



CN

09/ 12/ 16/ 19/ 25

CARBIDE INSERTS

CNGG



222

CNMA



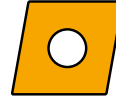
222

CNMG



223

CNMM



234

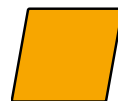
CER AND CBN INSERTS

CNGA CER



238

CNGN CER



238

CNGA CBN



239

MATCH THE RIGHT SIZE (example)

Insert

CNMM 120412E-OR

Tool Holder

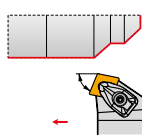
DCBNR 2525 M 12

ISO TURNING – EXTERNAL

DCBN(RL) EXT

75°

CN..


12
16
19

20×20
40×40

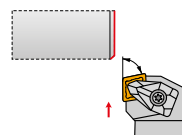
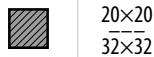
240

222 – 239

DCKN(RL) EXT

75°

CN..


12
16

20×20
32×32

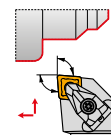
242

222 – 239

DCLN(RL) EXT

95°

CN..


09
12
16
19

16×16
40×40

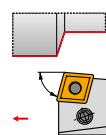
243

222 – 239

PCBN(RL) EXT

75°

CN..


12
16
19
25

20×20
50×50

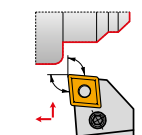
245

222 – 239

PCLN(RL) EXT

95°

CN..


12
16
19
25

20×20
50×50

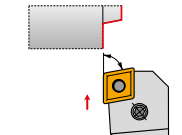
247

222 – 239

PCKN(RL) EXT

75°

CN..


12
16
19

20×20
40×40

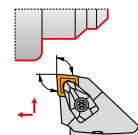
246

222 – 239

C.-DCLN(RL) EXT

95°

CN..


12
16
19

C3
C8

249

222 – 239



CN

09/ 12/ 16/ 19/ 25

ISO TURNING – HEAVY ROUGHING – EXTERNAL

KHP-CBNR + DKH(RL)

75°		CN..
		25
	40×50 60×80	
	251, 253	
		222 – 239

KHP-CBNL + DKH(RL)

75°		CN..
		25
	40×50 60×80	
	251, 253	
		222 – 239

KHP-CLNR/L + DKH(RL)

95°		CN..
		19 25
	40×50 60×80	
	252, 253	
		222 – 239

ISO TURNING – INTERNAL

DCLN(RL) INT

95°		CN..
		09 12
	32 50	
	254	
		222 – 239

PCLN(RL) INT

95°		CN..
		09 12 16 19
	20 80	
	255	
		222 – 239

C.-DCLN(RL) INT

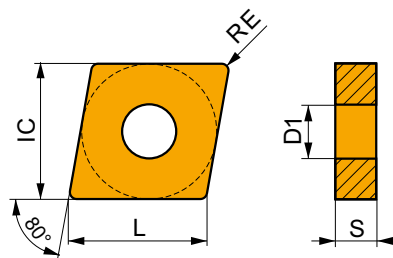
95°		CN..
		09 12 16
	25 50	
	257	
		222 – 239



CNGG

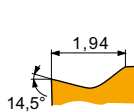


	IC	D1	L	S
	[mm]	[mm]	[mm]	[mm]
1204	12.700	5.16	12.90	4.76



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		
		vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
	[mm]	[m/min]	[mm/rev]	[mm]	[m/min]	[mm/rev]	[mm]	[m/min]	[mm/rev]	[mm]	[m/min]	[mm/rev]	[mm]	[m/min]	[mm/rev]	[mm]	[m/min]	[mm/rev]	[mm]



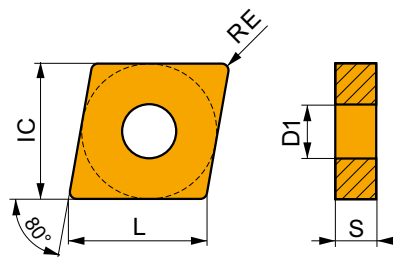
SF geometry with positive design for fine-finish machining of thin walls in continuous cuts.

CNGG 120402E-SF	H07	0.2	—	—	—	105	0.09	1.0	165	0.10	1.0	525	0.12	1.0	50	0.08	0.8	—	—	—
	T6310	0.2	195	0.10	1.0	140	0.09	1.0	155	0.10	1.0	585	0.12	1.0	55	0.08	0.8	35	0.15	1.0
	T8315	0.2	205	0.10	1.0	120	0.09	1.0	190	0.10	1.0	615	0.12	1.0	50	0.08	0.8	40	0.15	1.0
	T8330	0.2	195	0.10	1.0	115	0.09	1.0	185	0.10	1.0	585	0.12	1.0	45	0.08	0.8	35	0.15	1.0
	T8430	0.2	240	0.10	1.0	130	0.09	1.0	195	0.10	1.0	660	0.12	1.0	50	0.08	0.8	40	0.15	1.0

CNMA

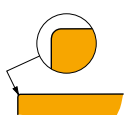
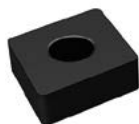


	IC	D1	L	S
	[mm]	[mm]	[mm]	[mm]
1204	12.700	5.16	12.90	4.76
1606	15.875	6.35	16.10	6.35
1906	19.050	7.94	19.30	6.35



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		
		vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
	[mm]	[m/min]	[mm/rev]	[mm]	[m/min]	[mm/rev]	[mm]	[m/min]	[mm/rev]	[mm]	[m/min]	[mm/rev]	[mm]	[m/min]	[mm/rev]	[mm]	[m/min]	[mm/rev]	[mm]



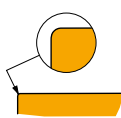
For fine-finish to semi-rough machining, and continuous to slightly interrupted cuts.

CNMA 120404	T5305	0.4	—	—	—	—	—	—	235	0.10	4.0	—	—	—	—	—	—	50	0.15	1.0
	T5315	0.4	—	—	—	—	—	—	200	0.10	4.0	—	—	—	—	—	—	40	0.15	1.0
CNMA 120408	T5305	0.8	—	—	—	—	—	—	220	0.20	4.0	—	—	—	—	—	—	45	0.15	1.0
	T5315	0.8	—	—	—	—	—	—	190	0.20	4.0	—	—	—	—	—	—	40	0.15	1.0
CNMA 120412	T6310	0.8	—	—	—	—	—	—	100	0.20	4.0	—	—	—	—	—	—	25	0.15	1.0
	T5305	1.2	—	—	—	—	—	—	195	0.30	4.0	—	—	—	—	—	—	40	0.15	1.0
CNMA 120416	T5315	1.2	—	—	—	—	—	—	180	0.30	4.0	—	—	—	—	—	—	35	0.15	1.0
	T6310	1.2	—	—	—	—	—	—	95	0.30	4.0	—	—	—	—	—	—	20	0.15	1.0
CNMA 120416	T5305	1.6	—	—	—	—	—	—	190	0.40	4.0	—	—	—	—	—	—	40	0.15	1.0
	T5315	1.6	—	—	—	—	—	—	170	0.40	4.0	—	—	—	—	—	—	35	0.15	1.0



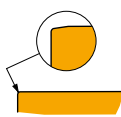
Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

Product		RE [mm]	P			M			K			N			S			H		
			vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
			[m/min]	[mm/rev]	[mm]	[m/min]	[mm/rev]	[mm]	[m/min]	[mm/rev]	[mm]	[m/min]	[mm/rev]	[mm]	[m/min]	[mm/rev]	[mm]	[m/min]	[mm/rev]	[mm]



For fine-finish to semi-rough machining, and continuous to slightly interrupted cuts.

