			MID
			vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	
		(inch)	(ft/min)	(in/rev)	(inch)	(ft/min)	(in/rev)	(inch)	(ft/min)	(in/rev)	(inch)	(ft/min)	(in/rev)	(inch)	(ft/min)	(in/rev)	(inch)	(ft/min)	(in/rev)	(inch)	
	20°		U E																		
	GM versatile geometry for grooving and longitudinal turning, and continuous to interrupted cuts.																				
GL2-D200M02-GM	**G8330**	.008	■ 623	.0039	.031	■ 361	.0035	.031	■ 591	.0039	.031	–	–	–	◪ 148	.0031	.024	–	–	–	8023038
	T7325	.008	◪ 722	.0039	.031	■ 558	.0035	.031	■ 673	.0039	.031	–	–	–	◪ 230	.0031	.024	–	–	–	8023039
GL3-D300M02-GM	**G8330**	.008	■ 492	.0079	.039	■ 295	.0071	.039	■ 459	.0079	.039	–	–	–	◪ 115	.0055	.031	–	–	–	8022955
	T7325	.008	◪ 574	.0079	.039	■ 443	.0071	.039	■ 541	.0079	.039	–	–	–	◪ 180	.0055	.031	–	–	–	8022956
GL3-D300M04-GM	**G8330**	.016	■ 525	.0079	.039	■ 312	.0071	.039	■ 492	.0079	.039	–	–	–	◪ 131	.0055	.031	–	–	–	7983471
	T7325	.016	◪ 607	.0079	.039	■ 459	.0071	.039	■ 574	.0079	.039	–	–	–	◪ 197	.0055	.031	–	–	–	7983472
GL4-D400M04-GM	**G8330**	.016	■ 492	.0098	.047	■ 295	.0091	.047	■ 459	.0098	.047	–	–	–	◪ 115	.0071	.039	–	–	–	7983475
	T7325	.016	◪ 558	.0098	.047	■ 427	.0091	.047	■ 525	.0098	.047	–	–	–	◪ 180	.0071	.039	–	–	–	7983476
	20°		U E																		
	GM versatile geometry for grooving and longitudinal turning, and continuous to interrupted cuts.																				
GL4-D400M08-GM	**G8330**	.031	■ 591	.0098	.047	■ 344	.0091	.047	■ 558	.0098	.047	–	–	–	◪ 148	.0071	.039	–	–	–	8022957
	T7325	.031	◪ 656	.0098	.047	■ 509	.0091	.047	■ 623	.0098	.047	–	–	–	◪ 213	.0071	.039	–	–	–	8022958
GL5-D500M08-GM	**G8330**	.031	■ 558	.0118	.047	■ 328	.0106	.047	■ 525	.0118	.047	–	–	–	◪ 131	.0083	.039	–	–	–	8023030
	T7325	.031	◪ 623	.0118	.047	■ 476	.0106	.047	■ 591	.0118	.047	–	–	–	◪ 197	.0083	.039	–	–	–	8023031
GL6-D600M08-GM	**G8330**	.031	■ 558	.0118	.047	■ 328	.0106	.047	■ 525	.0118	.047	–	–	–	◪ 131	.0083	.039	–	–	–	8023034
	T7325	.031	◪ 623	.0118	.047	■ 476	.0106	.047	■ 591	.0118	.047	–	–	–	◪ 197	.0083	.039	–	–	–	8023035
GL6-D800M08-GM	**G8330** [1]	.031	■ 558	.0118	.047	■ 328	.0106	.047	■ 525	.0118	.047	–	–	–	◪ 131	.0083	.047	–	–	–	8463347

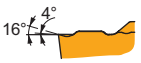
[1] Usable only in holders with CDX ≥ 24.

GL. D - MM

	CW	CWTOLL	CWTOLU	INSL
	(inch)	(inch)	(inch)	(inch)
200	.079	-.002	.002	.984
300	.118	-.002	.002	.984
400	.157	-.002	.002	.984
500	.197	-.002	.002	1.024
600	.236	-.002	.002	1.024



Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

Product		RE	P			M			K			N			S			H			MID
			vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	
		(inch)	(ft/min)	(in/rev)	(inch)	(ft/min)	(in/rev)	(inch)	(ft/min)	(in/rev)	(inch)	(ft/min)	(in/rev)	(inch)	(ft/min)	(in/rev)	(inch)	(ft/min)	(in/rev)	(inch)	
			**MM** geometry, with full radius shape for copy profiling and longitudinal turning, and continuous to interrupted cuts.																		
GL2-D200MM0-MM	**G8330**	.039	■ 820	.0039	.039	■ 492	.0035	.039	■ 771	.0039	.039	–	–	–	◪ 197	.0031	.031	–	–	–	8023060
	T7325	.039	◪ 935	.0039	.039	■ 722	.0035	.039	■ 886	.0039	.039	–	–	–	◪ 295	.0031	.031	–	–	–	8023061
GL3-D300MM0-MM	**G8330**	.059	■ 689	.0079	.047	■ 410	.0071	.047	■ 640	.0079	.047	–	–	–	◪ 164	.0055	.039	–	–	–	7983473
	T7325	.059	◪ 787	.0079	.047	■ 607	.0071	.047	■ 738	.0079	.047	–	–	–	◪ 246	.0055	.039	–	–	–	7983474
GL4-D400MM0-MM	**G8330**	.079	■ 722	.0079	.047	■ 427	.0071	.047	■ 673	.0079	.047	–	–	–	◪ 180	.0055	.039	–	–	–	7983477
	T7325	.079	◪ 820	.0079	.047	■ 640	.0071	.047	■ 771	.0079	.047	–	–	–	◪ 262	.0055	.039	–	–	–	7983478
GL5-D500MM0-MM	**G8330**	.098	■ 673	.0098	.047	■ 394	.0091	.047	■ 623	.0098	.047	–	–	–	◪ 164	.0071	.039	–	–	–	8023032
	T7325	.098	◪ 771	.0098	.047	■ 591	.0091	.047	■ 722	.0098	.047	–	–	–	◪ 246	.0071	.039	–	–	–	8023033
GL6-D600MM0-MM	**G8330**	.118	■ 640	.0118	.047	■ 377	.0106	.047	■ 607	.0118	.047	–	–	–	◪ 148	.0083	.039	–	–	–	8023036
	T7325	.118	◪ 722	.0118	.047	■ 558	.0106	.047	■ 673	.0118	.047	–	–	–	◪ 230	.0083	.039	–	–	–	8023037

XLXFL BS AXIAL

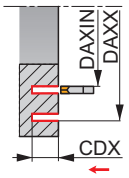
P M K N S H

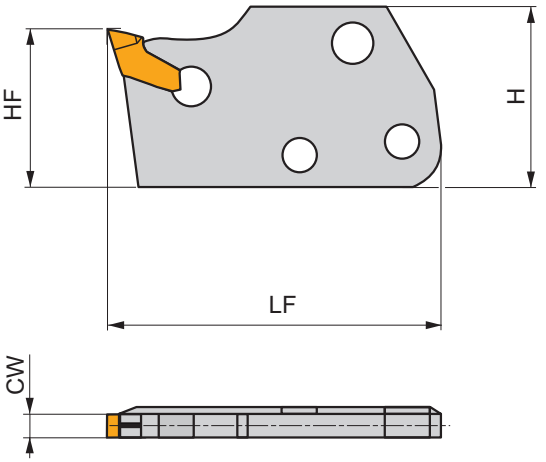
PRAMET

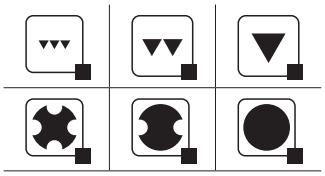
X

Axial Grooving Blade for Modular MS-EN Tool Holder for LFMX Inserts

Modular grooving blade for grooving with single-sided LFMX inserts. Suited for axial grooving (max. 20 mm cutting depth) applications. Can be fitted to MS-EN tool holder. Blades treated for longer tool life.







	Product	H (mm)	HF (mm)	LF (mm)	CW (mm)	CDX (mm)	DAXIN (mm)	DAXX (mm)	lbs			MID
L	XLXFL 250220-3.00-60	29	24	46	3.10	20	60	85	.12	GI001	KV	6756344
	XLXFL 250220-3.00-80	29	24	46	3.10	20	80	105	.10	GI001	KV	6756345
	XLXFL 250220-3.00-100	29	24	46	3.10	20	100	155	.07	GI001	KV	6756346
	XLXFL 250220-3.00-150	29	24	46	3.10	20	150	280	.07	GI001	KV	6756347

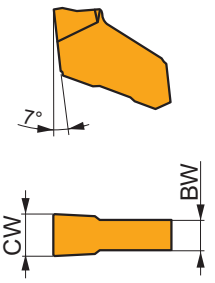
GI001	LFMX 3.1-.

KV	KV 5x70

LFMX - F1

PRAMET

	CW	CWTOLL	CWTOLU	
	(inch)	(inch)	(inch)	
1.5	.059	-.001	.001	.051
1.6	.063	-.001	.001	.051
2.0	.079	-.001	.001	.063
3.1	.122	-.002	.002	.102
4.1	.161	-.002	.002	.142



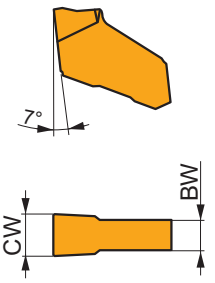
Suitability and starting values for cutting speed (vc) and feed (f). Refer to our Machining Calculator app for further calculations.

Product		RE	P		M		K		N		S		H		PSIRR	PSIRL	MID
			vc (ft/min)	f (in/rev)	vc (ft/min)	f (in/rev)	vc (ft/min)	f (in/rev)	vc (ft/min)	f (in/rev)	vc (ft/min)	f (in/rev)	vc (ft/min)	f (in/rev)	(°)	(°)	
F1 eN-geometry for parting-off and grooving, and continuous cuts.																	
LFMX 1.5-.16ENF1	**T8330**	.006	427	.0031	246	.0028	394	.0031	–	–	–	–	–	–	–	–	6755607
LFMX 1.6-.16ENF1	**T8330**	.006	427	.0031	246	.0028	394	.0031	–	–	–	–	–	–	–	–	6755608
LFMX 2.0-.16ENF1	**T8330**	.006	427	.0031	246	.0028	394	.0031	–	–	–	–	–	–	–	–	6754321
LFMX 3.1-.20ENF1	**T8330**	.008	427	.0039	246	.0035	394	.0039	–	–	–	–	–	–	–	–	6754336
LFMX 4.1-.20ENF1	**T8330**	.008	427	.0039	246	.0035	394	.0039	–	–	–	–	–	–	–	–	6754343

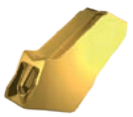
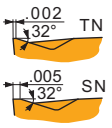
LFMX - F2

PRAMET

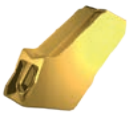
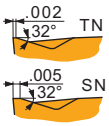
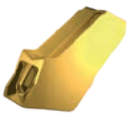
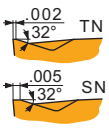
	CW	CWTOLL	CWTOLU	
	(inch)	(inch)	(inch)	
1.6	.063	-.001	.001	.051
2.0	.079	-.001	.001	.063
3.1	.122	-.002	.002	.102
4.1	.161	-.002	.002	.142
5.1	.201	-.002	.002	.181
6.35	.250	-.002	.002	.228



Suitability and starting values for cutting speed (vc) and feed (f). Refer to our Machining Calculator app for further calculations.

Product		RE	P		M		K		N		S		H		PSIRR	PSIRL	MID
			vc (ft/min)	f (in/rev)	vc (ft/min)	f (in/rev)	vc (ft/min)	f (in/rev)	vc (ft/min)	f (in/rev)	vc (ft/min)	f (in/rev)	vc (ft/min)	f (in/rev)	(°)	(°)	
																	
SN-F2 geometry for parting-off and grooving, and continuous cuts.																	
LFMX 1.6-.16SNF2	**T8330**	.006	427	.0039	246	.0035	394	.0039	–	–	–	–	–	–	–	–	6754320
LFMX 2.0-.16SNF2	**6640**	.006	492	.0039	295	.0035	459	.0039	–	–	–	–	–	–	–	–	6752157
	T8330	.006	427	.0039	246	.0035	394	.0039	–	–	–	–	–	–	–	–	6754324
LFMX 3.1-.20SNF2	**6640**	.008	492	.0039	295	.0035	459	.0039	–	–	–	–	–	–	–	–	6752366
	T8330	.008	427	.0039	246	.0035	394	.0039	–	–	–	–	–	–	–	–	6754338
LFMX 4.1-.20SNF2	**T8330**	.008	427	.0047	246	.0043	394	.0047	–	–	–	–	–	–	–	–	6754345

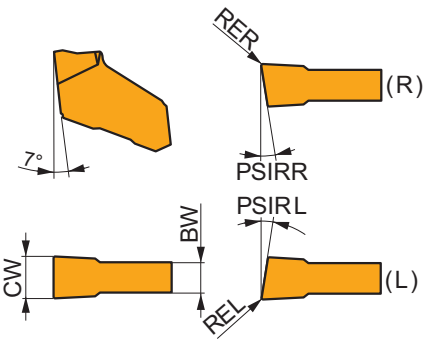
Suitability and starting values for cutting speed (vc) and feed (f). Refer to our Machining Calculator app for further calculations.

Product	RE (inch)	P vc (ft/min)	P f (in/rev)	M vc (ft/min)	M f (in/rev)	K vc (ft/min)	K f (in/rev)	N vc (ft/min)	N f (in/rev)	S vc (ft/min)	S f (in/rev)	H vc (ft/min)	H f (in/rev)	PSIRR (°)	PSIRL (°)	MID
																
SN-F2 geometry for parting-off and grooving, and continuous cuts.																
LFMX 5.1-.20SNF2	**T8330** .008	427	.0047	246	.0043	394	.0047	–	–	–	–	–	–	–	–	6754350
LFMX 6.35-.20SNF2	**T8330** .008	427	.0059	246	.0055	394	.0059	–	–	–	–	–	–	–	–	6754352
																
TN-F2 geometry for parting-off and grooving, and continuous cuts.																
LFMX 3.1-.20TNF2	**6640** .008	492	.0039	295	.0035	459	.0039	–	–	–	–	–	–	–	–	6752368
	T8330 .008	427	.0039	246	.0035	394	.0039	–	–	–	–	–	–	–	–	6754341
LFMX 4.1-.20TNF2	**T8330** .008	427	.0047	246	.0043	394	.0047	–	–	–	–	–	–	–	–	6754348

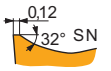
LFMX - M2

PRAMET

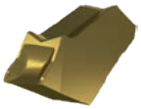
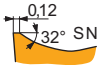
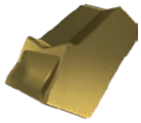
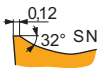
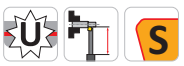
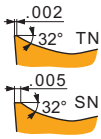
	CW (inch)	CWTOLL (inch)	CWTOLU (inch)	
2.0	.079	-.001	.001	.063
2.2	.087	-.001	.001	.063
3.1	.122	-.002	.002	.102
4.1	.161	-.002	.002	.142
5.1	.201	-.002	.002	.181
6.35	.250	-.002	.002	.228

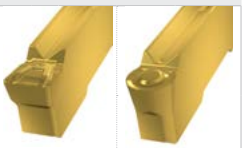


Suitability and starting values for cutting speed (vc) and feed (f). Refer to our Machining Calculator app for further calculations.

Product	RE (inch)	P vc (ft/min)	P f (in/rev)	M vc (ft/min)	M f (in/rev)	K vc (ft/min)	K f (in/rev)	N vc (ft/min)	N f (in/rev)	S vc (ft/min)	S f (in/rev)	H vc (ft/min)	H f (in/rev)	PSIRR (°)	PSIRL (°)	MID
																
SN-M2 geometry for parting-off and grooving, and continuous to slightly interrupted cuts.																
LFMX 2.0-.16SNM2	**6640** .006	492	.0043	295	.0039	459	.0043	–	–	–	–	–	–	–	–	6752158
	T8330 .006	427	.0043	246	.0039	394	.0043	–	–	–	–	–	–	–	–	6754325
LFMX 2.2-.16SNM2	**6640** .006	492	.0043	295	.0039	459	.0043	–	–	–	–	–	–	–	–	6752023
	T8330 .006	427	.0043	246	.0039	394	.0043	–	–	–	–	–	–	–	–	6754335
LFMX 3.1-.20SNM2	**6640** .008	492	.0059	295	.0055	459	.0059	–	–	–	–	–	–	–	–	6752416
	T8330 .008	427	.0059	246	.0055	394	.0059	–	–	–	–	–	–	–	–	6754339
LFMX 4.1-.20SNM2	**6640** .008	492	.0059	295	.0055	459	.0059	–	–	–	–	–	–	–	–	6752419
	T8330 .008	427	.0059	246	.0055	394	.0059	–	–	–	–	–	–	–	–	6754346
LFMX 5.1-.20SNM2	**6640** .008	492	.0079	295	.0071	459	.0079	–	–	–	–	–	–	–	–	6752009
	T8330 .008	427	.0079	246	.0071	394	.0079	–	–	–	–	–	–	–	–	6754351
LFMX 6.35-.20SNM2	**6640** .008	492	.0079	295	.0071	459	.0079	–	–	–	–	–	–	–	–	6752010
	T8330 .008	427	.0079	246	.0071	394	.0079	–	–	–	–	–	–	–	–	6754353

Suitability and starting values for cutting speed (vc) and feed (f). Refer to our Machining Calculator app for further calculations.

Product		RE	P		M		K		N		S		H		PSIRR	PSIRL	MID
			vc (ft/min)	f (in/rev)	vc (ft/min)	f (in/rev)	vc (ft/min)	f (in/rev)	vc (ft/min)	f (in/rev)	vc (ft/min)	f (in/rev)	vc (ft/min)	f (in/rev)	(°)	(°)	
																	
SR-M2 geometry, with right-handed design, for parting-off, and continuous to slightly interrupted cuts.																	
LFMX 2.0-.16SR12M2	**T8330**	.006	■ 427	.0035	◪ 246	.0031	◪ 394	.0035	–	–	–	–	–	–	12	–	6754326
LFMX 2.0-.16SR6M2	**T8330**	.006	■ 427	.0035	◪ 246	.0031	◪ 394	.0035	–	–	–	–	–	–	6	–	6754334
LFMX 3.1-.20SR8M2	**T8330**	.008	■ 427	.0043	◪ 246	.0039	◪ 394	.0043	–	–	–	–	–	–	8	–	6754340
LFMX 4.1-.20SR8M2	**T8330**	.008	■ 427	.0059	◪ 246	.0055	◪ 394	.0059	–	–	–	–	–	–	8	–	6754347
																	
SL-M2 geometry, with left-handed design, for parting-off, and continuous to slightly interrupted cuts.																	
LFMX 2.0-.16SL12M2	**T8330**	.006	■ 427	.0035	◪ 246	.0031	◪ 394	.0035	–	–	–	–	–	–	–	12	6754322
LFMX 2.0-.16SL6M2	**T8330**	.006	■ 427	.0035	◪ 246	.0031	◪ 394	.0035	–	–	–	–	–	–	–	6	6754323
LFMX 3.1-.20SL8M2	**T8330**	.008	■ 427	.0043	◪ 246	.0039	◪ 394	.0043	–	–	–	–	–	–	–	8	6754337
LFMX 4.1-.20SL8M2	**T8330**	.008	■ 427	.0059	◪ 246	.0055	◪ 394	.0059	–	–	–	–	–	–	–	8	6754344
																	
TN-M2 geometry for parting-off and grooving, and continuous to slightly interrupted cuts.																	
LFMX 3.1-.20TNM2	**6640**	.008	■ 492	.0059	◪ 295	.0055	◪ 459	.0059	–	–	–	–	–	–	–	–	6752417
	T8330	.008	■ 427	.0059	◪ 246	.0055	◪ 394	.0059	–	–	–	–	–	–	–	–	6754342
LFMX 4.1-.20TNM2	**6640**	.008	■ 492	.0059	◪ 295	.0055	◪ 459	.0059	–	–	–	–	–	–	–	–	6752418
	T8330	.008	■ 427	.0059	◪ 246	.0055	◪ 394	.0059	–	–	–	–	–	–	–	–	6754349

INSERT SEAT	0313	0413	GL2	GL3	GL4
GG.(RL) INT DCON MS = 16 – 25 mm DMIN = 16 mm					
IGG.(RL) INT DCON MS = .629 – .984 in DMIN = .629 in					
GLAG (RL)INT DCON MS = 25 – 40 mm DMIN = 32 mm					
Cutting width (mm) CW	3	4	2	3	4
Grooving (internal)	CM F	CM F	GM	GM	GM
Turning / Profiling (internal)	F MP	F MP	GM MM	GM MM	 GM MM

GLAG (RL) INT

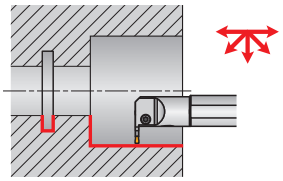
P M K N S H

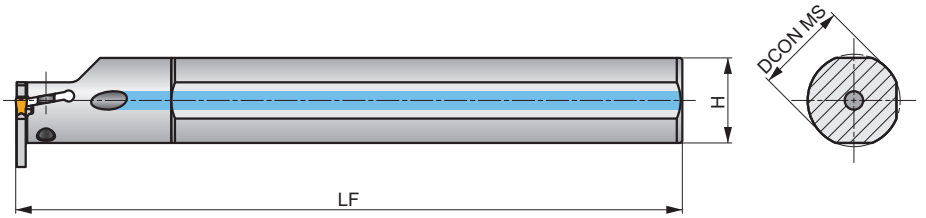
PRAMET

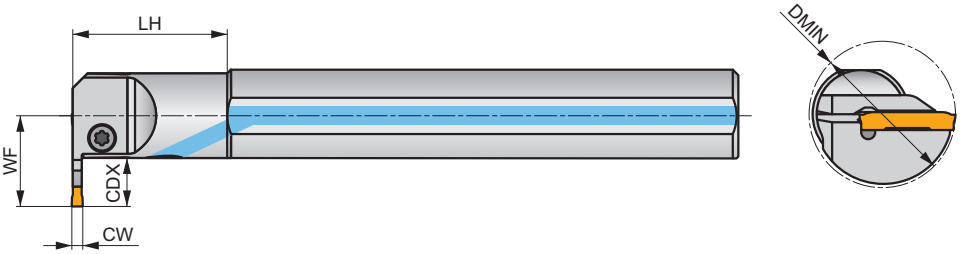
G

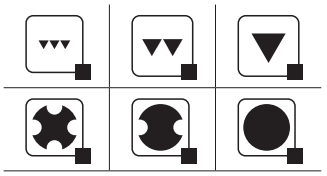
Internal Grooving tool for GL inserts

Internal Right/Left handed tool holder with internal coolant for GL inserts, designed with reinforced seating and blade for security. Suited for internal grooving, turning and profiling applications. Body treated for longer tool life.









	Product	DCON MS (mm)	H (mm)	WF (mm)	LF (mm)	LH (mm)	CW (mm)	CDX (mm)	DMIN (mm)		lbs			MID
R	GL2-A25QGR-06-32	25	23	18.5	180	41.2	2.00	6	32	✓	1.25	GI360	GL14	8461668
	GL2-A25QGR-10-38	25	23	22.5	180	41.2	2.00	10	38	✓	1.26	GI360	GL14	8461770
	GL3-A25QGR-06-32	25	23	18.5	180	42.0	3.00	6	32	✓	1.26	GI361	GL14	8461772
	GL3-A25QGR-12-38	25	23	24.5	180	42.0	3.00	12	38	✓	1.27	GI361	GL14	8461774
	GL4-A25QGR-06-40 [1]	25	23	18.6	180	43.0	4.00	6	40	✓	1.27	GI362	GL14	8461776
	GL4-A25QGR-12-40 [1]	25	23	24.6	180	43.0	4.00	12	40	✓	1.28	GI362	GL14	8461778
	GL2-A32SGR-06-40	32	30	22	250	51.2	2.00	6	40	✓	3.04	GI360	GL14	8461780
	GL2-A32SGR-10-45	32	30	26	250	51.2	2.00	10	45	✓	2.87	GI360	GL14	8461782
	GL3-A32SGR-06-40	32	30	22	250	52.0	3.00	6	40	✓	3.05	GI361	GL14	8461784
	GL3-A32SGR-12-45	32	30	28	250	52.0	3.00	12	45	✓	2.87	GI361	GL14	8461786
	GL4-A32SGR-06-40 [1]	32	30	22.1	250	53.0	4.00	6	40	✓	3.07	GI362	GL14	8461788
	GL4-A32SGR-12-45 [1]	32	30	28.1	250	53.0	4.00	12	45	✓	3.06	GI362	GL14	8461790
	GL3-A40TGR-12-54	40	38	32	300	52.0	3.00	12	54	✓	5.94	GI361	GL14	8461794
	GL4-A40TGR-12-56 [1]	40	38	32.1	300	53.0	4.00	12	56	✓	5.73	GI362	GL14	8461796
	GL4-A40TGR-20-62 [1]	40	38	40.1	300	53.0	4.00	20	62	✓	5.95	GI362	GL14	8461798
L	GL2-A25QGL-06-32	25	23	18.5	180	41.2	2.00	6	32	✓	1.26	GI360	GL14	8461667
	GL2-A25QGL-10-38	25	23	22.5	180	41.2	2.00	10	38	✓	1.26	GI360	GL14	8461669
	GL3-A25QGL-06-32	25	23	18.5	180	42.0	3.00	6	32	✓	1.26	GI361	GL14	8461771
	GL3-A25QGL-12-38	25	23	24.5	180	42.0	3.00	12	38	✓	1.27	GI361	GL14	8461773
	GL4-A25QGL-06-40 [1]	25	23	18.6	180	43.0	4.00	6	40	✓	1.27	GI362	GL14	8461775
	GL4-A25QGL-12-40 [1]	25	23	24.6	180	43.0	4.00	12	40	✓	1.28	GI362	GL14	8461777
	GL2-A32SGL-06-40	32	30	22	250	51.2	2.00	6	40	✓	3.04	GI360	GL14	8461779
	GL2-A32SGL-10-45	32	30	26	250	51.2	2.00	10	45	✓	3.04	GI360	GL14	8461781

	Product	DCON MS (mm)	H (mm)	WF (mm)	LF (mm)	LH (mm)	CW (mm)	CDX (mm)	DMIN (mm)		lbs			MID
L	**GL3-A32SGL-06-40**	32	30	22	250	52.0	3.00	6	40	✓	2.87	GI361	GL14	8461783
	GL3-A32SGL-12-45	32	30	28	250	52.0	3.00	12	45	✓	3.04	GI361	GL14	8461785
	GL4-A32SGL-06-40 [1]	32	30	22.1	250	53.0	4.00	6	40	✓	3.06	GI362	GL14	8461787
	GL4-A32SGL-12-45 [1]	32	30	28.1	250	53.0	4.00	12	45	✓	2.87	GI362	GL14	8461789
	GL3-A40TGL-12-54	40	38	32	300	52.0	3.00	12	54	✓	5.73	GI361	GL14	8461793
	GL4-A40TGL-12-56 [1]	40	38	32.1	300	53.0	4.00	12	56	✓	5.95	GI362	GL14	8461795
	GL4-A40TGL-20-62 [1]	40	38	40.1	300	53.0	4.00	20	62	✓	5.95	GI362	GL14	8461797

[1] Geometry MM is applicable only when DMIN >= 68 mm.

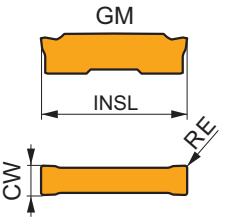
GI360	GL2-GM	GL2-MM
GI361	GL3-GM	GL3-MM
GI362	GL4-GM	GL4-MM

		Nm			
GL14	US 5015-T20P	5.0	M 5	0.591	LKT20P

GL. D - GM

PRAMET

	CW	CWTOLL	CWTOLU	INSL
	(inch)	(inch)	(inch)	(inch)
200	.079	-.002	.002	.984
300	.118	-.002	.002	.984
400	.157	-.002	.002	.984
500	.197	-.002	.002	.984
600	.236	-.002	.002	.984
800	.315	-.002	.002	.984



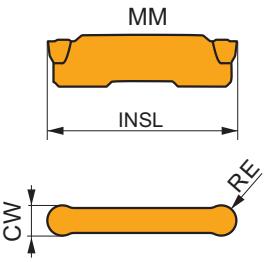
Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

Product		RE	P			M			K			N			S			H			MID
			vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	
		(inch)	(ft/min)	(in/rev)	(inch)	(ft/min)	(in/rev)	(inch)	(ft/min)	(in/rev)	(inch)	(ft/min)	(in/rev)	(inch)	(ft/min)	(in/rev)	(inch)	(ft/min)	(in/rev)	(inch)	
	20°		U E																		
	GM versatile geometry for grooving and longitudinal turning, and continuous to interrupted cuts.																				
GL2-D200M02-GM	**G8330**	.008	■ 623	.0039	.031	■ 361	.0035	.031	■ 591	.0039	.031	–	–	–	◪ 148	.0031	.024	–	–	–	8023038
	T7325	.008	◪ 722	.0039	.031	■ 558	.0035	.031	■ 673	.0039	.031	–	–	–	◪ 230	.0031	.024	–	–	–	8023039
GL3-D300M02-GM	**G8330**	.008	■ 492	.0079	.039	■ 295	.0071	.039	■ 459	.0079	.039	–	–	–	◪ 115	.0055	.031	–	–	–	8022955
	T7325	.008	◪ 574	.0079	.039	■ 443	.0071	.039	■ 541	.0079	.039	–	–	–	◪ 180	.0055	.031	–	–	–	8022956
GL3-D300M04-GM	**G8330**	.016	■ 525	.0079	.039	■ 312	.0071	.039	■ 492	.0079	.039	–	–	–	◪ 131	.0055	.031	–	–	–	7983471
	T7325	.016	◪ 607	.0079	.039	■ 459	.0071	.039	■ 574	.0079	.039	–	–	–	◪ 197	.0055	.031	–	–	–	7983472
GL4-D400M04-GM	**G8330**	.016	■ 492	.0098	.047	■ 295	.0091	.047	■ 459	.0098	.047	–	–	–	◪ 115	.0071	.039	–	–	–	7983475
	T7325	.016	◪ 558	.0098	.047	■ 427	.0091	.047	■ 525	.0098	.047	–	–	–	◪ 180	.0071	.039	–	–	–	7983476
	20°		U E																		
	GM versatile geometry for grooving and longitudinal turning, and continuous to interrupted cuts.																				
GL4-D400M08-GM	**G8330**	.031	■ 591	.0098	.047	■ 344	.0091	.047	■ 558	.0098	.047	–	–	–	◪ 148	.0071	.039	–	–	–	8022957
	T7325	.031	◪ 656	.0098	.047	■ 509	.0091	.047	■ 623	.0098	.047	–	–	–	◪ 213	.0071	.039	–	–	–	8022958
GL5-D500M08-GM	**G8330**	.031	■ 558	.0118	.047	■ 328	.0106	.047	■ 525	.0118	.047	–	–	–	◪ 131	.0083	.039	–	–	–	8023030
	T7325	.031	◪ 623	.0118	.047	■ 476	.0106	.047	■ 591	.0118	.047	–	–	–	◪ 197	.0083	.039	–	–	–	8023031
GL6-D600M08-GM	**G8330**	.031	■ 558	.0118	.047	■ 328	.0106	.047	■ 525	.0118	.047	–	–	–	◪ 131	.0083	.039	–	–	–	8023034
	T7325	.031	◪ 623	.0118	.047	■ 476	.0106	.047	■ 591	.0118	.047	–	–	–	◪ 197	.0083	.039	–	–	–	8023035
GL6-D800M08-GM	**G8330** [1]	.031	■ 558	.0118	.047	■ 328	.0106	.047	■ 525	.0118	.047	–	–	–	◪ 131	.0083	.047	–	–	–	8463347

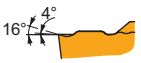
[1] Usable only in holders with CDX ≥ 24.

GL. D - MM

	CW	CWTOLL	CWTOLU	INSL
	(inch)	(inch)	(inch)	(inch)
200	.079	-.002	.002	.984
300	.118	-.002	.002	.984
400	.157	-.002	.002	.984
500	.197	-.002	.002	1.024
600	.236	-.002	.002	1.024



Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

Product		RE	P			M			K			N			S			H			MID
			vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	
		(inch)	(ft/min)	(in/rev)	(inch)	(ft/min)	(in/rev)	(inch)	(ft/min)	(in/rev)	(inch)	(ft/min)	(in/rev)	(inch)	(ft/min)	(in/rev)	(inch)	(ft/min)	(in/rev)	(inch)	
																					
MM geometry, with full radius shape for copy profiling and longitudinal turning, and continuous to interrupted cuts.																					
GL2-D200MM0-MM	**G8330**	.039	■	820	.0039	.039	■	492	.0035	.039	■	771	.0039	.039	–	–	–	◪	197	.0031	.031	–	–	–	8023060
	T7325	.039	◪	935	.0039	.039	■	722	.0035	.039	■	886	.0039	.039	–	–	–	◪	295	.0031	.031	–	–	–	8023061
GL3-D300MM0-MM	**G8330**	.059	■	689	.0079	.047	■	410	.0071	.047	■	640	.0079	.047	–	–	–	◪	164	.0055	.039	–	–	–	7983473
	T7325	.059	◪	787	.0079	.047	■	607	.0071	.047	■	738	.0079	.047	–	–	–	◪	246	.0055	.039	–	–	–	7983474
GL4-D400MM0-MM	**G8330**	.079	■	722	.0079	.047	■	427	.0071	.047	■	673	.0079	.047	–	–	–	◪	180	.0055	.039	–	–	–	7983477
	T7325	.079	◪	820	.0079	.047	■	640	.0071	.047	■	771	.0079	.047	–	–	–	◪	262	.0055	.039	–	–	–	7983478
GL5-D500MM0-MM	**G8330**	.098	■	673	.0098	.047	■	394	.0091	.047	■	623	.0098	.047	–	–	–	◪	164	.0071	.039	–	–	–	8023032
	T7325	.098	◪	771	.0098	.047	■	591	.0091	.047	■	722	.0098	.047	–	–	–	◪	246	.0071	.039	–	–	–	8023033
GL6-D600MM0-MM	**G8330**	.118	■	640	.0118	.047	■	377	.0106	.047	■	607	.0118	.047	–	–	–	◪	148	.0083	.039	–	–	–	8023036
	T7325	.118	◪	722	.0118	.047	■	558	.0106	.047	■	673	.0118	.047	–	–	–	◪	230	.0083	.039	–	–	–	8023037

GG.(RL) INT

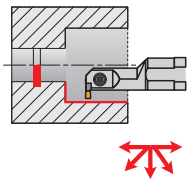
P M K N S H

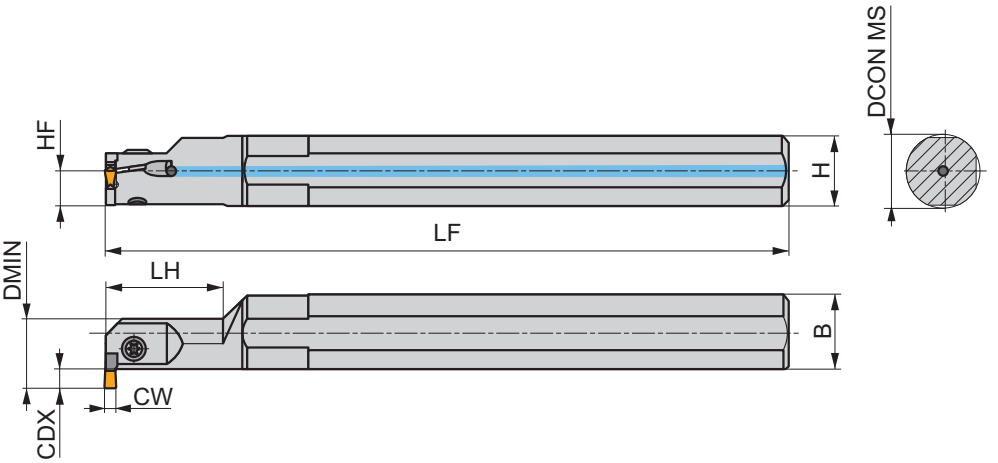
PRAMET

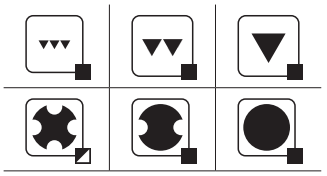
G

Internal Grooving Boring Bar for LCM. Inserts

Internal Right/Left hand grooving boring bar for grooving with LCM. inserts. Suited for internal grooving and multi-directional turning. Body treated for longer tool life.







	Product	DCON MS (mm)	HF (mm)	H (mm)	B (mm)	LF (mm)	LH (mm)	CW (mm)	CDX (mm)	DMIN (mm)		lbs			MID
R	A16Q-GGER 0313	16	7.5	15	15.5	180	25.0	3.00	3	16	✓	.56	GI143	GL06	6758153
	A20R-GGFR 0313	20	9	18	19	200	30.0	3.00	4.5	20	✓	.83	GI143	GL06	6758155
	A25S-GGHR 0313	25	11.5	23	24	250	40.0	3.00	6.5	25	✓	1.71	GI143	GL06	6758157
	A25S-GGFR 0413	25	11.5	23	24	250	40.0	4.00	6.5	25	✓	1.73	GI170	GL06	6758159
L	A16Q-GGEL 0313	16	7.5	15	15.5	180	25.0	3.00	3	16	✓	.60	GI143	GL06	6758154
	A20R-GGFL 0313	20	9	18	19	200	30.0	3.00	4.5	20	✓	.82	GI143	GL06	6758156
	A25S-GGHL 0313	25	11.5	23	24	250	40.0	3.00	6.5	25	✓	1.73	GI143	GL06	6758158

GI143	LCM. 0313..
GI170	LCM. 0413..

		Nm			
GL06	SR 85011-T15P	5.0	M 5	0.354	FLAG T15P

IGG.(RL) INT

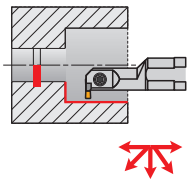
P M K N S H

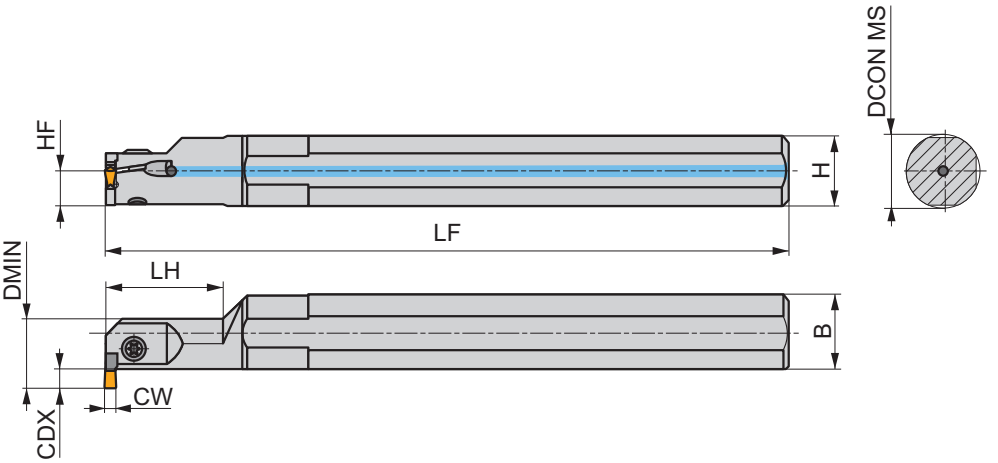
PRAMET

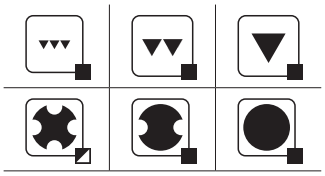
G

Internal Grooving Boring Bar for LCM. Inserts

Internal Right/Left hand grooving boring bar for grooving with LCM. inserts. Suited for internal grooving and multi-directional turning. Body treated for longer tool life.







	Product	DCON MS (inch)	HF (inch)	H (inch)	B (inch)	LF (inch)	LH (inch)	CW (inch)	CDX (inch)	DMIN (inch)		lbs			MID
R	A16S-GGHR 0313	1.000	.453	.906	.953	10.000	1.575	.118	.295	.984	✓	1.70	GI143	GL06	6790493
	A20T-GGHR 0413	1.250	.591	1.181	1.216	12.000	1.969	.158	.413	1.260	✓	3.41	GI170	GL06	6790495
	A10Q-GGER 0313	.625	.296	.591	.608	7.000	.984	.118	.118	.630	✓	.51	GI143	GL06	8589968
	A12R-GGFR 0313	.750	.355	.709	.709	8.000	1.181	.118	.177	.787	✓	.73	GI143	GL06	8590010
L	A10Q-GGEL 0313	.625	.296	.591	.608	7.000	.984	.118	.118	.630	✓	.51	GI143	GL06	8589967
	A12R-GGFL 0313	.750	.355	.709	.709	8.000	1.181	.118	.177	.787	✓	.73	GI143	GL06	8589969

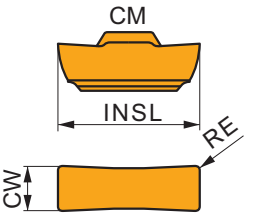
GI143	LCM. 0313..
GI170	LCM. 0413..

		Nm			
GL06	SR 85011-T15P	5.0	M 5	0.354	FLAG T15P

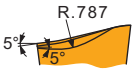
LCMF 13 - CM

PRAMET

	CW	CWTOLL	CWTOLU	INSL
	(inch)	(inch)	(inch)	(inch)
0313	.118	-.002	.002	.496
0413	.157	-.002	.002	.496



Suitability and starting values for cutting speed (vc) and feed (f). Refer to our Machining Calculator app for further calculations.

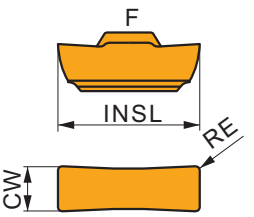
Product		RE	P		M		K		N		S		H		PSIRR	PSIRL	MID
			vc (ft/min)	f (in/rev)	vc (ft/min)	f (in/rev)	vc (ft/min)	f (in/rev)	vc (ft/min)	f (in/rev)	vc (ft/min)	f (in/rev)	vc (ft/min)	f (in/rev)	(°)	(°)	
																	
LCMF 031304-CM	**T8330**	.016	427	.0043	246	.0039	394	.0043	–	–	–	–	–	–	–	–	6754705
LCMF 041304-CM	**T8330**	.016	427	.0043	246	.0039	394	.0043	–	–	–	–	–	–	–	–	6754708

CM geometry and first choice for grooving.

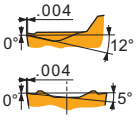
LCMF 13 - F

PRAMET

	CW	CWTOLL	CWTOLU	INSL
	(inch)	(inch)	(inch)	(inch)
0313	.118	-.002	.002	.496
0413	.157	-.002	.002	.496



Suitability and starting values for cutting speed (vc) and feed (f). Refer to our Machining Calculator app for further calculations.

Product		RE	P			M			K			N			S			H			MID
			vc (ft/min)	f (in/rev)	ap (inch)	vc (ft/min)	f (in/rev)	ap (inch)	vc (ft/min)	f (in/rev)	ap (inch)	vc (ft/min)	f (in/rev)	ap (inch)	vc (ft/min)	f (in/rev)	ap (inch)	vc (ft/min)	f (in/rev)	ap (inch)	
																					
LCMF 031302-F	**T8330**	.008	640	.0039	.012	377	.0035	.012	607	.0039	.012	–	–	–	–	–	–	–	–	–	6754704
LCMF 031302-F-04	**T8330** [1)]	.008	640	.0039	.012	377	.0035	.012	607	.0039	.012	–	–	–	–	–	–	–	–	–	6926959
LCMF 031304-F	**T8330**	.016	607	.0051	.020	361	.0047	.020	574	.0051	.020	–	–	–	–	–	–	–	–	–	6754264
LCMF 041304-F	**T8330**	.016	607	.0051	.020	361	.0047	.020	574	.0051	.020	–	–	–	–	–	–	–	–	–	6754271

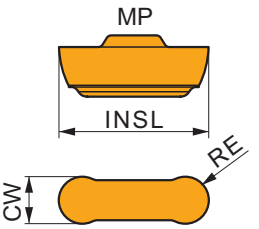
F geometry and first choice for turning.

[1)] Insert for internal holder A16Q-GGERIL0313-04, A20R-GGFRIL0313-04.

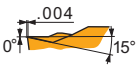
LCMF 13 - MP

PRAMET

	CW	CWTOLL	CWTOLU	INSL
	(inch)	(inch)	(inch)	(inch)
0313	.118	-.002	.002	.496
0413	.157	-.002	.002	.496

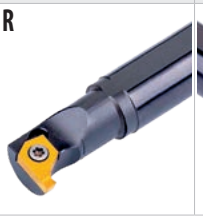
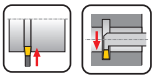
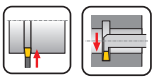


Suitability and starting values for cutting speed (vc) and feed (f). Refer to our Machining Calculator app for further calculations.

Product		RE	P			M			K			N			S			H			MID
			vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	
		(inch)	(ft/min)	(in/rev)	(inch)	(ft/min)	(in/rev)	(inch)	(ft/min)	(in/rev)	(inch)	(ft/min)	(in/rev)	(inch)	(ft/min)	(in/rev)	(inch)	(ft/min)	(in/rev)	(inch)	
																					
LCMF 0313MO-MP	**T8330**	.059	■	623	.0118	.031	◪	361	.0106	.031	■	591	.0118	.031	–	–	–	–	–	–	–	–	–	6754265
LCMF 0413MO-MP	**T8330**	.079	■	574	.0157	.039	◪	344	.0142	.039	■	541	.0157	.039	–	–	–	–	–	–	–	–	–	6754272

MP geometry for longitudinal turning and copy profiling, fine and finish machining, and continuous to interrupted cuts.

O-RING AND CIRCLIPS GROOVING

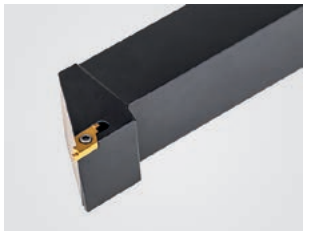
	EXTERNAL		INTERNAL			
P61(RL) EXT 16x16 20x20 25x25	R	L				
P61(RL) INT DCON MS = 12 – 32 mm DMIN = 16 – 40 mm			R	L		
P61S(RL)-1 INT DCON MS = 10 – 12 mm DMIN = 12.5 mm					R 	L
Grooving for circlips 	R **X61** CW = 0,85 – 3,2	L **X61** CW = 0,85 – 3,2	L **X61** CW=0,85 – 3,2	R **X61** CW =0,85 – 3,2	L **X61-1** CW=0,85 – 2,2	R **X61-1** CW=0,85 – 2,2
Grooving for o-rings 	R **X61 R** RE = 1 – 1.5	L **X61 R** RE = 1 – 1.5	L **X61 R** RE = 1 – 1.5	R **X61 R** RE = 1 – 1.5	L **X61 R-1** RE = 0.5 – 1	R **X61 R-1** RE = 0.5–1

P61(RL) EXT

P M K N S

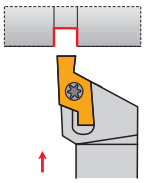
PRAMET

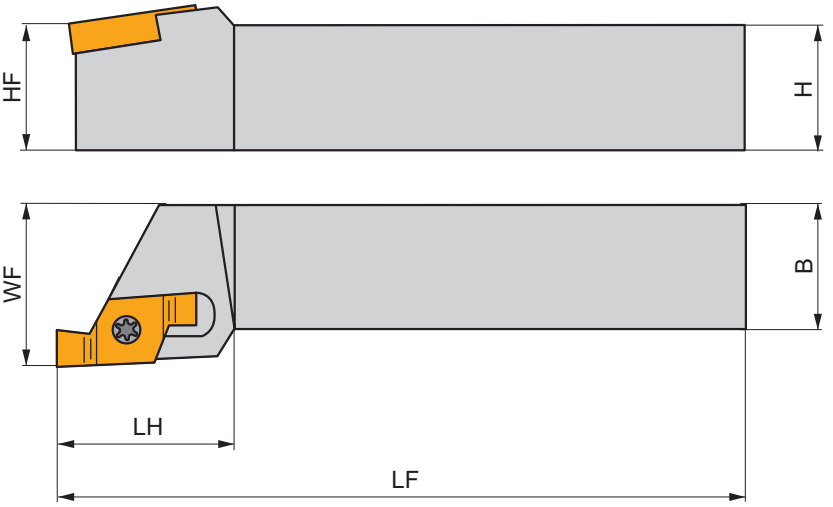
S

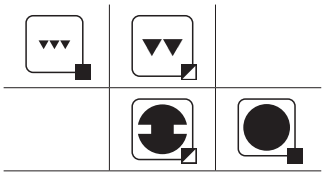


External Grooving Tool Holder for X61 Circlips and O-Ring Inserts

External Right/Left hand radial tool holder for grooving with X61 double-sided circlip or O-ring inserts. Gives smooth cutting action for high tolerated dimensions. Body treated for longer tool life.







	Product	HF (mm)	H (mm)	B (mm)	WF (mm)	LF (mm)	LH (mm)	lbs			MID
R	P61.SFR-1616H-06	16	16	16	20	100	21.0	.49	GI332_1	SV11	7725306
	P61.SFR-2020K-06	20	20	20	25	125	25.0	.89	GI332_1	SV11	7725307
	P61.SFR-2525M-06	25	25	25	32	150	32.0	1.58	GI332_1	SV11	7725308
L	P61.SFL-1616H-06	16	16	16	20	100	21.0	.49	GI332_2	SV11	7725303
	P61.SFL-2020K-06	20	20	20	25	125	25.0	.91	GI332_2	SV11	7725304
	P61.SFL-2525M-06	25	25	25	32	150	32.0	1.60	GI332_2	SV11	7725305

GI332_1	X61 0602.. R
GI332_2	X61 0602.. L

		Nm			
SV11	US 2003-T07P	0.8	M 2.5	0.256	FLAG T07P

P61(RL) INT

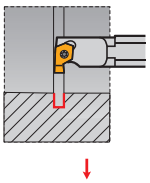
P M K N S

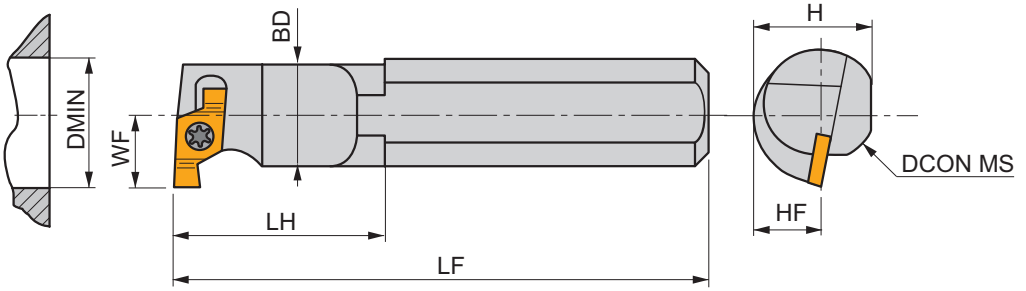
PRAMET

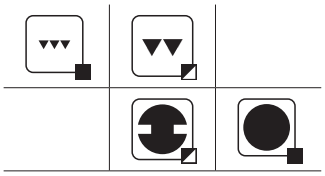
S

Internal Circlip Grooving Boring bar for X61 Inserts

Internal Right/Left hand grooving boring bar for grooving with X61 double-sided inserts. Suited for internal cutting of circlip or O-ring grooves. Body treated for longer tool life.







	Product	DCON MS (mm)	DMIN (mm)	BD (mm)	WF (mm)	H (mm)	LF (mm)	LH (mm)	KAPR (°)		lbs			MID
R	P61.SGR-0012M-06	12	16	11.5	9	11	150	22.0	0	–	.35	GI332_2	SV11	7725317
	P61.SGR-A-0016M-06	16	20	15	11	15	150	29.0	0	✓	.52	GI332_2	SV11	7725319
	P61.SGR-A-0020P-06	20	25	19	13	18	170	29.0	0	✓	.83	GI332_2	SV11	7725320
	P61.SGR-A-0025R-06	25	32	24	17	23	200	31.0	0	✓	1.54	GI332_2	SV11	7725321
	P61.SGR-A-0032T-06	32	40	31	22	30	300	49.0	0	✓	3.79	GI332_2	SV11	7725322
L	P61.SGL-0012M-06	12	16	11.5	9	11	150	22.0	0	–	.35	GI332_1	SV11	7725309
	P61.SGL-A-0016M-06	16	20	15	11	15	150	29.0	0	✓	.51	GI332_1	SV11	7725312
	P61.SGL-A-0020P-06	20	25	19	13	18	170	29.0	0	✓	.86	GI332_1	SV11	7725313
	P61.SGL-A-0025R-06	25	32	24	17	23	200	31.0	0	✓	1.57	GI332_1	SV11	7725314
	P61.SGL-A-0032T-06	32	40	31	22	30	300	49.0	0	✓	3.79	GI332_1	SV11	7725315

GI332_1	X61 0602.. R
GI332_2	X61 0602.. L

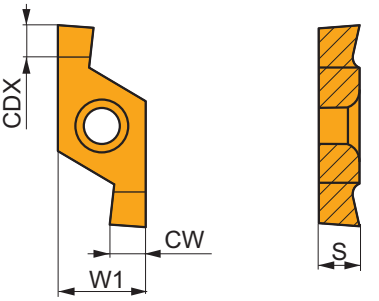
		Nm			
SV11	US 2003-T07P	0.8	M 2.5	0.256	FLAG T07P

Left hand insert mount to righ hand boring bar.

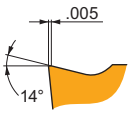
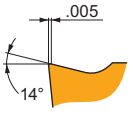
X 61

PRAMET

	W1	CWTOLL	CWTOLU	S
	(inch)	(inch)	(inch)	(inch)
0602	.250	-.001	.001	.092



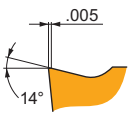
Suitability and starting values for cutting speed (vc) and feed (f). Refer to our Machining Calculator app for further calculations.

Product		RE	P		M		K		N		S		H		CW	CDX	MID
			vc (ft/min)	f (in/rev)	vc (ft/min)	f (in/rev)	vc (ft/min)	f (in/rev)	vc (ft/min)	f (in/rev)	vc (ft/min)	f (in/rev)	vc (ft/min)	f (in/rev)	(inch)	(inch)	
																	
X61 0602-080 R	**6640**	–	640	.0024	377	.002	607	.0024	–	–	–	–	–	–	.033	.031	7721538
	G8330	–	476	.0024	279	.002	443	.0024	–	–	–	–	–	–	.033	.031	7721539
X61 0602-090 R	**6640**	–	640	.0024	377	.002	607	.0024	–	–	–	–	–	–	.037	.031	7721594
	G8330	–	476	.0024	279	.002	443	.0024	–	–	–	–	–	–	.037	.031	7721595
X61 0602-100 R	**6640**	–	640	.0024	377	.002	607	.0024	–	–	–	–	–	–	.041	.031	7721599
	G8330	–	476	.0024	279	.002	443	.0024	–	–	–	–	–	–	.041	.031	7721600
X61 0602-110 R	**6640**	–	607	.0024	361	.002	574	.0024	–	–	–	–	–	–	.045	.047	7721604
	G8330	–	459	.0024	262	.002	427	.0024	–	–	–	–	–	–	.045	.047	7721605
X61 0602-130 R	**6640**	–	607	.0024	361	.002	574	.0024	–	–	–	–	–	–	.053	.055	7721610
	G8330	–	459	.0024	262	.002	427	.0024	–	–	–	–	–	–	.053	.055	7721611
X61 0602-150 R	**6640**	–	591	.0024	344	.002	558	.0024	–	–	–	–	–	–	.061	.063	7721614
	G8330	–	443	.0024	262	.002	410	.0024	–	–	–	–	–	–	.061	.063	7721662
X61 0602-160 R	**6640**	–	591	.0024	344	.002	558	.0024	–	–	–	–	–	–	.065	.067	7721618
	G8330	–	443	.0024	262	.002	410	.0024	–	–	–	–	–	–	.065	.067	7721619
X61 0602-185 R	**6640**	–	492	.0035	295	.0031	459	.0035	–	–	–	–	–	–	.075	.079	7721624
	G8330	–	394	.0035	230	.0031	361	.0035	–	–	–	–	–	–	.075	.079	7721625
X61 0602-200 R	**G8330**	–	377	.0035	213	.0031	344	.0035	–	–	–	–	–	–	.081	.087	7721628
X61 0602-215 R	**6640**	–	476	.0035	279	.0031	443	.0035	–	–	–	–	–	–	.087	.094	7721632
	G8330	–	377	.0035	213	.0031	344	.0035	–	–	–	–	–	–	.087	.094	7721633
X61 0602-250 R	**G8330**	–	377	.0035	213	.0031	344	.0035	–	–	–	–	–	–	.100	.102	7721636
X61 0602-265 R	**6640**	–	410	.0047	246	.0043	377	.0047	–	–	–	–	–	–	.106	.106	7721639
	G8330	–	344	.0047	197	.0043	312	.0047	–	–	–	–	–	–	.106	.106	7721640
X61 0602-300 R	**6640**	–	410	.0047	246	.0043	377	.0047	–	–	–	–	–	–	.120	.118	7721643
	G8330	–	344	.0047	197	.0043	312	.0047	–	–	–	–	–	–	.120	.118	7721644
X61 0602-315 R	**6640**	–	410	.0047	246	.0043	377	.0047	–	–	–	–	–	–	.126	.118	7721647
	G8330	–	344	.0047	197	.0043	312	.0047	–	–	–	–	–	–	.126	.118	7721648
																	
X61 0602-080 L	**6640**	–	640	.0024	377	.002	607	.0024	–	–	–	–	–	–	.033	.031	7721535
	G8330	–	476	.0024	279	.002	443	.0024	–	–	–	–	–	–	.033	.031	7721536
X61 0602-090 L	**6640**	–	640	.0024	377	.002	607	.0024	–	–	–	–	–	–	.037	.031	7721591
	G8330	–	476	.0024	279	.002	443	.0024	–	–	–	–	–	–	.037	.031	7721592
X61 0602-100 L	**6640**	–	640	.0024	377	.002	607	.0024	–	–	–	–	–	–	.041	.031	7721597
	G8330	–	476	.0024	279	.002	443	.0024	–	–	–	–	–	–	.041	.031	7721598

X61-R external and internal, right-handed geometry, for o-ring and circlip groove machining, with continuous cuts.

X61-L external and internal, left-handed geometry, for o-ring and circlip groove machining, with continuous cuts.

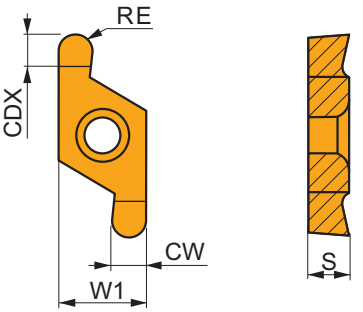
Suitability and starting values for cutting speed (vc) and feed (f). Refer to our Machining Calculator app for further calculations.

Product		RE	P vc (ft/min)	P f (in/rev)	M vc (ft/min)	M f (in/rev)	K vc (ft/min)	K f (in/rev)	N vc (ft/min)	N f (in/rev)	S vc (ft/min)	S f (in/rev)	H vc (ft/min)	H f (in/rev)	CW (inch)	CDX (inch)	MID
																	
X61 0602-110 L	**6640**	–	607	.0024	361	.002	574	.0024	–	–	–	–	–	–	.045	.047	7721601
	G8330	–	459	.0024	262	.002	427	.0024	–	–	–	–	–	–	.045	.047	7721602
X61 0602-130 L	**6640**	–	607	.0024	361	.002	574	.0024	–	–	–	–	–	–	.053	.055	7721607
	G8330	–	459	.0024	262	.002	427	.0024	–	–	–	–	–	–	.053	.055	7721608
X61 0602-150 L	**6640**	–	591	.0024	344	.002	558	.0024	–	–	–	–	–	–	.061	.063	7721613
	G8330	–	443	.0024	262	.002	410	.0024	–	–	–	–	–	–	.061	.063	7721661
X61 0602-160 L	**6640**	–	591	.0024	344	.002	558	.0024	–	–	–	–	–	–	.065	.067	7721615
	G8330	–	443	.0024	262	.002	410	.0024	–	–	–	–	–	–	.065	.067	7721616
X61 0602-185 L	**6640**	–	492	.0035	295	.0031	459	.0035	–	–	–	–	–	–	.075	.079	7721621
	G8330	–	394	.0035	230	.0031	361	.0035	–	–	–	–	–	–	.075	.079	7721622
X61 0602-200 L	**G8330**	–	377	.0035	213	.0031	344	.0035	–	–	–	–	–	–	.081	.087	7721627
X61 0602-215 L	**6640**	–	476	.0035	279	.0031	443	.0035	–	–	–	–	–	–	.087	.094	7721629
	G8330	–	377	.0035	213	.0031	344	.0035	–	–	–	–	–	–	.087	.094	7721630
X61 0602-250 L	**G8330**	–	377	.0035	213	.0031	344	.0035	–	–	–	–	–	–	.100	.102	7721635
X61 0602-265 L	**6640**	–	410	.0047	246	.0043	377	.0047	–	–	–	–	–	–	.106	.106	7721637
	G8330	–	344	.0047	197	.0043	312	.0047	–	–	–	–	–	–	.106	.106	7721638
X61 0602-300 L	**6640**	–	410	.0047	246	.0043	377	.0047	–	–	–	–	–	–	.120	.118	7721641
	G8330	–	344	.0047	197	.0043	312	.0047	–	–	–	–	–	–	.120	.118	7721642
X61 0602-315 L	**6640**	–	410	.0047	246	.0043	377	.0047	–	–	–	–	–	–	.126	.118	7721645
	G8330	–	344	.0047	197	.0043	312	.0047	–	–	–	–	–	–	.126	.118	7721646

X61-L external and internal, left-handed geometry, for o-ring and circlip groove machining, with continuous cuts.

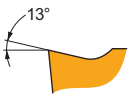
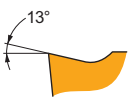
X 61 R

	W1 (inch)	CWTOLL (inch)	CWTOLU (inch)	S (inch)
0602	.250	-.001	.001	.092



PRAMET

Suitability and starting values for cutting speed (vc) and feed (f). Refer to our Machining Calculator app for further calculations.

Product		RE	P vc (ft/min)	P f (in/rev)	M vc (ft/min)	M f (in/rev)	K vc (ft/min)	K f (in/rev)	N vc (ft/min)	N f (in/rev)	S vc (ft/min)	S f (in/rev)	H vc (ft/min)	H f (in/rev)	CW (inch)	CDX (inch)	MID
																	
X61 0602-R100 R	**6640**	.039	558	.0024	328	.002	525	.0024	–	–	–	–	–	–	.082	.118	7721654
	G8330	.039	427	.0024	246	.002	394	.0024	–	–	–	–	–	–	.082	.118	7721655
X61 0602-R150 R	**6640**	.059	574	.0024	344	.002	541	.0024	–	–	–	–	–	–	.122	.118	7721659
	G8330	.059	443	.0024	262	.002	410	.0024	–	–	–	–	–	–	.122	.118	7721660
																	
X61 0602-R100 L	**6640**	.039	558	.0024	328	.002	525	.0024	–	–	–	–	–	–	.082	.118	7721651
	G8330	.039	427	.0024	246	.002	394	.0024	–	–	–	–	–	–	.082	.118	7721652
X61 0602-R150 L	**6640**	.059	574	.0024	344	.002	541	.0024	–	–	–	–	–	–	.122	.118	7721657
	G8330	.059	443	.0024	262	.002	410	.0024	–	–	–	–	–	–	.122	.118	7721658

X61R-R external and internal, right-handed geometry, for o-ring and circlip groove machining, with continuous cuts.

X61R-L external and internal, left-handed geometry, for o-ring and circlip groove machining, with continuous cuts.

P61S(RL)-1 INT

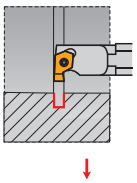
P M K N S

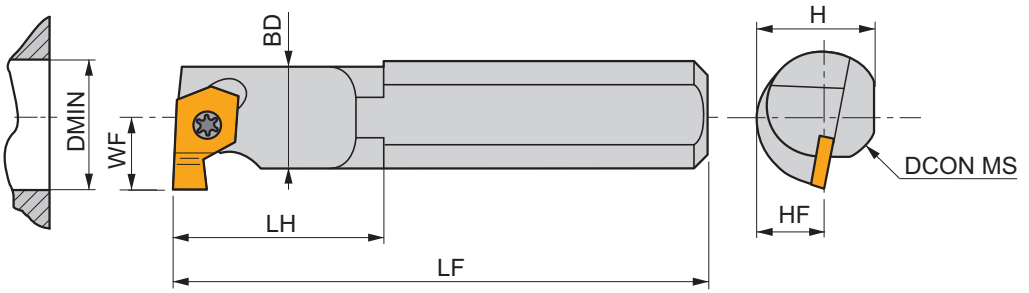
PRAMET

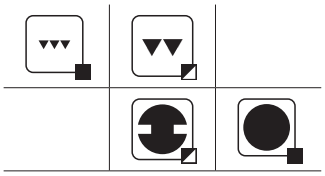
S

Internal Circlip Grooving Boring Bar for X61-1 Inserts

Internal Right/Left hand grooving boring bar for grooving with single-sided X61-1 inserts. Suited for internal cutting of circlip or O-ring grooves. Body treated for longer tool life.







	Product	DCON MS (mm)	DMIN (mm)	BD (mm)	WF (mm)	H (mm)	LF (mm)	LH (mm)	KAPR (°)	lbs			MID
R	P61.SGR-0010M-06/1	10	12.5	10	7.5	9	150	19.0	0	.27	GI333_2	SV11	7725316
	P61.SGR-0012M-06/1	12	12.5	10	7.5	11	150	19.0	0	.35	GI333_2	SV11	7725318
L	P61.SGL-0010M-06/1	10	12.5	10	7.5	9	150	19.0	0	.27	GI333_1	SV11	7725310
	P61.SGL-0012M-06/1	12	12.5	10	7.5	11	150	19.0	0	.35	GI333_1	SV11	7725311

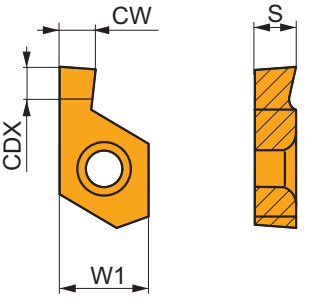
GI333_1	X61 0602..-1 R
GI333_2	X61 0602..-1 R

SV11	US 2003-T07P	0.8	M 2.5	0.256	FLAG T07P

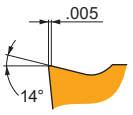
Left hand insert mount to righ hand boring bar.

X 61-1

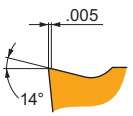
	W1	CWTOLL	CWTOLU	S
	(inch)	(inch)	(inch)	(inch)
0602	.250	-.001	.001	.092



Suitability and starting values for cutting speed (vc) and feed (f). Refer to our Machining Calculator app for further calculations.

Product		RE	P		M		K		N		S		H		CW	CDX	MID
			vc (ft/min)	f (in/rev)	vc (ft/min)	f (in/rev)	vc (ft/min)	f (in/rev)	vc (ft/min)	f (in/rev)	vc (ft/min)	f (in/rev)	vc (ft/min)	f (in/rev)	(inch)	(inch)	
																	
X61 0602-080 R1	**6640**	–	640	.0024	377	.002	607	.0024	–	–	–	–	–	–	.033	.031	7721590
X61 0602-090 R1	**6640**	–	640	.0024	377	.002	607	.0024	–	–	–	–	–	–	.037	.031	7721596
X61 0602-110 R1	**6640**	–	607	.0024	361	.002	574	.0024	–	–	–	–	–	–	.045	.047	7721606
X61 0602-130 R1	**6640**	–	607	.0024	361	.002	574	.0024	–	–	–	–	–	–	.053	.055	7721612
X61 0602-160 R1	**6640**	–	591	.0024	344	.002	558	.0024	–	–	–	–	–	–	.065	.067	7721620
X61 0602-185 R1	**6640**	–	492	.0035	295	.0031	459	.0035	–	–	–	–	–	–	.075	.079	7721626
X61 0602-215 R1	**6640**	–	476	.0035	279	.0031	443	.0035	–	–	–	–	–	–	.087	.087	7721634

X61-1-R internal, right-handed design, with one cutting edge for o-ring and circlip groove machining, with continuous cuts.



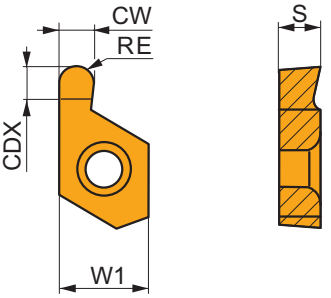
X61 0602-080 L1	**6640**	–	640	.0024	377	.002	607	.0024	–	–	–	–	–	–	.033	.031	7721537
X61 0602-090 L1	**6640**	–	640	.0024	377	.002	607	.0024	–	–	–	–	–	–	.037	.031	7721593
X61 0602-110 L1	**6640**	–	607	.0024	361	.002	574	.0024	–	–	–	–	–	–	.045	.047	7721603
X61 0602-130 L1	**6640**	–	607	.0024	361	.002	574	.0024	–	–	–	–	–	–	.053	.055	7721609
X61 0602-160 L1	**6640**	–	591	.0024	344	.002	558	.0024	–	–	–	–	–	–	.065	.067	7721617
X61 0602-185 L1	**6640**	–	492	.0035	295	.0031	459	.0035	–	–	–	–	–	–	.075	.079	7721623
X61 0602-215 L1	**6640**	–	476	.0035	279	.0031	443	.0035	–	–	–	–	–	–	.087	.087	7721631

X61-1-L internal, left-handed design, with one cutting edge for o-ring and circlip groove machining, with continuous cuts.

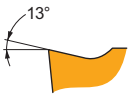
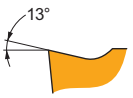
X 61 R-1

PRAMET

	W1	CWTOLL	CWTOLU	S
	(inch)	(inch)	(inch)	(inch)
0602	.250	-.001	.001	.092



Suitability and starting values for cutting speed (vc) and feed (f). Refer to our Machining Calculator app for further calculations.

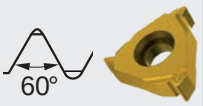
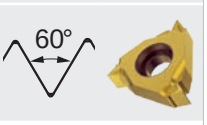
Product		RE	P		M		K		N		S		H		CW	CDX	MID
			vc (ft/min)	f (in/rev)	vc (ft/min)	f (in/rev)	vc (ft/min)	f (in/rev)	vc (ft/min)	f (in/rev)	vc (ft/min)	f (in/rev)	vc (ft/min)	f (in/rev)	(inch)	(inch)	
																	
X61R-1-R internal, right-handed design, with one cutting edge for o-ring and circlip groove machining, with continuous cuts.																	
X61 0602-R050 R1	**6640**	.020	476	.0024	279	.002	443	.0024	–	–	–	–	–	–	.043	.051	7721650
X61 0602-R100 R1	**6640**	.039	558	.0024	328	.002	525	.0024	–	–	–	–	–	–	.082	.110	7721656
																	
X61R-1-L internal, left-handed design, with one cutting edge for o-ring and circlip groove machining, with continuous cuts.																	
X61 0602-R050 L1	**6640**	.020	476	.0024	279	.002	443	.0024	–	–	–	–	–	–	.043	.051	7721649
X61 0602-R100 L1	**6640**	.039	558	.0024	328	.002	525	.0024	–	–	–	–	–	–	.082	.110	7721653

THREAD TURNING

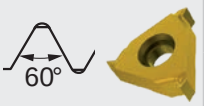
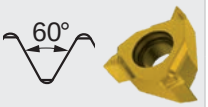
THEARDING – CONTENT

ECONOMY LINE -P1 (directly pressed)

FULL PROFILE

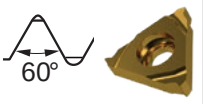
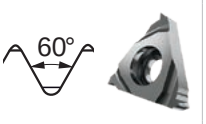
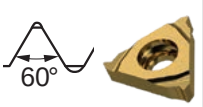
EXTERNAL		INTERNAL	
M		M	
UN		UN	
W		W	
NPT		NPT	

PARTIAL PROFILE

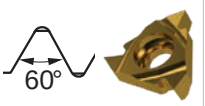
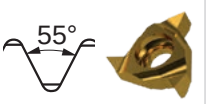
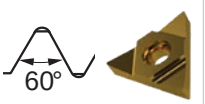
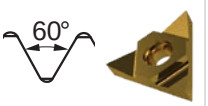
EXTERNAL		INTERNAL	
60°-PP		60°-PP	
55°-PP		55°-PP	

PRECISION LINE (all-ground)

FULL PROFILE

EXTERNAL		INTERNAL	
M		M	
M-AL		M-AL	
UN		UN	
W		W	
TR-S		TR-S	

PARTIAL PROFILE

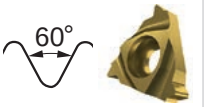
EXTERNAL		INTERNAL	
60°-PP		60°-PP	
55°-PP		55°-PP	
M-S PP		M-S PP	

PRECISION LINE (all-ground)

FULL PROFILE

EXTERNAL		INTERNAL	
TR		TR	
BSPT		BSPT	
RD		RD	

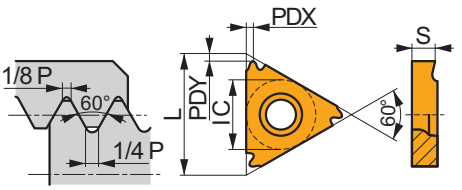
FULL PROFILE

EXTERNAL		INTERNAL	
ACME		ACME	
		STACME	
NPT		NPT	
API RD		API RD	

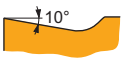
TN M EXT -P1

PRAMET

	IC (inch)	L (inch)	S (inch)
16	.375	.650	.137



Suitability and starting values for cutting speed (vc) and feed (f). Refer to our Machining Calculator app for further calculations.

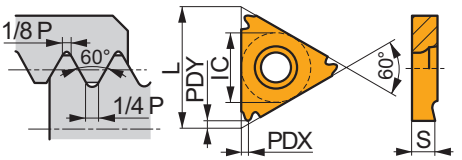
Product		RE (inch)	P vc (ft/min)	M vc (ft/min)	K vc (ft/min)	N vc (ft/min)	S vc (ft/min)	H vc (ft/min)	TP (inch)	TPI	PDX (inch)	PDY (inch)	MID
													
TN 16ER100M-P1	**T8030**	–	525	312	492	1575	131	–	.039	–	.031	.031	6755548
TN 16ER125M-P1	**T8030**	–	525	312	492	1575	131	–	.049	–	.031	.031	6755551
TN 16ER150M-P1	**T8030**	–	525	312	492	1575	131	–	.059	–	.031	.031	6755554
TN 16ER175M-P1	**T8030**	–	525	312	492	1575	131	–	.069	–	.059	.047	6755556
TN 16ER200M-P1	**T8030**	–	525	312	492	1575	131	–	.079	–	.059	.047	6755559
TN 16ER250M-P1	**T8030**	–	525	312	492	1575	131	–	.098	–	.059	.047	6755561
TN 16ER300M-P1	**T8030**	–	525	312	492	1575	131	–	.118	–	.059	.047	6755562

TN M-P1 ER pressed external, right-handed design, for machining ISO Metric threads, and continuous cuts.

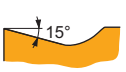
TN M INT -P1

PRAMET

	IC (inch)	L (inch)	S (inch)
11	.250	.433	.118
16	.375	.650	.137



Suitability and starting values for cutting speed (vc) and feed (f). Refer to our Machining Calculator app for further calculations.

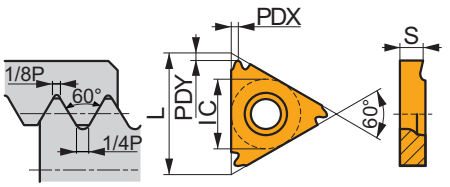
Product		RE (inch)	P vc (ft/min)	M vc (ft/min)	K vc (ft/min)	N vc (ft/min)	S vc (ft/min)	H vc (ft/min)	TP (inch)	TPI	PDX (inch)	PDY (inch)	MID
													
TN 11NR100M-P1	**T8030**	–	525	312	492	1575	131	–	.039	–	.031	.031	6755543
TN 11NR150M-P1	**T8030**	–	525	312	492	1575	131	–	.059	–	.031	.031	6755545
TN 11NR200M-P1	**T8030**	–	525	312	492	1575	131	–	.079	–	–	–	8598930
TN 16NR100M-P1	**T8030**	–	525	312	492	1575	131	–	.039	–	.031	.031	6755564
TN 16NR150M-P1	**T8030**	–	525	312	492	1575	131	–	.059	–	.031	.031	6755569
TN 16NR200M-P1	**T8030**	–	525	312	492	1575	131	–	.079	–	.059	.047	6755572
TN 16NR250M-P1	**T8030**	–	525	312	492	1575	131	–	.098	–	.059	.047	6755574
TN 16NR300M-P1	**T8030**	–	525	312	492	1575	131	–	.118	–	.059	.047	6755575

TN M-P1 NR pressed internal, right-handed design, for machining ISO Metric threads, and continuous cuts.

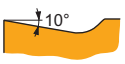
TN UN EXT -P1

PRAMET

	IC (inch)	L (inch)	S (inch)
16	.375	.650	.137



Suitability and starting values for cutting speed (vc) and feed (f). Refer to our Machining Calculator app for further calculations.

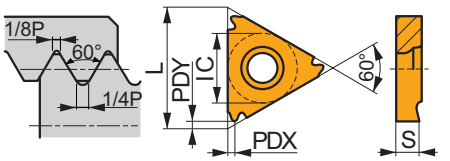
Product		RE (inch)	P vc (ft/min)	M vc (ft/min)	K vc (ft/min)	N vc (ft/min)	S vc (ft/min)	H vc (ft/min)	TP (inch)	TPI	PDX (inch)	PDY (inch)	MID
													
TN 16ER200UN-P1	**T8030**	–	525	312	492	1575	131	–	–	20.0	.031	.031	6755560
TN 16ER180UN-P1	**T8030**	–	525	312	492	1575	131	–	–	18.0	.031	.031	6755557
TN 16ER160UN-P1	**T8030**	–	525	312	492	1575	131	–	–	16.0	.031	.031	6755555
TN 16ER140UN-P1	**T8030**	–	525	312	492	1575	131	–	–	14.0	.059	.047	6755552
TN 16ER120UN-P1	**T8030**	–	525	312	492	1575	131	–	–	12.0	.059	.047	6755550

TN UN-P1 ER pressed external, right-handed design, for machining Unified threads, and continuous cuts.

TN UN INT -P1

PRAMET

	IC (inch)	L (inch)	S (inch)
16	.375	.650	.137



Suitability and starting values for cutting speed (vc) and feed (f). Refer to our Machining Calculator app for further calculations.

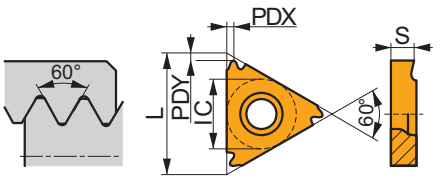
Product		RE (inch)	P vc (ft/min)	M vc (ft/min)	K vc (ft/min)	N vc (ft/min)	S vc (ft/min)	H vc (ft/min)	TP (inch)	TPI	PDX (inch)	PDY (inch)	MID
TN 16NR200UN-P1	**T8030**	–	525	312	492	1575	131	–	–	20.0	.031	.031	6755573
TN 16NR180UN-P1	**T8030**	–	525	312	492	1575	131	–	–	18.0	.031	.031	6755571
TN 16NR160UN-P1	**T8030**	–	525	312	492	1575	131	–	–	16.0	.031	.031	6755570
TN 16NR140UN-P1	**T8030**	–	525	312	492	1575	131	–	–	14.0	.059	.047	6755567
TN 16NR120UN-P1	**T8030**	–	525	312	492	1575	131	–	–	12.0	.059	.047	6755566

TN UN-P1 NR pressed internal, right-handed design, for machining Unified threads, and continuous cuts.

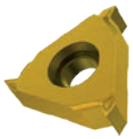
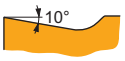
TN 60° PP EXT -P1

PRAMET

	IC (inch)	L (inch)	S (inch)
16	.375	.650	.137



Suitability and starting values for cutting speed (vc) and feed (f). Refer to our Machining Calculator app for further calculations.

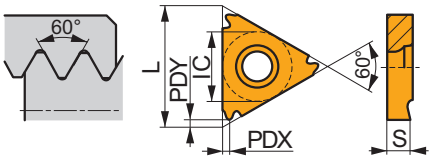
Product		RE (inch)	P vc (ft/min)	M vc (ft/min)	K vc (ft/min)	N vc (ft/min)	S vc (ft/min)	H vc (ft/min)	TPN (inch)	TPX (inch)	TPIN	TPIX	PDX (inch)	PDY (inch)	MID
															
TN 16ERA60-P1	**T8030**	–	525	312	492	1575	131	–	.02	.059	16	48	.031	.024	8320307
TN 16ERAG60-P1	**T8030**	–	525	312	492	1575	131	–	.02	.118	8	48	.059	.043	8320309
TN 16ERG60-P1	**T8030**	–	525	312	492	1575	131	–	.069	.118	8	14	.059	.047	8320308

TN M60-P1 PP ER pressed external, right-handed design, for machining Metric and Unified threads, and continuous cuts.

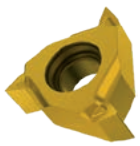
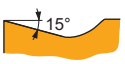
TN 60° PP INT -P1

PRAMET

	IC (inch)	L (inch)	S (inch)
11	.250	.433	.118
16	.375	.650	.137



Suitability and starting values for cutting speed (vc) and feed (f). Refer to our Machining Calculator app for further calculations.