CNMA 160612	T5305	1.2	—	—	—	—	—	—	190	0.30	5.0	—	—	—	—	—	—	40	0.15	1.0
	T5315	1.2	—	—	—	—	—	—	175	0.30	5.0	—	—	—	—	—	—	35	0.15	1.0
	T6310	1.2	—	—	—	—	—	—	90	0.30	5.0	—	—	—	—	—	—	20	0.15	1.0
CNMA 160616	T5305	1.6	—	—	—	—	—	—	185	0.40	5.0	—	—	—	—	—	—	35	0.15	1.0
	T5315	1.6	—	—	—	—	—	—	165	0.40	5.0	—	—	—	—	—	—	35	0.15	1.0
CNMA 190612	T5305	1.2	—	—	—	—	—	—	190	0.30	6.0	—	—	—	—	—	—	40	0.15	1.0
	T5315	1.2	—	—	—	—	—	—	170	0.30	6.0	—	—	—	—	—	—	35	0.15	1.0
	T6310	1.2	—	—	—	—	—	—	85	0.30	6.0	—	—	—	—	—	—	20	0.15	1.0
CNMA 190616	T5305	1.6	—	—	—	—	—	—	180	0.40	6.0	—	—	—	—	—	—	35	0.15	1.0
	T5315	1.6	—	—	—	—	—	—	160	0.40	6.0	—	—	—	—	—	—	30	0.15	1.0



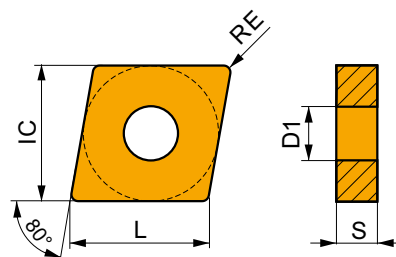
For fine-finish to semi-rough machining, and continuous to slightly interrupted cuts.

CNMA 120408S	T5305	0.8	—	—	—	—	—	—	220	0.20	4.0	—	—	—	—	—	—	45	0.15	1.0
CNMA 120412S	T5305	1.2	—	—	—	—	—	—	190	0.40	4.0	—	—	—	—	—	—	40	0.15	1.0
CNMA 160612S	T5305	1.2	—	—	—	—	—	—	190	0.30	5.0	—	—	—	—	—	—	40	0.15	1.0
CNMA 190616S	T5305	1.6	—	—	—	—	—	—	180	0.40	6.0	—	—	—	—	—	—	35	0.15	1.0

CNMG

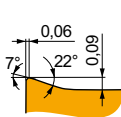
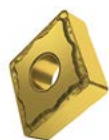


	IC [mm]	D1 [mm]	L [mm]	S [mm]
0903	9.525	3.81	9.70	3.18
1204	12.700	5.16	12.90	4.76
1606	15.880	6.35	16.10	6.35
1906	19.050	7.94	19.30	6.35
2509	25.400	9.12	25.80	9.53



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 [mm]	P			M			K			N			S			H		
			vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
			[m/min]	[mm/rev]	[mm]	[m/min]	[mm/rev]	[mm]	[m/min]	[mm/rev]	[mm]	[m/min]	[mm/rev]	[mm]	[m/min]	[mm/rev]	[mm]	[m/min]	[mm/rev]	[mm]



FF geometry with highly positive design for fine-finish machining, and continuous to slightly interrupted cuts.

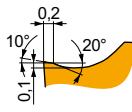
CNMG 120404E-FF	T7325	0.4	235	0.12	1.0	180	0.11	1.0	—	—	—	—	—	—	—	—	—	—	—	—
	T8315	0.4	220	0.12	1.0	130	0.11	1.0	205	0.12	1.0	—	—	—	—	—	—	—	—	—
CNMG 120408E-FF	T7325	0.8	265	0.15	1.0	205	0.14	1.0	—	—	—	—	—	—	—	—	—	—	—	—
	T8315	0.8	245	0.15	1.0	145	0.14	1.0	230	0.15	1.0	—	—	—	—	—	—	—	—	—

CN	DN	KN	LN	RN	SN	TN	VN	WN
----	----	----	----	----	----	----	----	----



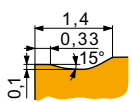
Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

Product		RE (mm)	P			M			K			N			S			H		
			vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
			[m/min]	[mm/rev]	[mm]	[m/min]	[mm/rev]	[mm]	[m/min]	[mm/rev]	[mm]	[m/min]	[mm/rev]	[mm]	[m/min]	[mm/rev]	[mm]	[m/min]	[mm/rev]	[mm]



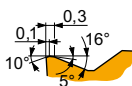
FM geometry with positive design for finish to semi-rough machining, and continuous to slightly interrupted cuts.

CNMG 090304E-FM	T7325	0.4	195	0.20	1.4	150	0.18	1.4	—	—	—	—	—	—	60	0.16	1.1	—	—	—
	T8330	0.4	175	0.20	1.4	105	0.18	1.4	165	0.20	1.4	—	—	—	40	0.14	1.1	—	—	—
	T8430	0.4	195	0.20	1.4	105	0.18	1.4	160	0.20	1.4	—	—	—	40	0.14	1.1	—	—	—
	T9315	0.4	265	0.20	1.4	—	—	—	250	0.20	1.4	—	—	—	—	—	—	—	—	—
	T9325	0.4	240	0.20	1.4	140	0.18	1.4	225	0.20	1.4	—	—	—	50	0.16	1.1	—	—	—
CNMG 090308E-FM	T7325	0.8	235	0.20	1.4	180	0.18	1.4	—	—	—	—	—	—	75	0.16	1.1	—	—	—
	T8330	0.8	205	0.20	1.4	120	0.18	1.4	190	0.20	1.4	—	—	—	50	0.14	1.1	—	—	—
	T8430	0.8	235	0.20	1.4	125	0.18	1.4	190	0.20	1.4	—	—	—	50	0.14	1.1	—	—	—
	T9315	0.8	315	0.20	1.4	—	—	—	295	0.20	1.4	—	—	—	—	—	—	—	—	—
	T9325	0.8	285	0.20	1.4	170	0.18	1.4	270	0.20	1.4	—	—	—	60	0.16	1.1	—	—	—
CNMG 120404E-FM	T7325	0.4	185	0.20	2.1	140	0.18	2.1	—	—	—	—	—	—	60	0.16	1.7	—	—	—
	T7335	0.4	180	0.20	2.1	140	0.18	2.1	—	—	—	—	—	—	55	0.16	1.7	—	—	—
	T8315	0.4	175	0.20	2.1	105	0.18	2.1	165	0.20	2.1	—	—	—	40	0.14	1.7	—	—	—
	T8330	0.4	165	0.20	2.1	95	0.18	2.1	155	0.20	2.1	—	—	—	40	0.14	1.7	—	—	—
	T8430	0.4	190	0.20	2.1	105	0.18	2.1	155	0.20	2.1	—	—	—	40	0.14	1.7	—	—	—
	T9310	0.4	285	0.20	2.1	—	—	—	270	0.20	2.1	—	—	—	—	—	—	—	—	—
	T9315	0.4	255	0.20	2.1	—	—	—	240	0.20	2.1	—	—	—	—	—	—	—	—	—
	T9325	0.4	230	0.20	2.1	135	0.18	2.1	215	0.20	2.1	—	—	—	50	0.16	1.7	—	—	—
	TT310	0.4	260	0.20	2.1	155	0.18	2.1	—	—	—	—	—	—	—	—	—	—	—	—
	T7325	0.8	220	0.20	2.1	170	0.18	2.1	—	—	—	—	—	—	70	0.16	1.7	—	—	—
CNMG 120408E-FM	T7335	0.8	215	0.20	2.1	165	0.18	2.1	—	—	—	—	—	—	65	0.16	1.7	—	—	—
	T8315	0.8	205	0.20	2.1	120	0.18	2.1	190	0.20	2.1	—	—	—	50	0.16	1.7	—	—	—
	T8330	0.8	195	0.20	2.1	115	0.18	2.1	185	0.20	2.1	—	—	—	45	0.16	1.7	—	—	—
	T8430	0.8	225	0.20	2.1	120	0.18	2.1	185	0.20	2.1	—	—	—	45	0.16	1.7	—	—	—
	T9310	0.8	335	0.20	2.1	—	—	—	315	0.20	2.1	—	—	—	—	—	—	—	—	—
	T9315	0.8	305	0.20	2.1	—	—	—	285	0.20	2.1	—	—	—	—	—	—	—	—	—
	T9325	0.8	275	0.20	2.1	165	0.18	2.1	260	0.20	2.1	—	—	—	60	0.16	1.7	—	—	—
	TT310	0.8	310	0.20	2.1	185	0.18	2.1	—	—	—	—	—	—	—	—	—	—	—	—
	T7325	1.2	210	0.27	2.1	160	0.24	2.1	—	—	—	—	—	—	65	0.19	1.7	—	—	—
	T9315	1.2	285	0.27	2.1	—	—	—	270	0.27	2.1	—	—	—	—	—	—	—	—	—
CNMG 120412E-FM	T9325	1.2	255	0.27	2.1	150	0.24	2.1	240	0.27	2.1	—	—	—	55	0.19	1.7	—	—	—



KR geometry for semi-rough to rough machining, and continuous to interrupted cuts.