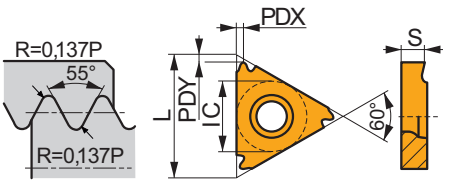
Product		RE (inch)	P vc (ft/min)	M vc (ft/min)	K vc (ft/min)	N vc (ft/min)	S vc (ft/min)	H vc (ft/min)	TPN (inch)	TPX (inch)	TPIN	TPIX	PDX (inch)	PDY (inch)	MID
															
TN 11NRA60-P1	**T8030**	–	525	312	492	1575	131	–	.02	.059	16	48	.031	.028	8320370
TN 16NRAG60-P1	**T8030**	–	525	312	492	1575	131	–	.02	.118	8	48	.059	.043	8320372
TN 16NRG60-P1	**T8030**	–	525	312	492	1575	131	–	.069	.118	8	14	.059	.047	8320371

TN M60-P1 PP NR pressed internal, right-handed design, for machining Metric and Unified threads, and continuous cuts.

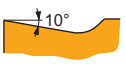
TN W EXT -P1

PRAMET

	IC (inch)	L (inch)	S (inch)
16	.375	.650	.137



Suitability and starting values for cutting speed (vc) and feed (f). Refer to our Machining Calculator app for further calculations.

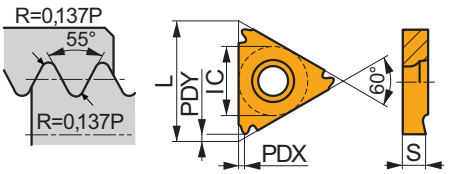
Product		RE (inch)	P vc (ft/min)	M vc (ft/min)	K vc (ft/min)	N vc (ft/min)	S vc (ft/min)	H vc (ft/min)	TP (inch)	TPI	PDX (inch)	PDY (inch)	MID
													
TN 16ER190W-P1	**T8030**	–	525	312	492	1575	131	–	–	19.0	.031	.031	6755558
TN 16ER140W-P1	**T8030**	–	525	312	492	1575	131	–	–	14.0	.059	.047	6755553
TN 16ER110W-P1	**T8030**	–	525	312	492	1575	131	–	–	11.0	.059	.047	6755549

TN W-P1 ER pressed external, right-handed design, for machining Whitworth form threads, and continuous cuts.

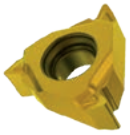
TN W INT -P1

PRAMET

	IC (inch)	L (inch)	S (inch)
11	.250	.433	.118
16	.375	.650	.137



Suitability and starting values for cutting speed (vc) and feed (f). Refer to our Machining Calculator app for further calculations.

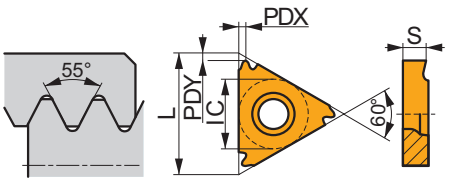
Product		RE (inch)	P vc (ft/min)	M vc (ft/min)	K vc (ft/min)	N vc (ft/min)	S vc (ft/min)	H vc (ft/min)	TP (inch)	TPI	PDX (inch)	PDY (inch)	MID
													
TN 11NR190W-P1	**T8030**	–	525	312	492	1575	131	–	–	19.0	.031	.031	6755546
TN 11NR140W-P1	**T8030**	–	525	312	492	1575	131	–	–	14.0	.035	.028	6755544
TN 16NR140W-P1	**T8030**	–	525	312	492	1575	131	–	–	14.0	.059	.047	6755568
TN 16NR110W-P1	**T8030**	–	525	312	492	1575	131	–	–	11.0	.059	.047	6755565

TN W-P1 NR pressed internal, right-handed design, for machining Whitworth form threads, and continuous cuts.

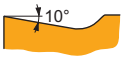
TN 55° PP EXT -P1

PRAMET

	IC (inch)	L (inch)	S (inch)
16	.375	.650	.137



Suitability and starting values for cutting speed (vc) and feed (f). Refer to our Machining Calculator app for further calculations.

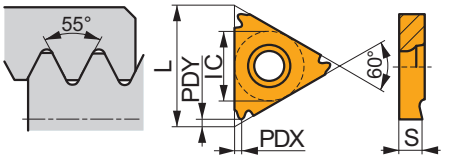
Product		RE (inch)	P vc (ft/min)	M vc (ft/min)	K vc (ft/min)	N vc (ft/min)	S vc (ft/min)	H vc (ft/min)	TPN (inch)	TPX (inch)	TPIN	TPIX	PDX (inch)	PDY (inch)	MID
															
TN 16ERAG55-P1	**T8030**	–	525	312	492	1575	131	–	.02	.118	8	48	–	–	8598931
TN 16ERG55-P1	**T8030**	–	525	312	492	1575	131	–	.069	.118	8	14	–	–	8598932

TN W55-P1 PP ER pressed external, right-handed design, for machining Whitworth threads, and continuous cuts.

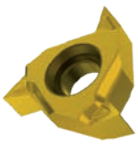
TN 55° PP INT -P1

PRAMET

	IC (inch)	L (inch)	S (inch)
16	.375	.650	.137



Suitability and starting values for cutting speed (vc) and feed (f). Refer to our Machining Calculator app for further calculations.

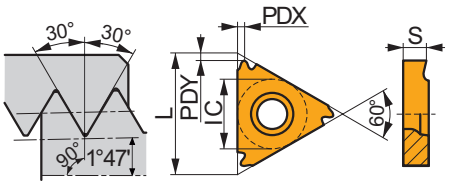
Product		RE (inch)	P vc (ft/min)	M vc (ft/min)	K vc (ft/min)	N vc (ft/min)	S vc (ft/min)	H vc (ft/min)	TPN (inch)	TPX (inch)	TPIN	TPIX	PDX (inch)	PDY (inch)	MID
															
TN 16NRAG55-P1	**T8030**	–	525	312	492	1575	131	–	.02	.059	16	48	–	–	8598933

TN W55-P1 PP NR pressed internal, right-handed design, for machining Whitworth threads, and continuous cuts.

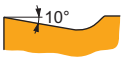
TN NPT EXT -P1

PRAMET

	IC (inch)	L (inch)	S (inch)
16	.375	.650	.137



Suitability and starting values for cutting speed (vc) and feed (f). Refer to our Machining Calculator app for further calculations.

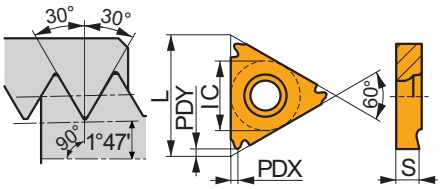
Product		RE (inch)	P vc (ft/min)	M vc (ft/min)	K vc (ft/min)	N vc (ft/min)	S vc (ft/min)	H vc (ft/min)	TP (inch)	TPI	PDX (inch)	PDY (inch)	MID
													
TN 16ER115NPT-P1	**T8030**	–	525	312	492	1575	131	–	–	11.5	–	–	8598868

TN NPT-P1 ER pressed external, right-handed design, for machining NPT threads, and continuous cuts.

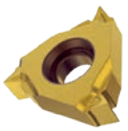
TN NPT INT -P1

PRAMET

	IC (inch)	L (inch)	S (inch)
16	.375	.650	.137



Suitability and starting values for cutting speed (vc) and feed (f). Refer to our Machining Calculator app for further calculations.

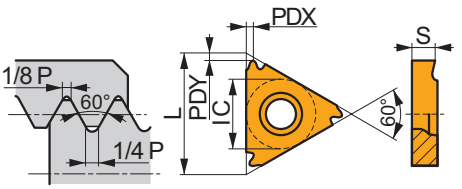
Product		RE (inch)	P vc (ft/min)	M vc (ft/min)	K vc (ft/min)	N vc (ft/min)	S vc (ft/min)	H vc (ft/min)	TP (inch)	TPI	PDX (inch)	PDY (inch)	MID
													
TN 16NR115NPT-P1	**T8030**	–	525	312	492	1575	131	–	–	11.5	–	–	8598869

TN NPT-P1 NR pressed internal, right-handed design, for machining NPT threads, and continuous cuts.

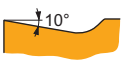
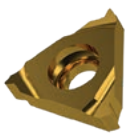
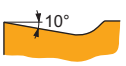
TN M EXT

PRAMET

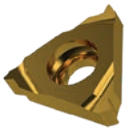
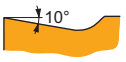
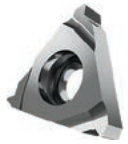
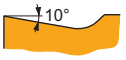
	IC (inch)	L (inch)	S (inch)
16	.375	.650	.137
22	.500	.866	.185



Suitability and starting values for cutting speed (vc) and feed (f). Refer to our Machining Calculator app for further calculations.

Product		RE (inch)	P vc (ft/min)	M vc (ft/min)	K vc (ft/min)	N vc (ft/min)	S vc (ft/min)	H vc (ft/min)	TP (inch)	TPI	PDX (inch)	PDY (inch)	MID
			**TN** M ER external, right-handed design, for machining ISO Metric threads, and continuous cuts.										
TN 16ER050M	**T8010**	–	574	344	541	–	131	–	.02	–	.031	.031	7575377
	T8030	–	525	312	492	1575	131	–	.02	–	.031	.031	6755176
TN 16ER075M	**T8010**	–	574	344	541	–	131	–	.03	–	.031	.031	7575378
	T8030	–	525	312	492	1575	131	–	.03	–	.031	.031	6755177
TN 16ER080M	**T8030**	–	525	312	492	1575	131	–	.031	–	.024	.031	6755393
TN 16ER100M	**T8010**	–	574	344	541	–	131	–	.039	–	.031	.031	7575380
	T8030	–	525	312	492	1575	131	–	.039	–	.031	.031	6755167
TN 16ER125M	**T8010**	–	574	344	541	–	131	–	.049	–	.031	.031	7575381
	T8030	–	525	312	492	1575	131	–	.049	–	.031	.031	6755172
TN 16ER150M	**T8010**	–	574	344	541	–	131	–	.059	–	.031	.031	7575382
	T8030	–	525	312	492	1575	131	–	.059	–	.031	.031	6755164
TN 16ER175M	**T8010**	–	574	344	541	–	131	–	.069	–	.059	.047	7575383
	T8030	–	525	312	492	1575	131	–	.069	–	.059	.047	6755173
TN 16ER200M	**T8010**	–	574	344	541	–	131	–	.079	–	.059	.047	7575384
	T8030	–	525	312	492	1575	131	–	.079	–	.059	.047	6755168
TN 16ER250M	**T8010**	–	574	344	541	–	131	–	.098	–	.059	.047	7575385
	T8030	–	525	312	492	1575	131	–	.098	–	.059	.047	6755175
TN 16ER300M	**T8010**	–	574	344	541	–	131	–	.118	–	.059	.047	7575386
	T8030	–	525	312	492	1575	131	–	.118	–	.059	.047	6755166
TN 16ER350M	**T8030** [1]	–	525	312	492	1575	131	–	.138	–	.067	.047	7800209
TN 22ER350M	**T8030**	–	525	312	492	1575	131	–	.138	–	.098	.071	6755209
TN 22ER400M	**T8010**	–	574	344	541	–	131	–	.157	–	.098	.071	7575388
	T8030	–	525	312	492	1575	131	–	.157	–	.098	.071	6755210
TN 22ER450M	**T8030**	–	525	312	492	1575	131	–	.177	–	.098	.071	6755211
TN 22ER500M	**T8030**	–	525	312	492	1575	131	–	.197	–	.098	.071	6755212
			**TN** M EL external, left-handed design, for machining ISO Metric threads, and continuous cuts.										
TN 16EL050M	**T8030**	–	525	312	492	1575	131	–	.02	–	.031	.031	6755196
TN 16EL075M	**T8030**	–	525	312	492	1575	131	–	.03	–	.031	.031	6755197
TN 16EL080M	**T8030**	–	525	312	492	1575	131	–	.031	–	.024	.031	6755392
TN 16EL100M	**T8010**	–	574	344	541	–	131	–	.039	–	.031	.031	7575370
	T8030	–	525	312	492	1575	131	–	.039	–	.031	.031	6755198
TN 16EL125M	**T8030**	–	525	312	492	1575	131	–	.049	–	.031	.031	6755199

Suitability and starting values for cutting speed (vc) and feed (f). Refer to our Machining Calculator app for further calculations.

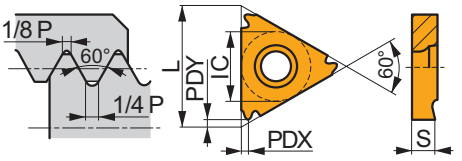
Product		RE (inch)	P vc (ft/min)		M vc (ft/min)		K vc (ft/min)		N vc (ft/min)		S vc (ft/min)		H vc (ft/min)		TP (inch)	TPI	PDX (inch)	PDY (inch)	MID
			**TN** M EL external, left-handed design, for machining ISO Metric threads, and continuous cuts.																
TN 16EL150M	**T8010**	–	574		344		541		–		131		–		.059	–	.031	.031	7575372
	T8030	–	525		312		492		1575		131		–		.059	–	.031	.031	6755200
TN 16EL175M	**T8030**	–	525		312		492		1575		131		–		.069	–	.059	.047	6755201
TN 16EL200M	**T8030**	–	525		312		492		1575		131		–		.079	–	.059	.047	6755202
TN 16EL250M	**T8030**	–	525		312		492		1575		131		–		.098	–	.059	.047	6755203
TN 16EL300M	**T8010**	–	574		344		541		–		131		–		.118	–	.059	.047	7575376
	T8030	–	525		312		492		1575		131		–		.118	–	.059	.047	6755204
TN 22EL350M	**T8030**	–	525		312		492		1575		131		–		.138	–	.098	.071	6755205
TN 22EL400M	**T8030**	–	525		312		492		1575		131		–		.157	–	.098	.071	6755206
TN 22EL450M	**T8030**	–	525		312		492		1575		131		–		.177	–	.098	.071	6755207
			**TN** M-AL ER external, right-handed design, for machining ISO Metric threads, and continuous cuts.																
TN 16ER100M-AL	**HF7**	–	–		312		–		1575		–		–		.039	–	.031	.031	7800246
TN 16ER125M-AL	**HF7**	–	–		312		–		1575		–		–		.049	–	.031	.031	7800247
TN 16ER150M-AL	**HF7**	–	–		312		–		1575		–		–		.059	–	.031	.031	7800248
TN 16ER200M-AL	**HF7**	–	–		312		–		1575		–		–		.079	–	.059	.047	7800250

[1] Toolholders have to be modified.

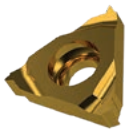
TN M INT

PRAMET

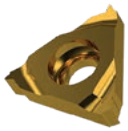
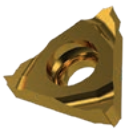
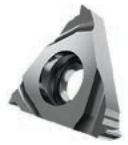
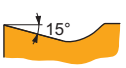
	IC (inch)	L (inch)	S (inch)
11	.250	.433	.118
16	.375	.650	.137
22	.500	.866	.185



Suitability and starting values for cutting speed (vc) and feed (f). Refer to our Machining Calculator app for further calculations.

Product		RE (inch)	P vc (ft/min)		M vc (ft/min)		K vc (ft/min)		N vc (ft/min)		S vc (ft/min)		H vc (ft/min)		TP (inch)	TPI	PDX (inch)	PDY (inch)	MID
			**TN** M NR internal, right-handed design, for machining ISO Metric threads, and continuous cuts.																
TN 11NR050M	**T8030**	–	525		312		492		1575		131		–		.02	–	.031	.031	6755373
TN 11NR075M	**T8010**	–	574		344		541		–		131		–		.03	–	.031	.031	7575394
	T8030	–	525		312		492		1575		131		–		.03	–	.031	.031	6755374
TN 11NR100M	**T8030**	–	525		312		492		1575		131		–		.039	–	.031	.031	6755375
TN 11NR125M	**T8030**	–	525		312		492		1575		131		–		.049	–	.031	.031	6755376
TN 11NR150M	**T8010**	–	574		344		541		–		131		–		.059	–	.031	.031	7575397
	T8030	–	525		312		492		1575		131		–		.059	–	.031	.031	6755377

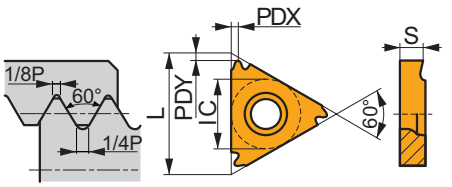
Suitability and starting values for cutting speed (vc) and feed (f). Refer to our Machining Calculator app for further calculations.

Product		RE (inch)	P vc (ft/min)	M vc (ft/min)	K vc (ft/min)	N vc (ft/min)	S vc (ft/min)	H vc (ft/min)	TP (inch)	TPI	PDX (inch)	PDY (inch)	MID
													
TN M NR internal, right-handed design, for machining ISO Metric threads, and continuous cuts.													
TN 11NR200M	**T8010**	–	574	344	541	–	131	–	.079	–	.035	.031	7575398
	T8030	–	525	312	492	1575	131	–	.079	–	.035	.031	6755394
TN 16NR050M	**T8030**	–	525	312	492	1575	131	–	.02	–	.031	.031	6755187
TN 16NR075M	**T8030**	–	525	312	492	1575	131	–	.03	–	.031	.031	6755188
TN 16NR100M	**T8010**	–	574	344	541	–	131	–	.039	–	.031	.031	7575408
	T8030	–	525	312	492	1575	131	–	.039	–	.031	.031	6755189
TN 16NR125M	**T8030**	–	525	312	492	1575	131	–	.049	–	.031	.031	6755190
TN 16NR150M	**T8010**	–	574	344	541	–	131	–	.059	–	.031	.031	7575410
	T8030	–	525	312	492	1575	131	–	.059	–	.031	.031	6755191
TN 16NR175M	**T8030**	–	525	312	492	1575	131	–	.069	–	.059	.047	6755192
TN 16NR200M	**T8010**	–	574	344	541	–	131	–	.079	–	.059	.047	7575412
	T8030	–	525	312	492	1575	131	–	.079	–	.059	.047	6755193
TN 16NR250M	**T8010**	–	574	344	541	–	131	–	.098	–	.059	.047	7575413
	T8030	–	525	312	492	1575	131	–	.098	–	.059	.047	6755194
TN 16NR300M	**T8010**	–	574	344	541	–	131	–	.118	–	.059	.047	7575414
	T8030	–	525	312	492	1575	131	–	.118	–	.059	.047	6755195
TN 16NR350M	**T8030** [1]	–	525	312	492	1575	131	–	.138	–	.063	.047	7800241
TN 22NR350M	**T8030**	–	525	312	492	1575	131	–	.138	–	.098	.071	6755216
TN 22NR400M	**T8010**	–	574	344	541	–	131	–	.157	–	.098	.071	7575416
	T8030	–	525	312	492	1575	131	–	.157	–	.098	.071	6755217
TN 22NR450M	**T8010**	–	574	344	541	–	131	–	.177	–	.098	.071	7575417
	T8030	–	525	312	492	1575	131	–	.177	–	.098	.071	6755218
TN 22NR500M	**T8010**	–	574	344	541	–	131	–	.197	–	.098	.071	7575418
	T8030	–	525	312	492	1575	131	–	.197	–	.098	.071	6755219
													
TN M NL internal, left-handed design, for machining ISO Metric threads, and continuous cuts.													
TN 11NL050M	**T8030**	–	525	312	492	1575	131	–	.02	–	.031	.031	6755368
TN 11NL100M	**T8030**	–	525	312	492	1575	131	–	.039	–	.031	.031	6755370
TN 11NL150M	**T8030**	–	525	312	492	1575	131	–	.059	–	.031	.031	6755372
TN 11NL200M	**T8030**	–	525	312	492	1575	131	–	.079	–	.035	.031	6755395
TN 16NL100M	**T8030**	–	525	312	492	1575	131	–	.039	–	.031	.031	6755180
TN 16NL125M	**T8030**	–	525	312	492	1575	131	–	.049	–	.031	.031	6755181
TN 16NL150M	**T8010**	–	574	344	541	–	131	–	.059	–	.031	.031	7575401
	T8030	–	525	312	492	1575	131	–	.059	–	.031	.031	6755182
TN 16NL175M	**T8030**	–	525	312	492	1575	131	–	.069	–	.059	.047	6755183
TN 16NL200M	**T8010**	–	574	344	541	–	131	–	.079	–	.059	.047	7575403
	T8030	–	525	312	492	1575	131	–	.079	–	.059	.047	6755184
TN 16NL250M	**T8030**	–	525	312	492	1575	131	–	.098	–	.059	.047	6755185
TN 16NL300M	**T8010**	–	574	344	541	–	131	–	.118	–	.059	.047	7575405
	T8030	–	525	312	492	1575	131	–	.118	–	.059	.047	6755186
TN 22NL350M	**T8030**	–	525	312	492	1575	131	–	.138	–	.098	.071	6755213
TN 22NL400M	**T8030**	–	525	312	492	1575	131	–	.157	–	.098	.071	6755214
													
TN M-AL NR internal, right-handed design, for machining ISO Metric threads, and continuous cuts.													
TN 16NR150M-AL	**HF7**	–	–	312	–	1575	–	–	.059	–	.031	.031	7800257
TN 16NR200M-AL	**HF7**	–	–	312	–	1575	–	–	.079	–	.059	.047	7800259

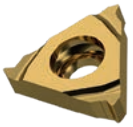
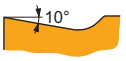
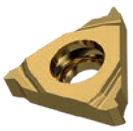
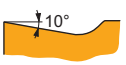
[1] Toolholders have to be modified.

TN UN EXT

	IC	L	S
	(inch)	(inch)	(inch)
16	.375	.650	.137
22	.500	.866	.185

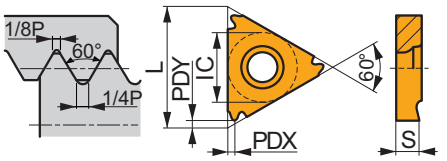


Suitability and starting values for cutting speed (vc) and feed (f). Refer to our Machining Calculator app for further calculations.

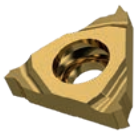
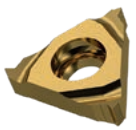
Product		RE	P	M	K	N	S	H	TP	TPI	PDX	PDY	MID
			vc	vc	vc	vc	vc	vc					
		(inch)	(ft/min)	(ft/min)	(ft/min)	(ft/min)	(ft/min)	(ft/min)	(inch)		(inch)	(inch)	
													
TN UN ER external, right-handed design, for machining Unified threads and continuous cuts.													
TN 16ER320UN	**T8030**	–	525	312	492	1575	131	–	–	32.0	.031	.031	6755292
TN 16ER280UN	**T8030**	–	525	312	492	1575	131	–	–	28.0	.031	.031	6755291
TN 16ER240UN	**T8030**	–	525	312	492	1575	131	–	–	24.0	.031	.031	6755290
TN 16ER200UN	**T8010**	–	574	344	541	–	131	–	–	20.0	.031	.031	7575423
	T8030	–	525	312	492	1575	131	–	–	20.0	.031	.031	6755289
TN 16ER180UN	**T8030**	–	525	312	492	1575	131	–	–	18.0	.031	.031	6755288
TN 16ER160UN	**T8030**	–	525	312	492	1575	131	–	–	16.0	.031	.031	6755287
TN 16ER140UN	**T8030**	–	525	312	492	1575	131	–	–	14.0	.059	.047	6755286
TN 16ER130UN	**T8030**	–	525	312	492	1575	131	–	–	13.0	.059	.047	6755285
TN 16ER120UN	**T8030**	–	525	312	492	1575	131	–	–	12.0	.059	.047	6755284
TN 16ER110UN	**T8030**	–	525	312	492	1575	131	–	–	11.0	.059	.047	6755283
TN 16ER100UN	**T8030**	–	525	312	492	1575	131	–	–	10.0	.059	.047	6755282
TN 16ER090UN	**T8030**	–	525	312	492	1575	131	–	–	9.0	.059	.047	6755281
TN 16ER080UN	**T8030**	–	525	312	492	1575	131	–	–	8.0	.059	.047	6755280
TN 22ER070UN	**T8030**	–	525	312	492	1575	131	–	–	7.0	.098	.071	6755321
TN 22ER060UN	**T8030**	–	525	312	492	1575	131	–	–	6.0	.098	.071	6755320
													
TN UN EL external, left-handed design, for machining Unified threads, and continuous cuts.													
TN 16EL200UN	**T8030**	–	525	312	492	1575	131	–	–	20.0	.031	.031	6755276
TN 16EL120UN	**T8030**	–	525	312	492	1575	131	–	–	12.0	.059	.047	6755272
TN 16EL100UN	**T8030**	–	525	312	492	1575	131	–	–	10.0	.059	.047	6755270

TN UN INT

	IC	L	S
	(inch)	(inch)	(inch)
16	.375	.650	.137
22	.500	.866	.185



Suitability and starting values for cutting speed (vc) and feed (f). Refer to our Machining Calculator app for further calculations.

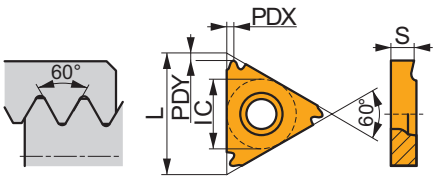
Product		RE	P	M	K	N	S	H	TP	TPI	PDX	PDY	MID
			vc	vc	vc	vc	vc	vc					
		(inch)	(ft/min)	(ft/min)	(ft/min)	(ft/min)	(ft/min)	(ft/min)	(inch)		(inch)	(inch)	
													
TN 16NR200UN	**T8030**	–	525	312	492	1575	131	–	–	20.0	.031	.031	6755312
TN 16NR180UN	**T8030**	–	525	312	492	1575	131	–	–	18.0	.031	.031	6755311
TN 16NR160UN	**T8030**	–	525	312	492	1575	131	–	–	16.0	.031	.031	6755310
TN 16NR140UN	**T8030**	–	525	312	492	1575	131	–	–	14.0	.059	.047	6755309
TN 16NR120UN	**T8030**	–	525	312	492	1575	131	–	–	12.0	.059	.047	6755307
TN 16NR110UN	**T8030**	–	525	312	492	1575	131	–	–	11.0	.059	.047	6755306
TN 16NR100UN	**T8030**	–	525	312	492	1575	131	–	–	10.0	.059	.047	6755305
TN 16NR080UN	**T8030**	–	525	312	492	1575	131	–	–	8.0	.059	.047	6755304
TN 22NR050UN	**T8030**	–	525	312	492	1575	131	–	–	5.0	.098	.071	6755324
													
TN 16NL120UN	**T8030**	–	525	312	492	1575	131	–	–	12.0	.059	.047	6755296
TN 16NL080UN	**T8030**	–	525	312	492	1575	131	–	–	8.0	.059	.047	6755293

TN UN NR internal, right-handed design, for machining Unified threads, and continuous cuts.

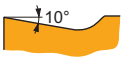
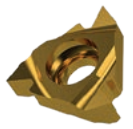
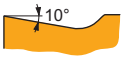
TN UN NL internal, left-handed design, for machining Unified threads, and continuous cuts.

TN 60° PP EXT

	IC	L	S
	(inch)	(inch)	(inch)
16	.375	.650	.137
22	.500	.866	.185



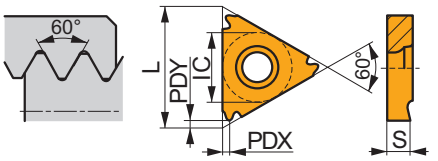
Suitability and starting values for cutting speed (vc) and feed (f). Refer to our Machining Calculator app for further calculations.

Product		RE	P	M	K	N	S	H	TPN	TPX	TPIN	TPIX	PDX	PDY	MID
			vc	vc	vc	vc	vc	vc							
		(inch)	(ft/min)	(ft/min)	(ft/min)	(ft/min)	(ft/min)	(ft/min)	(inch)	(inch)			(inch)	(inch)	
															
TN M60 PP ER external, right-handed design, for machining Metric and Unified threads, and continuous cuts.															
TN 16ERA60	**T8030**	–	525	312	492	1575	131	–	.02	.059	16	48	.031	.024	6755508
TN 16ERAG60	**T8010**	–	574	344	541	–	131	–	.02	.118	8	48	.059	.043	7575361
	T8030	–	525	312	492	1575	131	–	.02	.118	8	48	.059	.043	6755507
TN 16ERG60	**T8010**	–	574	344	541	–	131	–	.069	.118	8	14	.059	.043	7575362
	T8030	–	525	312	492	1575	131	–	.069	.118	8	14	.059	.043	6755509
TN 22ERN60	**T8010**	–	574	344	541	–	131	–	.138	.197	5	7	.098	.071	7575363
	T8030	–	525	312	492	1575	131	–	.138	.197	5	7	.098	.071	6755511
															
TN M60 PP EL external, left-handed design, for machining Metric and Unified threads, and continuous cuts.															
TN 16ELA60	**T8030**	–	525	312	492	1575	131	–	.02	.059	16	48	.031	.024	6755534
TN 16ELAG60	**T8010**	–	574	344	541	–	131	–	.02	.118	8	48	.059	.043	7575319
	T8030	–	525	312	492	1575	131	–	.02	.118	8	48	.059	.043	6755510
TN 16ELG60	**T8030**	–	525	312	492	1575	131	–	.069	.118	8	14	.059	.043	6755535
TN 22ELN60	**T8030**	–	525	312	492	1575	131	–	.138	.197	5	7	.098	.071	6755512

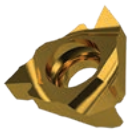
TN 60° PP INT

PRAMET

	IC	L	S
	(inch)	(inch)	(inch)
11	.250	.433	.118
16	.375	.650	.137
22	.500	.866	.185



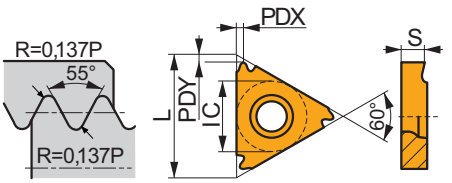
Suitability and starting values for cutting speed (vc) and feed (f). Refer to our Machining Calculator app for further calculations.

Product		RE	P	M	K	N	S	H	TPN	TPX	TPIN	TPIX	PDX	PDY	MID
			vc	vc	vc	vc	vc	vc							
		(inch)	(ft/min)	(ft/min)	(ft/min)	(ft/min)	(ft/min)	(ft/min)	(inch)	(inch)			(inch)	(inch)	
															
TN M60 PP NR internal, right-handed design, for machining Metric and Unified threads, and continuous cuts.															
TN 11NRA60	**T8030**	–	■ 525	■ 312	■ 492	◪ 1575	◪ 131	–	.02	.059	16	48	.031	.028	6755513
TN 16NRA60	**T8030**	–	■ 525	■ 312	■ 492	◪ 1575	◪ 131	–	.02	.059	16	48	.031	.028	6755517
TN 16NRAG60	**T8010**	–	■ 574	◪ 344	■ 541	–	◪ 131	–	.02	.118	8	48	.059	.043	7575367
	T8030	–	■ 525	■ 312	■ 492	◪ 1575	◪ 131	–	.02	.118	8	48	.059	.043	6755515
TN 16NRG60	**T8030**	–	■ 525	■ 312	■ 492	◪ 1575	◪ 131	–	.069	.118	8	14	.059	.043	6755516
TN 22NRN60	**T8010**	–	■ 574	◪ 344	■ 541	–	◪ 131	–	.138	.197	5	7	.098	.071	7575369
	T8030	–	■ 525	■ 312	■ 492	◪ 1575	◪ 131	–	.138	.197	5	7	.098	.071	6755519
TN M60 PP NL internal, left-handed design, for machining Metric and Unified threads, and continuous cuts.															
TN 11NLA60	**T8030**	–	■ 525	■ 312	■ 492	◪ 1575	◪ 131	–	.02	.059	16	48	.031	.028	6755514
TN 16NLAG60	**T8030**	–	■ 525	■ 312	■ 492	◪ 1575	◪ 131	–	.02	.118	8	48	.059	.043	6755518
TN 22NLN60	**T8030**	–	■ 525	■ 312	■ 492	◪ 1575	◪ 131	–	.138	.197	5	7	.098	.071	6755520

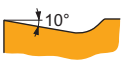
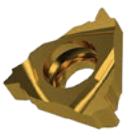
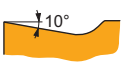
TN W EXT

PRAMET

	IC (inch)	L (inch)	S (inch)
16	.375	.650	.137
22	.500	.866	.185



Suitability and starting values for cutting speed (vc) and feed (f). Refer to our Machining Calculator app for further calculations.

Product		RE (inch)	P vc (ft/min)		M vc (ft/min)		K vc (ft/min)		N vc (ft/min)		S vc (ft/min)		H vc (ft/min)		TP (inch)	TPI	PDX (inch)	PDY (inch)	MID
																			
TN 16ER280W	**T8030**	–	■	525	■	312	■	492	◪	1575	◪	131		–	–	28.0	.031	.031	6755237
TN 16ER240W	**T8030**	–	■	525	■	312	■	492	◪	1575	◪	131		–	–	24.0	.031	.031	7800266
TN 16ER200W	**T8030**	–	■	525	■	312	■	492	◪	1575	◪	131		–	–	20.0	.031	.031	6755236
TN 16ER190W	**T8010**	–	■	574	◪	344	■	541		–	◪	131		–	–	19.0	.031	.031	7575429
	T8030	–	■	525	■	312	■	492	◪	1575	◪	131		–	–	19.0	.031	.031	6755235
TN 16ER180W	**T8030**	–	■	525	■	312	■	492	◪	1575	◪	131		–	–	18.0	.031	.031	6755234
TN 16ER160W	**T8030**	–	■	525	■	312	■	492	◪	1575	◪	131		–	–	16.0	.031	.031	6755233
TN 16ER140W	**T8030**	–	■	525	■	312	■	492	◪	1575	◪	131		–	–	14.0	.059	.047	6755169
TN 16ER120W	**T8030**	–	■	525	■	312	■	492	◪	1575	◪	131		–	–	12.0	.059	.047	6755232
TN 16ER110W	**T8010**	–	■	574	◪	344	■	541		–	◪	131		–	–	11.0	.059	.047	7575427
	T8030	–	■	525	■	312	■	492	◪	1575	◪	131		–	–	11.0	.059	.047	6755165
TN 16ER100W	**T8030**	–	■	525	■	312	■	492	◪	1575	◪	131		–	–	10.0	.059	.047	6755367
TN 16ER080W	**T8030**	–	■	525	■	312	■	492	◪	1575	◪	131		–	–	8.0	.059	.047	6755230
TN 22ER070W	**T8030**	–	■	525	■	312	■	492	◪	1575	◪	131		–	–	7.0	.098	.071	6755261
TN 22ER060W	**T8030**	–	■	525	■	312	■	492	◪	1575	◪	131		–	–	6.0	.098	.071	6755260
TN 22ER050W	**T8030**	–	■	525	■	312	■	492	◪	1575	◪	131		–	–	5.0	.098	.067	6755259
																			
TN 16EL190W	**T8030**	–	■	525	■	312	■	492	◪	1575	◪	131		–	–	19.0	.031	.031	6755227
TN 16EL140W	**T8030**	–	■	525	■	312	■	492	◪	1575	◪	131		–	–	14.0	.059	.047	6755225
TN 16EL120W	**T8030**	–	■	525	■	312	■	492	◪	1575	◪	131		–	–	12.0	.059	.047	6755224
TN 16EL110W	**T8030**	–	■	525	■	312	■	492	◪	1575	◪	131		–	–	11.0	.059	.047	6755223
TN 16EL100W	**T8030**	–	■	525	■	312	■	492	◪	1575	◪	131		–	–	10.0	.059	.047	6755222
TN 16EL080W	**T8030**	–	■	525	■	312	■	492	◪	1575	◪	131		–	–	8.0	.059	.047	6755220

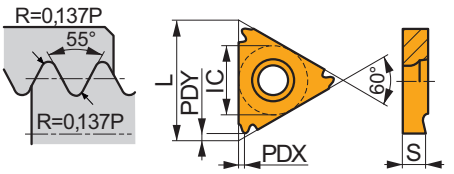
TN W ER external, right-handed design, for machining Whitworth form threads, and continuous cuts.

TN W EL external, left-handed design, for machining Whitworth form threads, and continuous cuts.

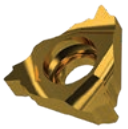
TN W INT

PRAMET

	IC	L	S
	(inch)	(inch)	(inch)
11	.250	.433	.118
16	.375	.650	.137
22	.500	.866	.185



Suitability and starting values for cutting speed (vc) and feed (f). Refer to our Machining Calculator app for further calculations.

Product		RE	P	M	K	N	S	H	TP	TPI	PDX	PDY	MID
			vc	vc	vc	vc	vc	vc					
		(inch)	(ft/min)	(ft/min)	(ft/min)	(ft/min)	(ft/min)	(ft/min)	(inch)		(inch)	(inch)	
													
TN 11NR190W	**T8030**	–	■ 525	■ 312	■ 492	◪ 1575	◪ 131	–	–	19.0	.031	.031	6755381
TN 11NR140W	**T8010**	–	■ 574	◪ 344	■ 541	–	◪ 131	–	–	14.0	.035	.028	7575430
	T8030	–	■ 525	■ 312	■ 492	◪ 1575	◪ 131	–	–	14.0	.035	.028	6755380
TN 16NR280W	**T8030**	–	■ 525	■ 312	■ 492	◪ 1575	◪ 131	–	–	28.0	.031	.031	6755255
TN 16NR190W	**T8010**	–	■ 574	◪ 344	■ 541	–	◪ 131	–	–	19.0	.031	.031	7575434
	T8030	–	■ 525	■ 312	■ 492	◪ 1575	◪ 131	–	–	19.0	.031	.031	6755253
TN 16NR160W	**T8030**	–	■ 525	■ 312	■ 492	◪ 1575	◪ 131	–	–	16.0	.031	.031	6755252
TN 16NR140W	**T8010**	–	■ 574	◪ 344	■ 541	–	◪ 131	–	–	14.0	.059	.047	7575433
	T8030	–	■ 525	■ 312	■ 492	◪ 1575	◪ 131	–	–	14.0	.059	.047	6755170
TN 16NR120W	**T8030**	–	■ 525	■ 312	■ 492	◪ 1575	◪ 131	–	–	12.0	.059	.047	6755251
TN 16NR110W	**T8010**	–	■ 574	◪ 344	■ 541	–	◪ 131	–	–	11.0	.059	.047	7575432
	T8030	–	■ 525	■ 312	■ 492	◪ 1575	◪ 131	–	–	11.0	.059	.047	6755171
TN 16NR100W	**T8030**	–	■ 525	■ 312	■ 492	◪ 1575	◪ 131	–	–	10.0	.059	.047	6755250
TN 16NR090W	**T8030**	–	■ 525	■ 312	■ 492	◪ 1575	◪ 131	–	–	9.0	.059	.047	6755249
TN 16NR080W	**T8030**	–	■ 525	■ 312	■ 492	◪ 1575	◪ 131	–	–	8.0	.059	.047	6755248
TN 22NR060W	**T8030**	–	■ 525	■ 312	■ 492	◪ 1575	◪ 131	–	–	6.0	.098	.071	6755266
TN 22NR050W	**T8030**	–	■ 525	■ 312	■ 492	◪ 1575	◪ 131	–	–	5.0	.098	.067	6755265

TN W NR internal, right-handed design, for machining Whitworth form threads, and continuous cuts.

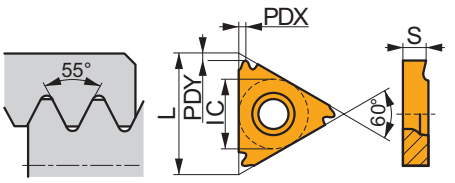
TN W NL internal, left-handed design, for machining Whitworth form threads, and continuous cuts.

TN 16NL140W	**T8030**	–	■ 525	■ 312	■ 492	◪ 1575	◪ 131	–	–	14.0	.059	.047	6755243
TN 16NL120W	**T8030**	–	■ 525	■ 312	■ 492	◪ 1575	◪ 131	–	–	12.0	.059	.047	6755242
TN 16NL110W	**T8030**	–	■ 525	■ 312	■ 492	◪ 1575	◪ 131	–	–	11.0	.059	.047	6755241
TN 16NL100W	**T8030**	–	■ 525	■ 312	■ 492	◪ 1575	◪ 131	–	–	10.0	.059	.047	6755240
TN 16NL080W	**T8030**	–	■ 525	■ 312	■ 492	◪ 1575	◪ 131	–	–	8.0	.059	.047	6755238

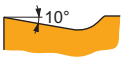
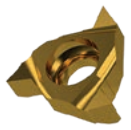
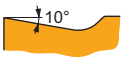
TN 55° PP EXT

PRAMET

	IC (inch)	L (inch)	S (inch)
16	.375	.650	.137
22	.500	.866	.185



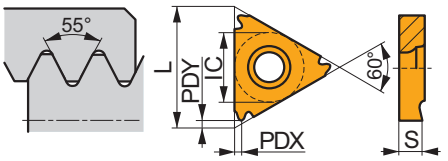
Suitability and starting values for cutting speed (vc) and feed (f). Refer to our Machining Calculator app for further calculations.

Product		RE (inch)	P vc (ft/min)	M vc (ft/min)	K vc (ft/min)	N vc (ft/min)	S vc (ft/min)	H vc (ft/min)	TPN (inch)	TPX (inch)	TPIN	TPIX	PDX (inch)	PDY (inch)	MID
			**TN** W55 PP ER external, right-handed design, for machining Whitworth threads, and continuous cuts.												
TN 16ERA55	**T8030**	–	■ 525	■ 312	■ 492	◪ 1575	◪ 131	–	.02	.059	16	48	.031	.024	6755523
TN 16ERAG55	**T8010**	–	■ 574	◪ 344	■ 541	–	◪ 131	–	.02	.118	8	48	.059	.043	7575316
	T8030	–	■ 525	■ 312	■ 492	◪ 1575	◪ 131	–	.02	.118	8	48	.059	.043	6755521
TN 16ERG55	**T8030**	–	■ 525	■ 312	■ 492	◪ 1575	◪ 131	–	.069	.118	8	14	.059	.043	6755522
TN 22ERN55	**T8010**	–	■ 574	◪ 344	■ 541	–	◪ 131	–	.138	.197	5	7	.098	.071	7575317
	T8030	–	■ 525	■ 312	■ 492	◪ 1575	◪ 131	–	.138	.197	5	7	.098	.071	6755524
			**TN** W55 PP EL external, left-handed design, for machining Whitworth threads, and continuous cuts.												
TN 16ELAG55	**T8030**	–	■ 525	■ 312	■ 492	◪ 1575	◪ 131	–	.02	.118	8	48	.059	.043	6755536
TN 16ELG55	**T8030**	–	■ 525	■ 312	■ 492	◪ 1575	◪ 131	–	.069	.118	8	14	.059	.043	6755537
TN 22ELN55	**T8030**	–	■ 525	■ 312	■ 492	◪ 1575	◪ 131	–	.138	.197	5	7	.098	.071	6755525

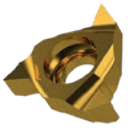
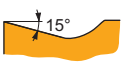
TN 55° PP INT

PRAMET

	IC (inch)	L (inch)	S (inch)
11	.250	.433	.118
16	.375	.650	.137
22	.500	.866	.185



Suitability and starting values for cutting speed (vc) and feed (f). Refer to our Machining Calculator app for further calculations.

Product		RE (inch)	P vc (ft/min)	M vc (ft/min)	K vc (ft/min)	N vc (ft/min)	S vc (ft/min)	H vc (ft/min)	TPN (inch)	TPX (inch)	TPIN	TPIX	PDX (inch)	PDY (inch)	MID
															
TN 11NRA55	**T8030**	–	525	312	492	1575	131	–	.02	.059	16	48	.031	.024	6755526
TN 16NRA55	**T8030**	–	525	312	492	1575	131	–	.02	.059	16	48	.031	.024	6755530
TN 16NRAG55	**T8010**	–	574	344	541	–	131	–	.02	.118	8	48	.059	.043	7575318
	T8030	–	525	312	492	1575	131	–	.02	.118	8	48	.059	.043	6755528
TN 16NRG55	**T8030**	–	525	312	492	1575	131	–	.069	.118	8	14	.059	.043	6755529
TN 22NRN55	**T8030**	–	525	312	492	1575	131	–	.138	.197	5	7	.098	.071	6755532
															
TN 11NLA55	**T8030**	–	525	312	492	1575	131	–	.02	.059	16	48	.031	.024	6755527
TN 16NLA55	**T8030**	–	525	312	492	1575	131	–	.02	.059	16	48	.031	.024	6755542
TN 16NLAG55	**T8030**	–	525	312	492	1575	131	–	.02	.118	8	48	.059	.043	6755531
TN 16NLG55	**T8030**	–	525	312	492	1575	131	–	.069	.118	8	14	.059	.043	6755541

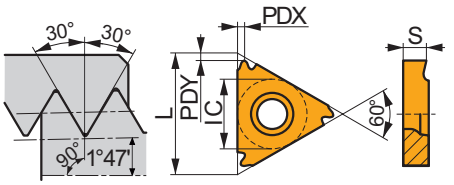
TN W55 PP NR internal, right-handed design, for machining Whitworth threads, and continuous cuts.

TN W55 PP NL internal, left-handed design, for machining Whitworth threads, and continuous cuts.

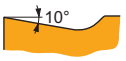
TN NPT EXT

PRAMET

	IC (inch)	L (inch)	S (inch)
16	.375	.650	.137



Suitability and starting values for cutting speed (vc) and feed (f). Refer to our Machining Calculator app for further calculations.

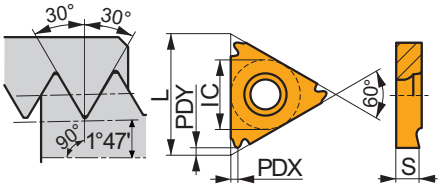
Product		RE (inch)	P vc (ft/min)	M vc (ft/min)	K vc (ft/min)	N vc (ft/min)	S vc (ft/min)	H vc (ft/min)	TP (inch)	TPI	PDX (inch)	PDY (inch)	MID
													
TN 16ER270NPT	**T8030**	–	525	312	492	1575	131	–	–	27.0	.031	.028	6755496
TN 16ER180NPT	**T8030**	–	525	312	492	1575	131	–	–	18.0	.031	.028	6755495
TN 16ER140NPT	**T8030**	–	525	312	492	1575	131	–	–	14.0	.059	.043	6755494
TN 16ER115NPT	**T8030**	–	525	312	492	1575	131	–	–	11.5	.059	.043	6755493
TN 16ER080NPT	**T8030**	–	525	312	492	1575	131	–	–	8.0	.063	.043	6755497

TN NPT ER external, right-handed design, for machining NPT threads, and continuous cuts.

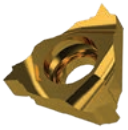
TN NPT INT

PRAMET

	IC (inch)	L (inch)	S (inch)
11	.250	.433	.118
16	.375	.650	.137



Suitability and starting values for cutting speed (vc) and feed (f). Refer to our Machining Calculator app for further calculations.

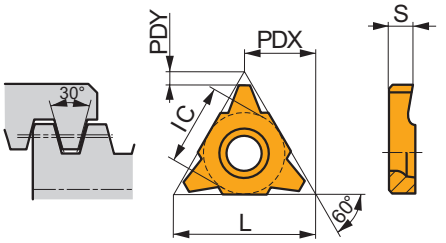
Product		RE (inch)	P vc (ft/min)	M vc (ft/min)	K vc (ft/min)	N vc (ft/min)	S vc (ft/min)	H vc (ft/min)	TP (inch)	TPI	PDX (inch)	PDY (inch)	MID
													
TN 11NR180NPT	**T8030**	–	525	312	492	1575	131	–	–	18.0	.031	.028	6755499
TN 11NR140NPT	**T8030**	–	525	312	492	1575	131	–	–	14.0	.039	.028	6755498
TN 16NR140NPT	**T8010**	–	574	344	541	–	131	–	–	14.0	.059	.043	7575422
	T8030	–	525	312	492	1575	131	–	–	14.0	.059	.043	6755501
TN 16NR115NPT	**T8010**	–	574	344	541	–	131	–	–	11.5	.059	.043	7575421
	T8030	–	525	312	492	1575	131	–	–	11.5	.059	.043	6755500
TN 16NR080NPT	**T8030**	–	525	312	492	1575	131	–	–	8.0	.063	.043	6755502

TN NPT NR internal, right-handed design, for machining NPT threads, and continuous cuts.

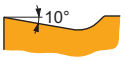
TN TR-S EXT

PRAMET

	IC	L	S
	(inch)	(inch)	(inch)
22	.500	.866	.181



Suitability and starting values for cutting speed (vc) and feed (f). Refer to our Machining Calculator app for further calculations.

Product		RE	P	M	K	N	S	H	TP	TPI	PDX	PDY	MID
			vc	vc	vc	vc	vc	vc					
		(inch)	(ft/min)	(ft/min)	(ft/min)	(ft/min)	(ft/min)	(ft/min)	(inch)		(inch)	(inch)	
													

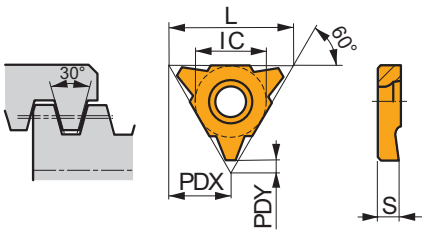
TN TR-S EN external, left and right-handed design for machining Trapezoidal threads, and continuous cuts.

TN 22EN600TR	**T8030**	–	525	312	492	1575	131	–	.236	–	.433	.075	6755388
TN 22EN700TR	**T8030**	–	525	312	492	1575	131	–	.276	–	.433	.091	6755390

TN TR-S INT

PRAMET

	IC	L	S
	(inch)	(inch)	(inch)
22	.500	.866	.181



Suitability and starting values for cutting speed (vc) and feed (f). Refer to our Machining Calculator app for further calculations.

Product		RE	P	M	K	N	S	H	TP	TPI	PDX	PDY	MID
			vc	vc	vc	vc	vc	vc					
		(inch)	(ft/min)	(ft/min)	(ft/min)	(ft/min)	(ft/min)	(ft/min)	(inch)		(inch)	(inch)	

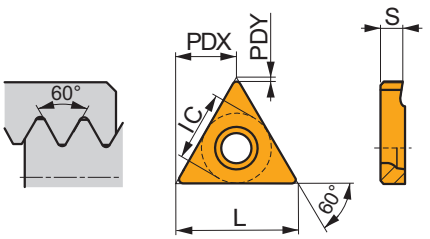
TN TR-S NN internal, left and right-handed design, for machining Metric and Unified threads, and continuous cuts.

TN 22NN600TR	**T8030**	–	525	312	492	1575	131	–	.236	–	.433	.075	6755389
TN 22NN700TR	**T8030**	–	525	312	492	1575	131	–	.276	–	.433	.091	6755391

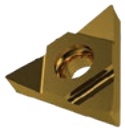
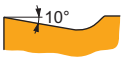
TN 60°-S PP EXT

PRAMET

	IC	L	S
	(inch)	(inch)	(inch)
22	.500	.866	.181



Suitability and starting values for cutting speed (vc) and feed (f). Refer to our Machining Calculator app for further calculations.

Product		RE	P	M	K	N	S	H	TPN	TPX	TPIN	TPIX	PDX	PDY	MID
			vc	vc	vc	vc	vc	vc							
		(inch)	(ft/min)	(ft/min)	(ft/min)	(ft/min)	(ft/min)	(ft/min)	(inch)	(inch)			(inch)	(inch)	
															

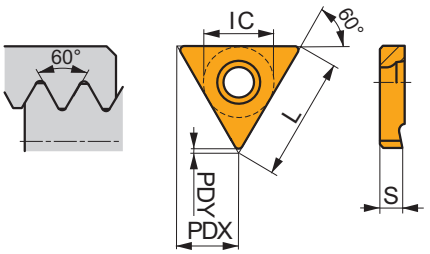
TN M60-S PP EN external, left and right-handed design, for machining Metric and Unified threads, and continuous cuts.

TN 22EN350-500M	**T8030**	–	525	312	492	1575	131	–	.138	.197	5	7	.433	.02	6755657
TN 22EN550-800M	**T8030**	–	525	312	492	1575	131	–	.217	.315	3	4.5	.433	.031	6755658

TN 60°-S PP INT

PRAMET

	IC	L	S
	(inch)	(inch)	(inch)
22	.500	.866	.181



Suitability and starting values for cutting speed (vc) and feed (f). Refer to our Machining Calculator app for further calculations.

Product		RE	P	M	K	N	S	H	TPN	TPX	TPIN	TPIX	PDX	PDY	MID
			vc	vc	vc	vc	vc	vc							
		(inch)	(ft/min)	(ft/min)	(ft/min)	(ft/min)	(ft/min)	(ft/min)	(inch)	(inch)			(inch)	(inch)	

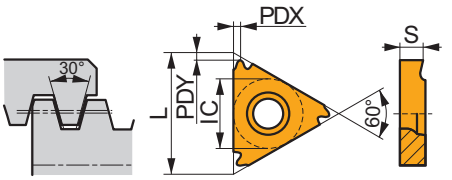
TN M60-S PP NN internal, left and right-handed design, for machining Metric and Unified threads, and continuous cuts.

TN 22NN350-500M	**T8030**	–	525	312	492	1575	131	–	.138	.197	5	7	.433	.008	6755659
TN 22NN550-800M	**T8030**	–	525	312	492	1575	131	–	.217	.315	3	4.5	.433	.02	6755660

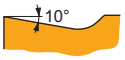
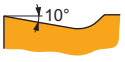
TN TR EXT

PRAMET

	IC (inch)	L (inch)	S (inch)
16	.375	.650	.137
22	.500	.866	.185



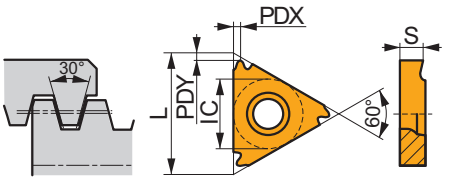
Suitability and starting values for cutting speed (vc) and feed (f). Refer to our Machining Calculator app for further calculations.

Product		RE (inch)	P vc (ft/min)	M vc (ft/min)	K vc (ft/min)	N vc (ft/min)	S vc (ft/min)	H vc (ft/min)	TP (inch)	TPI	PDX (inch)	PDY (inch)	MID
													
TN TR ER external, right-handed design, for machining Trapezoidal threads, and continuous cuts.													
TN 16ER150TR	**T8030**	–	525	312	492	1575	131	–	.059	–	.031	.035	6755330
TN 16ER200TR	**T8030**	–	525	312	492	1575	131	–	.079	–	.059	.051	6755331
TN 16ER300TR	**T8030**	–	525	312	492	1575	131	–	.118	–	.063	.051	6755332
TN 22ER400TR	**T8030**	–	525	312	492	1575	131	–	.157	–	.087	.071	6755341
TN 22ER500TR	**T8030**	–	525	312	492	1575	131	–	.197	–	.087	.071	6755342
													
TN TR EL external, left-handed design, for machining Trapezoidal threads, and continuous cuts.													
TN 16EL300TR	**T8030**	–	525	312	492	1575	131	–	.118	–	.063	.051	6755329
TN 22EL400TR	**T8030**	–	525	312	492	1575	131	–	.157	–	.087	.071	6755339
TN 22EL500TR	**T8030**	–	525	312	492	1575	131	–	.197	–	.087	.071	6755340

TN TR INT

PRAMET

	IC (inch)	L (inch)	S (inch)
16	.375	.650	.137
22	.500	.866	.185



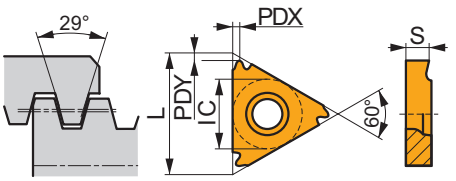
Suitability and starting values for cutting speed (vc) and feed (f). Refer to our Machining Calculator app for further calculations.

Product		RE (inch)	P vc (ft/min)	M vc (ft/min)	K vc (ft/min)	N vc (ft/min)	S vc (ft/min)	H vc (ft/min)	TP (inch)	TPI	PDX (inch)	PDY (inch)	MID
TN TR NR internal, right-handed design, for machining Trapezoidal threads, and continuous cuts.													
TN 16NR150TR	**T8030**	–	525	312	492	1575	131	–	.059	–	.031	.035	6755336
TN 16NR200TR	**T8030**	–	525	312	492	1575	131	–	.079	–	.059	.051	6755337
TN 16NR300TR	**T8030**	–	525	312	492	1575	131	–	.118	–	.063	.051	6755338
TN 22NR400TR	**T8030**	–	525	312	492	1575	131	–	.157	–	.087	.071	6755345
TN 22NR500TR	**T8030**	–	525	312	492	1575	131	–	.197	–	.087	.071	6755346
TN TR NL internal, left-handed design, for machining Trapezoidal threads, and continuous cuts.													
TN 16NL300TR	**T8030**	–	525	312	492	1575	131	–	.118	–	.063	.051	6755335

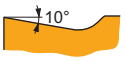
TN ACME EXT

PRAMET

	IC (inch)	L (inch)	S (inch)
16	.375	.650	.137
22	.500	.866	.185



Suitability and starting values for cutting speed (vc) and feed (f). Refer to our Machining Calculator app for further calculations.

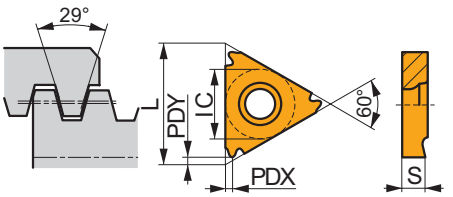
Product		RE (inch)	P vc (ft/min)	M vc (ft/min)	K vc (ft/min)	N vc (ft/min)	S vc (ft/min)	H vc (ft/min)	TP (inch)	TPI	PDX (inch)	PDY (inch)	MID
													
TN 16ER080ACME	**T8030**	–	525	312	492	1575	131	–	–	8.0	.059	.051	6755357
TN 22ER060ACME	**T8030**	–	525	312	492	1575	131	–	–	6.0	.098	.079	6755364
TN 22ER050ACME	**T8030**	–	525	312	492	1575	131	–	–	5.0	.091	.079	6755363

TN ACME ER external, right-handed design, for machining ACME threads, and continuous cuts.

TN ACME INT

PRAMET

	IC (inch)	L (inch)	S (inch)
22	.500	.866	.185



Suitability and starting values for cutting speed (vc) and feed (f). Refer to our Machining Calculator app for further calculations.

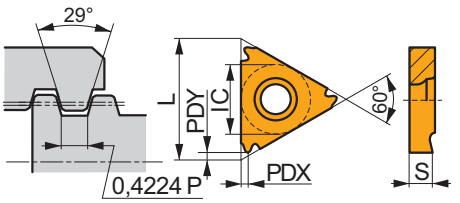
Product		RE (inch)	P vc (ft/min)	M vc (ft/min)	K vc (ft/min)	N vc (ft/min)	S vc (ft/min)	H vc (ft/min)	TP (inch)	TPI	PDX (inch)	PDY (inch)	MID
TN 22NR060ACME	**T8030**	–	525	312	492	1575	131	–	–	6.0	.098	.079	6755174

TN ACME NR internal, right-handed design, for machining ACME threads, and continuous cuts.

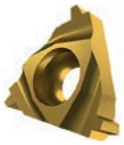
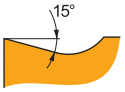
TN STACME INT

PRAMET

	IC	L	S
	(inch)	(inch)	(inch)
16	.375	.650	.137



Suitability and starting values for cutting speed (vc) and feed (f). Refer to our Machining Calculator app for further calculations.

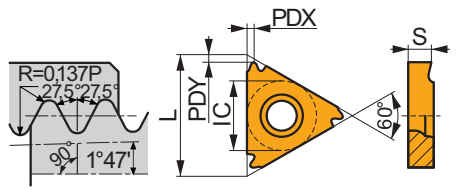
Product		RE (inch)	P vc (ft/min)	M vc (ft/min)	K vc (ft/min)	N vc (ft/min)	S vc (ft/min)	H vc (ft/min)	TP (inch)	TPI	PDX (inch)	PDY (inch)	MID
													
			TN STACME NR internal, right-handed, design for machining Stub ACME threads, and continuous cuts.										
TN 16NR060STACME	**T8030** [1]	–	525	312	492	1575	131	–	–	6.0	.051	.051	7800303

[1] Toolholders have to be modified.

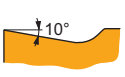
TN BSPT EXT

PRAMET

	IC	L	S
	(inch)	(inch)	(inch)
16	.375	.650	.137



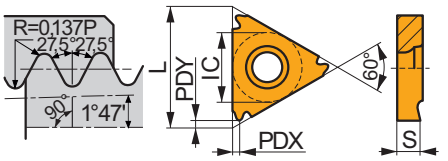
Suitability and starting values for cutting speed (vc) and feed (f). Refer to our Machining Calculator app for further calculations.

Product		RE (inch)	P vc (ft/min)	M vc (ft/min)	K vc (ft/min)	N vc (ft/min)	S vc (ft/min)	H vc (ft/min)	TP (inch)	TPI	PDX (inch)	PDY (inch)	MID
													
			TN BSPT ER external, right-handed design, for machining BSPT threads, and continuous cuts.										
TN 16ER190BSPT	**T8030**	–	525	312	492	1575	131	–	–	19.0	.059	.047	7800309
TN 16ER140BSPT	**T8030**	–	525	312	492	1575	131	–	–	14.0	.059	.047	6755504
TN 16ER110BSPT	**T8030**	–	525	312	492	1575	131	–	–	11.0	.059	.047	6755503

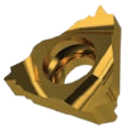
TN BSPT INT

PRAMET

	IC (inch)	L (inch)	S (inch)
16	.375	.650	.137



Suitability and starting values for cutting speed (vc) and feed (f). Refer to our Machining Calculator app for further calculations.

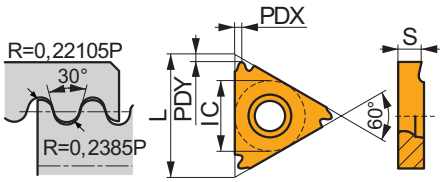
Product		RE (inch)	P vc (ft/min)	M vc (ft/min)	K vc (ft/min)	N vc (ft/min)	S vc (ft/min)	H vc (ft/min)	TP (inch)	TPI	PDX (inch)	PDY (inch)	MID
													
TN 16NR140BSPT	**T8030**	–	525	312	492	1575	131	–	–	14.0	.059	.047	6755506
TN 16NR110BSPT	**T8030**	–	525	312	492	1575	131	–	–	11.0	.059	.047	6755505

TN BSPT NR internal, right-handed design, for machining BSPT threads, and continuous cuts.

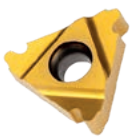
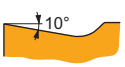
TN RD EXT

PRAMET

	IC (inch)	L (inch)	S (inch)
16	.375	.650	.137
22	.500	.866	.185



Suitability and starting values for cutting speed (vc) and feed (f). Refer to our Machining Calculator app for further calculations.

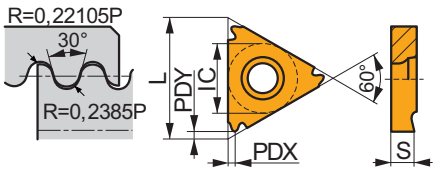
Product		RE (inch)	P vc (ft/min)	M vc (ft/min)	K vc (ft/min)	N vc (ft/min)	S vc (ft/min)	H vc (ft/min)	TP (inch)	TPI	PDX (inch)	PDY (inch)	MID
													
TN 16ER080RD	**T8030**	–	525	312	492	1575	131	–	–	8.0	.059	.047	6755348
TN 16ER060RD	**T8030** [1)]	–	525	312	492	1575	131	–	–	6.0	.059	.047	6755347
TN 22ER060RD	**T8030**	–	525	312	492	1575	131	–	–	6.0	.098	.071	6755354

TN RD ER external, right-handed design, for machining Metric Round threads, and continuous cuts.

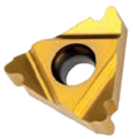
[1)] Toolholders have to be modified.

TN RD INT

	IC	L	S
	(inch)	(inch)	(inch)
16	.375	.650	.137
22	.500	.866	.185



Suitability and starting values for cutting speed (vc) and feed (f). Refer to our Machining Calculator app for further calculations.

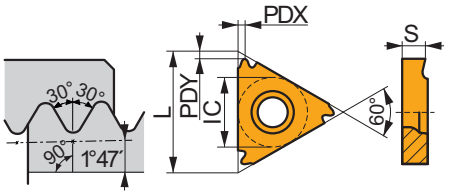
Product		RE	P	M	K	N	S	H	TP	TPI	PDX	PDY	MID
			vc	vc	vc	vc	vc	vc					
		(inch)	(ft/min)	(ft/min)	(ft/min)	(ft/min)	(ft/min)	(ft/min)	(inch)		(inch)	(inch)	
													
TN 16NR080RD	**T8030**	–	525	312	492	1575	131	–	–	8.0	.059	.047	6755351
TN 16NR060RD	**T8030** [1]	–	525	312	492	1575	131	–	–	6.0	.059	.047	6755350
TN 22NR060RD	**T8030**	–	525	312	492	1575	131	–	–	6.0	.098	.071	6755356

TN RD NR internal, right-handed design, for machining Metric Round threads, and continuous cuts.

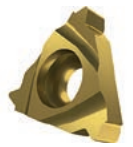
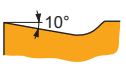
[1] Toolholders have to be modified.

TN API RD EXT

	IC	L	S
	(inch)	(inch)	(inch)
16	.375	.650	.137



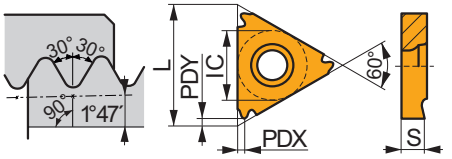
Suitability and starting values for cutting speed (vc) and feed (f). Refer to our Machining Calculator app for further calculations.

Product		RE	P	M	K	N	S	H	TP	TPI	PDX	PDY	MID
			vc	vc	vc	vc	vc	vc					
		(inch)	(ft/min)	(ft/min)	(ft/min)	(ft/min)	(ft/min)	(ft/min)	(inch)		(inch)	(inch)	
													
TN 16ER100API-RD01	**T8030**	–	525	312	492	1575	131	–	–	10.0	.059	.047	6755160
TN 16ER080API-RD01	**T8030**	–	525	312	492	1575	131	–	–	8.0	.059	.047	6755161

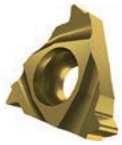
TN API ER external, right-handed design, for machining API threads, and continuous cuts.

TN API RD INT

	IC	L	S
	(inch)	(inch)	(inch)
16	.375	.650	.137



Suitability and starting values for cutting speed (vc) and feed (f). Refer to our Machining Calculator app for further calculations.

Product		RE	P	M	K	N	S	H	TP	TPI	PDX	PDY	MID
			vc	vc	vc	vc	vc	vc					
		(inch)	(ft/min)	(ft/min)	(ft/min)	(ft/min)	(ft/min)	(ft/min)	(inch)		(inch)	(inch)	
													
TN 16NR100API-RD01	**T8030**	–	■ 525	■ 312	■ 492	◪ 1575	◪ 131	–	–	10.0	.059	.047	6755162
TN 16NR080API-RD01	**T8030**	–	■ 525	■ 312	■ 492	◪ 1575	◪ 131	–	–	8.0	.059	.047	6755163

TN API NR internal, right-handed design, for machining API threads, and continuous cuts.

SE(RL)

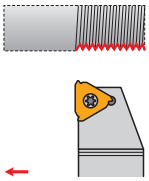
P M K N S H

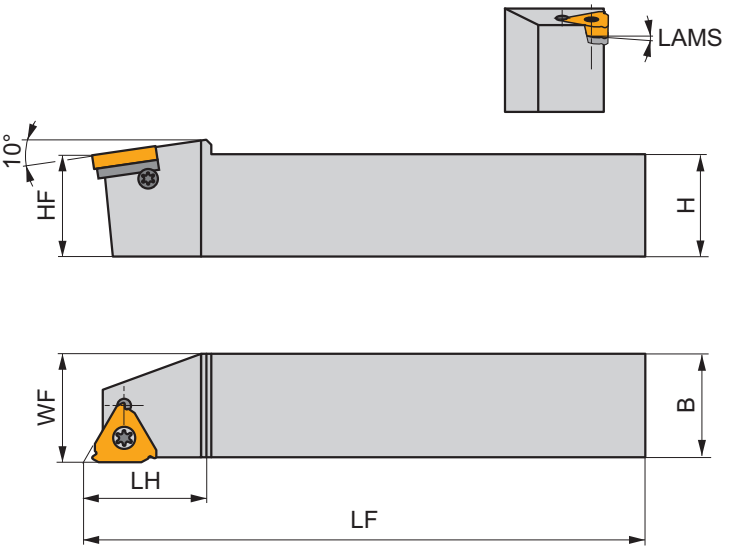
PRAMET

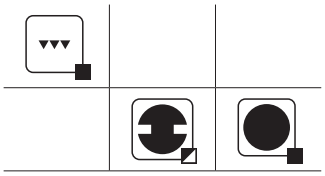
S

External Threading Holder for TN 16, 22 inserts clamped by screw

Right/Left hand tool holder for external threading with TN or ER/EL inserts clamped by screw. Suited for threading in metric or inch profile. Body treated for longer tool life.







	Product	H (mm)	HF (mm)	B (mm)	WF (mm)	LF (mm)	LH (mm)	LAMS (°)	lbs			MID
R	**SER 2020 K 16**	20	20	20	20	125	22.5	–	.85	GI068	Z12	6756898
	SER 2525 M 16	25	25	25	25	150	24.0	–	1.61	GI068	Z12	6756940
	SER 3225 P 16	32	32	25	25	170	24.5	–	2.27	GI068	Z12	6756973
	SER 2525 M 22-A	25	25	25	25	150	25.5	–	1.54	GI071	Z13	6756923
	SER 3225 P 22-A	32	32	25	25	170	25.5	–	2.18	GI071	Z13	6756981
L	**SEL 2020 K 16**	20	20	20	20	125	22.5	–	.90	GI068	Z12	6756971
	SEL 2525 M 16	25	25	25	25	150	24.0	–	1.64	GI068	Z12	6756972
	SEL 2525 M 22-A	25	25	25	25	150	25.5	–	1.54	GI071	Z13	6757165

GI068	TN 16ER..	TN 16EL..
GI071	TN 22ER..	TN 22EL..

		Nm							
Z12	US 3512A-T15P	3.0	M 3.5	0.5	–	HS 0304	FLAG T15P	HXK 2.5	Page 570
Z13	US 4514A-T20	5.0	M 4.5	0.551	SP 0405	–	FLAG T20	–	Page 570

ISE(RL)

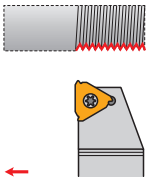
P M K N S H

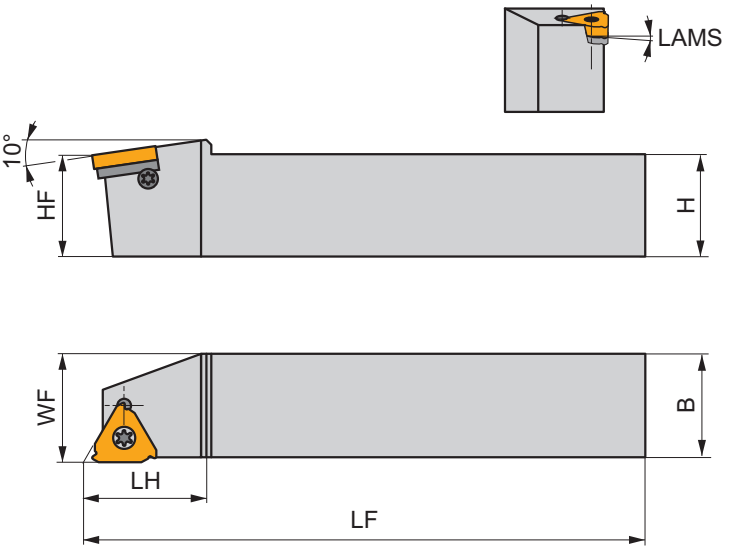
PRAMET

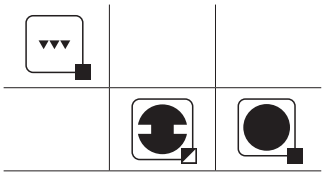
S

External Threading Holder for TN 16, 22 inserts clamped by screw

Right/Left hand tool holder for external threading with TN or ER/EL inserts clamped by screw. Suited for threading in metric or inch profile. Body treated for longer tool life.







	Product	H (inch)	HF (inch)	B (inch)	WF (inch)	LF (inch)	LH (inch)	LAMS (°)			lbs	MID
R	**SER 12 C16**	.750	.750	.750	.750	5.000	.900	–	GI068	Z12	.77	6790636
	SER 16 D16	1.000	1.000	1.000	1.000	6.000	.950	–	GI068	Z12	1.54	6790637
	SER 16 D22	1.000	1.000	1.000	1.000	6.000	1.000	–	GI071	Z13	1.54	6790638
L	**SEL 12 C16**	.750	.750	.750	.750	5.000	.900	–	GI068	Z12	.77	6790619

GI068	TN 16ER..	TN 16EL..
GI071	TN 22ER..	TN 22EL..

		Nm							
Z12	US 3512A-T15P	3.0	M 3.5	0.5	–	HS 0304	FLAG T15P	HXK 2.5	Page 570
Z13	US 4514A-T20	5.0	M 4.5	0.551	SP 0405	–	FLAG T20	–	Page 570

SE(RL)-S

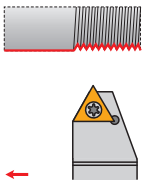
P M K N S H

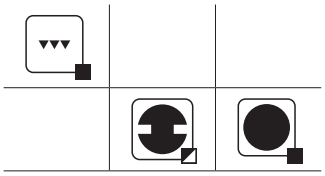
PRAMET

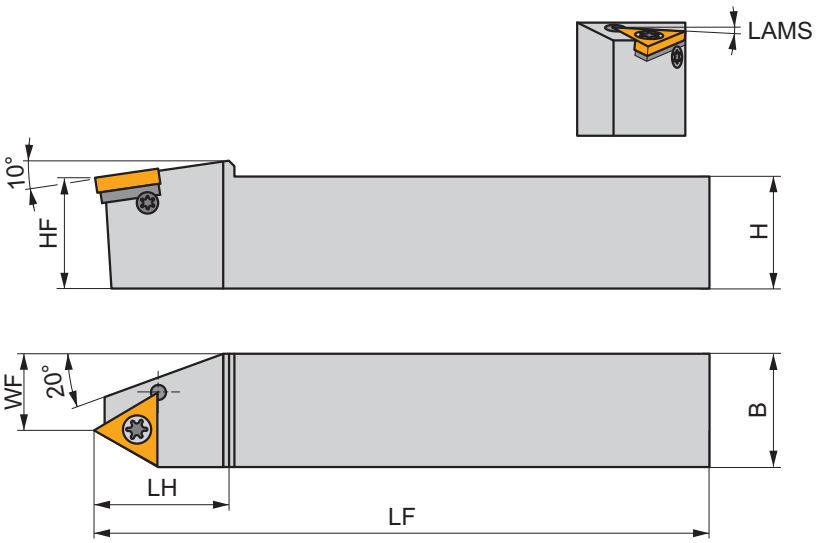
S

External Threading Holder for TN 22 EN inserts clamped by screw

Right/Left hand tool holder for external large threading with TN EN neutral inserts clamped by screw. Suited for threading in metric or inch profile. Body treated for longer tool life.







	Product	H (mm)	HF (mm)	B (mm)	WF (mm)	LF (mm)	LH (mm)	LAMS (°)	lbs			MID
R	SER-S 2525 M 22-A	25	25	25	14	150	30.0	–	1.63	GI086	Z15	6757114
	SER-S 3225 P 22-A	32	32	25	14	170	30.0	–	2.32	GI086	Z15	6757316
L	SEL-S 2525 M 22-A	25	25	25	14	150	30.0	–	1.62	GI086	Z15	6757161

GI086	TN 22EN..

Z15	US 4514A-T20	5.0 Nm	M 4.5	0.551	SP 0405	FLAG T20	Page 570

SI(RL)

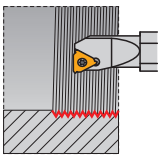
P M K N S H

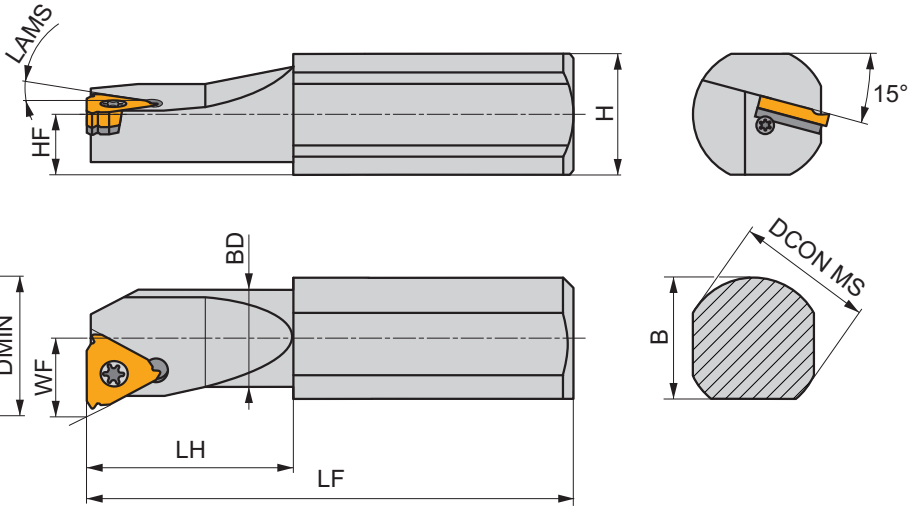
PRAMET

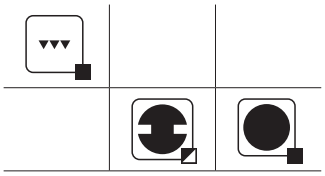
S

Internal Threading Holder for TN 11, 16, 22 inserts clamped by screw

Right/Left hand boring bar for internal threading with TN NR/NL inserts clamped by screw. Suited for threading in metric or inch profile. Body treated for longer tool life.







	Product	B (mm)	DCON MS (mm)	DMIN (mm)	BD (mm)	WF (mm)	H (mm)	HF (mm)	LF (mm)	LH (mm)	LAMS (°)		lbs			MID
R	SIR 0010 K 11-0	14.5	16	13	10	7.45	14	7	125	25.0	0	–	.35	GI085	Z11	6761681
	SIR 0010 K 11-1	14.5	16	13	10	7.45	14	7	125	25.0	1	–	.35	GI085	Z11	6757137
	SIR 0013 M 11-0	14.5	16	16	13	9	14	7	150	32.0	0	–	.50	GI085	Z11	6761682
	SIR 0013 M 11-1	14.5	16	16	13	9	14	7	150	32.0	1	–	.44	GI085	Z11	6757098
	SIR 1416 N 16-0	14	16	22	17	11.4	14.5	7.25	160	–	0	–	.55	GI022	Z9	6756979
	SIR 1416 N 16-1	14	16	22	17	11.4	14.5	7.25	160	–	1	–	.55	GI022	Z9	6756953
	SIR 1416 N 16-2	14	16	16.5	15.5	10.6	14.5	7.25	160	40.0	2	✓	.49	GI022	Z10	6759686
	SIR 1820 P 16	18.5	20	27	21	13.85	18	9	170	–	–	–	.85	GI022	Z12	6756676
	SIR 2325 Q 16	23.5	25	29	26	16.55	23	11.5	180	–	–	–	1.32	GI022	Z12	6756677
	SIR 2532 S 16	30	32	36	32	19.75	25	12.5	250	–	–	–	2.95	GI022	Z12	6756775
	SIR 2532 S 22-2	30	32	25	25	16.65	25	12.5	250	80.0	2	✓	2.34	GI076	Z14	6759689
	SIR 2532 S 22-A	30	32	36	32	21.65	25	12.5	250	–	–	–	2.87	GI076	Z13	6756974
	SIR 3240 T 22-A	38	40	48	40	25.85	32	16	300	–	–	–	5.40	GI076	Z13	6757168
L	SIL 0010 K 11-0	14.5	16	13	10	7.45	14	7	125	25.0	0	–	.33	GI085	Z11	6761679
	SIL 0010 K 11-1	14.5	16	13	10	7.45	14	7	125	25.0	1	–	.39	GI085	Z11	6757166
	SIL 0013 M 11-1	14.5	16	16	13	9	14	7	150	32.0	1	–	.49	GI085	Z11	6757253
	SIL 1416 N 16-0	14	16	22	17	11.4	14.5	7.25	160	–	0	–	.55	GI022	Z9	6757162
	SIL 1416 N 16-1	14	16	22	17	11.4	14.5	7.25	160	–	1	–	.51	GI022	Z9	6757225
	SIL 1416 N 16-2	14	16	16.5	15.5	10.6	14.5	7.25	160	40.0	2	✓	.48	GI022	Z10	6759688
	SIL 1820 P 16	18.5	20	24	21	13.85	18	9	170	–	–	–	.90	GI022	Z12	6757254
	SIL 2325 Q 16	23.5	25	29	26	16.55	23	11.5	180	–	–	–	1.42	GI022	Z12	6757255
	SIL 2532 S 16	30	32	36	32	19.75	25	12.5	250	–	–	–	2.94	GI022	Z12	6757167
	SIL 2532 S 22-2	30	32	25	25	16.65	25	12.5	250	80.0	2	✓	2.33	GI076	Z14	6759690

GI022	TN 16NR..	TN 16NL..
GI076	TN 22NR..	TN 22NL..
GI085	TN 11NR..	TN 11NL..