CNMG 120408E-KR	T5305	0.8	255	0.35	4.0	—	—	—	240	0.35	4.0	—	—	—	—	—	—	50	0.15	1.0
	T5315	0.8	225	0.35	4.0	—	—	—	210	0.35	4.0	—	—	—	—	—	—	45	0.15	1.0
CNMG 120412E-KR	T5305	1.2	255	0.40	4.0	—	—	—	240	0.40	4.0	—	—	—	—	—	—	50	0.15	1.0
	T5315	1.2	230	0.40	4.0	—	—	—	215	0.40	4.0	—	—	—	—	—	—	45	0.15	1.0



M geometry for finish to semi-rough machining, and continuous to interrupted cuts.

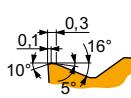
CNMG 090308E-M	T9315	0.8	230	0.32	1.8	—	—	—	215	0.32	1.8	—	—	—	—	—	—	45	0.15	1.0
	T9325	0.8	205	0.32	1.8	—	—	—	190	0.32	1.8	—	—	—	—	—	—	—	—	—
	T9335	0.8	180	0.32	1.8	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
CNMG 120404E-M	T5315	0.4	245	0.20	2.1	—	—	—	230	0.20	2.1	—	—	—	—	—	—	45	0.15	1.0
	T9310	0.4	260	0.20	2.1	—	—	—	245	0.20	2.1	—	—	—	—	—	—	50	0.15	1.0
	T9315	0.4	235	0.20	2.1	—	—	—	220	0.20	2.1	—	—	—	—	—	—	45	0.15	1.0
	T9325	0.4	210	0.20	2.1	—	—	—	195	0.20	2.1	—	—	—	—	—	—	—	—	—
	T9335	0.4	180	0.20	2.1	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—

CN	DN	KN	LN	RN	SN	TN	VN	WN
----	----	----	----	----	----	----	----	----



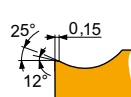
Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

Product		RE (mm)	P			M			K			N			S			H		
			vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
			[m/min]	[mm/rev]	[mm]	[m/min]	[mm/rev]	[mm]	[m/min]	[mm/rev]	[mm]	[m/min]	[mm/rev]	[mm]	[m/min]	[mm/rev]	[mm]	[m/min]	[mm/rev]	[mm]



M geometry for finish to semi-rough machining, and continuous to interrupted cuts.

CNMG 120408E-M	6640	0.8	■	165	0.32	2.1	■	—	—	—	■	155	0.32	2.1	■	—	—	—	■	—	—	—
	T5305	0.8	▣	280	0.32	2.1	■	—	—	—	■	265	0.32	2.1	■	—	—	—	▣	55	0.15	1.0
	T5315	0.8	▣	250	0.32	2.1	■	—	—	—	■	235	0.32	2.1	■	—	—	—	▣	50	0.15	1.0
	T8330	0.8	■	155	0.32	2.1	■	—	—	—	■	145	0.32	2.1	■	—	—	—	▣	30	0.15	1.0
	T8430	0.8	■	170	0.32	2.1	■	—	—	—	▣	135	0.32	2.1	■	—	—	—	▣	25	0.15	1.0
	T9310	0.8	■	245	0.32	2.1	■	—	—	—	▣	230	0.32	2.1	■	—	—	—	▣	45	0.15	1.0
	T9315	0.8	■	225	0.32	2.1	■	—	—	—	▣	210	0.32	2.1	■	—	—	—	▣	45	0.15	1.0
	T9325	0.8	■	200	0.32	2.1	■	—	—	—	▣	190	0.32	2.1	■	—	—	—	■	—	—	—
	T9335	0.8	■	180	0.32	2.1	■	—	—	—	■	—	—	—	■	—	—	—	■	—	—	—
CNMG 120412E-M	T5305	1.2	▣	275	0.40	2.1	■	—	—	—	■	260	0.40	2.1	■	—	—	—	▣	55	0.15	1.0
	T5315	1.2	▣	245	0.40	2.1	■	—	—	—	■	230	0.40	2.1	■	—	—	—	▣	45	0.15	1.0
	T9310	1.2	■	235	0.40	2.1	■	—	—	—	▣	220	0.40	2.1	■	—	—	—	▣	45	0.15	1.0
	T9315	1.2	■	220	0.40	2.1	■	—	—	—	▣	205	0.40	2.1	■	—	—	—	▣	40	0.15	1.0
	T9325	1.2	■	195	0.40	2.1	■	—	—	—	▣	185	0.40	2.1	■	—	—	—	■	—	—	—
CNMG 120416E-M	T9325	1.6	■	200	0.40	2.1	■	—	—	—	▣	190	0.40	2.1	■	—	—	—	■	—	—	—
	T9335	1.6	■	175	0.40	2.1	■	—	—	—	■	—	—	—	■	—	—	—	■	—	—	—
CNMG 160608E-M	T9310	0.8	■	235	0.32	3.6	■	—	—	—	▣	220	0.32	3.6	■	—	—	—	▣	45	0.15	1.0
	T9315	0.8	■	215	0.32	3.6	■	—	—	—	▣	200	0.32	3.6	■	—	—	—	▣	40	0.15	1.0
	T9325	0.8	■	190	0.32	3.6	■	—	—	—	▣	180	0.32	3.6	■	—	—	—	■	—	—	—
	T9335	0.8	■	170	0.32	3.6	■	—	—	—	■	—	—	—	■	—	—	—	■	—	—	—
CNMG 160612E-M	T9315	1.2	■	210	0.40	3.6	■	—	—	—	▣	195	0.40	3.6	■	—	—	—	▣	40	0.15	1.0
	T9325	1.2	■	185	0.40	3.6	■	—	—	—	▣	175	0.40	3.6	■	—	—	—	■	—	—	—
	T9335	1.2	■	160	0.40	3.6	■	—	—	—	■	—	—	—	■	—	—	—	■	—	—	—
CNMG 160616E-M	T9325	1.6	■	190	0.40	3.6	■	—	—	—	▣	180	0.40	3.6	■	—	—	—	■	—	—	—
	T9335	1.6	■	165	0.40	3.6	■	—	—	—	■	—	—	—	■	—	—	—	■	—	—	—
CNMG 190608E-M	T9315	0.8	■	210	0.32	4.2	■	—	—	—	▣	195	0.32	4.2	■	—	—	—	▣	40	0.15	1.0
	T9325	0.8	■	190	0.32	4.2	■	—	—	—	▣	180	0.32	4.2	■	—	—	—	■	—	—	—
	T9335	0.8	■	165	0.32	4.2	■	—	—	—	■	—	—	—	■	—	—	—	■	—	—	—
CNMG 190612E-M	6640	1.2	■	145	0.40	4.2	■	—	—	—	■	135	0.40	4.2	■	—	—	—	■	—	—	—
	T9310	1.2	■	220	0.40	4.2	■	—	—	—	▣	205	0.40	4.2	■	—	—	—	▣	40	0.15	1.0
	T9315	1.2	■	205	0.40	4.2	■	—	—	—	▣	190	0.40	4.2	■	—	—	—	▣	40	0.15	1.0
	T9325	1.2	■	185	0.40	4.2	■	—	—	—	▣	175	0.40	4.2	■	—	—	—	■	—	—	—
	T9335	1.2	■	160	0.40	4.2	■	—	—	—	■	—	—	—	■	—	—	—	■	—	—	—
CNMG 190616E-M	T9310	1.6	■	230	0.40	4.2	■	—	—	—	▣	215	0.40	4.2	■	—	—	—	▣	45	0.15	1.0
	T9315	1.6	■	215	0.40	4.2	■	—	—	—	▣	200	0.40	4.2	■	—	—	—	▣	40	0.15	1.0
	T9325	1.6	■	190	0.40	4.2	■	—	—	—	▣	180	0.40	4.2	■	—	—	—	■	—	—	—
	T9335	1.6	■	165	0.40	4.2	■	—	—	—	■	—	—	—	■	—	—	—	■	—	—	—



NF geometry with highly positive design for fine-finish to medium machining, and continuous cuts.