Z10	US 3510A-T15P	3.0	M 3.5	0.417	–	–	FLAG T15P	–	–
Z11	US 2506-T07P	0.9	M 2.5	0.248	–	–	FLAG T07P	–	–
Z12	US 3512A-T15P	3.0	M 3.5	0.5	–	HS 0304	FLAG T15P	HXK 2.5	Page 570
Z13	US 4514A-T20	5.0	M 4.5	0.551	SP 0405	–	FLAG T20	–	Page 570
Z14	US 4514A-T20	5.0	M 4.5	0.551	–	–	FLAG T20	–	–
Z9	US 3510A-T15P	3.0	M 3.5	0.417	–	–	FLAG T15P	–	P-16

ISI(RL)

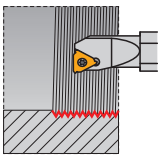
P M K N S H

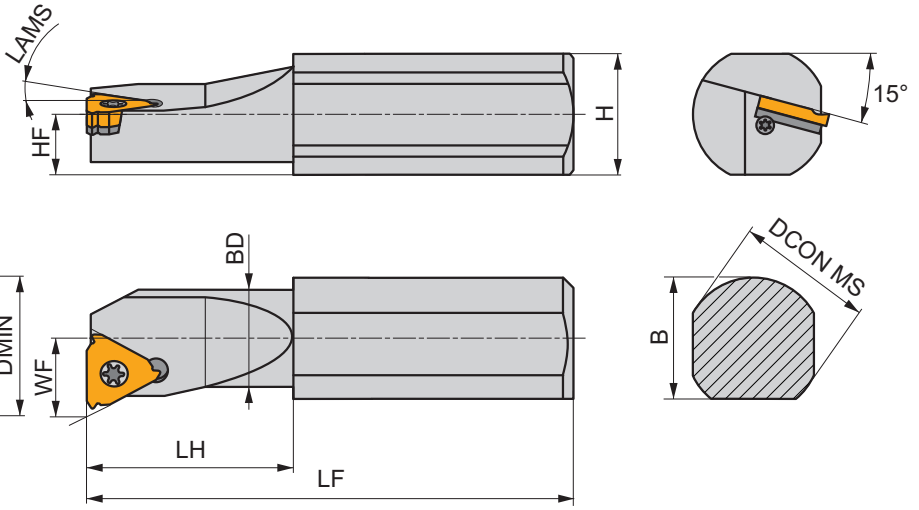
PRAMET

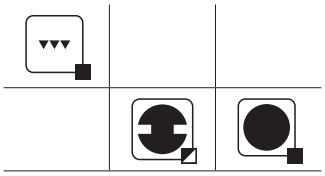
S

Internal Threading Holder for TN 11, 16, 22 inserts clamped by screw

Right/Left hand boring bar for internal threading with TN NR/NL inserts clamped by screw. Suited for threading in metric or inch profile. Body treated for longer tool life.







	Product	B (inch)	DCON MS (inch)	DMIN (inch)	BD (inch)	WF (inch)	H (inch)	HF (inch)	LF (inch)	LH (inch)	LAMS (°)		lbs			MID
R	**SIR 10 M11-1**	.570	.625	.630	.500	.350	.550	–	6.000	1.250	1	–	.44	GI085	Z11	6790661
	SIR 12 P16	.700	.750	.850	–	.500	.700	–	6.250	–	–	–	.66	GI022	Z12	6790665
	SIR 16 Q16	.900	1.000	1.150	–	.650	.900	–	7.250	–	–	–	1.37	GI022	Z12	6790666

GI022	TN 16NR..	TN 16NL..
GI085	TN 11NR..	TN 11NL..

		Nm						
Z11	US 2506-T07P	0.9	M 2.5	0.248	–	FLAG T07P	–	–
Z12	US 3512A-T15P	3.0	M 3.5	0.5	HS 0304	FLAG T15P	HXK 2.5	Page 570

SI(RL)-S

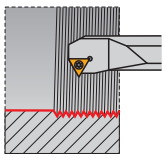
P M K N S H

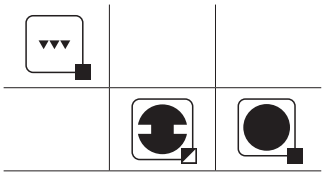
PRAMET

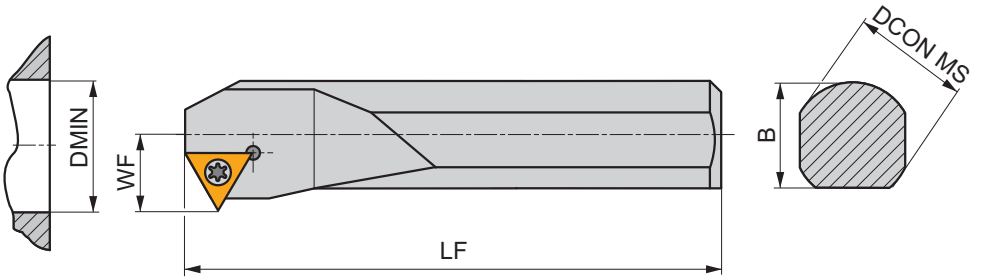
S

Internal Threading Holder for TN 22 NN inserts clamped by screw

Right/Left hand boring bar for internal threading with TN NN neutral inserts clamped by screw. Suited for threading in metric or inch profile. Body treated for longer tool life.



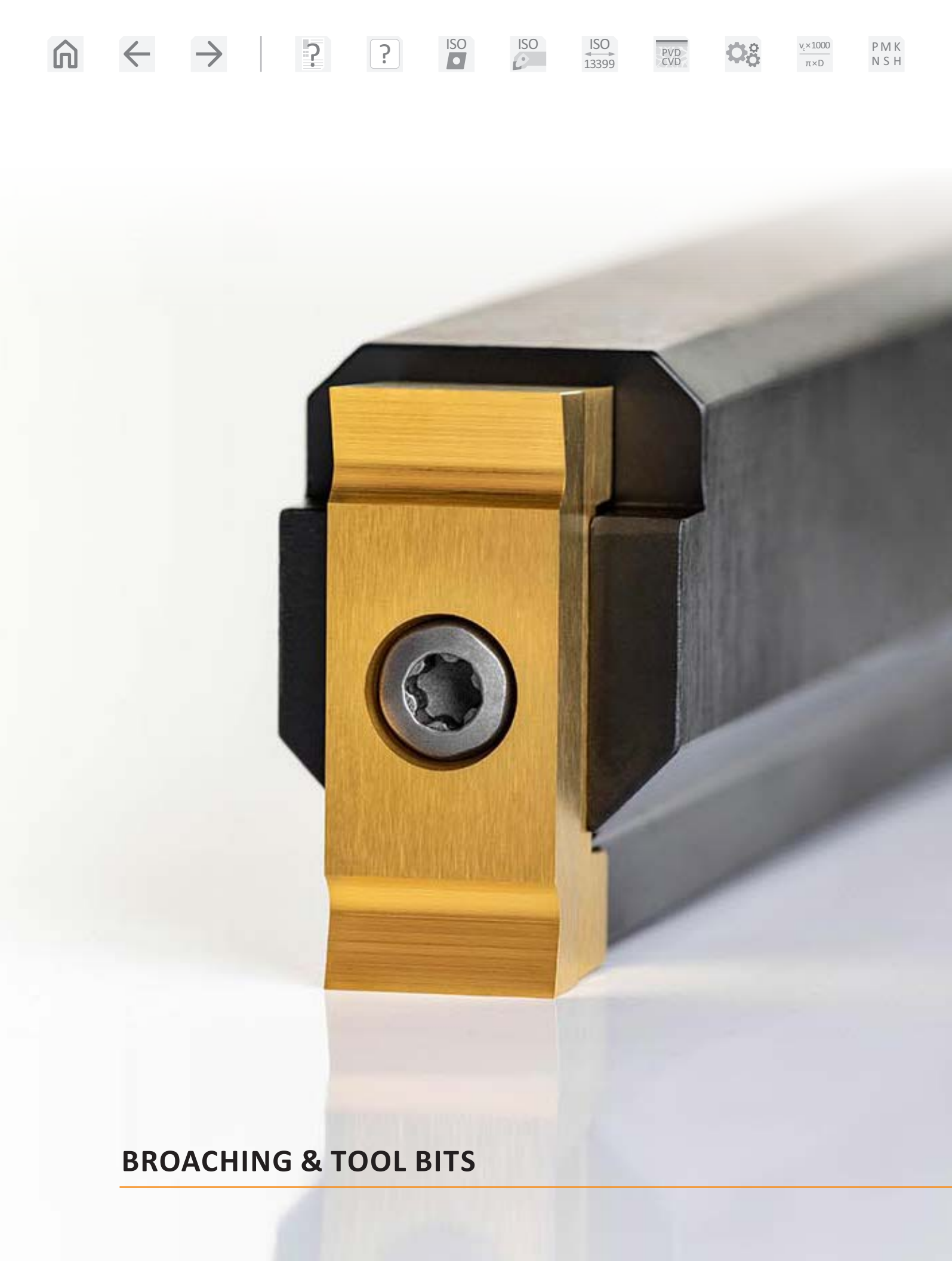




	Product	B (mm)	DCON MS (mm)	DMIN (mm)	WF (mm)	H (mm)	HF (mm)	LF (mm)	LAMS (°)	lbs			MID
R	**SIR-S 2532 S 22-A**	30	32	39	22.3	25	12.5	250	–	2.20	GI107	Z15	6757419
	SIR-S 3240 T 22-A	38	40	48	27	32	16	300	–	5.40	GI107	Z15	6757317

GI107	TN 22NN..

Z15	US 4514A-T20	5.0 Nm	M 4.5	0.551	SP 0405	FLAG T20	Page 570



BROACHING & TOOL BITS

PHZ

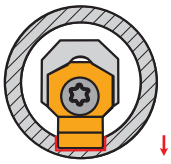
P M K N S H

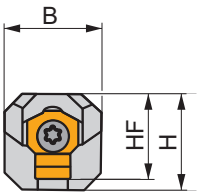
PRAMET

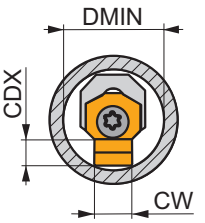
S

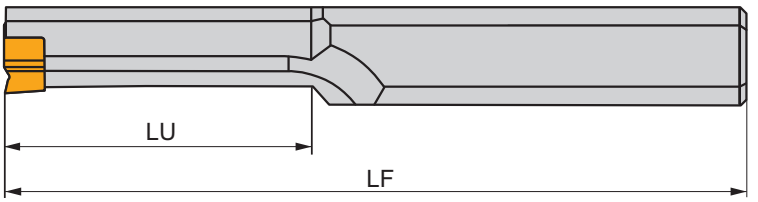
Int. Broaching Tool Holder for Small Diameters with Single-Sided HZ Inserts

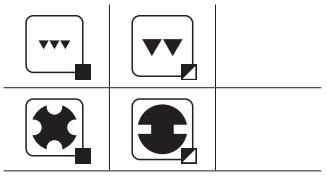
Internal tool holder for broaching up to 12 mm width. Body treated for longer tool life.











	Product	H (mm)	HF (mm)	B (mm)	OAL (mm)	LU (mm)	CW (mm)	DMIN (mm)	CDX (mm)	lbs			MID
N	**PHZ 90 1104-06**	11.3	9	8.5	160	35	3.00	9.5	1.6	.31	GI239	SH21	6760938
	PHZ 90 1107-06	11.3	10	7	200	60	–	–	–	.41	GI240	SH21	6760939
	PHZ 90 1111-06	11.3	12	–	200	60	–	–	–	.46	GI240	SH21	6760940
	PHZ 1512-10	15.5	16.2	–	220	–	–	–	–	.72	GI224	SH22	6760618
	PHZ 2014-13	20.6	21.5	–	250	–	–	–	–	1.28	GI225	SH23	6760623

GI224	HZ 1006-60	HZ 1006-80
GI225	HZ 1309-100	HZ 1309-120
GI239	HZ90 0604-30	–
GI240	HZ90 0604-40	HZ90 0604-50

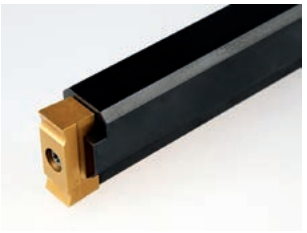
SH21	DVF 3593	0.8	M 2.5	0.394	TX207PLUS
SH22	DVF 2260	3.6	M 4	0.591	TX215PLUS
SH23	5513 020-14	8.5	M 6	0.709	TX225PLUS

PHZ-2

P M K N S H

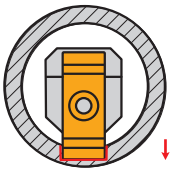
PRAMET

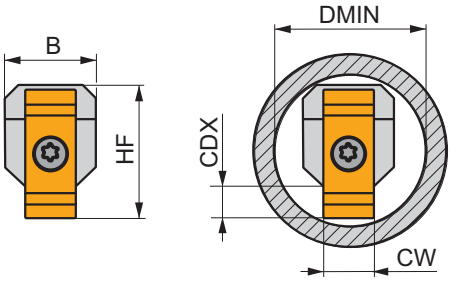
S

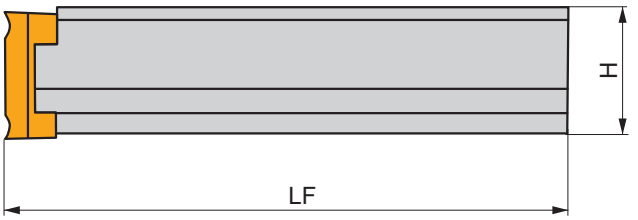


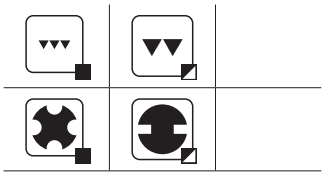
Int. Broaching Tool Holder for Larger Diameters with Double-Sided HZ Inserts

Internal tool holder for broaching up to 20 mm width. Body treated for longer tool life.









	Product	H (mm)	HF (mm)	B (mm)	OAL (mm)	CW (mm)	DMIN (mm)	CDX (mm)	lbs			MID
N	**PHZ/2 3625-14**	36	37.5	25	300	–	44	–	4.05	GI235	SH23	6760769
	PHZ/2 4832-18	48	50	32	400	–	58	–	4.41	GI241	SH24	6760941

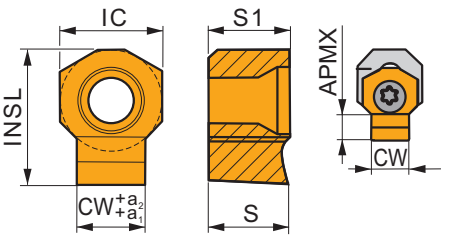
GI235	HZ/2 14-14	HZ/2 16-16
GI241	HZ/2 18-18	HZ/2 20-20

		Nm			
SH23	5513 020-14	8.5	M 6	0.709	TX225PLUS
SH24	5513 021-03	13.0	M 8	0.866	DMN 3124

HZ

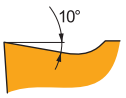
PRAMET

	CW	INSL	APMX	S	S1
	(inch)	(inch)	(inch)	(inch)	(inch)
0604-30	.118	.295	.063	.183	.187
0604-40	.157	.315	.098	.183	.187
0604-50	.197	.315	.118	.183	.187
1006-60	.236	.531	.165	.246	.250
1006-80	.315	.531	.205	.246	.250
1309-100	.394	.728	.244	.370	.375
1309-120	.472	.728	.283	.370	.375



Suitability and starting values for cutting speed (vc) and feed (f). Refer to our Machining Calculator app for further calculations.

Product		RE	P		M		K		N		S		H		CW	CWTOLL	CWTOLU	MID
			vc	f	vc	f	vc	f	vc	f	vc	f	vc	f				
		(inch)	(ft/min)	(in/rev)	(ft/min)	(in/rev)	(ft/min)	(in/rev)	(ft/min)	(in/rev)	(ft/min)	(in/rev)	(ft/min)	(in/rev)	(inch)	(inch)	(inch)	



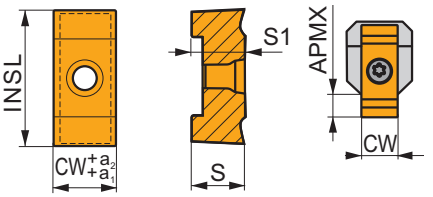
HZ positive geometry for broaching (one cutting edge).

HZ 1006-60 C11	**333TN**	–	164	.0039	98	.0035	148	.0039	–	–	–	–	–	–	.236	.003	.006	6755403
HZ 1006-60 D10	**333TN**	–	164	.0039	98	.0035	148	.0039	–	–	–	–	–	–	.236	.001	.003	6755947
HZ 1006-60 H7	**333TN**	–	164	.0039	98	.0035	148	.0039	–	–	–	–	–	–	.236	0	0	6755406
HZ 1006-60 P9	**333TN**	–	164	.0039	98	.0035	148	.0039	–	–	–	–	–	–	.236	-.002	0	6755948
HZ 1006-80 C11	**333TN**	–	164	.0039	98	.0035	148	.0039	–	–	–	–	–	–	.315	.003	.007	6755404
HZ 1006-80 D10	**333TN**	–	164	.0039	98	.0035	148	.0039	–	–	–	–	–	–	.315	.002	.004	6755949
HZ 1006-80 H7	**333TN**	–	164	.0039	98	.0035	148	.0039	–	–	–	–	–	–	.315	0	.001	6755405
HZ 1006-80 P9	**333TN**	–	164	.0039	98	.0035	148	.0039	–	–	–	–	–	–	.315	-.002	-.001	6755950
HZ 1309-100 C11	**333TN**	–	164	.0039	98	.0035	148	.0039	–	–	–	–	–	–	.394	.003	.007	6755408
HZ 1309-100 D10	**333TN**	–	164	.0039	98	.0035	148	.0039	–	–	–	–	–	–	.394	.002	.004	6755951
HZ 1309-100 H7	**333TN**	–	164	.0039	98	.0035	148	.0039	–	–	–	–	–	–	.394	0	.001	6755407
HZ 1309-100 P9	**333TN**	–	164	.0039	98	.0035	148	.0039	–	–	–	–	–	–	.394	-.002	-.001	6755952
HZ 1309-120 C11	**333TN**	–	164	.0039	98	.0035	148	.0039	–	–	–	–	–	–	.472	.004	.008	6755409
HZ 1309-120 D10	**333TN**	–	164	.0039	98	.0035	148	.0039	–	–	–	–	–	–	.472	.002	.005	6755953
HZ 1309-120 H7	**333TN**	–	164	.0039	98	.0035	148	.0039	–	–	–	–	–	–	.472	0	.001	6755410
HZ 1309-120 P9	**333TN**	–	164	.0039	98	.0035	148	.0039	–	–	–	–	–	–	.472	-.002	-.001	6755954
HZ90 0604-30 C11	**333TN**	–	164	.0039	98	.0035	148	.0039	–	–	–	–	–	–	.118	.002	.005	6755478
HZ90 0604-30 D10	**333TN**	–	164	.0039	98	.0035	148	.0039	–	–	–	–	–	–	.118	.001	.002	6755484
HZ90 0604-30 H7	**333TN**	–	164	.0039	98	.0035	148	.0039	–	–	–	–	–	–	.118	0	0	6755479
HZ90 0604-30 P9	**333TN**	–	164	.0039	98	.0035	148	.0039	–	–	–	–	–	–	.118	-.001	0	6755959
HZ90 0604-40 C11	**333TN**	–	164	.0039	98	.0035	148	.0039	–	–	–	–	–	–	.157	.003	.006	6755480
HZ90 0604-40 D10	**333TN**	–	164	.0039	98	.0035	148	.0039	–	–	–	–	–	–	.157	.001	.003	6755485
HZ90 0604-40 H7	**333TN**	–	164	.0039	98	.0035	148	.0039	–	–	–	–	–	–	.157	0	0	6755481
HZ90 0604-40 P9	**333TN**	–	164	.0039	98	.0035	148	.0039	–	–	–	–	–	–	.157	-.002	0	6755960
HZ90 0604-50 C11	**333TN**	–	164	.0039	98	.0035	148	.0039	–	–	–	–	–	–	.197	.003	.006	6755482
HZ90 0604-50 D10	**333TN**	–	164	.0039	98	.0035	148	.0039	–	–	–	–	–	–	.197	.001	.003	6755486
HZ90 0604-50 H7	**333TN**	–	164	.0039	98	.0035	148	.0039	–	–	–	–	–	–	.197	0	0	6755483
HZ90 0604-50 P9	**333TN**	–	164	.0039	98	.0035	148	.0039	–	–	–	–	–	–	.197	-.002	0	6755961

HZ-2

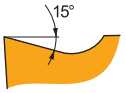
PRAMET

	INSL	APMX	S	S1	CW
	(inch)	(inch)	(inch)	(inch)	(inch)
14-14	1.417	.315	.547	.551	.551
16-16	1.417	.354	.547	.551	.630
18-18	1.772	.472	.626	.630	.709
20-20	1.772	.512	.626	.630	.787



Suitability and starting values for cutting speed (vc) and feed (f). Refer to our Machining Calculator app for further calculations.

Product		RE	P		M		K		N		S		H		CW	CWTOLL	CWTOLU	MID
			vc	f	vc	f	vc	f	vc	f	vc	f	vc	f				
		(inch)	(ft/min)	(in/rev)	(ft/min)	(in/rev)	(ft/min)	(in/rev)	(ft/min)	(in/rev)	(ft/min)	(in/rev)	(ft/min)	(in/rev)	(inch)	(inch)	(inch)	

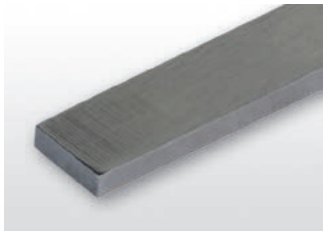


HZ-2 positive geometry for broaching (two cutting edges).

HZ/2 14-14 C11	**333TN**	–	164	.0039	98	.0035	148	.0039	–	–	–	–	–	–	.551	.004	.008	6755462
HZ/2 14-14 H7	**333TN**	–	164	.0039	98	.0035	148	.0039	–	–	–	–	–	–	.551	0	.001	6755460
HZ/2 14-14 P9	**333TN**	–	164	.0039	98	.0035	148	.0039	–	–	–	–	–	–	.551	-.002	-.001	6755955
HZ/2 16-16 C11	**333TN**	–	164	.0039	98	.0035	148	.0039	–	–	–	–	–	–	.630	.004	.008	6755459
HZ/2 16-16 H7	**333TN**	–	164	.0039	98	.0035	148	.0039	–	–	–	–	–	–	.630	0	.001	6755461
HZ/2 16-16 P9	**333TN**	–	164	.0039	98	.0035	148	.0039	–	–	–	–	–	–	.630	-.002	-.001	6755956
HZ/2 18-18 C11	**333TN**	–	164	.0039	98	.0035	148	.0039	–	–	–	–	–	–	.709	.004	.008	6755487
HZ/2 18-18 H7	**333TN**	–	164	.0039	98	.0035	148	.0039	–	–	–	–	–	–	.709	0	.001	6755488
HZ/2 18-18 P9	**333TN**	–	164	.0039	98	.0039	148	.0039	–	–	–	–	–	–	.709	-.002	-.001	6755957
HZ/2 20-20 C11	**333TN**	–	164	.0039	98	.0035	148	.0039	–	–	–	–	–	–	.787	.004	.009	6755489
HZ/2 20-20 H7	**333TN**	–	164	.0039	98	.0035	148	.0039	–	–	–	–	–	–	.787	0	.001	6755490
HZ/2 20-20 P9	**333TN**	–	164	.0039	98	.0039	148	.0039	–	–	–	–	–	–	.787	-.003	-.001	6755958

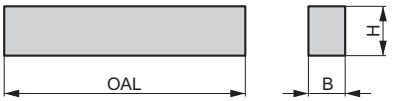
TOOL BITS F

DORMER



HSS-E Rectangular Tool bit

Ground rectangular tool bit according to DIN 4964 D standard. T2000S HSS-E bright steel with 10% Cobalt content in hardness 65 – 67 HRC.



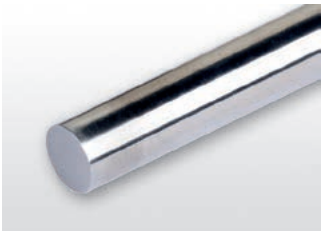
HSS-E	DIN 4964D	Bright
h13		

Product	H	B	OAL
	(mm)	(mm)	(mm)
8X6X200:T2000S	8	6	200.0
10X2X200:T2000S	10	2	200.0
10X3X200:T2000S	10	3	200.0
10X4X200:T2000S	10	4	200.0
10X5X200:T2000S	10	5	200.0
10X6X200:T2000S	10	6	200.0
10X8X200:T2000S	10	8	200.0
12X3X200:T2000S	12	3	200.0
12X4X200:T2000S	12	4	200.0
12X6X200:T2000S	12	6	200.0
12X8X200:T2000S	12	8	200.0
15X3X200:T2000S	15	3	200.0
15X4X200:T2000S	15	4	200.0
15X5X200:T2000S	15	5	200.0
15X6X200:T2000S	15	6	200.0
15X8X200:T2000S	15	8	200.0
15X10X200:T2000S	15	10	200.0
16X8X200:T2000S	16	8	200.0
16X10X200:T2000S	16	10	200.0

Product	H	B	OAL
	(mm)	(mm)	(mm)
16X12X200:T2000S	16	12	200.0
20X3X200:T2000S	20	3	200.0
20X4X200:T2000S	20	4	200.0
20X5X200:T2000S	20	5	200.0
20X6X200:T2000S	20	6	200.0
20X8X200:T2000S	20	8	200.0
20X10X200:T2000S	20	10	200.0
20X12X200:T2000S	20	12	200.0
20X15X200:T2000S	20	15	200.0
25X5X200:T2000S	25	5	200.0
25X6X200:T2000S	25	6	200.0
25X10X200:T2000S	25	10	200.0
25X12X200:T2000S	25	12	200.0
30X4X200:T2000S	30	4	200.0
30X5X200:T2000S	30	5	200.0
30X10X200:T2000S	30	10	200.0
30X15X200:T2000S	30	15	200.0
30X20X200:T2000S	30	20	200.0

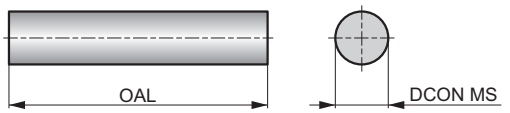
TOOL BITS R

DORMER



HSS-E Round Tool bit

Ground round tool bit according to DIN 4964 A standard. T2000S HSS-E bright steel with 10% Cobalt content in hardness 65 – 67 HRC.



HSS-E	DIN 4964A	Bright
h9		

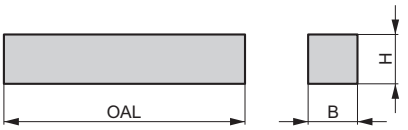
Product	DCON MS (mm)	OAL (mm)
3X200 T:T2000S	3.00	200.0
4X200 T:T2000S	4.00	200.0
5X200 T:T2000S	5.00	200.0
6X200 T:T2000S	6.00	200.0
7X200 T:T2000S	7.00	200.0
8X200 T:T2000S	8.00	200.0
10X200 T:T2000S	10.00	200.0
12X200 T:T2000S	12.00	200.0
14X200 T:T2000S	14.00	200.0
16X200 T:T2000S	16.00	200.0
20X200 T:T2000S	20.00	200.0

TOOL BITS S

DORMER

HSS-E Square Tool bit

Ground square tool bit according to DIN 4964 B standard. T2000S HSS-E bright steel with 10% Cobalt content in hardness 65 – 67 HRC.

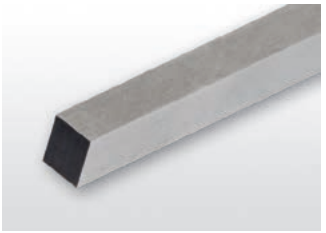


HSS-E	DIN 4964B	Bright
+0 -0.1		

Product	H	B	OAL
	(mm)	(mm)	(mm)
4X4X200:T2000S	4	4	200.0
6X6X200:T2000S	6	6	200.0
8X8X200:T2000S	8	8	200.0
10X10X200:T2000S	10	10	200.0
12X12X200:T2000S	12	12	200.0
14X14X200:T2000S	14	14	200.0
15X15X200:T2000S	15	15	200.0
16X16X200:T2000S	16	16	200.0
20X20X200:T2000S	20	20	200.0
25X25X200:T2000S	25	25	200.0

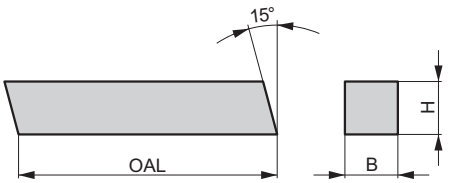
TOOL BITS SA

DORMER



HSS-E Square Tool bit with Bevel

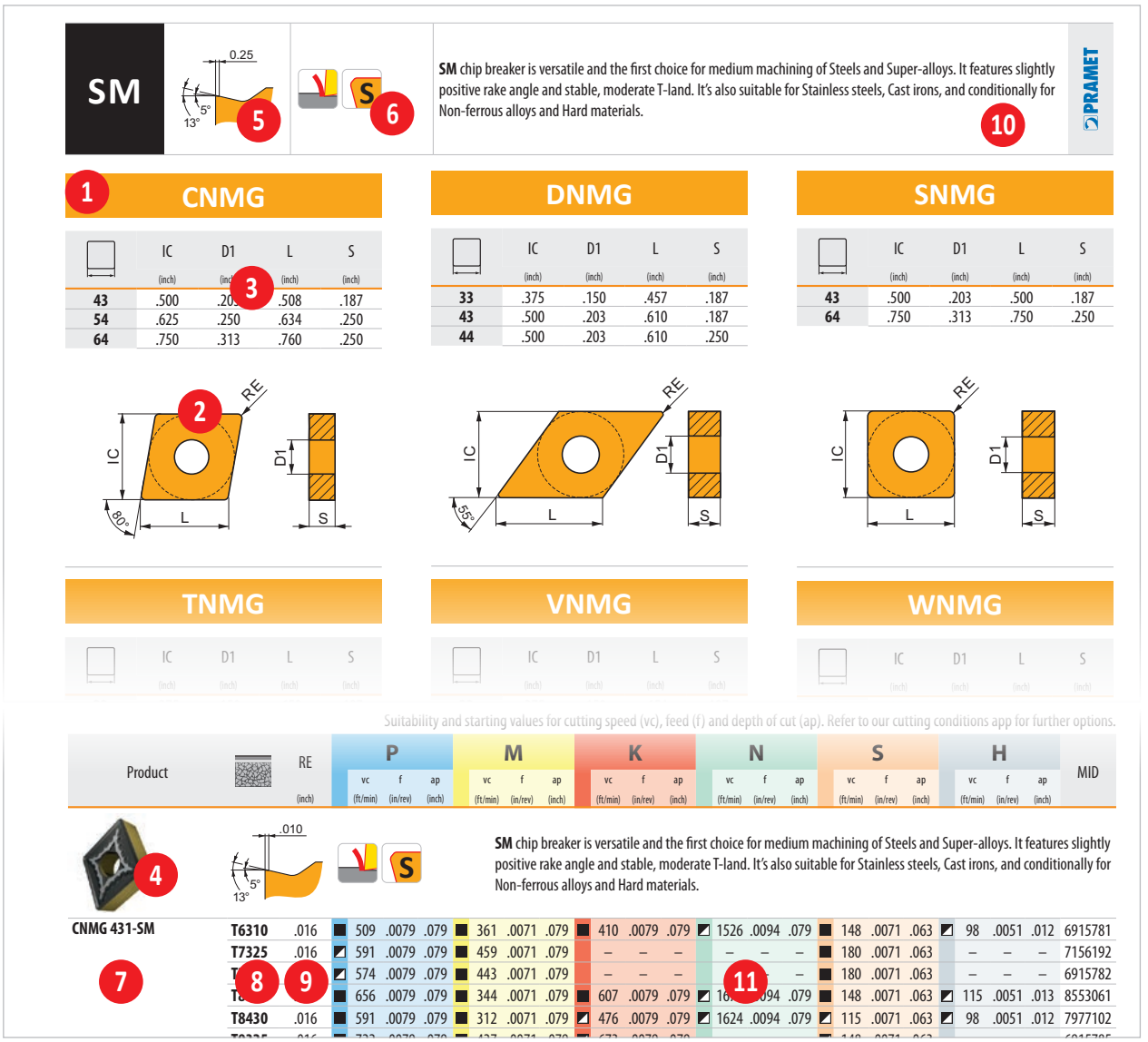
Ground square tool bit with beveled ends according to DIN 4964 B standard. T2000S HSS-E bright steel with 10% Cobalt content in hardness 65 – 67 HRC.



HSS-E	DIN 4964B	Bright
h13		

Product	H	B	OAL	H	B	OAL
	(mm)	(mm)	(mm)	(inch)	(inch)	(inch)
4X4X200A:T2000S	4	4	200.0	–	–	–
6X6X100A:T2000S	6	6	100.0	–	–	–
6X6X200A:T2000S	6	6	200.0	–	–	–
8X8X100A:T2000S	8	8	100.0	–	–	–
8X8X160A:T2000S	8	8	160.0	–	–	–
8X8X200A:T2000S	8	8	200.0	–	–	–
10X10X100A:T2000S	10	10	100.0	–	–	–
10X10X160A:T2000S	10	10	160.0	–	–	–
10X10X200A:T2000S	10	10	200.0	–	–	–
12X12X100A:T2000S	12	12	100.0	–	–	–
12X12X200A:T2000S	12	12	200.0	–	–	–
14X14X200A:T2000S	14	14	200.0	–	–	–
15X15X200A:T2000S	15	15	200.0	–	–	–
16X16X200A:T2000S	16	16	200.0	–	–	–
20X20X200A:T2000S	20	20	200.0	–	–	–
25X25X200A:T2000S	25	25	200.0	–	–	–
3/16X3/16X2.1/2A:T2000S	–	–	–	3/16	3/16	2.500
1/4X1/4X2.1/2A:T2000S	–	–	–	1/4	1/4	2.500
1/4X1/4X4A:T2000S	–	–	–	1/4	1/4	4.000
5/16X5/16X2.1/2A:T2000S	–	–	–	5/16	5/16	2.500
5/16X5/16X4A:T2000S	–	–	–	5/16	5/16	4.000
3/8X3/8X3A:T2000S	–	–	–	3/8	3/8	3.000
3/8X3/8X4A:T2000S	–	–	–	3/8	3/8	4.000
3/8X3/8X6A:T2000S	–	–	–	3/8	3/8	6.000
1/2X1/2X4A:T2000S	–	–	–	1/2	1/2	4.000
1/2X1/2X6A:T2000S	–	–	–	1/2	1/2	6.000
5/8X5/8X6A:T2000S	–	–	–	5/8	5/8	6.000

INSTRUCTIONS



Pos.	Description
1	Designation of insert
2	Schematic drawing of insert
3	Table with insert sizes (in)
4	Picture of representative insert
5	Profile of main cutting edge
6	Icons – specific features and cutting edge type

Pos.	Description
7	ISO insert code:Grade
8	Working conditions
9	Insert radii (in)
10	Geometry description
11	Application area of insert

Typical page with turning inserts displayed – specific page details will differ.

1 **DDUN(RL) INT**

P M K N S H 2

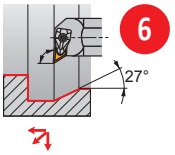
PRAMET

D 3

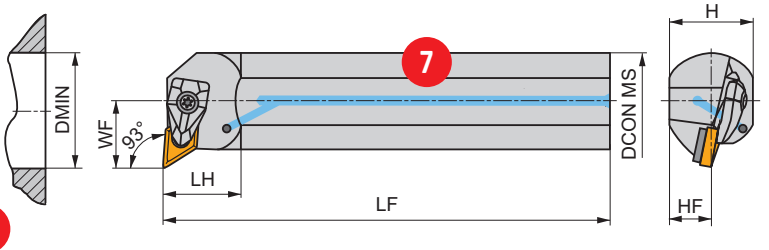
4

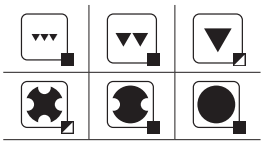
Internal Double Clamp Boring Bar with 93° Cutting Angle for DN.. Inserts

Internal Right/Left hand double clamp boring bar, through coolant, 93° cutting angle for DN.. inserts. Suited for wide range of int[illegible]rning applications, copy turning up to 27°.Body treated for longer tool life. 5



6




8 9

10

	Product	DCON MS (mm)	DMIN (mm)	WF (mm)	H (mm)	HF (mm)	LF (mm)	LH (mm)	LAMS (°)	GAMO (°)		lbs				MID
R	A25T-DDUNR 11	25	32	17	23	11.5	300	28.0	-12	-6	✓	2.12	GI046	DD11	–	7028480
	A32T-DDUNR 11	32	40	22	30	15	300	30.0	-10	-6	✓	3.71	GI046	DD11	–	7028488
	A40T-DDUNR 15	40	50	27	37	18.5	300	36.0	-11	-6	✓	5.70	GI044	DD154	AT002	7028496
	A50U-DDUNR 15	50	63	35	47	23.5	350	39.0	-8	-6	✓	11.54	GI044	DD154	AT002	7028506
	A25T-DDUNL 11	25	32	17	23	11.5	300	28.0	-12	-6	✓	2.12	GI046	DD11	–	7028479
L	A32T-DDUNL 11	32	40	22	30	15	300	30.0	-10	-6	✓	3.71	GI046	DD11	–	7028487
	A40T-DDUNL 15	40	50	27	37	18.5	300	36.0	-11	-6	✓	5.70	GI044	DD154	AT002	7028495
	A50U-DDUNL 15	50	63	35	47	23.5	350	39.0	-8	-6	✓	11.58	GI044	DD154	AT002	7028505

11 12 13 14 15 16 17 18

GI044	DN.. 44[illegible]506..)
GI046	DN.. 33.. (DN.. 1104..)

19

		Nm			
DD11	DCS 09	1.7	DD[illegible]01	US 2004-T09P	FLAG T09P
DD154	DCS 12	3.9	DD[illegible]02	US 2002-T15P	FLAG T15P/3,5

20

AT002a	DN.. 1504..		DDS 266-01
AT002b	CER DN.N 1506..	[illegible]4	–
AT002c	CER DN.A 1506..	DCS 12C2	–

21

302

Typical page with turning holder displayed – specific page details will differ.

TURNING HOLDERS – PAGE OVERVIEW

Pos.	Description
1	Designation of turning holder
2	Material group recommendations
3	Clamping system of insert
4	Illustrative picture [1]
5	Tool description
6	Workpiece profile
7	Schematic drawing of tool
8	Achievable quality of surface
9	Character of cut/working conditions
10	Product applications
11	Tool design

Pos.	Description
12	ISO code of holder
13	Dimensions (in) and angles [2] (°) of holder
14	Internal coolant supply
15	Weight (kg)
16	Group of compatible inserts [3]
17	Group of spare parts [3], [4]
18	Group of accessories [3], [4]
19	Compatible inserts
20	Spare parts
21	Special accessories

[1] Turning holder is primarily displayed in its right design (R)

[2] GAMO = orthogonal rake angle (see technical pages)
LAMS = inclination angle of main cutting edge (see technical pages)

[3] Code of Group of compatible inserts, spare parts and special accessories is used only for purposes of this catalogue. It cannot be used for orders.

[4] Spare parts and special accessories icons are designed schematically for ease of understanding. They aren't included in list of icons. Screws are, in some cases, completed with info on torque value in Nm, length of screw and size of thread.