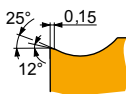
CNMG 090304E-NF	T6310	0.4	■	190	0.17	0.8	■	135	0.15	0.8	▣	150	0.17	0.8	▣	570	0.20	0.8	▣	55	0.12	0.6	■	—	—	—
	T7335	0.4	▣	210	0.18	0.8	■	160	0.16	0.8	■	—	—	—	■	—	—	—	▣	65	0.16	0.6	■	—	—	—
	T8315	0.4	▣	200	0.17	0.8	■	120	0.15	0.8	▣	190	0.17	0.8	▣	600	0.20	0.8	▣	50	0.12	0.6	■	—	—	—
	T8430	0.4	■	225	0.17	0.8	■	120	0.15	0.8	▣	185	0.17	0.8	▣	615	0.20	0.8	▣	45	0.12	0.6	■	—	—	—
	T9325	0.4	■	265	0.18	0.8	■	155	0.16	0.8	▣	250	0.18	0.8	■	—	—	—	▣	55	0.16	0.6	■	—	—	—
CNMG 090308E-NF	T6310	0.8	■	215	0.19	1.0	■	150	0.17	1.0	▣	170	0.19	1.0	▣	645	0.23	1.0	▣	60	0.15	0.8	■	—	—	—
	T7335	0.8	▣	240	0.19	1.0	■	185	0.17	1.0	■	—	—	—	■	—	—	—	▣	75	0.15	0.8	■	—	—	—
	T8330	0.8	■	215	0.19	1.0	■	125	0.17	1.0	▣	200	0.19	1.0	▣	645	0.23	1.0	▣	50	0.15	0.8	■	—	—	—
	T8430	0.8	■	245	0.19	1.0	■	135	0.17	1.0	▣	200	0.19	1.0	▣	675	0.23	1.0	▣	50	0.15	0.8	■	—	—	—
	T9325	0.8	■	300	0.19	1.0	■	180	0.17	1.0	▣	285	0.19	1.0	■	—	—	—	▣	65	0.15	0.8	■	—	—	—

CN	DN	KN	LN	RN	SN	TN	VN	WN
----	----	----	----	----	----	----	----	----



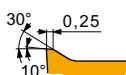
Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

Product		RE (mm)	P			M			K			N			S			H		
			vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
			[m/min]	[mm/rev]	[mm]	[m/min]	[mm/rev]	[mm]	[m/min]	[mm/rev]	[mm]	[m/min]	[mm/rev]	[mm]	[m/min]	[mm/rev]	[mm]	[m/min]	[mm/rev]	[mm]



NF geometry with highly positive design for fine-finish to medium machining, and continuous cuts.

CNMG 120404E-NF	HF7	0.4	—	—	—	95	0.15	1.7	155	0.17	1.7	495	0.20	1.7	—	—	—	—	—	—
	T6310	0.4	180	0.17	1.7	125	0.15	1.7	145	0.17	1.7	540	0.20	1.7	50	0.14	1.4	—	—	—
	T7325	0.4	200	0.18	1.7	155	0.16	1.7	—	—	—	—	—	—	65	0.16	1.4	—	—	—
	T7335	0.4	195	0.18	1.7	150	0.16	1.7	—	—	—	—	—	—	60	0.16	1.4	—	—	—
	T8315	0.4	185	0.17	1.7	110	0.15	1.7	175	0.17	1.7	555	0.20	1.7	45	0.14	1.4	—	—	—
	T8330	0.4	180	0.17	1.7	105	0.15	1.7	170	0.17	1.7	540	0.20	1.7	45	0.14	1.4	—	—	—
	T8430	0.4	200	0.17	1.7	110	0.15	1.7	165	0.17	1.7	555	0.20	1.7	40	0.14	1.4	—	—	—
	T9315	0.4	285	0.17	1.7	—	—	—	270	0.17	1.7	—	—	—	—	—	—	—	—	—
	T9325	0.4	250	0.18	1.7	150	0.16	1.7	235	0.18	1.7	—	—	—	55	0.16	1.4	—	—	—
CNMG 120408E-NF	HF7	0.8	—	—	—	110	0.17	1.7	180	0.19	1.7	570	0.23	1.7	—	—	—	—	—	—
	T6310	0.8	200	0.19	1.7	140	0.17	1.7	160	0.19	1.7	600	0.23	1.7	60	0.15	1.4	—	—	—
	T7325	0.8	235	0.19	1.7	180	0.17	1.7	—	—	—	—	—	—	75	0.15	1.4	—	—	—
	T7335	0.8	225	0.19	1.7	175	0.17	1.7	—	—	—	—	—	—	70	0.15	1.4	—	—	—
	T8315	0.8	215	0.19	1.7	125	0.17	1.7	200	0.19	1.7	645	0.23	1.7	50	0.15	1.4	—	—	—
	T8330	0.8	200	0.19	1.7	120	0.17	1.7	190	0.19	1.7	600	0.23	1.7	50	0.15	1.4	—	—	—
	T8430	0.8	235	0.19	1.7	125	0.17	1.7	190	0.19	1.7	645	0.23	1.7	50	0.15	1.4	—	—	—
	T9315	0.8	320	0.19	1.7	—	—	—	300	0.19	1.7	—	—	—	—	—	—	—	—	—
	T9325	0.8	285	0.19	1.7	170	0.17	1.7	270	0.19	1.7	—	—	—	60	0.15	1.4	—	—	—
CNMG 120412E-NF	T6310	1.2	185	0.30	2.1	130	0.27	2.1	145	0.30	2.1	555	0.36	2.1	55	0.21	1.7	—	—	—
	T7325	1.2	205	0.30	2.1	155	0.27	2.1	—	—	—	—	—	—	65	0.21	1.7	—	—	—
	T7335	1.2	200	0.30	2.1	155	0.27	2.1	—	—	—	—	—	—	65	0.21	1.7	—	—	—
	T8330	1.2	185	0.30	2.1	110	0.27	2.1	175	0.30	2.1	555	0.36	2.1	45	0.21	1.7	—	—	—
	T8430	1.2	200	0.30	2.1	110	0.27	2.1	165	0.30	2.1	555	0.36	2.1	40	0.21	1.7	—	—	—
	T9315	1.2	275	0.30	2.1	—	—	—	260	0.30	2.1	—	—	—	—	—	—	—	—	—
	T9325	1.2	245	0.30	2.1	145	0.27	2.1	230	0.30	2.1	—	—	—	55	0.21	1.7	—	—	—



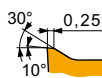
NM geometry with highly positive design for fine-finish, medium and rough machining, with continuous cuts.

CNMG 120404E-NM	T7325	0.4	195	0.20	2.1	150	0.18	2.1	—	—	—	—	—	—	60	0.16	1.7	—	—	—
	T7335	0.4	190	0.20	2.1	145	0.18	2.1	—	—	—	—	—	—	60	0.16	1.7	—	—	—
	T8315	0.4	180	0.20	2.1	105	0.18	2.1	—	—	—	540	0.24	2.1	45	0.16	1.7	—	—	—
	T8330	0.4	170	0.20	2.1	100	0.18	2.1	—	—	—	510	0.24	2.1	40	0.16	1.7	—	—	—
	T8430	0.4	195	0.20	2.1	105	0.18	2.1	—	—	—	540	0.24	2.1	40	0.16	1.7	—	—	—
	T9315	0.4	270	0.20	2.1	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
	T9325	0.4	240	0.20	2.1	140	0.18	2.1	—	—	—	—	—	—	50	0.16	1.7	—	—	—
CNMG 120408E-NM	T7325	0.8	215	0.25	2.1	165	0.23	2.1	—	—	—	—	—	—	65	0.20	1.7	—	—	—
	T7335	0.8	210	0.25	2.1	160	0.23	2.1	—	—	—	—	—	—	65	0.20	1.7	—	—	—
	T8315	0.8	205	0.25	2.1	120	0.23	2.1	—	—	—	615	0.30	2.1	50	0.20	1.7	—	—	—
	T8330	0.8	195	0.25	2.1	115	0.23	2.1	—	—	—	585	0.30	2.1	45	0.20	1.7	—	—	—
	T8430	0.8	210	0.25	2.1	115	0.23	2.1	—	—	—	585	0.30	2.1	45	0.20	1.7	—	—	—
	T9315	0.8	290	0.25	2.1	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
	T9325	0.8	260	0.25	2.1	155	0.23	2.1	—	—	—	—	—	—	55	0.20	1.7	—	—	—
CNMG 120412E-NM	T7325	1.2	215	0.30	2.1	165	0.27	2.1	—	—	—	—	—	—	65	0.24	1.7	—	—	—
	T7335	1.2	210	0.30	2.1	160	0.27	2.1	—	—	—	—	—	—	65	0.24	1.7	—	—	—
	T8315	1.2	205	0.30	2.1	120	0.27	2.1	—	—	—	615	0.36	2.1	50	0.24	1.7	—	—	—
	T8330	1.2	195	0.30	2.1	115	0.27	2.1	—	—	—	585	0.36	2.1	45	0.24	1.7	—	—	—
	T8430	1.2	210	0.30	2.1	115	0.27	2.1	—	—	—	585	0.36	2.1	45	0.24	1.7	—	—	—
	T9315	1.2	285	0.30	2.1	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
	T9325	1.2	255	0.30	2.1	150	0.27	2.1	—	—	—	—	—	—	55	0.24	1.7	—	—	—
CNMG 160608E-NM	T7325	0.8	195	0.30	3.6	150	0.27	3.6	—	—	—	—	—	—	60	0.27	2.9	—	—	—
	T7335	0.8	190	0.30	3.6	145	0.27	3.6	—	—	—	—	—	—	60	0.27	2.9	—	—	—
	T8315	0.8	185	0.30	3.6	110	0.27	3.6	—	—	—	555	0.36	3.6	45	0.27	2.9	—	—	—
	T8330	0.8	170	0.30	3.6	100	0.27	3.6	—	—	—	510	0.36	3.6	40	0.27	2.9	—	—	—
	T8430	0.8	185	0.30	3.6	100	0.27	3.6	—	—	—	510	0.36	3.6	40	0.27	2.9	—	—	—
	T9325	0.8	225	0.30	3.6	135	0.27	3.6	—	—	—	—	—	—	50	0.27	2.9	—	—	—



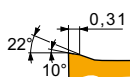
Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

Product		RE [mm]	P			M			K			N			S			H		
			vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
			[m/min]	[mm/rev]	[mm]	[m/min]	[mm/rev]	[mm]	[m/min]	[mm/rev]	[mm]	[m/min]	[mm/rev]	[mm]	[m/min]	[mm/rev]	[mm]	[m/min]	[mm/rev]	[mm]



NM geometry with highly positive design for fine-finish, medium and rough machining, with continuous cuts.

CNMG 160612E-NM	T7325	1.2	205	0.30	3.6	155	0.27	3.6	—	—	—	—	—	—	65	0.27	2.9	—	—	—
	T7335	1.2	200	0.30	3.6	155	0.27	3.6	—	—	—	—	—	—	65	0.27	2.9	—	—	—
	T8315	1.2	195	0.30	3.6	115	0.27	3.6	—	—	—	585	0.36	3.6	45	0.27	2.9	—	—	—
	T9325	1.2	240	0.30	3.6	140	0.27	3.6	—	—	—	—	—	—	50	0.27	2.9	—	—	—
CNMG 190612E-NM	T7325	1.2	195	0.35	4.2	150	0.32	4.2	—	—	—	—	—	—	60	0.32	3.4	—	—	—
	T7335	1.2	180	0.35	4.2	140	0.32	4.2	—	—	—	—	—	—	55	0.32	3.4	—	—	—
	T8315	1.2	180	0.35	4.2	105	0.32	4.2	—	—	—	540	0.42	4.2	45	0.32	3.4	—	—	—
	T8330	1.2	170	0.35	4.2	100	0.32	4.2	—	—	—	510	0.42	4.2	40	0.32	3.4	—	—	—
	T8430	1.2	180	0.35	4.2	95	0.32	4.2	—	—	—	495	0.42	4.2	35	0.32	3.4	—	—	—
	T9325	1.2	220	0.35	4.2	130	0.32	4.2	—	—	—	—	—	—	45	0.32	3.4	—	—	—



NMR geometry with positive design for medium to rough machining, and continuous cuts.

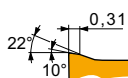
CNMG 090308E-NMR	T7325	0.8	175	0.35	1.6	135	0.32	1.6	—	—	—	—	—	—	55	0.25	1.3	—	—	—
	T7335	0.8	170	0.35	1.6	130	0.32	1.6	—	—	—	—	—	—	55	0.25	1.3	—	—	—
	T9325	0.8	200	0.35	1.6	120	0.32	1.6	—	—	—	—	—	—	45	0.25	1.3	—	—	—
CNMG 120404E-NMR	T6310	0.4	140	0.25	2.7	100	0.23	2.7	—	—	—	—	—	—	40	0.20	2.2	—	—	—
	T7325	0.4	155	0.25	2.7	120	0.23	2.7	—	—	—	—	—	—	50	0.20	2.2	—	—	—
	T7335	0.4	155	0.25	2.0	120	0.23	2.0	—	—	—	—	—	—	50	0.20	1.6	—	—	—
	T8330	0.4	140	0.25	2.0	80	0.23	2.0	—	—	—	—	—	—	35	0.20	1.6	—	—	—
	T8430	0.4	150	0.25	2.7	80	0.23	2.7	—	—	—	—	—	—	30	0.20	2.2	—	—	—
	T9315	0.4	215	0.25	2.0	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
	T9325	0.4	190	0.25	2.0	110	0.23	2.0	—	—	—	—	—	—	40	0.20	1.6	—	—	—
CNMG 120408E-NMR	T6310	0.8	150	0.35	2.7	105	0.32	2.7	—	—	—	—	—	—	45	0.25	2.2	—	—	—
	T7325	0.8	170	0.35	2.7	130	0.32	2.7	—	—	—	—	—	—	55	0.25	2.2	—	—	—
	T7335	0.8	160	0.35	2.7	120	0.32	2.7	—	—	—	—	—	—	50	0.25	2.2	—	—	—
	T8330	0.8	150	0.35	2.7	90	0.32	2.7	—	—	—	—	—	—	35	0.25	2.2	—	—	—
	T8430	0.8	155	0.35	2.7	85	0.32	2.7	—	—	—	—	—	—	30	0.25	2.2	—	—	—
	T9315	0.8	210	0.35	2.7	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
	T9325	0.8	190	0.35	2.7	110	0.32	2.7	—	—	—	—	—	—	40	0.25	2.2	—	—	—
CNMG 120412E-NMR	T6310	1.2	150	0.40	2.7	105	0.36	2.7	—	—	—	—	—	—	45	0.28	2.2	—	—	—
	T7325	1.2	170	0.40	2.7	130	0.36	2.7	—	—	—	—	—	—	55	0.28	2.2	—	—	—
	T7335	1.2	160	0.40	2.7	120	0.36	2.7	—	—	—	—	—	—	50	0.28	2.2	—	—	—
	T8330	1.2	150	0.40	2.7	90	0.36	2.7	—	—	—	—	—	—	35	0.28	2.2	—	—	—
	T8430	1.2	155	0.40	2.7	85	0.36	2.7	—	—	—	—	—	—	30	0.28	2.2	—	—	—
	T9315	1.2	215	0.40	2.7	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
	T9325	1.2	190	0.40	2.7	110	0.36	2.7	—	—	—	—	—	—	40	0.28	2.2	—	—	—
CNMG 120416E-NMR	T7325	1.6	170	0.45	2.7	130	0.41	2.7	—	—	—	—	—	—	55	0.32	2.2	—	—	—
	T7335	1.6	160	0.45	2.7	120	0.41	2.7	—	—	—	—	—	—	50	0.32	2.2	—	—	—
	T9325	1.6	190	0.45	2.7	110	0.41	2.7	—	—	—	—	—	—	40	0.32	2.2	—	—	—
CNMG 160608E-NMR	T7325	0.8	160	0.35	4.0	120	0.32	4.0	—	—	—	—	—	—	50	0.25	3.2	—	—	—
	T7335	0.8	150	0.35	4.0	115	0.32	4.0	—	—	—	—	—	—	45	0.25	3.2	—	—	—
	T9315	0.8	205	0.35	4.0	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
	T9325	0.8	185	0.35	4.0	110	0.32	4.0	—	—	—	—	—	—	40	0.25	3.2	—	—	—
CNMG 160612E-NMR	T7325	1.2	165	0.40	4.0	125	0.36	4.0	—	—	—	—	—	—	50	0.28	3.2	—	—	—
	T7335	1.2	155	0.40	4.0	120	0.36	4.0	—	—	—	—	—	—	50	0.28	3.2	—	—	—
	T8330	1.2	145	0.40	4.0	85	0.36	4.0	—	—	—	—	—	—	35	0.28	3.2	—	—	—
	T8430	1.2	150	0.40	4.0	80	0.36	4.0	—	—	—	—	—	—	30	0.28	3.2	—	—	—
	T9315	1.2	205	0.40	4.0	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
	T9325	1.2	185	0.40	4.0	110	0.36	4.0	—	—	—	—	—	—	40	0.28	3.2	—	—	—