ICONS OVERVIEW

General Icons

■	Primary use
◪	Possible use

▼▼▼	Finishing – very good surface quality
▼▼	Medium machining – good surface quality
▼	Roughing – unlimited surface roughness

●	Suitable for stable working conditions
◖	Suitable for unstable working conditions
✱	Suitable for very unstable working conditions

Turning operations

	Longitudinal turning without shoulder – external
	Longitudinal turning with shoulder – external
	Cone turning – external
	Chamfering (bevelling)
	Face turning without shoulder
	Face turning with shoulder
	One directional copy turning – external
	Multi directional copy turning – external
	Face copy turning
	Shallow radial groove
	Shallow groove for o-ring
	Wide radial groove (with following expansion)

	Longitudinal turning without shoulder – internal
	Longitudinal turning with shoulder – internal
	Cone turning – internal
	Chamfering (bevelling) in hole
	Chamfering (bevelling) from the back
	Machining the rear face (shoulder) from the back
	One directional copy turning – internal
	Multi directional copy turning – internal
	Face copy turning in hole
	Internal grooving
	Internal groove for o-ring
	Internal grooving (with following expansion)

	Deep radial groove
	Parting off
	Tube parting off
	Shallow axial groove
	Shallow and wide axial groove (with following expansion)
	Deep axial groove
	Deep and wide axial groove (with following expansion)
	Copy turning (multi directional machining)
	Face copy turning
	Thread turning – external
	Thread turning – internal
	Shaping

ICONS OVERVIEW

General Icons

■	Primary use
◪	Possible use

▼▼▼	Finishing – very good surface quality
▼▼	Medium machining – good surface quality
▼	Roughing – unlimited surface roughness

●	Suitable for stable working conditions
	Suitable for unstable working conditions
	Suitable for very unstable working conditions

Features

1	First choice
U	Universal wide range option
	For short chipping materials
	For tough materials (long chipping)
	Thin-walled and slim workpieces
	Large overhang
	Heavy working conditions
W	Insert with Wiper geometry
HSC	High Speed Cutting
HFC	High Feed Cutting

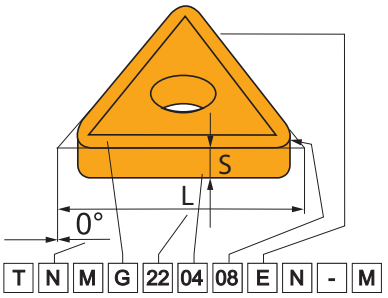
Cutting edge condition code (CECC)

F	Sharp edge
E	Rounded edge
T	Edge with facet
S	Rounded edge with facet
K	Edge with double facet
P	Rounded edge with double facet

Technical parts

FF	Fine finishing
F	Finishing
M	Medium machining
R	Roughing
HR	Heavy roughing
V	Cutting speed
f	Feed (mm/rev)
a_p	Depth of cut (in)
X.V	Multiplication factor for cutting speed
	Durability (min)
Nm	Clamping torque of screw (Nm)
	Group of heads for roughing
	Internal supply of coolant

INSERTS – ISO CODE DESIGNATION



	1	2	3	4
ISO	T	N	U	N
	T	N	M	G
ANSI	1	2	3	4
	T	N	U	
	T	N	M	G

1 Insert shape

H	O	P	R
S	T	C 80°	D 55°
E 75°	M 86°	V 35°	W 80°
L	A 85°	B 82°	K 55°

2 Insert clearance angle

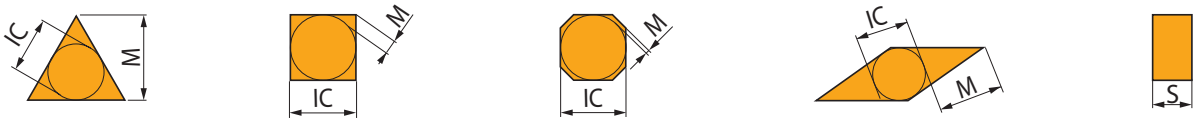
A 3°		B 5°	
C 7°		D 15°	
E 20°		F 25°	
G 30°		N 0°	
P 11°		O	Special

4 Insert type

N	
R	
F	
A	
M	
G	
W	40° – 60°
T	
Q	
U	
B	70° – 90°
H	
C	
J	
X	Special

3 Tolerances

	(mm)			(")		
	M (±)	S (±)	IC (±)	M (±)	S (±)	IC (±)
A	0.005	0.025	0.025	.0002"	.001"	.0010"
F	0.005	0.025	0.013	.0002"	.001"	.0005"
C	0.013	0.025	0.025	.0005"	.001"	.0010"
H	0.013	0.025	0.013	.0005"	.001"	.0005"
E	0.025	0.025	0.025	.0010"	.001"	.0010"
G	0.025	0.130	0.025	.0010"	.005"	.0010"
J	0.005	0.025	0.05 – 0.13	.0002"	.001"	.002 – 0.005"
K	0.013	0.025	0.05 – 0.13	.0005"	.001"	.002 – 0.005"
L	0.025	0.025	0.05 – 0.13	.0010"	.001"	.002 – 0.005"
M	0.08 – 0.18	0.130	0.05 – 0.13	.003 – 0.007"	.005"	.002 – 0.005"
N	0.08 – 0.18	0.025	0.05 – 0.13	.003 – 0.007"	.001"	.002 – 0.005"
U	0.05 – 0.38	0.130	0.05 – 0.13	.005 – 0.015"	.005"	.003 – 0.010"



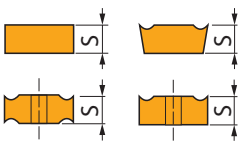
INSERTS – ISO CODE DESIGNATION

5	6	7	8	9		10
22	04	08				
22	04	08	E	N	-	M
5	6	7	8	9		10
4	3	2				
4	3	2	E	N	-	M

5 – Insert cutting edge length (insert size)

d = I.C. (mm)	d = I.C. (in)	H	O	P	S	T	C	D	E	M	V	W	R	K
3.97					03	06		04			06	02		
	5/32"	1.2												
4.76					04	08	04	05	04	04	08	L3		
	3/16"	1.5												
5.56					05	09	05	06	05	05	09	03		
	7/32"	1.8												
6.35		03	02	04	08	11	06	07	08	08	11	04	06	
	1/4"	2												
7.94		04	03	05	07	13	08	09	06	07	13	05	07	
	5/16"	2.5												
9.525		05	04	07	09	16	09	11	09	09	16	06	09	16
	3/8"	3												
12.7		07	05	09	12	22	12	15	13	12	22	08	12	
	1/2"	4												
15.875		09	06	11	15	27	16	19	16	15	27	10	15	
	5/8"	5												
19.05		11	07	13	19	33	19	23	19	19	33	13	19	
	3/4"	6												
25.40		14	10	18	25	44	25	31	26	25	44	17	25	
	1"	8												
31.75		18	13	23	31	54	32	38	32	31	54	21	31	
	1 1/4"	10												

6 – Insert thickness



	S (mm)	S (")
01	1.59	1/16"
T1	1.98	5/64"
02	2.38	3/32"
03	3.18	1/8"
T3	3.97	5.32"
04	4.76	3/16"
05	5.56	7/32"
06	6.35	1/4"
07	7.94	5/16"
09	9.52	3/8"

7 – Insert nose radius

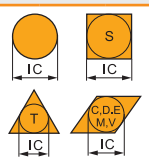
	RE (mm)	RE (")
00	0	0"
02	0.2	1/128"
04	0.4	1/64"
08	0.8	1/32"
12	1.2	3/64"
16	1.6	1/16"
24	2.4	3/32"
32	3.2	1/8"

Round inserts

d = I.C.	
(")	00
(mm)	M0

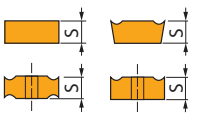
ANSI

5 – Inscribed circle



Symbol	d = I.C. (mm)	d = I.C. (")
1	3.175	1/8"
1.2	3.969	5/32"
1.5	4.763	3/16"
1.8	5.556	7/32"
2	6.350	1/4"
2.5	7.938	5/16"
3	9.525	3/8"
4	12.700	1/2"
5	15.875	5/8"
6	19.050	3/4"
7	22.225	7/8"
8	25.400	1"
10	31.750	5/4"
12	38.100	6/4"

6 – Insert thickness



Symbol	S (mm)	S (")
1	1.588	1/16"
1.2	1.984	5/64"
1.5	2.381	3/32"
2	3.175	1/8"
2.5	3.969	5/32"
3	4.763	3/16"
3.5	5.556	7/32"
4	6.350	1/4"
5	7.938	5/16"
6	9.525	3/8"
7	11.113	7/16"
8	12.700	1/2"
9	14.288	9/16"
10	15.875	5/8"

7 – Insert nose radius

Symbol	RE (mm)	RE (")
0	0	0"
0.2	0.099	1/256"
0.5	0.198	1/128"
1	0.397	1/64"
2	0.794	1/32"
3	1.191	3/64"
4	1.588	1/16"
5	1.984	5/64"
6	2.381	3/32"
7	2.778	7/64"
8	3.175	1/8"
10	3.969	5/32"
12	4.763	3/16"
14	5.556	7/32"
16	6.350	1/4"

8 – Insert cutting edge design

F Sharp edges	E Rounded edges
T Edges with facet	S Rounded edges with facet
K Edges with double facet	P Rounded edges with double facet

9 – Feed direction

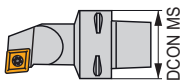
R	Feed ←	N	Feed ← Feed →
L	Feed →		

10 – Chip breaker designation

EXTERNAL TURNING TOOLS – ISO CODE DESIGNATION

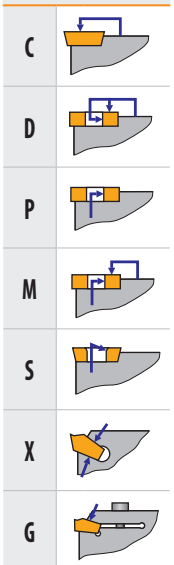
Shank tool	ISO	2	3	4	5	6		7	8	11	12		13	
		P	C	L	N	R	–	32	25	L	12	–	M	
PSC	ISO	1	2	3	4	5	6		9	10		12		
		C4	– D	C	L	N	R	–	27	050	–	12		
Shank tool	ANSI	2	3	4	5	6		7 & 8		12		11		
		D	C	L	N	R	–	16		4		D		

1 Coupling size

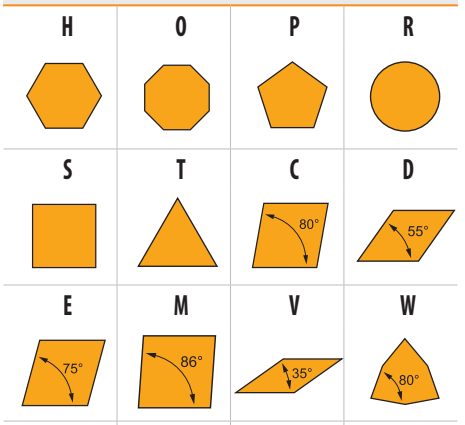


C	DCON MS
C3	32
C4	40
C5	50
C6	63
C8	80

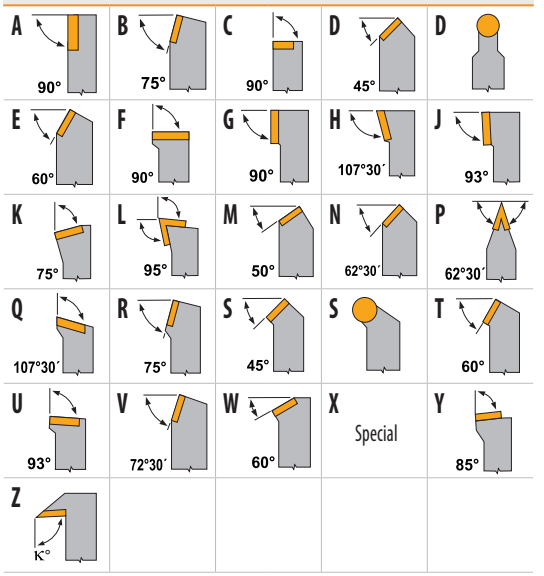
2 Clamping designation



3 Insert shape



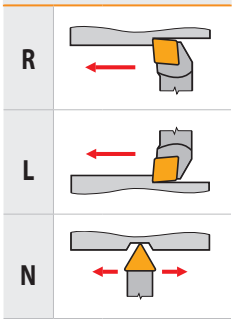
4 Holder style – cutting edge angle



5 Insert clearance angle

N	B	C	P
0°	5°	7°	11°

6 Direction of cut



7 & 8 Shank width & Shank height (″)

Symbol	B (″)	H (″)
05	5/16″	5/16″
06	3/8″	3/8″
08	1/2″	1/2″
10	5/8″	5/8″
12	3/4″	3/4″
16	1″	1″
85	1″	1 1/4″
86	1″	1 1/2″
20	1 1/4″	1 1/4″
24	1 1/2″	1 1/2″
32	2″	2″

For square shanks, the number is the width or height in terms of 16ths. For rectangular shanks the first digit is the width in terms of 8ths and the second digit is the height in terms of 4ths.

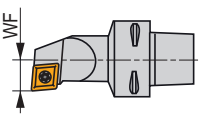
7 Shank height (mm)

08	10	12	16	20	25
32	38	40	45	50	60

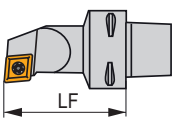
8 Shank width (mm)

08	10	12	16	20	25
32	38	40	45	50	60

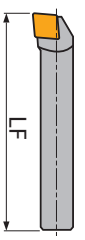
9 Functional width (mm)



10 Functional lenght (mm)



11 Holder total length



	LF (″)
A	4.000″
B	4.500″
C	5.000″
D	6.000″
E	7.000″
F	8.000″
M	4.000″
N	4.500″
R	6.000″
S	7.000″
T	8.000″

	LF (mm)
D	60
E	70
F	80
H	100
J	110
K	125
L	140
M	150
N	160
P	170
Q	180
R	200
S	250
T	300
U	350
V	400
W	450
X	Spec.
Y	500

INTERNAL TURNING TOOLS – ISO CODE DESIGNATION

	15	16	17		2	3	4	5	6	12		14
ISO	A	25	T	–	P	C	L	N	L	12	–	X
ANSI	A	16	T	–	D	C	L	N	L	4		

12 / 12 – Insert cutting edge length (insert size)

d = I.C. (mm)	d = I.C. (")	H	O	P	S	T	C	D	E	M	V	W	R	K
3.97					03	06		04			06	02		
	5/32"	1.2												
4.76					04	08	04	05	04	04	08	L3		
	3/16"	1.5												
5.56					05	09	05	06	05	05	09	03		
	7/32"	1.8												
6.35		03	02	04	08	11	06	07	08	08	11	04	06	
	1/4"	2												
7.94		04	03	05	07	13	08	09	06	07	13	05	07	
	5/16"	2.5												
9.525		05	04	07	09	16	09	11	09	09	16	06	09	16
	3/8"	3												
12.7		07	05	09	12	22	12	15	13	12	22	08	12	
	1/2"	4												
15.875		09	06	11	15	27	16	19	16	15	27	10	15	
	5/8"	5												
19.05		11	07	13	19	33	19	23	19	19	33	13	19	
	3/4"	6												
25.40		14	10	18	25	44	25	31	26	25	44	17	25	
	1"	8												
31.75		18	13	23	31	54	32	38	32	31	54	21	31	
	1 1/4"	10												

13 – Manufacturer's designation

M	Clamping system "S" with shim

14 – Manufacturer's designation

X	Special shank style
. .	
93	Z – style tool setting angle
. .	

15 / 15 – Shank

S	Steel shank
A	Steel shank with coolant hole
E	Tungsten carbide shank with coolant hole

16 / 16 – Shank Ø (mm)

DCON MS (mm)		DCON MS (")	
08	8	03	.1875"
10	10	04	.250"
12	12	05	.3125"
16	16	06	.375"
20	20	08	.500"
25	25	10	.625"
32	32	12	.750"
40	40	16	1.000"
50	50	20	1.250"
60	60	24	1.500"
		32	2.000"

17 / 17 – Holder total Length

	LF (")
F	3.250"
H	4.000"
K	5.000"
M	6.000"
P	6.250"
Q	7.250"
R	8.000"
S	10.000"
T	12.000"
U	14.000"
V	15.750"
W	17.750"
Y	20.000"
X	Spec.

	LF (mm)
D	60
E	70
F	80
H	100
J	110
K	125
L	140
M	150
N	160
P	170
Q	180
R	200
S	250
T	300
U	350
V	400
W	450
X	Spec.
Y	500

HEADS – ISO CODE DESIGNATION

CARTRIDGE

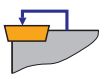
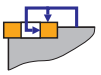
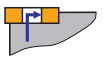
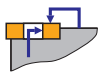
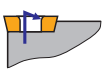
1	2		3	4	5	6	7
KH	P	–	C	L	N	R	25

HOLDER

8	6	9	10	11
DKH	R	50	60	W

1 Cartridge

2 Clamping designation

C	
D	
P	
M	
S	
X	
G	

3 Insert shape

S		C	
T		D	
R		K	
W		V	
L		X	Special

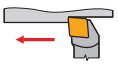
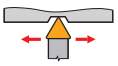
4 Holder style – cutting edge angle

A 90°	B 75°	C 90°	D 45°	D
E 60°	F 90°	G 90°	H 107°30′	J 93°
K 75°	L 95°	M 50°	N 62°30′	P 62°30′
Q 107°30′	R 75°	S 45°	S	T 60°
U 93°	V 72°30′	W 60°	X Special	Y 85°
Z K°				

5 Insert clearance angle

N	C	P
0°	7°	11°

6 Direction of cut

R	
L	
N	

7 Insert cutting edge length (insert size)

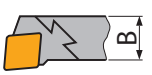
d = I.C. (mm)	(″)	H	O	P	S	T	C	D	E	M	V	W	R	K
3.97					03	06		04			06	02		
	5/32″	1.2												
4.76					04	08	04	05	04	04	08	L3		
	3/16″	1.5												
5.56					05	09	05	06	05	05	09	03		
	7/32″	1.8												
6.35		03	02	04	08	11	06	07	08	08	11	04	06	
	1/4″	2												
7.94		04	03	05	07	13	08	09	06	07	13	05	07	
	5/16″	2.5												
9.525		05	04	07	09	16	09	11	09	09	16	06	09	16
	3/8″	3												
12.7		07	05	09	12	22	12	15	13	12	22	08	12	
	1/2″	4												
15.875		09	06	11	15	27	16	19	16	15	27	10	15	
	5/8″	5												
19.05		11	07	13	19	33	19	23	19	19	33	13	19	
	3/4″	6												
25.40		14	10	18	25	44	25	31	26	25	44	17	25	
	1″	8												
31.75		18	13	23	31	54	32	38	32	31	54	21	31	
	1 1/4″	10												

8 Cartridge holder

9 Shank height (mm)

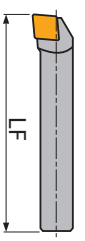
08	10	12	16	20	25
32	40	50	60	70	80

10 Shank width (mm)



08	10	12	16	20	25
32	40	50	60	70	80

11 Holder total length



	LF (mm)
H	100
J	110
K	125
L	140
M	150
N	160
P	170
Q	180
R	200
S	250
T	300
U	350
V	400
W	450
X	Spec.
Y	500

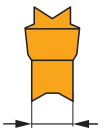
1	2		3	4	5	6	7		8
GL	3	–	D	300	G	02	L06	–	PM

1 Tool group

GL

2 Pocket size

1, 2, 3, 4, 5, 6



3 Number of edges

S	One edge
D	Two edges

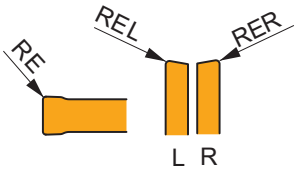
4 Cutting width – CW

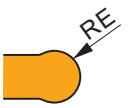
	CW
150	1.50
200	2.00
250	2.50
300	3.00
400	4.00
500	5.00
600	6.00
800	8.00

5 Edge design

G	Ground
M	Direct pressed

6 Nose radius



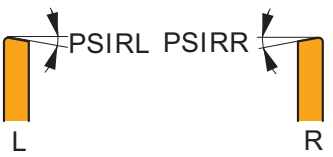


	RE, RER, REL (mm)
015	0.15
02	0.2
03	0.3
04	0.4
08	0.8

ROUND GEOMETRY

	RE (mm)
M0	RE = CW/2

7 Primary cutting edge angle



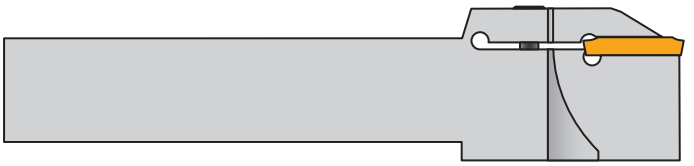
	(°)
06	6
12	12

8 Chipbreaker designation

PM
PR
GM
MM

PARTING – OFF & GROOVING HOLDERS (EXTERNAL TURNING) – GL – CODE DESIGNATION

1	2		3	4	5	6	7		8		9	10	11
GL	3	–	S	2525	M	F	R	–	20	–	R	120	090

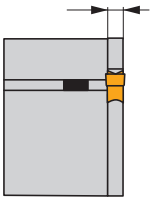


1 Tool group

GL

2 Pocket size

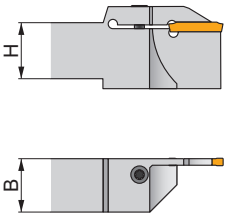
1, 2, 3, 4, 5, 6



3 Shank type

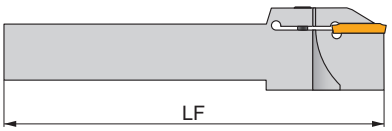
A	steel shank with internal coolant
S	steel shank without internal coolant

4 Shank dimensions



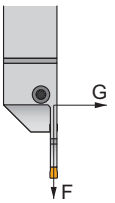
	H × B (mm)
1212 –	12 × 12
1616 –	16 × 16
2020 –	20 × 20
2525 –	25 × 25
3232 –	32 × 32

5 Holder total length – LF

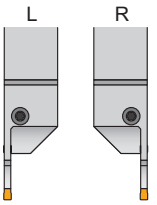


	LF (mm)
H	100
K	125
M	150
P	170

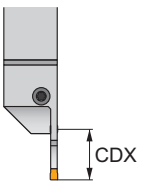
6 Tool style – cutting edge angle



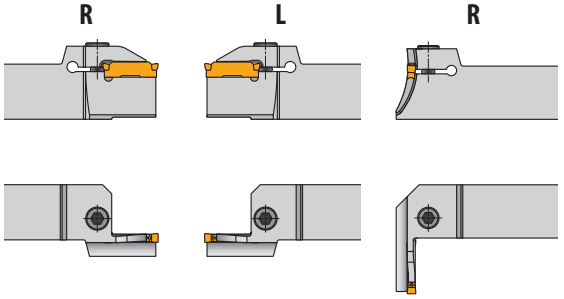
7 Version (right/left)



8 Cutting depth maximum – CDX

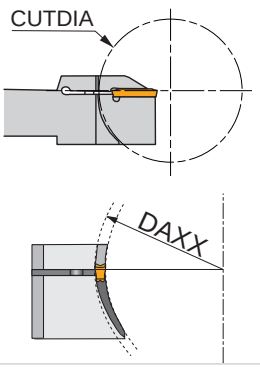


9 Blade curvature direction

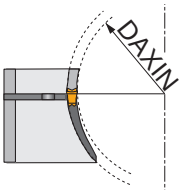


Additional information for axial turning.

10 Maximum diameter



11 Minimum diameter

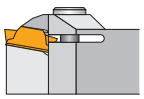


PARTING – OFF & GROOVING TOOLS – EXTERNAL TURNING – ISO CODE DESIGNATION

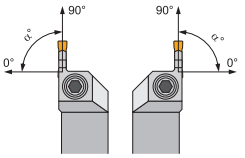
	1	2	3	4	5	6	7	8	9	10	11
ISO	G	F	I	L	25	25	M	0316	R	030	017
ANSI	1	2	3	4	5 & 6		7	8	9	10	11
	G	F	I	L	16		D	0316	R	1.18	.670

1 | 1 Clamping designation

G



2 | 2 Holder style – cutting edge angle

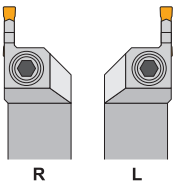


α°	
G = 0°	K = 75°
R = 15°	F = 90°
T = 30°	B = 105°
S = 45°	E = 120°
W = 60°	D = 135°

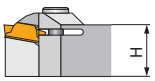
3 | 3 Cutting depth maximum – CDX

G = 2.0 × CW	N = 5.5 × CW
H = 2.5 × CW	O = 6.0 × CW
I = 3.0 × CW	P = 6.5 × CW
J = 3.5 × CW	Q = 7.0 × CW
K = 4.0 × CW	R = 7.5 × CW
L = 4.5 × CW	S = 8.0 × CW
M = 5.0 × CW	T = 8.5 × CW

4 | 4 Version (right/left) R/L

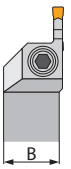


5 Shank height (mm)



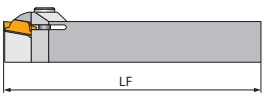
12 = 12 mm
16 = 16 mm
20 = 20 mm
etc.

6 Shank width (mm)



12 = 12 mm
16 = 16 mm
20 = 20 mm
etc.

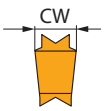
7 | 7 Holder total length



	LF (mm)
H	100
J	110
K	125
L	140
M	150
N	160
P	170
Q	180
R	200

	LF (")
A	4.000"
B	4.500"
C	5.000"
D	6.000"
E	7.000"
F	8.000"

8 | 8 Insert width



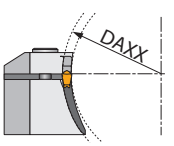
	CW (mm)	CW (")
02	2.0	.079"
03, 0313, 0316	3.0	.118"
04, 0413, 0416	4.0	.157"
05, 0516	5.0	.197"
06, 0616	6.0	.236"
08, 0830	8.0	.315"

5 & 6

	B (")	H (")
05	5/16"	5/16"
06	3/8"	3/8"
08	1/2"	1/2"
10	5/8"	5/8"
12	3/4"	3/4"
16	1"	1"
85	1"	1 1/4"
86	1"	1 1/2"
20	1 1/4"	1 1/4"
24	1 1/2"	1 1/2"
32	2"	2"

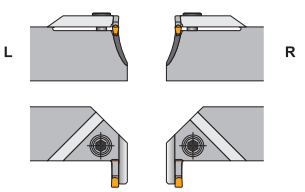
For square shanks, the number is the width or height in terms of 16ths. For rectangular shanks the first digit is the width in terms of 8ths and the second digit is the height in terms of 4ths.

10 | 10 Maximum diameter – face grooving



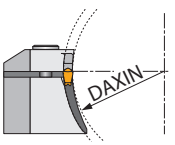
Additional information for axial turning

9 | 9 Blade curvature direction



Additional information for axial turning

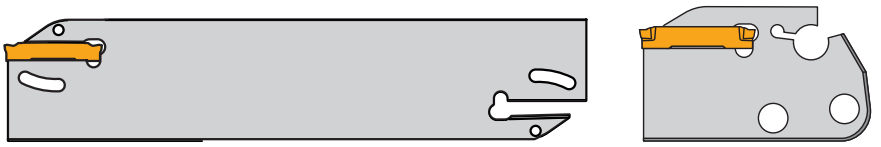
11 | 11 Minimum diameter – face grooving



Additional information for axial turning

PARTING – OFF & GROOVING BLADES (EXTERNAL TURNING) – GL – CODE DESIGNATION

1	2		3	4	5	6	7		8
GL	1	–	S	26	K	B	R	–	16

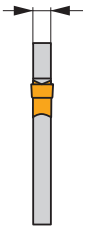


1 – Tool group

GL

2 – Pocket size

1, 2, 3, 4, 5, 6



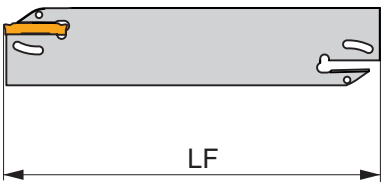
3 – Shank type

A	Steel shank with internal coolant
S	Steel shank without Internal coolant

4 – Shank dimensions

	H (mm)
26	26
29	29
32	32

5 – Blade total length – LF

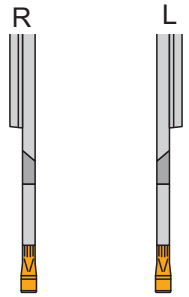


	LF (mm)
C	50
K	125
M	150

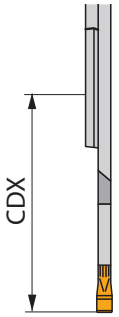
6 – Tool style

B – blade
BS – modular blade

7 – Version (right/left)

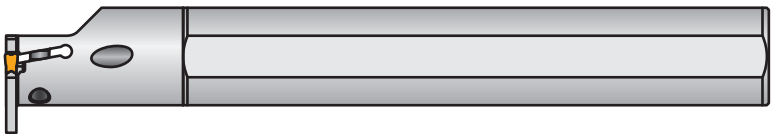


8 – Cutting depth maximum – CDX



PARTING – OFF & GROOVING HOLDERS (INTERNAL TURNING) – GL – CODE DESIGNATION

1	2		3	4	5	6	7		8		9
GL	3	–	A	32	S	G	R	–	12	–	45

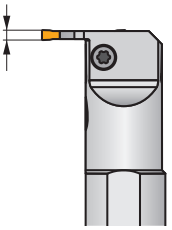


1 Tool group

GL

2 Pocket size

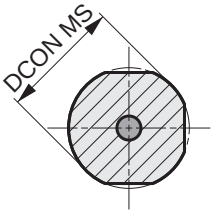
2, 3, 4



3 Shank type

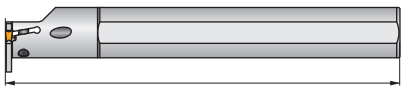
A	Steel shank with internal coolant
S	Steel shank without internal coolant

4 Shank dimensions



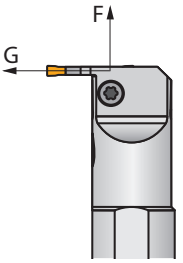
	DCON MS (mm)
25	25
32	32
40	40

5 Holder total length – LF

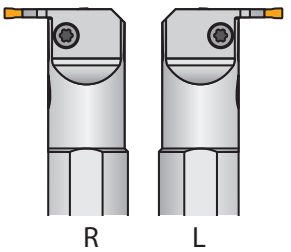


	LF (mm)
Q	180
S	250
T	300

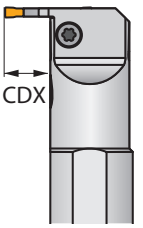
6 Tool style – cutting edge angle



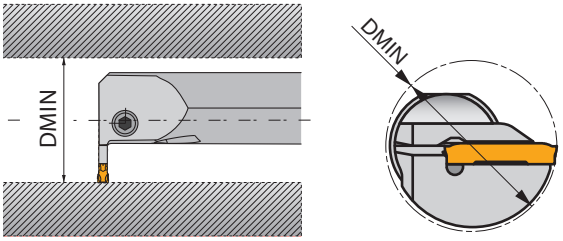
7 Version (right/left)



8 Cutting depth maximum – CDX



9 Minimum diameter



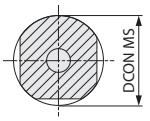
PARTING – OFF & GROOVING TOOLS – INTERNAL TURNING – ISO CODE DESIGNATION

	1	2	3	–	4	5	6	7	8
ISO	A	25	S	–	G	G	H	L	0313
ANSI	A	16	S	–	G	G	H	L	0313

1 Shank

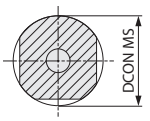
S	Steel shank
A	Steel shank with coolant hole

2 Diameter of shank



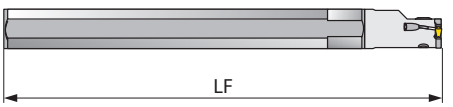
	DCON MS (mm)
12	12
16	16
20	20
25	25
32	32
40	40

2 Diameter of shank



	DCON MS (")
08	.500"
10	.625"
12	.750"
16	1.000"
20	1.250"
24	1.500"

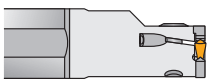
3 Holder total length



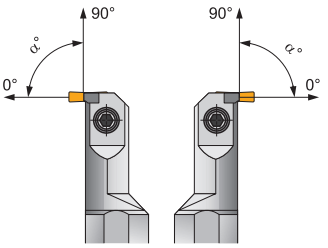
	LF (mm)	LF (")		LF (mm)	LF (")
M	150	6.000"	S	250	10.000"
P	170	6.250"	T	300	12.000"
Q	180	7.250"	U	350	14.000"
R	200	8.000"	V	400	15.750"

4 Clamping designation

G



5 Tool style – cutting edge angle



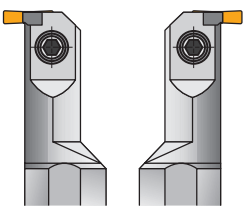
α°	
G = 0°	K = 75°
R = 15°	F = 90°
T = 30°	B = 105°
S = 45°	E = 120°
W = 60°	D = 135°

6 Cutting depth maximum – CDX

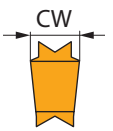
E = 1.0 × CW	J = 3.5 × CW
F = 1.5 × CW	K = 4.0 × CW
G = 2.0 × CW	L = 4.5 × CW
H = 2.5 × CW	M = 5.0 × CW
I = 3.0 × CW	N = 5.5 × CW
X = Special	

7 Version (right/left) R/L

R L



8 Insert width

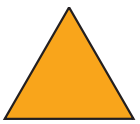


	CW (mm)
0313	3.0
0413	4.0

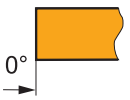
INDEXABLE CUTTING INSERTS FOR THREADING ISO – CODE DESIGNATION

	1	2	3	4	5	6	7		8
ISO	T	N	16	E	R	175	M	–	P1
ANSI	1 T	2 N	3 16	4 E	5 R	6 120	7 W	–	8 P1

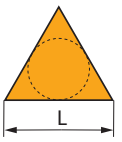
1 Insert shape

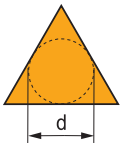
T	

2 Insert clearance angle

N	

3 Insert cutting edge length (insert size)





L		d = IC	
(mm)	(")	(mm)	(")
11	.433"	**6,350**	1/4"
16	.650"	**9,525**	3/8"
22	.866"	**12,7**	1/2"

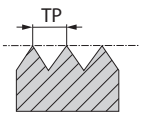
4 External – Internal

E	External
N	Internal

5 Direction of cut

R	Right
L	Left
N	Neutral

6 Thread pitch



s × 100

Thread Pitch mm × 100

6 No. of threads

No. of threads per inch × 10

7 Thread profile

M	Metric 60°	**TR**	TR 30° ISO 2901/3–1977
MJ	SEA MA1370	**UN**	American UN 60° ISO 5864–1978
W	Whitworth 55° ISO 228–1982	**UNJ**	SEA AS8879
RD	Round 30°	**ACME**	ACME 29° ANSI B1.5–1988
BSPT	ISO 228/1 35 21 1959 ISO 7/1	**STACME**	ASME/ANSI B1.8-1988
NPT	ANSI B1.1–1983	**API RD**	API

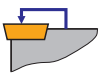
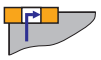
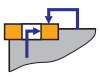
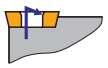
8 Chip breaker designation

P1	Pressed
AL	For nonferous

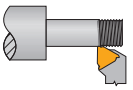
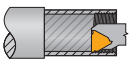
ISO CODE DESIGNATION – HOLDERS THREADING

	1	2	3	–	4	5	6	7	–	8
ISO	S	E	R	–	S	2525	M	16	–	
ANSI	1	2	3	–	4	5	6	7	–	8
	S	E	R	–	S	16	D	16	–	

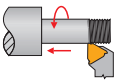
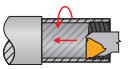
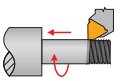
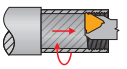
1 Clamping designation

C	
P	
M	
S	

2 Machining orientation

E	External	
I	Internal	

3 Direction of cut

R	Right	External	
		Internal	
L	Left	External	
		Internal	

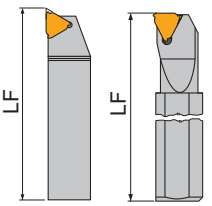
4 Type of construction

–	Normal
S	Special

5 Holder dimensions (mm)

External turning	2525	25 × 25 mm
Internal turning	1416	Shank – 14 mm Shank height Ø – 16 mm

6 Holder total length (mm)

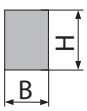


	LF (mm)
K	125
L	140
M	150
N	160
P	170
Q	180
R	200
S	250
T	300

7 Insert cutting edge length (insert size)

d = IC (mm)	d = IC (")	T
6.350	1/4"	11
9.525	3/8"	16
12.700	1/2"	22

5 Tool dimensions (")

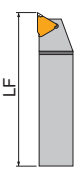


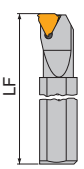
	B (")	H (")
10	5/8"	5/8"
12	3/4"	3/4"
16	1"	1"
85	1"	1 1/4"
86	1"	1 1/2"
20	1 1/4"	1 1/4"

	DCON (")
08	.500"
10	.625"
12	.750"
16	1.000"
20	1.250"
24	1.500"

For square shanks, the number is the width or height in terms of 16ths. For rectangular shanks the first digit is the width in terms of 8ths and the second digit is the height in terms of 4ths.

6 Holder total length (")





	LF (")
C	5.000"
D	6.000"
E	7.000"
F	8.000"
K	5.000"
M	6.000"
P	6.250"
Q	7.250"
R	8.000"
S	10.000"
T	12.000"
U	14.000"

8 Helix angle λ

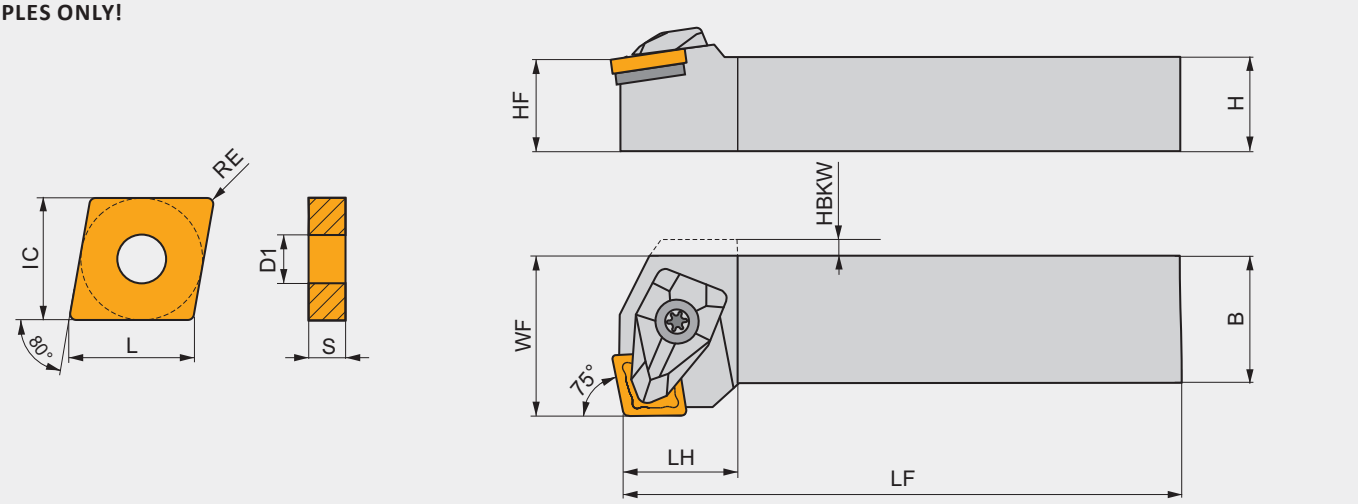
0	Helix angle λ = 0°
1	Helix angle λ = 1°
2	Helix angle λ = 2°

CUTTING TOOL PARAMETERS ACCORDING TO ISO 13399

All cutting tools are defined by a number of parameters according to the standard ISO 13399. This list contains all the parameters used in this catalogue and their definitions.

ISO 13399 is an international cutting tool information standard. It provides dimensions and parameters in a neutral format that is independent of any particular system or company nomenclature. When cutting tools are clearly defined according to a global standard, all types of software can process the electronic data more quickly, improving the quality of communication and helping to make the exchange of information run smoothly. Supporting a common language in our cutting tool descriptions this will assist system to system communication. It will save you a significant amount of time, providing an easier gathering of high-quality data across our 40,000 solid and indexable tools. By using an ISO 13399 compliant system, there will be no need to manually interpret data and key-enter it into your system.

EXAMPLES ONLY!



ISO 13399	Description
APMX	Depth of cut maximum
B	Shank width
BD	Body diameter
BLRAD	Blade reinforcement radius
BW	Insert body width
CDX	Cutting depth maximum
CND	Coolant entry diameter
CUTDIA	Work piece parting diameter maximum
CW	Cutting width
CWTOLL	Cutting width lower tolerance
CWTOLU	Cutting width upper tolerance
D1	Fixing hole diameter
DAXIN	Minimum axial groove inside diameter
DAXN	Minimum axial groove outside diameter
DAXX	Maximum axial groove outside diameter
DCON MS	Connection diameter
DMIN	Minimum bore diameter
DMINP	Minimum bore diameter perpendicular
GAMO	Ortogonal rake angle
GAMP	Axial rake angle
H	Shank height
HBH	Head bottom offset height
HBKW	Head bottom offset width
HF	Functional height
IC	Inscribed circle diameter
INSD	Insert diameter
INSL	Insert length

ISO 13399	Description
KAPR	Tool cutting edge angle
L	Cutting edge length
LAMS	Inclination angle
LB	Body length
LF	Functional length
LFA	A dimension on LF
LFS	Functional length secondary
LH	Head length
LU	Usable length
M	M-dimension
OAL	Overall length
PDX	Profile distance X
PDY	Profile distance Y
PSIRL	Tool lead angle left
PSIRR	Tool lead angle right
RE	Corner radius
S	Insert thickness
S1	Insert thickness total
TP	Thread pitch
TPI	Threads per inch
TPIN	Threads per inch
TPIX	Threads per inch
TPN	Thread pitch minimum
TPX	Thread pitch maximum
W1	Insert width
WF	Functional width
WFS	Functional width secondary

T	9	4	1	5
Operation	Coating/Substrate	Generation	ISO range	

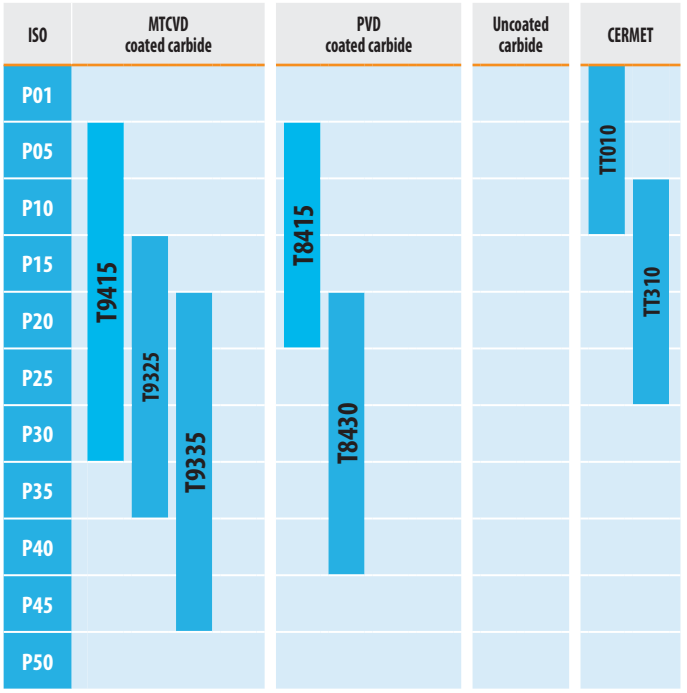
D	Drilling
M	Milling
T	Turning
G	Grooving and Parting off

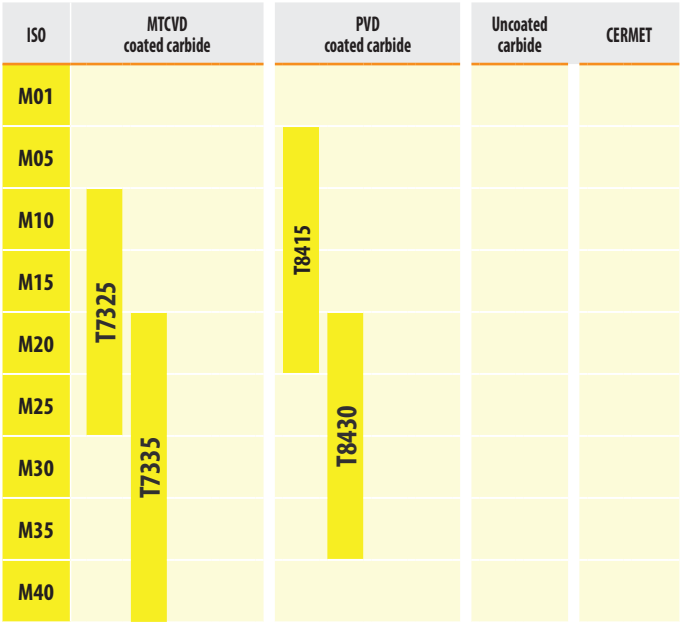
0 PVD 1 CVD	Special application
2 PVD 3 CVD	Free
4 PVD 5 CVD	Group K, H
6 PVD 7 CVD	Group M, S
8 PVD 9 CVD	Universal
B	CBN
C	Ceramic
D	PCD
T	Cermet

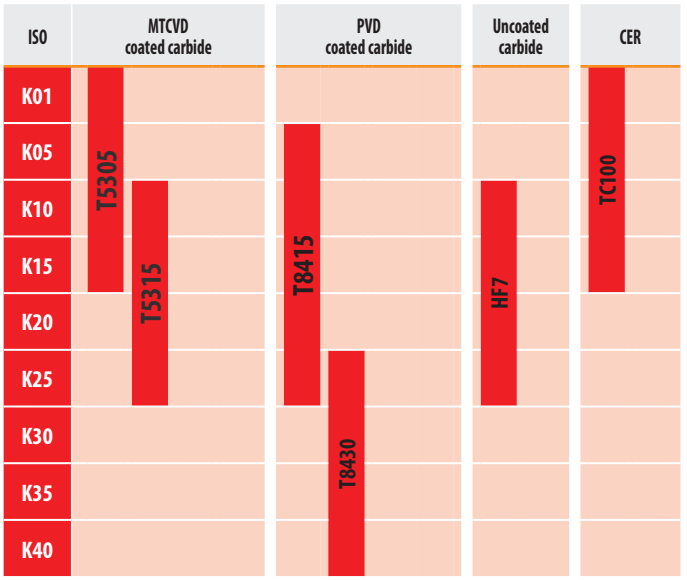
1 – 9

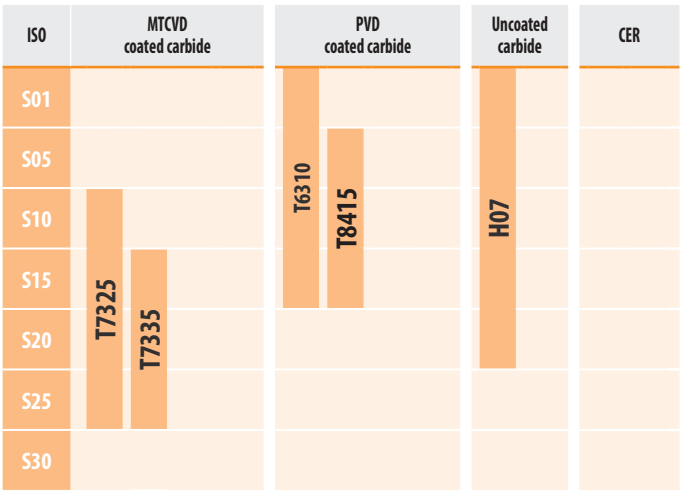
01 – 50	
	01 – 05
	05 – 10
	10 – 20
	20 – 30
	30 – 40
	40 – 50

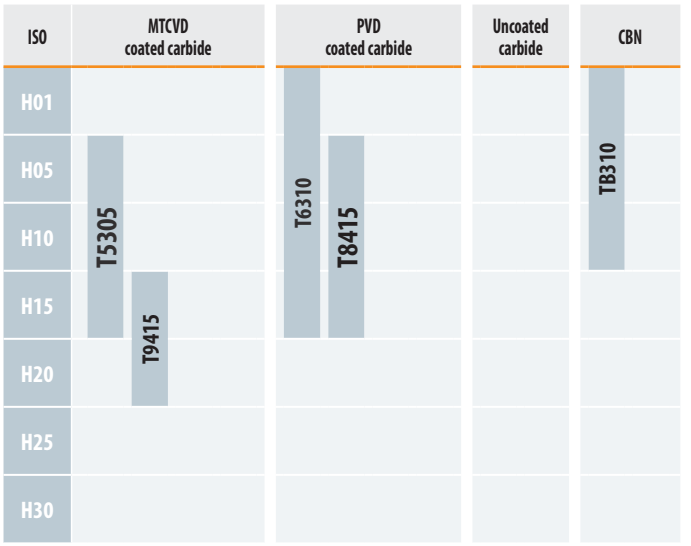
ISO TURNING GRADES – NAVIGATOR











CVD TURNING GRADES

Grade Identification	Area of Application	Application	Feed	Cutting speed	Resistance to adverse Working Conditions	Coating	Colour	Substrate	Coolant benefit	Grade description
T9415 NEW	P05 - P30	■				MT-CVD		FGM	+ +	Highly wear-resistant material designed primarily for finish turning of common carbon and alloy steels. Despite its high abrasion resistance, it is also suitable for interrupted cutting operations. We recommend this material as the first choice for most turning operations, especially in high production applications.
	K05 - K25	◪								
	H10 - H20	◪								
T9310	P01 - P15	■				MT-CVD		FGM	+ +	Grade with high abrasion resistance which can be used for slightly interrupted cutting. It will be used for finishing or semi-roughing operations. This material can also be used for roughing operations provided the machine-tool-workpiece configuration is sufficiently rigid.
	K05 - K20	◪								
	H10 - H20	◪								
T9315	P05 - P25	■				MT-CVD		FGM	+ +	A versatile grade with excellent wear resistance properties even under intense cutting conditions. It can also be used for operations with interrupted cuts.
	K05 - K25	◪								
	H10 - H20	◪								
T9325	P15 - P35	■				MT-CVD		FGM	+ +	From a technological perspective this is an extremely versatile grade with high resistance to mechanical damage in adverse cutting conditions and retains excellent wear resistance. The correct application of this material requires high cutting speeds.
	M10 - M30	■								
	K15 - K35	◪								
	S10 - S20	◪								
T9335	P20 - P45	■				MT-CVD		FGM	+ + +	One of the toughest grades which is especially suitable for adverse cutting conditions at medium to high feed rates and medium cutting speeds. Compared to its predecessors, M15 – M40 it is not only tougher, but also more abrasion resistant which will be useful when using intensive cutting conditions.
	M15 - M40	■								
	S15 - S25	◪								
T9226	P15 - P35	■				MT-CVD		FGM	+ + +	Grade designed for heave roughing applications. A versatile grade with high resistance to mechanical damage and retains very good wear resistance. Usable at lower cutting speeds.
	M10 - M30	■								
	K15 - K35	◪								
	S15 - S25	□								
T7325	P15 - P35	◪				MT-CVD		FGM	+ + +	One of the most universal turning grades. Especially designed for stainless steel machining. Optimal balance between wear resistance and performance reliability. Suitable for broad variety of application in turning operations.
	M10 - M25	■								
	S10 - S25	■								
T7335	P20 - P40	◪				MT-CVD		FGM	+ + +	Grade with functionally graded substrate, featuring very high operational reliability and very good wear-resistance. It is best suited to use in the machining of very tough M20 – M40 materials.
	M20 - M40	■								
	S15 - S25	■								
T5305	P05 - P15	◪				MT-CVD		H	+	Grade with very high resistance to chemical wear; suitable for finishing operations using high cutting speeds. With its high abrasion resistance, it is also suitable for productive K01 – K15, machining of hardened and treated materials.
	K01 - K15	■								
	H05 - H15	◪								
T5315	P10 - P25	◪				MT-CVD		H	+	Grade intended primarily for productive machining which has high abrasion resistance and good operational reliability. Due to its properties, this material is particularly suitable for roughing and finishing operations for good or slightly adverse cutting conditions.
	K10 - K25	■								
	H15 - H25	◪								
6640	P20 - P40	■				MT-CVD		H	+ + +	One of the toughest turning materials which can be used especially in roughing operations, or where operational reliability under adverse cutting conditions is a priority. Another ideal choice for machines working with low to medium cutting speeds and medium to high feed rates.
	M20 - M35	■								
	K25 - K40	■								

Grade Identification	Area of Application	Application	Feed	Cutting speed	Resistance to adverse Working Conditions	Coating	Colour	Substrate	Coolant benefit	Grade description
T8415 NEW	P05 - P20 M05 - M20 K05 - K25 N05 - N25 S05 - S15 H05 - H15	■ ■ ■ ◪ ■ ■				PVD		submicron H	+ +	A versatile, high performance turning grade primarily intended for steel machining, but well suitable for stainless steels and heat resistant super alloys (HRSA) too, possibly applicable for hardened steels. It is suitable for machining at wide range of cutting speeds, light to medium feeds and under good cutting conditions, preferably with coolant.
T8315	P05 - P20 M05 - M20 K05 - K25 N05 - N25 S05 - S15 H05 - H15	◪ ■ ■ ■ ◪ ■				PVD		submicron H	+ +	Grade featuring excellent abrasion resistance while maintaining above average operational reliability, it is suitable for machining at medium to high cutting speeds in short chipping harder materials.
T8430	P20 - P40 M20 - M35 K25 - K40 N15 - N30 S15 - S25 H15 - H25	■ ■ ◪ ◪ ◪ ◪				PVD		submicron H	+ + +	Undoubtedly the most versatile cutting material, this is useful for machining of all types of machined materials and is practically applicable in almost all types of turning operations. Its main benefits are its high operational reliability and very good frictional properties; it is therefore suitable for applications at medium and lower cutting speeds.
T8345	P30 - P50 M20 - M40 K30 - K40 S20 - S30	■ ◪ ◪ ◪				PVD		submicron H	+ + +	This is the toughest turning grade, which is intended mainly for machining under the worst cutting conditions and in applications with the highest requirements for operating reliability. Because of these properties, this material is recommended for lower cutting speeds.
T6310	P01 - P15 M01 - M15 K05 - K20 N05 - N20 S01 - S15 H01 - H15	■ ■ ■ ■ ■ ■				PVD		ultra submicron H	+ + +	High wear resistant turning grade with top PVD coating. Suitable for finishing operation and applications, where sharp cutting edge together with high flank wear resistance is of high importance
T0315	N05 - N20	■				PVD		submicron H	+ +	Submicron grade for turning non-ferrous metals and their alloys with a balance of wear resistance and toughness. It is provided with a unique coating with excellent friction properties.
G8330	P25 - P40 M20 - M35 K20 - K40 N15 - N30 S15 - S25	■ ■ ■ ◪ ◪				PVD		submicron H	+ + +	Universal cutting grade for grooving and parting-off applications. This grade is characterized by its exceptional reliability and versatility. Developed to fit machining conditions for most workpiece materials.
T8330	P25 - P40 M20 - M35 K20 - K40 N15 - N30 S15 - S25 H15 - H25	■ ■ ■ ◪ ◪ ◪				PVD		submicron H	+ + +	Undoubtedly the most versatile cutting material, this is useful for machining of all types of machined materials and is practically applicable in almost all types of turning operations. Its main benefits are its high operational reliability and very good frictional properties; it is therefore suitable for applications at medium and lower cutting speeds.
T8010	P05 - P15 M05 - M15 K10 - K20 S10 - S15	■ ■ ■ ◪				PVD		submicron H	+ + +	This grade is suitable for continuous high precision thread turning of steels, stainless steel, cast iron and super alloys. Offering excellent wear resistance while ensuring operational reliability
T8030	P25 - P40 M20 - M35 K20 - K40 N15 - N30 S15 - S25	■ ■ ■ ◪ ◪				PVD		submicron H	+ + +	Undoubtedly the most versatile grade it is suitable for machining all types of materials and can be applied in almost all turning operations. It's main benefits are high operational reliability and excellent frictional properties; it is therefore suited to applications at medium to low cutting speeds.

OTHER TURNING GRADES

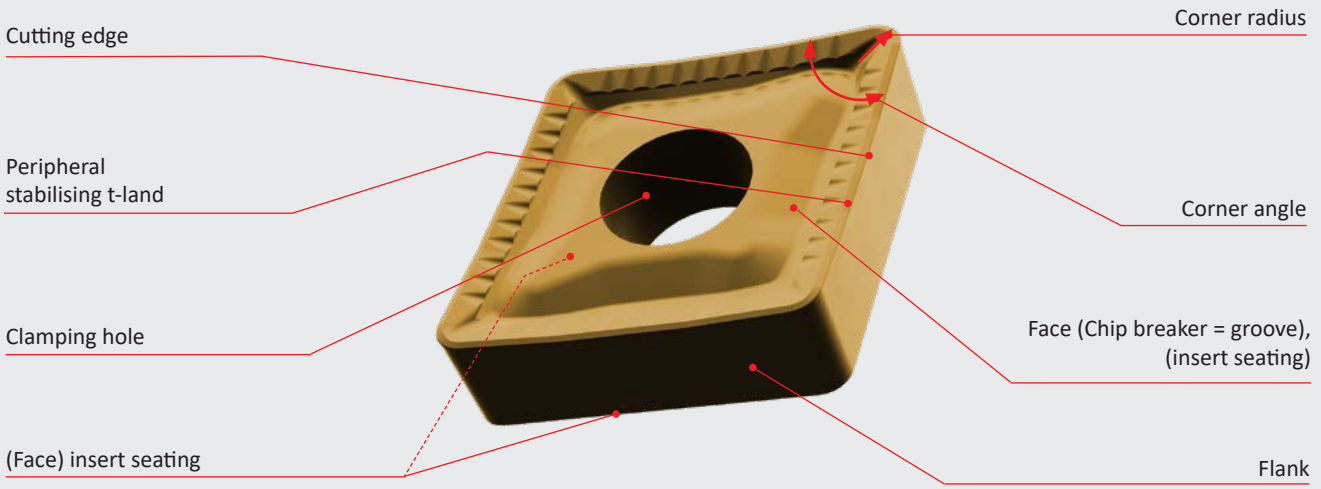
Grade Identification	Area of Application	Application	Feed	Cutting speed	Resistance to adverse Working Conditions	Coating	Colour	Substrate	Coolant benefit	Grade description
HF7	M10 - M20 K10 - K25 N10 - N25	◪ ■ ■				×		submicron H	+ +	Uncoated grade which is primarily designed for machining non-ferrous metals; but can also be used for other machined materials (except steel). This material can be used in turning, milling, and even boring.
H07	M05 - M15 K10 - K25 N10 - N30 S01 - S20	◪ ■ ■ ■				×		submicron H	+ +	Uncoated turning grade suitable for machining applications where oxidation resistance is not dominating criterion of tool life. Designed for machining of Ti-based alloys. Grade exhibits high strength of cutting edge together with good wear resistance.
TT310	P10 - P25 M15 - M25	■ ◪				PVD		cermet	+ / -	Coated cermet used for fine and finish turning of carbon and alloy steels (including stainless). Its excellent friction properties are further improved by the coating applied using the PVD technique.
TT010	P01 - P10 M01 - M10	■ ◪				×		cermet	+ / -	Uncoated cermet, which is suitable for fine machining of all types of steel (including stainless) at very low feed rates. Its main advantage is the minimal radius of the cutting edge and its high resistance to physical and chemical wear mechanisms.
TC100	K01 - K15	■				×		ceramics	- -	Ceramic grade for cast iron machining. Suitable for machining with high cutting speed at stable conditions.
TB310	K01 - K10 S05 - S10 H01 - H10	■ ◪ ◪				×		CBN	- -	CBN grade for machining of hardened materials. Suitable for machining with high cutting speed and small feeds at stable conditions.
PD1	N05 - N25	■				×		PCD	-	PKD grade for turning non-ferrous materials. Ideal choice for working with high cutting speed and small feeds at stable conditions.
333TN	P45 - P50 M35 - M40 K35 - K40	■ ◪ ◪				PVD		HSS	+ + +	Special grade composed of HSS substrate and thin hard PVD coating. The most tough cutting grade in the portfolio. Inserts with this grade are one and only used for slotting of key groove.

Substrat	
H	WC-Co based substrate
submicron H	WC-Co based substrate fine grained (< 1 µm)
ultra submicron H	WC-Co based substrate very fine grained (< 0,5 µm)
FGM	Functionally graded substrate
Cermet	Cemented carbide without WC
ceramics	Cutting ceramics
PCD	Polycrystalline Diamond
CBN	Cubic Boron Nitride
HSS	High speed steel

Coating	
MT-CVD	Medium-temperature chemical method of coating
PVD	Low-temperature physical method of coating
×	Uncoated grade

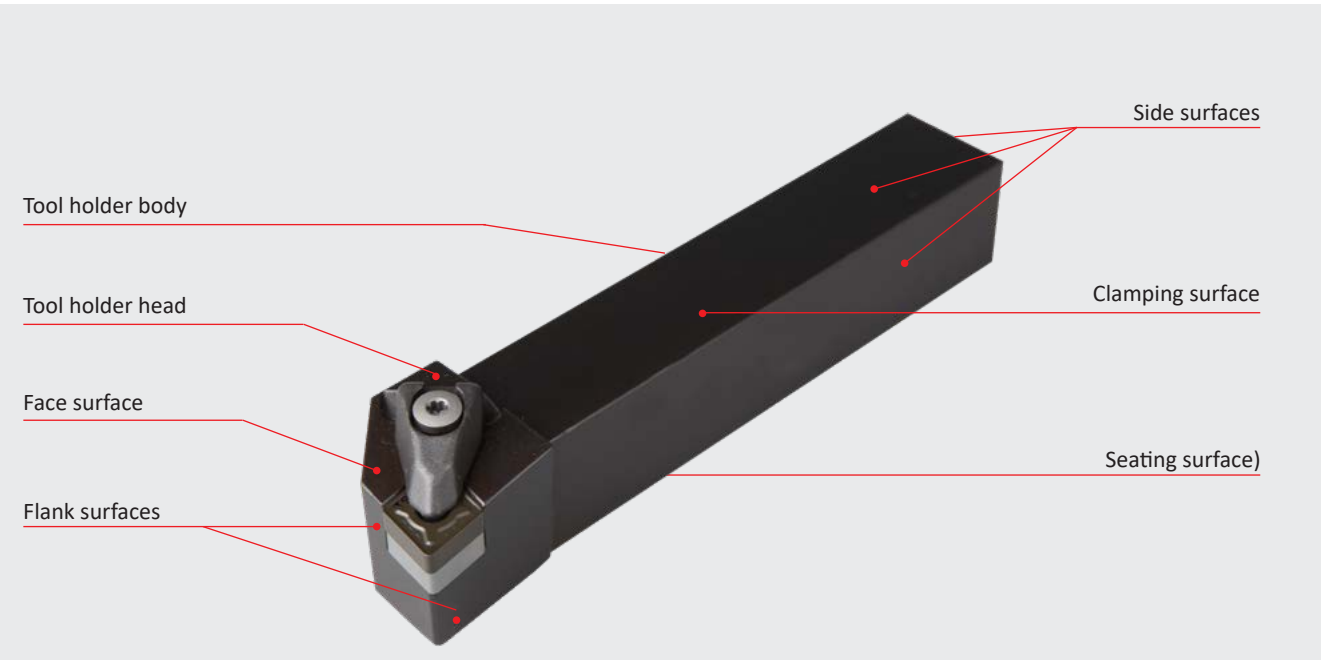
Benefits of cutting fluid	
+ + +	Use of coolant is essential
+ +	Highly recommended
+	Recommended
+ / –	Optional
– -	Do not use coolant
–	Coolant not recommended

Insert parts



Corner radius – determines in most cases the recommended minimum depth of cut and, together with the feed, also determines the achieved roughness.
The **Cutting edge** is the intersection of face and flank surfaces. Its longitudinal roughness is one of the first evaluation criteria when assessing an insert.
The **insert corner angle** is very important with regard to the usable cutting edge length, resistance in the interrupted cut, heat dissipation from the cutting point, etc.
The **peripheral stabilising t-land** is an area located after the cutting edge. Its width is very often variable and its angle also changes regularly. In most cases, the width of the t-land, together with the adjustment angle at which the insert works, is a limiting factor for specifying the minimum feed.
The **chip breaker** – together with the t-land determines the application area (narrow grooves – finishing and materials with short chip, wide grooves – mostly roughing operations and tough materials).
The **clamping hole** – if there is no hole, the insert will definitely be designed for the ISO C clamping system. If the hole is cylindrical, the insert is designed for the ISO P, M, D + clamping systems (in nearly all cases the flank angle is 0°. If the hole is trumpet-shaped and the flank angle is positive, the insert is single-sided and is designed for the ISO S clamping system. If the hole is conical and is the same on both sides of the insert, then it is most likely a tangential insert (double-sided).
The **insert seating** – if it is formed by the same relief as the face surface, the insert is double-sided, if it is different, the insert is single-sided. It must be assessed with regard to the planned load or the type of cut. (the size and distance of the radius and the cutting edges).

Tool holder parts



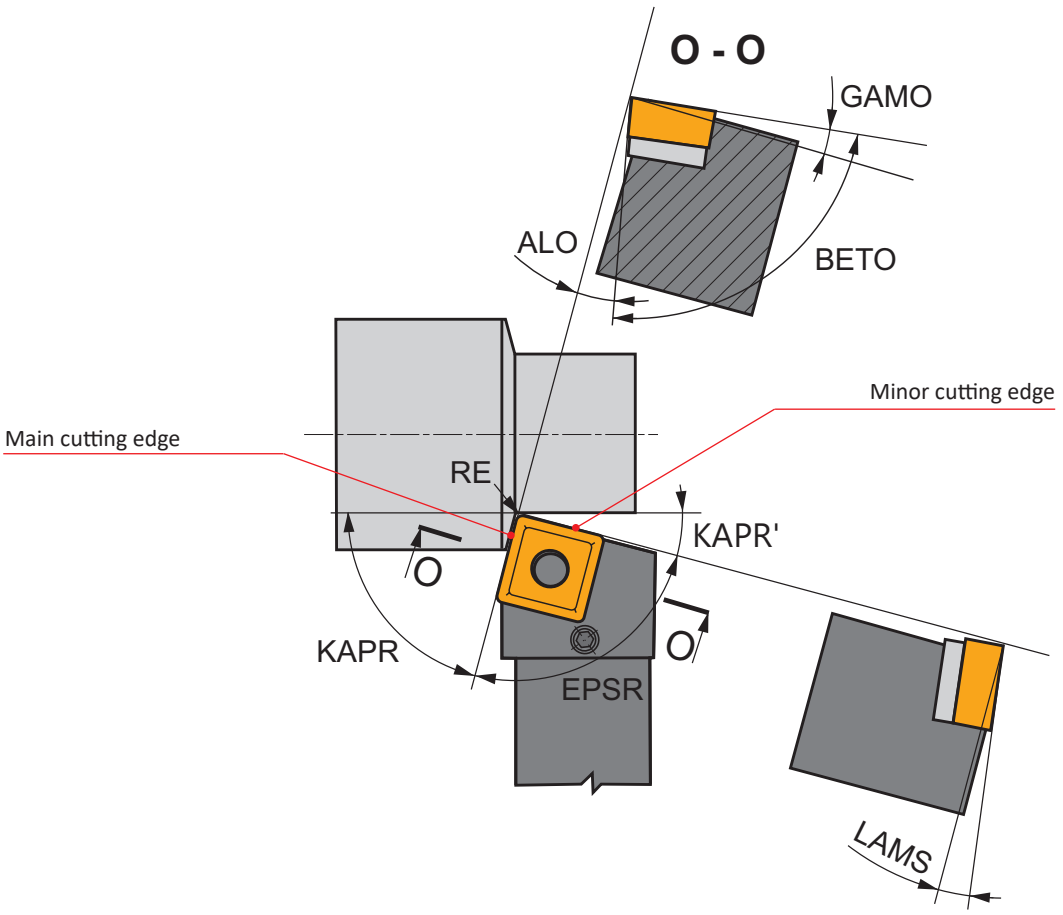
The turning tool consists of two basic parts:
1) the body consisting of:
seating surface
clamping surface
side surfaces (which can further be provided with adjusting screws)
Note: For external turning, the tool holder body is usually a square cross section (square or rectangle). For internal turning, the cross section of the holder body is circular and, for larger cross sections, it is provided with adjusting surfaces. But the holder body can also be formed by a special type of shank, such as CAPTO (PSC) or HSK

2) the head with:
face
flank surfaces
The tool holder head also includes a clamping system into which the inserts are inserted
From the face side (for radial inserts) or from the flank surface side (for tangential inserts)
Note: the types of heads are:
straight – allows turning in both directions
side – distinguish between right and left design
bent – distinguish between right and left design (allows better access when turning more complex surfaces)

Working and construction angles of turning tools

The position and orientation of the cutting edge in relation to the workpiece and its geometric shape determine the cutting angle characteristics.
The angles on the cutting edge are determined by a two coordinate system:
a) design
b) working

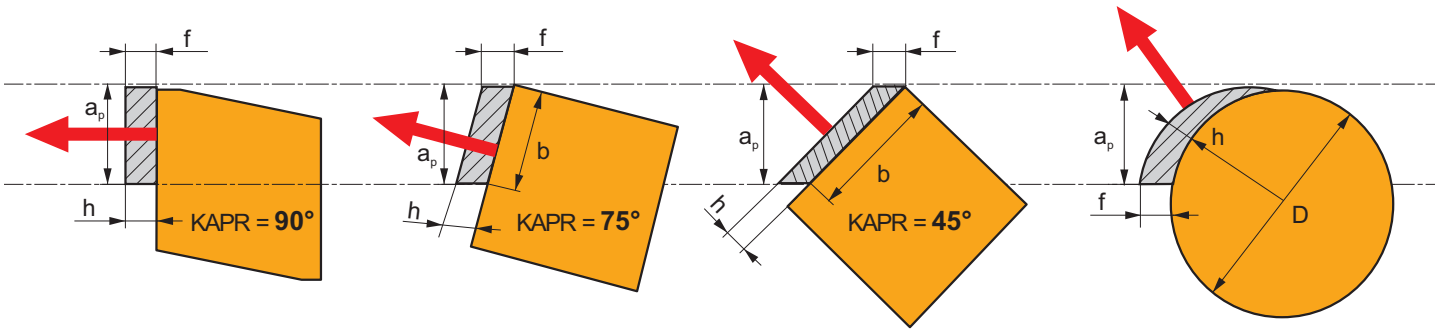
a) tool coordinate system (stationary), which is used to determine the cutting edge geometry during design, production and checking. All angles defined in this system are called tool cutting angles. All angles defined by ISO standards according to the insert shape belong in this group.



b) working coordinate system, used to determine the cutting edge geometry during the machining process. These angles are called working angles and they depend on the position of the insert clamped into the tool holder. For example, the cutting insert SNUN ..... has a tool clearance angle ***AN*** = 0° and a rake angle ***GAMP*** = 0°, however the insert is clamped in the tool holder to give a working clearance angle ***ALO*** = 6° and a working rake angle ***GAMO*** = -6°. The working angles affect the tool angles with pre-formed chip breakers. However the most important are the working angles for the cutting process.

The basic tool angles are indicated in the picture in the basic tool plane (interlaid by the bearing surface of the tool holder) and in the normal tool plane (interlaid across to cutting edge – cut O-O).
We are concerned with the following angles:
The rake angle ***GAMO*** – substantially affects the cutting process. Its size determines the progress and the intensity of plastic deformation during chip forming; it also determines the value of the cutting forces and the thermal stress on the cutting edge. The range of rake angles is wide, from ***GAMO*** = +25° to -15° for cutting tools with indexable cutting inserts for milling and turning. A positive rake angle improves the chip forming conditions, reduces the cutting forces and reduces the cutting temperature level. A negative rake angle improves the strength of the cutting edge, however it increases plastic deformation during chip forming and thereby also the cutting forces and temperatures.

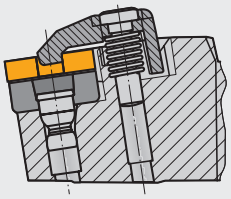
Clearance angle ***ALO*** affects the value of friction between the flank and the machined surface. Increasing the clearance angle ***ALO*** reduces this friction and thereby flank wear as well.
Wedge angle ***BETO*** is the angle of the cutting insert's wedge. Increasing angle ***BETO*** increases the strength of the cutting edge (resistance against shock), however it also increases the cutting resistance.
Inclination angle of main cutting edge ***LAMS*** – determines the point of first contact between the cutting edge and the workpiece, which is important for interrupted cut. If ***LAMS*** is positive, the point of contact is close to the nose of the cutting insert. The negative angle ***LAMS*** moves the point of first contact far from the nose and thereby affects the resistance of the cutting edge against mechanical stress. Furthermore, ***LAMS*** affects the direction of chip evacuation. If ***LAMS*** is negative, the direction of chip evacuation is towards the machined surface. Whereas if ***LAMS*** is positive, the direction of chip evacuation is away from the machined surface.
Setting angle of main cutting edge ***KAPR*** has main influence on the values of cutting forces and the cross section shape of the chip. Reducing angle ***KAPR*** makes the chip thinner at a given feed f and depth of cut a_p. Whereas if ***KAPR*** = 90° the chip thickness $h = f$ and the chip width $b = a_p$ becomes wider. Regarding the decreasing setting angle the function width of the T-land is increasing and the rake angle of insert is decreasing.
Setting angle of minor cutting edge ***KAPR'*** together with corner radius ***RE*** define the final surface quality.



$h = f$ | $h = 0{,}96\ f$ | $h = 0{,}71\ f$ | $h = 0 \div f$

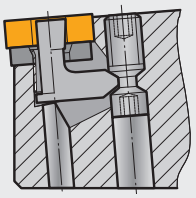
Tool holder choice with regard to the clamping technique

The PRAMET TOOLS offer includes tool holders, adjustable holders, turret heads and adjustable holders for external longitudinal, facing, copy turning, and naturally also for internal turning. Tool holders are classified according to the inserts clamping system into six groups that are schematically illustrated in the following passage.



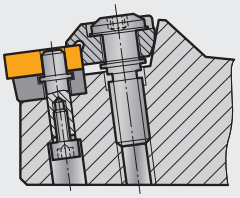
ISO D

This is the most rigid system for clamping of negative inserts with a cylindrical hole. The insert is fixed in the pocket only by a special clamp, which fits into the hole of the insert and it pushes the insert downwards and the same time against the rear faces of the pocket. The disadvantage of this system is again the clamp, which can cause problems with chip evacuation. Holders with this system are therefore particularly suitable for external machining operations characterised by high dynamic stresses on the tool.



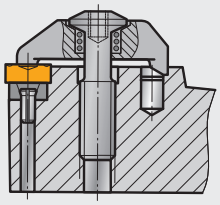
ISO P

This system serves for the clamping of negative inserts with cylindrical hole, both with chip formers and/or without them. The insert clamping is achieved as a result of an angle lever that after tightening the screw presses the insert down to the holder bed. Tool holders with this clamping system of inserts ensure a reliable and exact clamping of an insert. They perform the best and also the most frequent use at external turning operations, namely both finishing and roughing ones. Alternatively this type of clamping can be also used for holders intended for internal turning of holes with larger diameters.



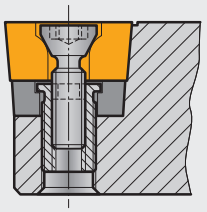
ISO M

This system is used for the clamping of cutting inserts of the same type as that of the system ISO P. In this case an insert is set onto a strong pin to which it is pressed by a clamp that is also fixing at the same time the top of insert. This clamping system is suitable mainly for holders with supposed enhanced dynamic load. These holders are used almost exclusively for the external turning.



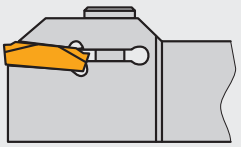
ISO C

This system serves for the clamping of both negative and positive inserts without holes, namely with both chip formers (pre-pressed, ground and side-pressed ones) and without them. The insert is fixed in the bed of a tool holder by a screw-held clamp, under which there is still embedded a side-pressed chip former at some insert types. Holders with this clamping system are used for both the external and internal surface machining. At present the clamping system C loses its importance. Especially at tools for internal turning it is replaced by the system S with benefit.



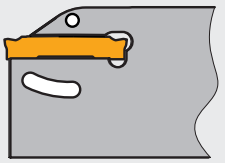
ISO S

This clamping system is mainly used for small cross-section tools, designed for both external and internal turning (drilling). In this case a special screw, going through an insert cone hole, achieves the clamping. By tightening this screw an insert is fixed in the tool bed. This solution is especially convenient because there is no obstacle for chip flow.



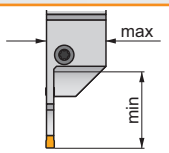
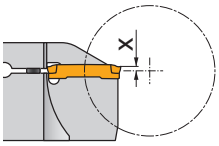
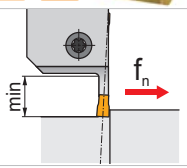
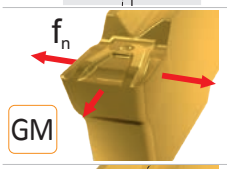
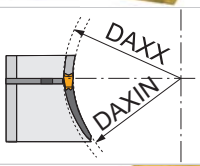
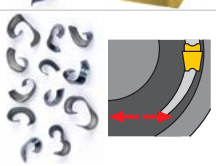
ISO G

This clamping system is used at tools for recess turning and at tools for copy turning (system CTP). The insert is pushed into the holder bed by a clamp from the top. The contact surface in the holder, in the clamp and also in the insert is shaped in such a way that it hinders the insert displacing by a feeding component of cutting speed.



ISO X

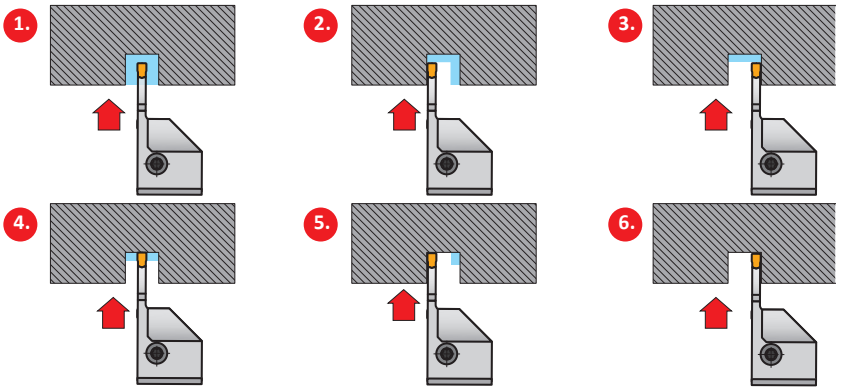
This marking identifies tools with so called special clamping system (i.e. it is different at individual tool manufacturers and suppliers). In our case we have identified under this marking tool holders that use the cutting resistance to clamp an insert into the self-locking bed. This clamping system is used for tools intended for parting and recessing.

Example	Recommendation
	Choose a tool holder with the maximum possible cross-section and the minimum possible tool overhang and CDX (maximum cutting depth) to reduce vibrations.
	Applying coolant directly to the cutting edge in sufficient quantities reduces the temperature of the cutting edge and seat, resulting in prolonged tool life.
	When parting off or deep grooving, it is advisable to set the cutting edge slightly higher than the workpiece axis to reduce vibrations.
	For parting off or deep grooving operations, use PM or PR chip breakers, which both form the desired spiral-shaped chips.
	When longitudinal turning, it is advisable to use tools with the minimum possible CDX (maximum cutting depth) to reduce vibrations and deflection of the tool.
	For longitudinal turning operations, use the GM chip breaker, which has the proper geometry on the front and both sides of the cutting edge.
	When copy turning with the MM chip breaker, the maximum depth of cut is 50% of the diameter of the geometry.
	For internal grooving operations, use only the GM and MM chip breakers, which both form the desired short chips.
	When face grooving, it is necessary to select a tool holder with the correct range of diameters.
	For deep face grooving operations, use only the GM chip breaker, which forms the desired long helical chips that don't get stuck in the face groove.
	For face turning and profiling operations, use only the GM and MM chip breakers, which both form the desired short chips.

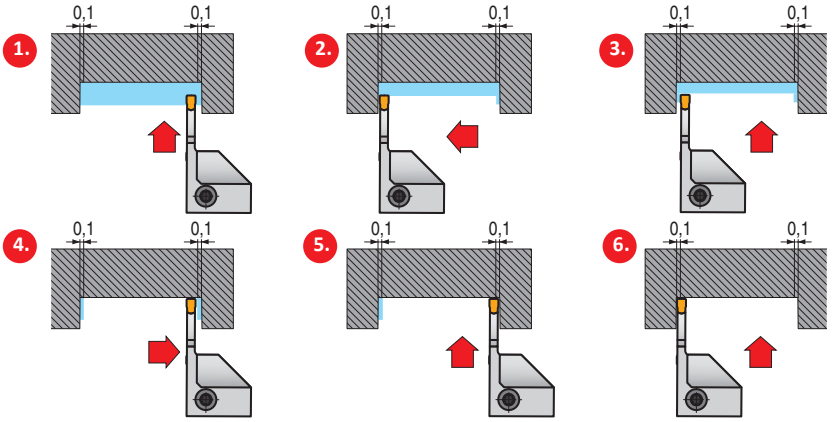
Recommendation for practical usage:

The procedure for turning a recess (deepening and widening) is shown in the following illustration.

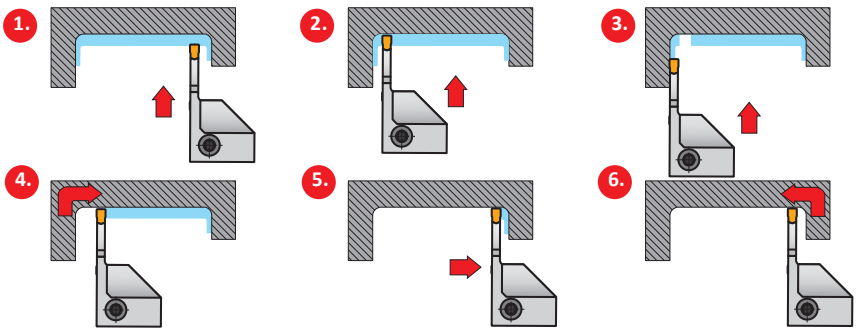
Note: To create a flat seating surface, use insert type **GL** with chip breaker **GM** or LCMF with chipbreaker F. The outboard radial grooving passes should overlap the central pass by two times the insert corner radius.



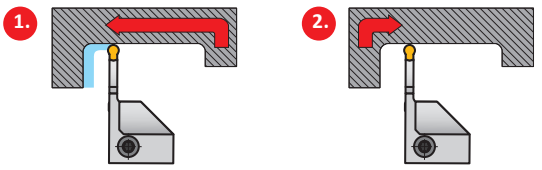
When machining a wide recess, follow the procedure shown in the following illustration.