CN	DN	KN	LN	RN	SN	TN	VN	WN
----	----	----	----	----	----	----	----	----



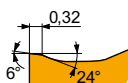
Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

Product		RE	P			M			K			N			S			H		
			vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
		(mm)	[m/min]	[mm/rev]	[mm]	[m/min]	[mm/rev]	[mm]	[m/min]	[mm/rev]	[mm]	[m/min]	[mm/rev]	[mm]	[m/min]	[mm/rev]	[mm]	[m/min]	[mm/rev]	[mm]



NMR geometry with positive design for medium to rough machining, and continuous cuts.

CNMG 160616E-NMR	T7325	1.6	165	0.45	4.0	125	0.41	4.0	—	—	—	—	—	—	50	0.32	3.2	—	—	—
	T7335	1.6	155	0.45	4.0	120	0.41	4.0	—	—	—	—	—	—	50	0.32	3.2	—	—	—
	T8330	1.6	145	0.45	4.0	85	0.41	4.0	—	—	—	—	—	—	35	0.32	3.2	—	—	—
	T8430	1.6	150	0.45	4.0	80	0.41	4.0	—	—	—	—	—	—	30	0.32	3.2	—	—	—
	T9315	1.6	200	0.45	4.0	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
CNMG 190608E-NMR	T9325	1.6	180	0.45	4.0	105	0.41	4.0	—	—	—	—	—	—	40	0.32	3.2	—	—	—
	T6310	0.8	140	0.35	5.2	100	0.32	5.2	—	—	—	—	—	—	40	0.25	4.2	—	—	—
	T7325	0.8	155	0.35	5.2	120	0.32	5.2	—	—	—	—	—	—	50	0.25	4.2	—	—	—
	T7335	0.8	150	0.35	5.2	115	0.32	5.2	—	—	—	—	—	—	45	0.25	4.2	—	—	—
	T9315	0.8	195	0.35	5.2	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
CNMG 190612E-NMR	T9325	0.8	180	0.35	5.2	105	0.32	5.2	—	—	—	—	—	—	40	0.25	4.2	—	—	—
	T6310	1.2	140	0.40	5.2	100	0.36	5.2	—	—	—	—	—	—	40	0.28	4.2	—	—	—
	T7325	1.2	160	0.40	5.2	120	0.36	5.2	—	—	—	—	—	—	50	0.28	4.2	—	—	—
	T7335	1.2	150	0.40	5.2	115	0.36	5.2	—	—	—	—	—	—	45	0.28	4.2	—	—	—
	T8330	1.2	140	0.40	5.2	80	0.36	5.2	—	—	—	—	—	—	35	0.28	4.2	—	—	—
	T8430	1.2	145	0.40	5.2	80	0.36	5.2	—	—	—	—	—	—	30	0.28	4.2	—	—	—
	T9315	1.2	200	0.40	5.2	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
CNMG 190616E-NMR	T9325	1.2	180	0.40	5.2	105	0.36	5.2	—	—	—	—	—	—	40	0.28	4.2	—	—	—
	T7325	1.6	160	0.45	5.2	120	0.41	5.2	—	—	—	—	—	—	50	0.32	4.2	—	—	—
	T7335	1.6	150	0.45	5.2	115	0.41	5.2	—	—	—	—	—	—	45	0.32	4.2	—	—	—
	T9315	1.6	195	0.45	5.2	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
	T9325	1.6	175	0.45	5.2	105	0.41	5.2	—	—	—	—	—	—	35	0.32	4.2	—	—	—



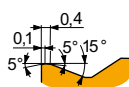
NRM geometry with positive design for semi-rough to rough machining, and continuous to moderate interrupted cuts.

CNMG 120408-NRM	T7325	0.8	160	0.35	4.0	120	0.32	4.0	—	—	—	—	—	—	50	0.28	3.2	—	—	—
	T7335	0.8	150	0.35	4.0	115	0.32	4.0	—	—	—	—	—	—	45	0.28	3.2	—	—	—
	T9315	0.8	205	0.35	4.0	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
CNMG 120412-NRM	T7325	1.2	165	0.40	4.0	125	0.36	4.0	—	—	—	—	—	—	50	0.28	3.2	—	—	—
	T7335	1.2	155	0.40	4.0	120	0.36	4.0	—	—	—	—	—	—	50	0.28	3.2	—	—	—
	T9315	1.2	205	0.40	4.0	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
CNMG 120416-NRM	T7325	1.6	165	0.45	4.0	125	0.41	4.0	—	—	—	—	—	—	50	0.36	3.2	—	—	—
	T7335	1.6	155	0.45	4.0	120	0.41	4.0	—	—	—	—	—	—	50	0.36	3.2	—	—	—
	T9315	1.6	200	0.45	4.0	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
CNMG 160608-NRM	T7325	0.8	155	0.35	6.0	120	0.32	6.0	—	—	—	—	—	—	50	0.28	4.8	—	—	—
	T7335	0.8	145	0.35	6.0	110	0.32	6.0	—	—	—	—	—	—	45	0.28	4.8	—	—	—
	T9315	0.8	195	0.35	6.0	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
CNMG 160612-NRM	T7325	1.2	155	0.40	6.0	120	0.36	6.0	—	—	—	—	—	—	50	0.32	4.8	—	—	—
	T7335	1.2	150	0.40	6.0	115	0.36	6.0	—	—	—	—	—	—	45	0.32	4.8	—	—	—
	T9315	1.2	200	0.40	6.0	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
CNMG 160616-NRM	T7325	1.6	155	0.45	6.0	120	0.41	6.0	—	—	—	—	—	—	50	0.36	4.8	—	—	—
	T7335	1.6	150	0.45	6.0	115	0.41	6.0	—	—	—	—	—	—	45	0.36	4.8	—	—	—
	T9315	1.6	195	0.45	6.0	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
CNMG 190608-NRM	T7325	0.8	150	0.35	8.0	115	0.32	8.0	—	—	—	—	—	—	45	0.28	6.4	—	—	—
	T7335	0.8	140	0.35	8.0	105	0.32	8.0	—	—	—	—	—	—	45	0.28	6.4	—	—	—
	T9315	0.8	190	0.35	8.0	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
CNMG 190612-NRM	T7325	1.2	155	0.40	8.0	120	0.36	8.0	—	—	—	—	—	—	50	0.32	6.4	—	—	—
	T7335	1.2	145	0.40	8.0	110	0.36	8.0	—	—	—	—	—	—	45	0.32	6.4	—	—	—
	T9315	1.2	190	0.40	8.0	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
CNMG 190616-NRM	T7325	1.6	150	0.45	8.0	115	0.41	8.0	—	—	—	—	—	—	45	0.36	6.4	—	—	—
	T7335	1.6	145	0.45	8.0	110	0.41	8.0	—	—	—	—	—	—	45	0.36	6.4	—	—	—
	T9315	1.6	190	0.45	8.0	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
CNMG 250924-NRM	T7325	2.4	95	0.70	10.0	70	0.63	10.0	—	—	—	—	—	—	30	0.49	8.0	—	—	—
	T7335	2.4	90	0.70	10.0	70	0.63	10.0	—	—	—	—	—	—	25	0.49	8.0	—	—	—
	T9315	2.4	115	0.70	10.0	—	—	—	105	0.70	10.0	—	—	—	—	—	—	—	—	—



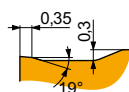
Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

Product		RE	P			M			K			N			S			H		
			vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
			[m/min]	[mm/rev]	[mm]	[m/min]	[mm/rev]	[mm]	[m/min]	[mm/rev]	[mm]	[m/min]	[mm/rev]	[mm]	[m/min]	[mm/rev]	[mm]	[m/min]	[mm/rev]	[mm]



R geometry for semi-rough to rough machining, and continuous to interrupted cuts.

CNMG 120408E-R	6640	0.8	■	140	0.40	4.0	—	—	—	■	130	0.40	4.0	—	—	—	—	—	—			
	T5305	0.8	▣	240	0.40	4.0	—	—	—	■	225	0.40	4.0	—	—	—	—	▣	45	0.15	1.0	
	T5315	0.8	▣	215	0.40	4.0	—	—	—	■	200	0.40	4.0	—	—	—	—	▣	40	0.15	1.0	
	T9310	0.8	■	205	0.40	4.0	—	—	—	▣	190	0.40	4.0	—	—	—	—	▣	40	0.15	1.0	
	T9315	0.8	■	190	0.40	4.0	—	—	—	▣	180	0.40	4.0	—	—	—	—	▣	35	0.15	1.0	
	T9325	0.8	■	175	0.40	4.0	—	—	—	▣	165	0.40	4.0	—	—	—	—	—	—	—	—	
	T9335	0.8	■	150	0.40	4.0	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	
CNMG 120412E-R	T5305	1.2	▣	245	0.45	4.0	—	—	—	■	230	0.45	4.0	—	—	—	—	—	▣	45	0.15	1.0
	T5315	1.2	▣	220	0.45	4.0	—	—	—	■	205	0.45	4.0	—	—	—	—	—	▣	40	0.15	1.0
	T9315	1.2	■	195	0.45	4.0	—	—	—	▣	185	0.45	4.0	—	—	—	—	—	▣	35	0.15	1.0
	T9325	1.2	■	175	0.45	4.0	—	—	—	▣	165	0.45	4.0	—	—	—	—	—	—	—	—	
	T9335	1.2	■	155	0.45	4.0	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	
CNMG 120416E-R	T5315	1.6	▣	225	0.50	4.0	—	—	—	■	210	0.50	4.0	—	—	—	—	—	▣	45	0.15	1.0
	T9335	1.6	■	150	0.50	4.0	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	
CNMG 160608E-R	T5315	0.8	▣	210	0.40	5.5	—	—	—	■	195	0.40	5.5	—	—	—	—	—	▣	40	0.15	1.0
CNMG 160612E-R	T5305	1.2	▣	235	0.45	5.5	—	—	—	■	220	0.45	5.5	—	—	—	—	—	▣	45	0.15	1.0
	T5315	1.2	▣	215	0.45	5.5	—	—	—	■	200	0.45	5.5	—	—	—	—	—	▣	40	0.15	1.0
	T7335	1.2	▣	145	0.45	5.5	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	
	T9310	1.2	■	205	0.45	5.5	—	—	—	▣	190	0.45	5.5	—	—	—	—	—	▣	40	0.15	1.0
	T9315	1.2	■	190	0.45	5.5	—	—	—	▣	180	0.45	5.5	—	—	—	—	—	▣	35	0.15	1.0
	T9325	1.2	■	170	0.45	5.5	—	—	—	▣	160	0.45	5.5	—	—	—	—	—	—	—	—	—
	T9335	1.2	■	140	0.45	5.5	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	
CNMG 160616E-R	T5305	1.6	▣	240	0.50	5.5	—	—	—	■	225	0.50	5.5	—	—	—	—	—	▣	45	0.15	1.0
CNMG 190608E-R	T5315	0.8	▣	205	0.40	7.0	—	—	—	■	190	0.40	7.0	—	—	—	—	—	▣	40	0.15	1.0
CNMG 190612E-R	6640	1.2	■	135	0.45	7.0	—	—	—	■	125	0.45	7.0	—	—	—	—	—	—	—	—	—
	T5305	1.2	▣	230	0.45	7.0	—	—	—	■	215	0.45	7.0	—	—	—	—	—	▣	45	0.15	1.0
	T5315	1.2	▣	210	0.45	7.0	—	—	—	■	195	0.45	7.0	—	—	—	—	—	▣	40	0.15	1.0
	T9315	1.2	■	185	0.45	7.0	—	—	—	▣	175	0.45	7.0	—	—	—	—	—	▣	35	0.15	1.0
	T9325	1.2	■	165	0.45	7.0	—	—	—	▣	155	0.45	7.0	—	—	—	—	—	—	—	—	—
	T9335	1.2	■	145	0.45	7.0	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
	T9335	1.2	■	145	0.45	7.0	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
CNMG 190616E-R	6640	1.6	■	130	0.50	7.0	—	—	—	■	120	0.50	7.0	—	—	—	—	—	—	—	—	—
	T5305	1.6	▣	235	0.50	7.0	—	—	—	■	220	0.50	7.0	—	—	—	—	—	▣	45	0.15	1.0
	T5315	1.6	▣	210	0.50	7.0	—	—	—	■	195	0.50	7.0	—	—	—	—	—	▣	40	0.15	1.0
	T9310	1.6	■	195	0.50	7.0	—	—	—	▣	185	0.50	7.0	—	—	—	—	—	▣	35	0.15	1.0
	T9315	1.6	■	180	0.50	7.0	—	—	—	▣	170	0.50	7.0	—	—	—	—	—	▣	35	0.15	1.0
	T9325	1.6	■	165	0.50	7.0	—	—	—	▣	155	0.50	7.0	—	—	—	—	—	—	—	—	—
	T9335	1.6	■	145	0.50	7.0	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—



RM geometry for semi-rough to rough machining, and continuous to interrupted cuts.

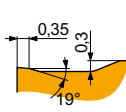
CNMG 120408E-RM	T5305	0.8	🟩	275	0.40	4.0		—	—	—	🟩	260	0.40	4.0		—	—	—		—	—	—		—	—	—		—	—	—
	T5315	0.8	🟩	250	0.40	4.0		—	—	—	🟩	235	0.40	4.0		—	—	—		—	—	—		—	—	—		—	—	—
	T6310	0.8	🟩	155	0.40	4.0	🟩	110	0.36	4.0	🟩	125	0.40	4.0		—	—	—		—	—	—		—	—	—		—	—	—
	T7325	0.8	🟩	180	0.40	4.0	🟩	140	0.36	4.0	🔴	—	—	—		—	—	—		—	—	—		—	—	—		—	—	—
	T7335	0.8	🟩	165	0.40	4.0	🟩	125	0.36	4.0	🔴	—	—	—		—	—	—		—	—	—		—	—	—		—	—	—
	T8315	0.8	🟩	165	0.40	4.0	🟩	95	0.36	4.0	🟩	155	0.40	4.0		—	—	—		—	—	—		—	—	—		—	—	—
	T8330	0.8	🟩	155	0.40	4.0	🟩	90	0.36	4.0	🟩	145	0.40	4.0		—	—	—		—	—	—		—	—	—		—	—	—
	T8430	0.8	🟩	165	0.40	4.0	🟩	90	0.36	4.0	🟩	135	0.40	4.0		—	—	—		—	—	—		—	—	—		—	—	—
	T9310	0.8	🟩	240	0.40	4.0		—	—	—	🟩	225	0.40	4.0		—	—	—		—	—	—		—	—	—		—	—	—
	T9315	0.8	🟩	220	0.40	4.0		—	—	—	🟩	205	0.40	4.0		—	—	—		—	—	—		—	—	—		—	—	—
	T9325	0.8	🟩	200	0.40	4.0	🟩	120	0.36	4.0	🟩	190	0.40	4.0		—	—	—		—	—	—		—	—	—		—	—	—
	T9335	0.8	🟩	170	0.40	4.0	🟩	100	0.36	4.0	🔴	—	—	—		—	—	—		—	—	—		—	—	—		—	—	—

CN	DN	KN	LN	RN	SN	TN	VN	WN
----	----	----	----	----	----	----	----	----



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 (mm)	P			M			K			N			S			H		
			vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
			[m/min]	[mm/rev]	[mm]	[m/min]	[mm/rev]	[mm]	[m/min]	[mm/rev]	[mm]	[m/min]	[mm/rev]	[mm]	[m/min]	[mm/rev]	[mm]	[m/min]	[mm/rev]	[mm]



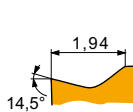
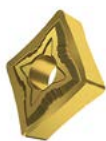
RM geometry for semi-rough to rough machining, and continuous to interrupted cuts.