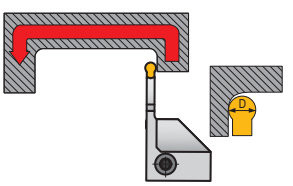
When opening up or deepening a contour using side turning, use the procedure shown in the following illustration.



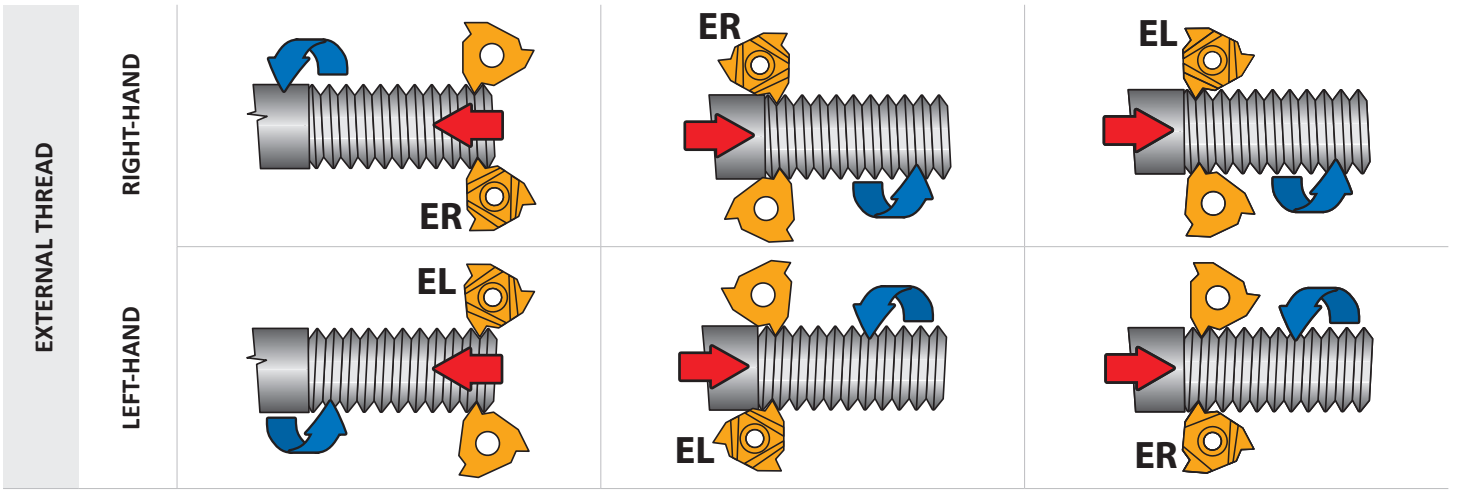
Roughing of contour (insert with round cutting edge).

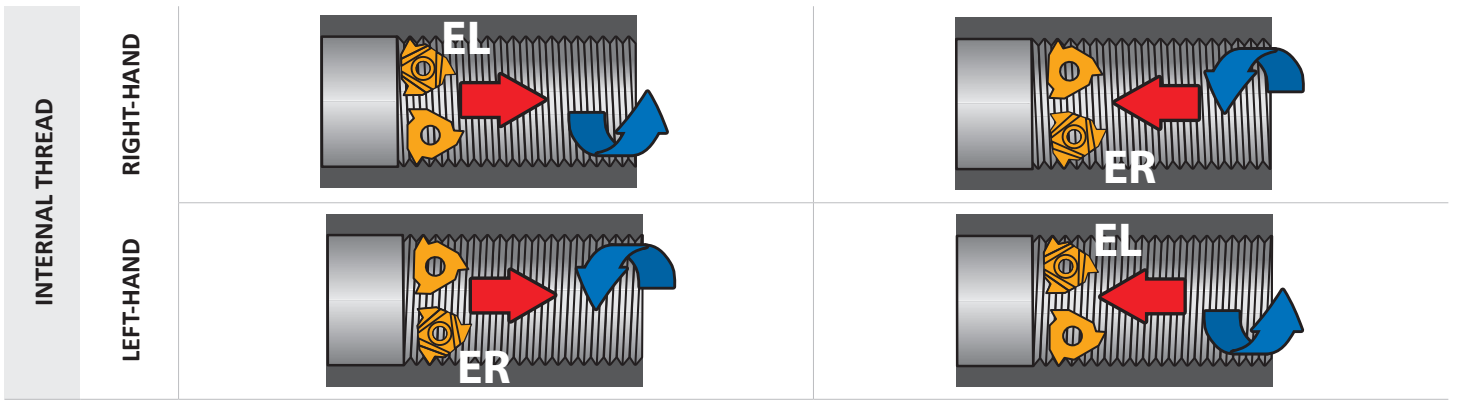


Finishing of contour (insert with round cutting edge).



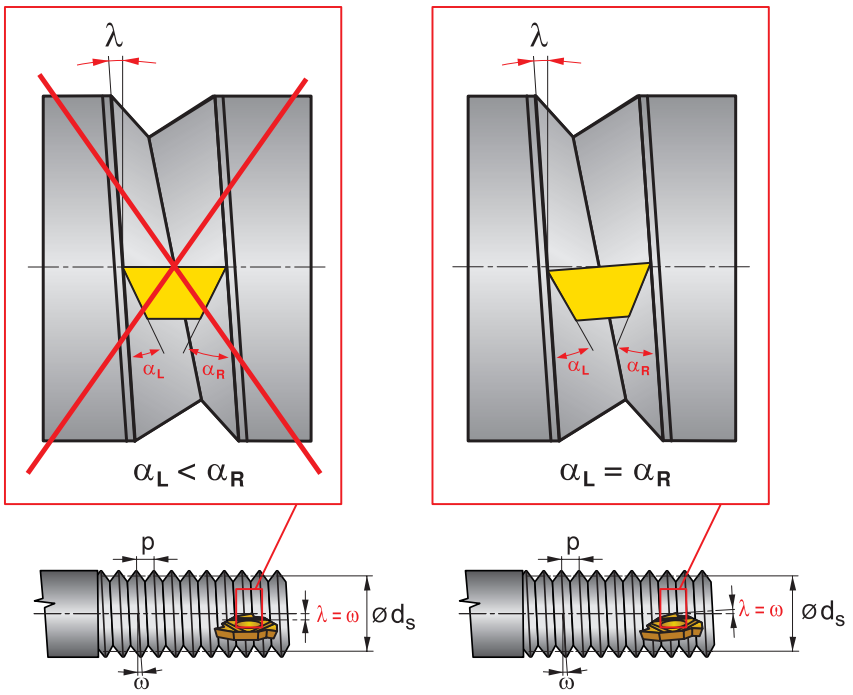
The choice of production method is influenced by the workpiece and the machine. Workpiece – external or internal thread, right – or left-hand thread. Machine – right – or left-hand tool. For guidance, you can use table below.





Movement of the workpiece Tool movement **L / R** Insert design

The following formula can be used to calculate the helix angle:



$$tg\,\omega = \frac{p}{d_s \cdot \pi}$$

ω helix angle [°]

p pitch [in]

d_s pitch diameter [in]

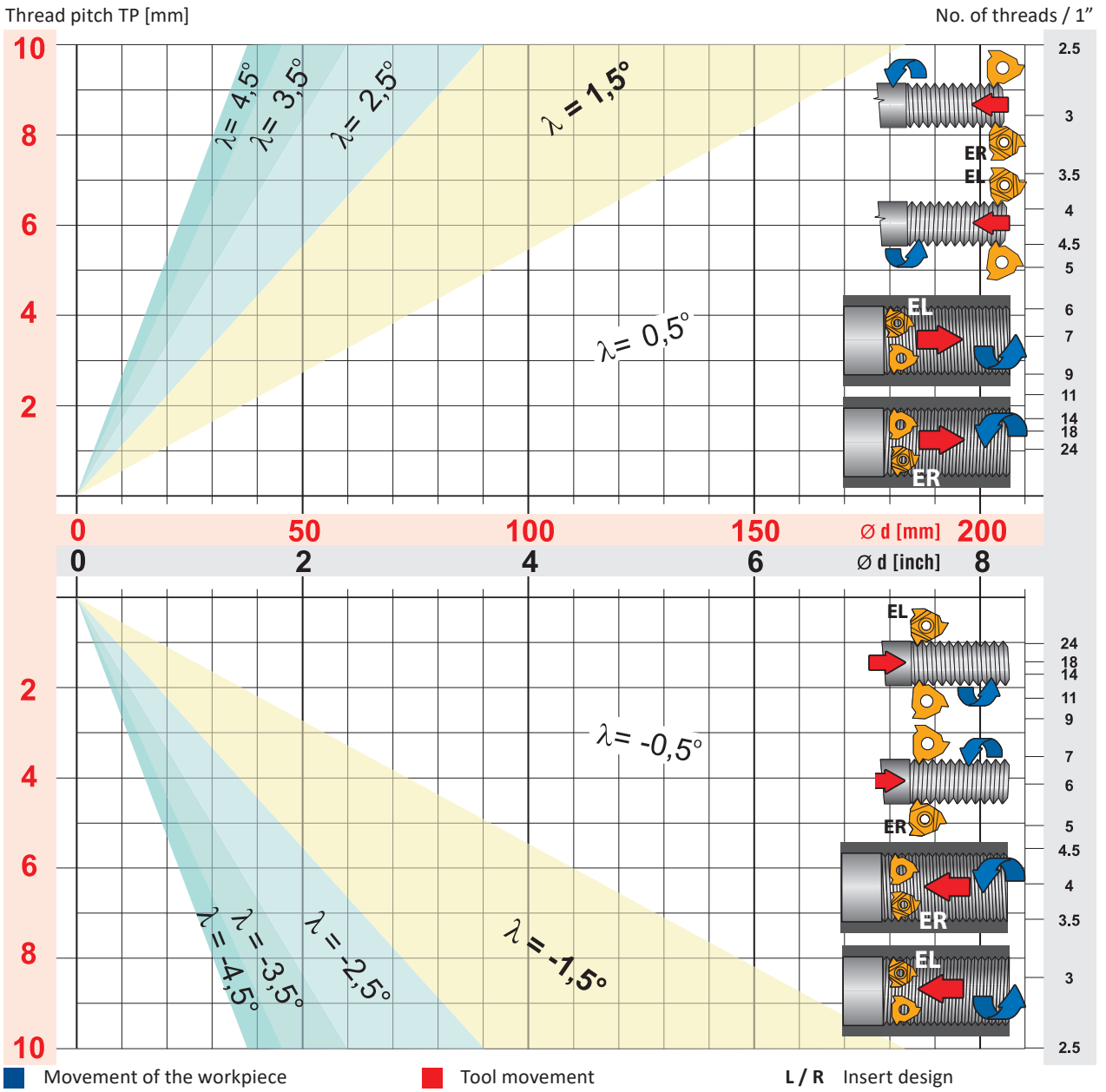
To generate the correct shape on the thread and uniform wear on the insert, the cutting edge helix angle should be equal to the thread lead angle.
Tool holders are usually supplied with a helix angle λ = 1.5°. A different helix angle can be selected by changing the anvil.
Use the following graph or table to choose the correct anvil.

Choice of shim

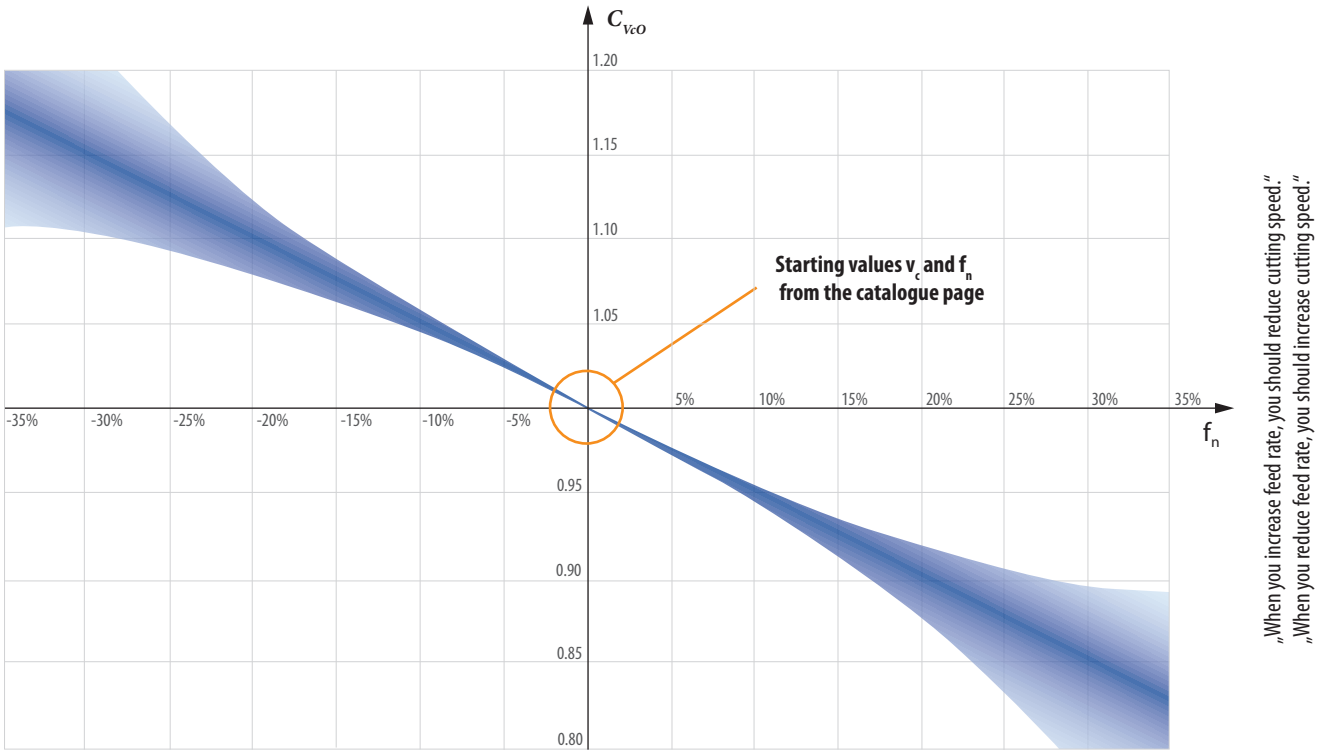
Helix angle λ	Positive					Negative	
	4.5°	3.5°	2.5°	1.5°	0.5°	-0.5°	-1.5°
Tool holder	**Anvil specification**						
SER .... .16; SIL .... .16	PE16+4.5	PE16+3.5	PE16+2.5	**PE16+1.5**	PE16+0.5	PE16-0.5	PE16-1.5
SEL .... .16; SIR .... .16	PI16+4.5	PI16+3.5	PI16+2.5	**PI16+1.5**	PI16+0.5	PI16-0.5	PI16-1.5
SER .... .22; SIL .... .22	PE22+4.5	PE22+3.5	PE22+2.5	**PE22+1.5**	PE22+0.5	PE22-0.5	PE22-1.5
SEL .... .22; SIR .... .22	PI22+4.5	PI22+3.5	PI22+2.5	**PI22+1.5**	PI22+0.5	PI22-0.5	PI22-1.5
SER-S .... .22; SIL-S .... .22	PE22S+4.5	PE22S+3.5	PE22S+2.5	**PE22S+1.5**	PE22S+0.5	PE22S-0.5	PE22S-1.5
SEL-S .... .22; SIR-S .... .22	PI22S+4.5	PI22S+3.5	PI22S+2.5	**PI22S+1.5**	PI22S+0.5	PI22S-0.5	PI22S-1.5

Tool holders are usually supplied with a helix angle λ = 1.5°. A different helix angle can be selected by changing the anvil.
Shims for holders SER-S ...., SIR-S .... are marked with „*S*“

Graph for shim selection



Cutting speed correction factor C_{VcO} as a function of the feed rate change:



Correction factors for required durability C_{VcT}

minutes	10	15	20	30	45	60
General machining operations (fine finishing up to roughing)	1.13	1.00	0.93	0.84	0.76	0.71
Heavy machining operations (heavy roughing)	–	–	–	1.10	1.00	0.93

Additional correction factors C_{VcA}

Machining environment	C_{VcA}	C_{VcB}
Condition of the work-material (hard skin due to forging or casting)	0.70	
Internal turning	0.75	
Parting and grooving (radial)	0.88	
Face grooving	0.80	
Interrupted cut		0.80
Unstable machining conditions		0.85
Common machining conditions		1.00
Stable machining conditions		1.20

Resulting corrected cutting speed v_{cC}

$$v_{cC} = v_c \cdot k_{vG} \cdot C_{VcO} \cdot C_{VcT} \cdot C_{VcA} \cdot C_{VcB}$$

k_{vG} – coefficient of used material
v_c – starting speed from catalogue page

FORMULA FOR CALCULATING CUTTING DATA

Value	Formula	Unit	Note
Number of revolutions	$n = \frac{v_c \,.\, 1000}{D \,.\, \pi}$	(1/min)	n Number of revolutions (1/min) D Diameter (of tool or workpiece) (in) v_c Cutting speed (ft/min) f_{rev} Feed per revolution (in/rev) f_{min} Feed per minute (Linear Feedrate) (in/min)
Cutting speed	$v_c = \frac{\pi \,.\, D \,.\, n}{1000}$	(ft/min)	
Feed per revolution	$f_{rev} = \frac{f_{min}}{n}$	(in/rev)	
Feed per minute (Linear Feedrate)	$f_{min} = v_f = f_{rev} \,.\, n$	(in/min)	
Max. height of profile R_{max}	$R_{max} = \frac{125 \,.\, f_{rev}^{\,2}}{RE}$	(µm)	R_{max} max. height of profile (mm) R_a surface finish (mm) f_{rev} feed per revolution (in/rev) RE nose radius (in)
Surface finish R_a	$R_a = \frac{43{,}9 \,.\, f_{rev}^{\,1{,}88}}{RE^{\,0{,}97}}$	(µm)	
Chip cross section	$A = f_{rev} \,.\, a_p$	(in^2)	A Chip cross section (in^2) f_{rev} Feed per revolution (in/rev) a_p Axial depth of cut (in) κ_r Primary edge setting angle (°) h Chip thickness (in) v_c Cutting speed (ft/min) f_{min} Feed per minute (Linear Feedrate) (in/min) Q Material removal rate per minute (cm^3/min) $INSD$ Insert diameter (in)
Chip thickness (For insert with straight edge)	$h = f_{rev} \,.\, \sin \kappa_r$	(in)	
Chip thickness (For round cutting insert)	$h = f_{rev} \,.\, \sqrt{\frac{a_p}{INSD}}$	(in)	
Metal removal rate	$Q = a_p \,.\, f_{rev} \,.\, v_c$	(cm^3/min)	
Power demand	$P_c = \frac{a_p \,.\, f_{rev}^{\,1-c} \,.\, k_{c1} \,.\, v_c \,.\, k\kappa_r}{6 \,.\, 10^4 \,.\, \eta}$	(kW)	P_c Power demand (kW) a_p Depth of cut (in) f_{rev} Feed (in/rev) c Constant KTV (1) k_c Specific cutting force (MPa) k_{κ_r} κ_r angle constant (1) η Efficiency (usually $\eta = 0{,}75$) (1) x Machined material constant (1)
Approximate power demand	$P_c = \frac{a_p \,.\, f_{rev} \,.\, v_c}{x}$	(kW)	

Material	Steel	Cast iron	Al
Coefficient x	20	25	100

RECOMMENDED SCREW TORQUES

CLAMPING SCREW

Screw designation	Screwdriver	Torque (Nm)
28588	MA2-8304	0.8
28992	MA2-8304	0.8
416.1-832	PT-8002	3.6
5513 020-01	PT-8004	3.6
5513 020-03	PT-8001	0.8
5513 020-04	PT-8003	1.5
5513 020-05	PT-8001	0.8
5513 020-14	TX 225PLUS	8.5
5513 020-24	PT-8002	1.5
5513 020-27	PT-8000	0.6
5513 020-28	PT-8000	0.6
5513 021-03	DMN 3124	13
CS 8601-T09P	SDR T09P	1.7
CS 8601-T15P	SDR T15P	3.9
CS 8601-T20P	SDR T20P	6.4
CS 8601-T25P	SDR T25P	9.5
DVF 0573	PT-8002	1.5
DVF 2260	TX 215PLUS	3.6
DVF 3584	DMD 1650	0.6
DVF 3593	TX 207PLUS	0.8
HS 0408	HXK 3	5
HS 0412	HXK 3	5
HS 0516	HXK 4	5
HS 0520C	HXK 4	5
HS 0616C	HXK 5	8
HS 0620	HXK 5	6
HS 0620C	HXK 5	6
HS 0625	HXK 5	6
HS 0625C	HXK 5	6
HS 0630	HXK 5	6
HS 0825	HXK 6	10
HS 0830	HXK 6	10
HS 0835	HXK 6	10
HS 0840	HXK 8	11
HS 1030	HXK 8	8
HS 1060	HXK 6	10
HS 93	HXK 5	8
HS 94	HXK 5	8
HSI 1020	HXK 6	8
PS 0512	HXK 2	2
PS 0512-A	HXK 2	2
PS 0616	HXK 2,5	4
PS 12040	HXK 5	8

CLAMPING SCREW

Screw designation	Screwdriver	Torque (Nm)
PS 6026-709P	SRD T09P	2
PS 8290	HXK 2	2
SR 14	HXK 10	10
SR 85011-T15P	SDR T15P	5
SR 85017-T09P	SDR T09P	2
SR 85020-T15P	SDR T15P	3
SR 86025-T20P	SRD T20P	5
SR 88026-T30P	LKT30P	5
T20.037	DMD 1650	0.6
UP 0909-T09P	SRD T09P	2
UP 1515-T15P	SDR T15P	8
US 2505-T07P	SDR T07P	0.9
US 2506-T07P	SDR T07P	0.9
US 3007-T09P	SDR T09P	2
US 34	HXK 3	5
US 35	HXK 4	6
US 3508-T15P	SDR T15P	3
US 3510A-T15P	SDR T15P	3
US 3510-T15P	SDR T15P	3
US 3512A-T15P	SDR T15P	3
US 3512-T15P	SDR T15P	3
US 36	HXK 4	6
US 38	HXK 5	8
US 39	HXK 5	8
US 40	HXK 4	6
US 4008-T15P	SDR T15P	3.5
US 4011-T15P	SDR T15P	3.5
US 41	HXK 4	6
US 42	HXK 4	6
US 45013-T20P	SDR T20P	5
US 4512-T15P	SDR T15P	5
US 4514A-T20	SDR T20	5
US 46	HXK 3	5
US 46017-T20P	SDR T20P	5
US 47	HXK 5	8
US 5012-T15P	SDR T15P	5
US 5015-T20P	SDR T20P	5
US 5018-T20P	SDR T20P	5
US 6020-T25P	SDR T25P	6
US 64518-T15P	SDR T15P	5
US 8025-T30P	SDR T20P	13
US 83	HXK 4	6
US 95	HXK 4	10

TORQUE SCREWDRIVERS

Torque handle	Torque (Nm)	Clamping screw thread
MR-0.8-2.0 vario	0.5 – 2.0	M 2 – M 3
MR-1.0-5.0 vario	0.8 – 5.0	M 2.5 – M 5
MR-0.9 fix	0.9	M 2
MR-2.0 fix	2.0	M 3
MR-3.0 fix	3.0	M 3.5
MR-3.5 fix	3.5	M 4
MR-5.0 fix	5.0	M 5

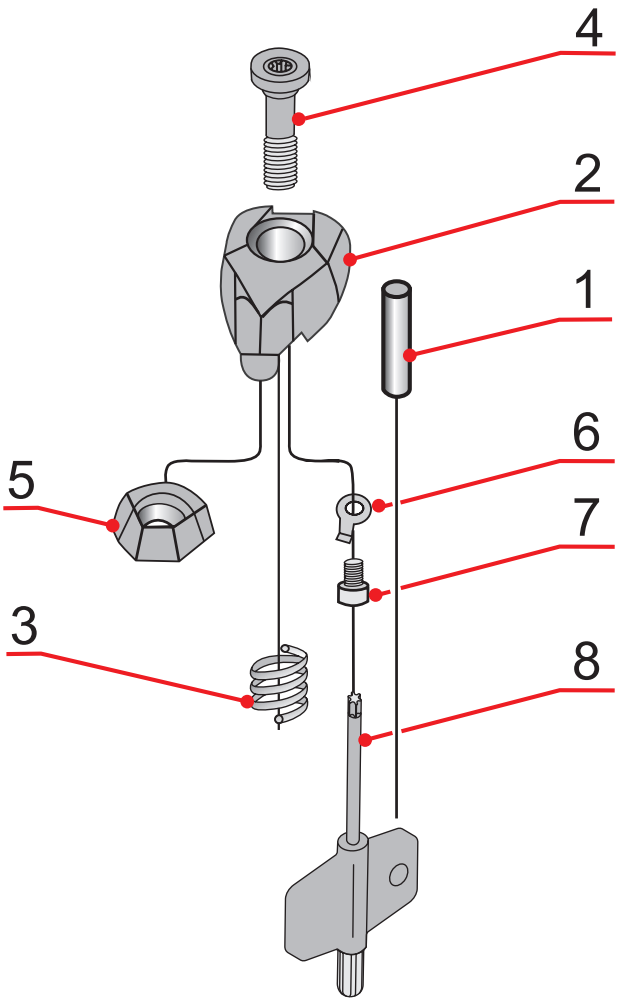
REPLACEABLE SHANKS

Replaceable shanks		
D-T6	**D-T8**	**D-T15**
D-T6P	**D-T8P**	**D-T15P**
D-T7	**D-T9**	**D-T20**
D-T7P	**D-T9P**	**D-T20P**

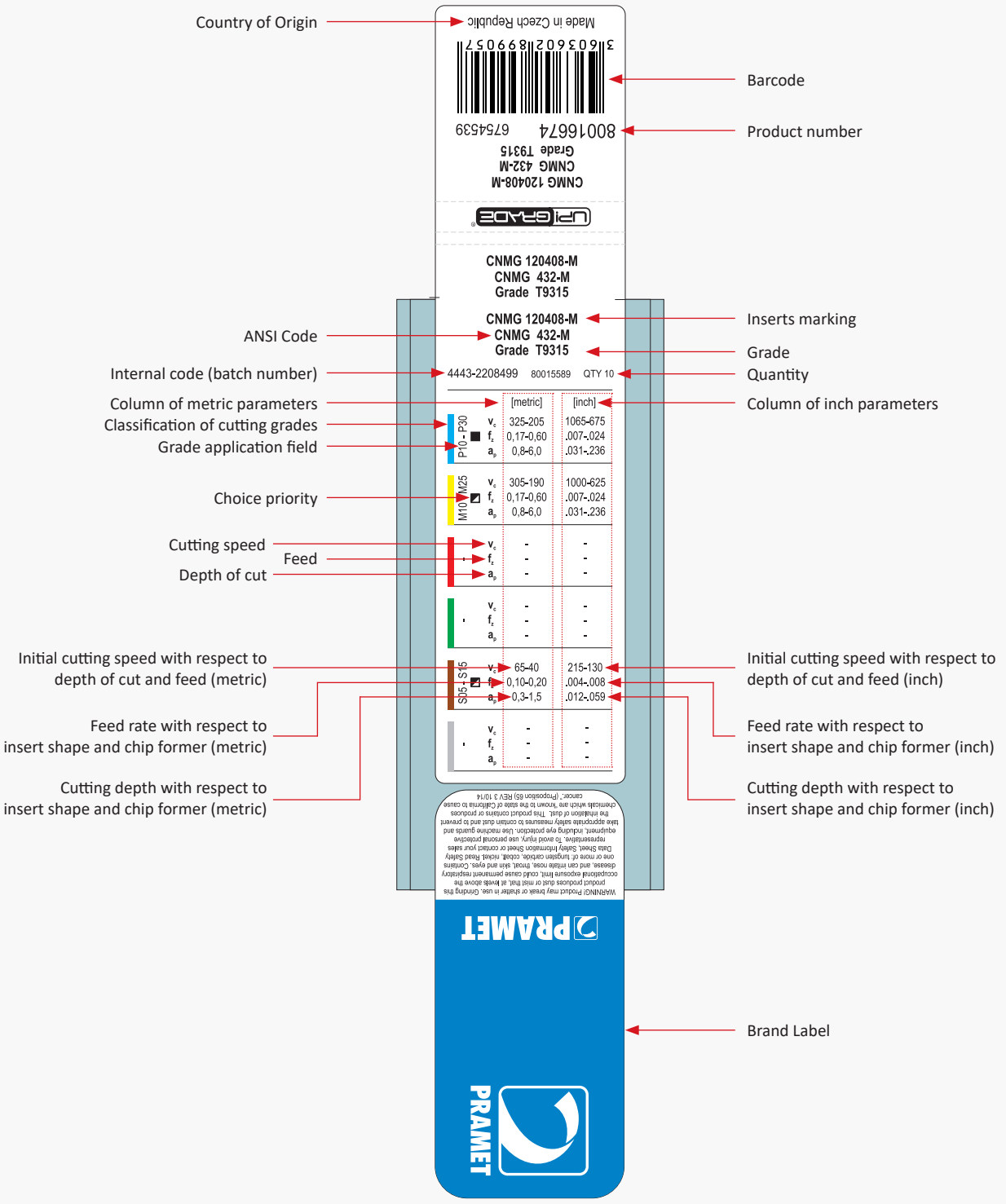
SCREW LUBRICATION

Insert clamping screws are subject to high thermal stresses. It is recommended that all screws be lubricated with a high quality paste such as MOLYKOTE 1000.

COMPLETE CLAMP SET



	1	2	3	4		5	6	7	8
					Nm				
DCS 09	CP 2655	CD 09	PR 0157	CS 8601-T09P	1.7	–	–	–	–
DCS 12	CP 2607	CD 12	PR 0158	CS 8602-T15P	3.9	–	–	–	–
DCS 16	CP 2607	CD 16	PR 0159	CS 8603-T20P	6.4	–	–	–	–
DCS 19	CP 2607	CD 19	PR 0159	CS 8603-T20P	6.4	–	–	–	–
DCS 25	CP 2607	CD 25	PR 0101	CS 8604-T25P	9.5	–	–	–	–
DCS 16V	CP 2607	CD 16V	PR 0158	CS 8602-T15P	3.9	–	–	–	–
DCS 12C2	CP 2607	CD 12C2	PR 0158	CS 8602-T15P	3.9	PP 3002	H 1201	CS 9701-T07P	FLAG T07P
DCS 16C2	CP 2607	CD 16C2	PR 0159	CS 8603-T20P	6.4	PP 3003	H 1201	CS 9701-T07P	FLAG T07P
DCS 12C4	CP 2607	CD 12C4	PR 0158	CS 8602-T15P	3.9	PP 3002	H 1201	CS 9701-T07P	FLAG T07P
DCS 16C4	CP 2607	CD 16C4	PR 0159	CS 8603-T20P	6.4	PP 3003	H 1201	CS 9701-T07P	FLAG T07P


Country of Origin
Barcode
Product number
ANSI Code
Internal code (batch number)
Column of metric parameters
Classification of cutting grades
Grade application field
Choice priority
Cutting speed
Feed
Depth of cut
Initial cutting speed with respect to depth of cut and feed (metric)
Feed rate with respect to insert shape and chip former (metric)
Cutting depth with respect to insert shape and chip former (metric)
Inserts marking
Grade
Quantity
Column of inch parameters
Initial cutting speed with respect to depth of cut and feed (inch)
Feed rate with respect to insert shape and chip former (inch)
Cutting depth with respect to insert shape and chip former (inch)
Brand Label
Made in Czech Republic
CNMG 120408-M
CNMG 432-M
Grade T9315
4443-2208499
80015589
QTY 10
[metric]
[inch]
P10 - P30
M10 - M25
S05-1 S15
PRAMET

WMG (WORK MATERIAL GROUP)

ISO group		WMG (Work Material Group)			Hardness (HB or HRC)	Ultimate Tensile Strength (MPa)	Correction factor *kvG*
P	P1	P1.1	Free machining steel (carbon steels with increased machinability)	Sulfurized	< 240 HB	≤ 830	1.33
		P1.2		Sulfurized and phosphorized	< 180 HB	≤ 620	1.49
		P1.3		Sulfurized/phosphorized and leaded	< 180 HB	≤ 620	1.53
	P2	P2.1	Plain carbon steel (steels comprised of mainly iron and carbon)	Containing <0.25 % C	< 180 HB	≤ 620	1.14
		P2.2		Containing <0.55 % C	< 240 HB	≤ 830	1.00
		P2.3		Containing >0.55 % C	< 300 HB	≤ 1030	0.89
	P3	P3.1	Alloy steel (carbon steels with an alloying content ≤ 10%)	Annealed	< 180 HB	≤ 620	0.92
		P3.2		Hardened and tempered	180 – 260 HB	> 620 ≤ 900	0.74
		P3.3			260 – 360 HB	> 900 ≤ 1240	0.63
	P4	P4.1	Tool steel (special alloy steel for tools, dies and molds)	Annealed	< 26 HRC	≤ 900	0.55
		P4.2		Hardened and tempered	26 – 39 HRC	> 900 ≤ 1240	0.47
		P4.3			39 – 45 HRC	> 1240 ≤ 1450	0.38
M	M1	M1.1	Ferritic stainless steel (straight chromium non-hardenable alloys)		< 160 HB	≤ 520	1.22
		M1.2			160 – 220 HB	> 520 ≤ 700	1.03
	M2	M2.1	Martensitic stainless steel (straight chromium hardenable alloys)	Annealed	< 200 HB	≤ 670	1.08
		M2.2		Quenched and tempered	200 – 280 HB	> 670 ≤ 950	0.89
		M2.3		Precipitation-hardened	280 – 380 HB	> 950 ≤ 1300	0.75
	M3	M3.1	Austenitic stainless steel (chromium-nickel and chromium-nickel-manganese alloys)		< 200 HB	≤ 750	1.00
		M3.2			200 – 260 HB	> 750 ≤ 870	0.86
		M3.3			260 – 300 HB	> 870 ≤ 1040	0.77
	M4	M4.1	Austenitic-ferritic (DUPLEX) or super-austenitic stainless steel		< 300 HB	≤ 990	0.75
		M4.2	Precipitation hardening austenitic stainless steel		300 – 380 HB	≤ 1320	0.64
K	K1	K1.1	Gray iron or Automotive Gray iron (GG) (iron-carbon castings with a lamellar graphite microstructure)	Ferritic or ferritic-pearlitic	< 180 HB	≤ 190	1.35
		K1.2		Ferritic-pearlictic or pearlitic	180 – 240 HB	> 190 ≤ 310	1.00
		K1.3		Pearlitic	240 – 280 HB	> 310 ≤ 390	0.75
	K2	K2.1	Malleable iron (GTS/GTW) (iron-carbon castings with a graphite-free microstructure)	Ferritic	< 160 HB	≤ 400	1.39
		K2.2		Ferritic or pearlitic	160 – 200 HB	> 400 ≤ 550	1.13
		K2.3		Pearlitic	200 – 240 HB	> 550 ≤ 660	0.90
	K3	K3.1	Ductile iron (GGG) (iron-carbon castings with a nodular graphite microstructure)	Ferritic	< 180 HB	≤ 560	1.23
		K3.2		Ferritic or pearlitic	180 – 220 HB	> 560 ≤ 680	0.94
		K3.3		Pearlitic	220 – 260 HB	> 680 ≤ 800	0.76
	K4	K4.1	Austenitic gray iron (ASTM A436) (iron-carbon alloy castings with an austenitic lamellar graphite microstructure)		< 180 HB	≤ 190	1.14
		K4.2	Austenitic ductile iron (ASTM A439 or ASTM A571) (iron-carbon alloy castings with an austenitic nodular graphite microstructure)		< 240 HB	≤ 740	0.86
		K4.3	Austempered ductile iron (ASTM A897) (iron-carbon alloy castings with an ausferrite microstructure)		< 280 HB	> 840 ≤ 980	0.63
		K4.4			280 – 320 HB	> 980 ≤ 1130	0.54
		K4.5			320 – 360 HB	> 1130 ≤ 1280	0.45
	K5	K5.1	Compacted graphite iron CGI (ASTM A842) (iron-carbon castings with a vermicular graphite structure)	Ferritic	< 180 HB	≤ 400	1.29
		K5.2		Ferritic-pearlitic	180 – 220 HB	> 400 ≤ 450	0.97
		K5.3		Pearlitic	220 – 260 HB	> 450 ≤ 500	0.75
N	N1	N1.1	Commercially pure wrought aluminium		< 60 HB	≤ 240	1.33
		N1.2	Wrought aluminium alloys	Half hard tempered	60 – 100 HB	> 240 ≤ 400	1.00
		N1.3		Full hard tempered	100 – 150 HB	> 400 ≤ 590	0.67
	N2	N2.1	Cast aluminium alloys		< 75 HB	≤ 240	0.67
		N2.2			75 – 90 HB	> 240 ≤ 270	0.60
		N2.3			90 – 140 HB	> 270 ≤ 440	0.43
	N3	N3.1	Free-cutting copper-alloys materials with excellent machining properties		–	–	0.70
		N3.2	Short-chip copper-alloys with good to moderate machining properties		–	–	0.41
		N3.3	Electrolytic copper and long-chip copper-alloys with moderate to poor machining properties		–	–	0.21
	N4	N4.1	Thermoplastic polymers		–	–	0.70
		N4.2	Thermosetting polymers		–	–	0.27
		N4.3	Reinforced polymers or composites		–	–	0.29
	N5	N5.1	Graphite		–	–	1.00
S	S1	S1.1	Titanium or titanium alloys		< 200 HB	≤ 660	1.94
		S1.2			200 – 280 HB	> 660 ≤ 950	1.72
		S1.3			280 – 360 HB	> 950 ≤ 1200	1.44
	S2	S2.1	Fe-based high-temperature alloys		< 200 HB	≤ 690	1.33
		S2.2			200 – 280 HB	> 690 ≤ 970	1.17
	S3	S3.1	Ni-based high-temperature alloys		< 280 HB	≤ 940	1.00
		S3.2			280 – 360 HB	> 940 ≤ 1200	0.83
	S4	S4.1	Co-based high-temperature alloys		< 240 HB	≤ 800	0.78
		S4.2			240 – 320 HB	> 800 ≤ 1070	0.67
H	H1	H1.1	Chilled cast iron		< 440 HB	–	1.52
	H2	H2.1	Hardened cast iron		< 55 HRC	–	0.90
		H2.2			> 55 HRC	–	0.77
	H3	H3.1	Hardened steel < 55 HRC		< 51 HRC	–	1.00
		H3.2			51 – 55 HRC	–	0.82
	H4	H4.1	Hardened steel > 55 HRC		55 – 59 HRC	–	0.64
		H4.2			> 59 HRC	–	0.54

HARDNESS CONVERSION TABLE

Strength (MPa)	Hardness			
	BRINELL	VICKERS	ROCKWELL	ROCKWELL
R_m	HB	HV	HRB	HRC
285	86	**90**	1190	–
320	95	**100**	56.2	–
350	105	**110**	62.3	–
385	114	**120**	66.7	–
415	124	**130**	71.2	–
450	133	**140**	75.0	–
480	143	**150**	78.7	–
510	152	**160**	81.7	–
545	162	**170**	85.8	–
575	171	**180**	87.1	–
610	181	**190**	89.5	–
640	190	**200**	91.5	–
675	199	**210**	93.5	–
705	209	**220**	95	–
740	219	**230**	96.7	–
770	228	**240**	98.1	–
800	238	**250**	99.5	–
820	242	**255**	–	23.1
850	252	**265**	–	24.8
880	261	**275**	–	26.4
900	266	**280**	–	27.1
930	276	**290**	–	28.5
950	280	**295**	–	29.2
995	295	**310**	–	31.0
1030	304	**320**	–	32.2
1060	314	**330**	–	33.3
1095	323	**340**	–	34.4
1125	333	**350**	–	35.5
1155	342	**360**	–	36.6

Strength (MPa)	Hardness			
	BRINELL	VICKERS	ROCKWELL	ROCKWELL
R_m	HB	HV	HRB	HRC
1190	352	**370**	–	37.7
1220	361	**380**	–	38.8
1255	371	**390**	–	39.8
1290	380	**400**	–	40.8
1320	390	**410**	–	41.8
1350	399	**420**	–	42.7
1385	409	**430**	–	43.6
1420	418	**440**	–	44.5
1455	428	**450**	–	45.3
1485	437	**460**	–	46.1
1520	447	**470**	–	46.9
1555	456	**480**	–	47.7
1595	466	**490**	–	48.4
1630	475	**500**	–	49.1
1665	485	**510**	–	49.8
1700	494	**520**	–	50.5
1740	504	**530**	–	51.1
1775	513	**540**	–	51.7
1810	523	**550**	–	52.3
1845	532	**560**	–	53.0
1880	542	**570**	–	53.6
1920	551	**580**	–	54.1
1955	561	**590**	–	54.7
1995	570	**600**	–	55.2
2030	580	**610**	–	55.7
2070	589	**620**	–	56.3
2105	599	**630**	–	56.8
2145	608	**640**	–	57.3
2180	618	**650**	–	57.8

SIMPLY RELIABLE

As a professional you can judge the quality of work by just looking at the chip. Our chip is a clean and uncomplicated shape that in itself tells a story. It is a clear and consistent signal and that's why we use it as a symbol for being **Simply Reliable**.

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