CNMG 120412E-RM	T5305	1.2		280	0.45	4.0					265	0.45	4.0							
	T5315	1.2		250	0.45	4.0					235	0.45	4.0							
	T6310	1.2		160	0.45	4.0		115	0.41	4.0		125	0.45	4.0						
	T7325	1.2		180	0.45	4.0		140	0.41	4.0										
	T7335	1.2		170	0.45	4.0		130	0.41	4.0										
	T8315	1.2		170	0.45	4.0		100	0.41	4.0		160	0.45	4.0						
	T8330	1.2		160	0.45	4.0		95	0.41	4.0		150	0.45	4.0						
	T8430	1.2		170	0.45	4.0		90	0.41	4.0		135	0.45	4.0						
	T9310	1.2		240	0.45	4.0					225	0.45	4.0							
	T9315	1.2		220	0.45	4.0					205	0.45	4.0							
	T9325	1.2		200	0.45	4.0		120	0.41	4.0		190	0.45	4.0						
	T9335	1.2		175	0.45	4.0		105	0.41	4.0										
CNMG 120416E-RM	T5305	1.6		280	0.50	4.0					265	0.50	4.0							
	T5315	1.6		255	0.50	4.0					240	0.50	4.0							
	T7325	1.6		185	0.50	4.0		140	0.45	4.0										
	T7335	1.6		175	0.50	4.0		135	0.45	4.0										
	T8330	1.6		160	0.50	4.0		95	0.45	4.0		150	0.50	4.0						
	T8430	1.6		170	0.50	4.0		90	0.45	4.0		135	0.50	4.0						
	T9310	1.6		240	0.50	4.0					225	0.50	4.0							
	T9315	1.6		220	0.50	4.0					205	0.50	4.0							
	T9325	1.6		205	0.50	4.0		120	0.45	4.0		190	0.50	4.0						
CNMG 160608E-RM	T5305	0.8		265	0.40	6.0					250	0.40	6.0							
	T5315	0.8		240	0.40	6.0					225	0.40	6.0							
	T8330	0.8		150	0.40	6.0		90	0.36	6.0		140	0.40	6.0						
	T8430	0.8		155	0.40	6.0		85	0.36	6.0		130	0.40	6.0						
	T9315	0.8		215	0.40	6.0					200	0.40	6.0							
	T9325	0.8		190	0.40	6.0		110	0.36	6.0		180	0.40	6.0						
	T9335	0.8		165	0.40	6.0		95	0.36	6.0										
CNMG 160612E-RM	T5305	1.2		270	0.45	6.0					255	0.45	6.0							
	T5315	1.2		245	0.45	6.0					230	0.45	6.0							
	T6310	1.2		155	0.45	6.0		110	0.41	6.0		125	0.45	6.0						
	T7325	1.2		170	0.45	6.0		130	0.41	6.0										
	T7335	1.2		165	0.45	6.0		125	0.41	6.0										
	T8330	1.2		155	0.45	6.0		90	0.41	6.0		145	0.45	6.0						
	T8430	1.2		155	0.45	6.0		85	0.41	6.0		130	0.45	6.0						
	T9310	1.2		230	0.45	6.0					215	0.45	6.0							
	T9315	1.2		215	0.45	6.0					200	0.45	6.0							
	T9325	1.2		195	0.45	6.0		115	0.41	6.0		185	0.45	6.0						
CNMG 160616E-RM	T9335	1.2		165	0.45	6.0		95	0.41	6.0										
	T5305	1.6		270	0.50	6.0					255	0.50	6.0							
	T5315	1.6		245	0.50	6.0					230	0.50	6.0							
	T7325	1.6		175	0.50	6.0		135	0.45	6.0										
	T7335	1.6		165	0.50	6.0		125	0.45	6.0										
	T9310	1.6		225	0.50	6.0					210	0.50	6.0							
	T9315	1.6		215	0.50	6.0					200	0.50	6.0							
	T9325	1.6		190	0.50	6.0		110	0.45	6.0		180	0.50	6.0						
CNMG 190608E-RM	T9335	1.6		165	0.50	6.0		95	0.45	6.0										
	T5305	0.8		260	0.40	7.5					245	0.40	7.5							
	T5315	0.8		230	0.40	7.5					215	0.40	7.5							
	T7335	0.8		155	0.40	7.5		120	0.36	7.5										
	T9315	0.8		210	0.40	7.5					195	0.40	7.5							
	T9325	0.8		190	0.40	7.5		110	0.36	7.5		180	0.40	7.5						
	T9335	0.8		160	0.40	7.5		95	0.36	7.5										



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 (mm)	P			M			K			N			S			H		
			vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
			[m/min]	[mm/rev]	[mm]	[m/min]	[mm/rev]	[mm]	[m/min]	[mm/rev]	[mm]	[m/min]	[mm/rev]	[mm]	[m/min]	[mm/rev]	[mm]	[m/min]	[mm/rev]	[mm]
CNMG 190612E-RM	T5305	1.2	260	0.45	7.5	—	—	—	245	0.45	7.5	—	—	—	—	—	—	—	—	—
	T5315	1.2	240	0.45	7.5	—	—	—	225	0.45	7.5	—	—	—	—	—	—	—	—	—
	T6310	1.2	155	0.45	7.5	110	0.41	7.5	125	0.45	7.5	—	—	—	—	—	—	—	—	—
	T7325	1.2	170	0.45	7.5	130	0.41	7.5	—	—	—	—	—	—	—	—	—	—	—	—
	T7335	1.2	160	0.45	7.5	120	0.41	7.5	—	—	—	—	—	—	—	—	—	—	—	—
	T8330	1.2	155	0.45	7.5	90	0.41	7.5	145	0.45	7.5	—	—	—	—	—	—	—	—	—
	T8430	1.2	150	0.45	7.5	80	0.41	7.5	125	0.45	7.5	—	—	—	—	—	—	—	—	—
	T9310	1.2	220	0.45	7.5	—	—	—	205	0.45	7.5	—	—	—	—	—	—	—	—	—
	T9315	1.2	210	0.45	7.5	—	—	—	195	0.45	7.5	—	—	—	—	—	—	—	—	—
	T9325	1.2	185	0.45	7.5	110	0.41	7.5	175	0.45	7.5	—	—	—	—	—	—	—	—	—
CNMG 190616E-RM	T5305	1.6	265	0.50	7.5	—	—	—	250	0.50	7.5	—	—	—	—	—	—	—	—	—
	T5315	1.6	240	0.50	7.5	—	—	—	225	0.50	7.5	—	—	—	—	—	—	—	—	—
	T6310	1.6	155	0.50	7.5	110	0.45	7.5	125	0.50	7.5	—	—	—	—	—	—	—	—	—
	T7325	1.6	175	0.50	7.5	135	0.45	7.5	—	—	—	—	—	—	—	—	—	—	—	—
	T7335	1.6	160	0.50	7.5	120	0.45	7.5	—	—	—	—	—	—	—	—	—	—	—	—
	T9310	1.6	225	0.50	7.5	—	—	—	210	0.50	7.5	—	—	—	—	—	—	—	—	—
	T9315	1.6	210	0.50	7.5	—	—	—	195	0.50	7.5	—	—	—	—	—	—	—	—	—
	T9325	1.6	190	0.50	7.5	110	0.45	7.5	180	0.50	7.5	—	—	—	—	—	—	—	—	—
CNMG 250924E-RM	T7325	2.4	105	0.80	12.0	80	0.72	12.0	—	—	—	—	—	—	—	—	—	—	—	—
	T7335	2.4	100	0.80	12.0	75	0.72	12.0	—	—	—	—	—	—	—	—	—	—	—	—
	T9226	2.4	90	0.80	12.0	50	0.72	12.0	85	0.80	12.0	—	—	—	—	—	—	—	—	—
	T9315	2.4	120	0.80	12.0	—	—	—	110	0.80	12.0	—	—	—	—	—	—	—	—	—
	T9325	2.4	105	0.80	12.0	60	0.72	12.0	95	0.80	12.0	—	—	—	—	—	—	—	—	—
	T9335	2.4	85	0.80	12.0	50	0.72	12.0	—	—	—	—	—	—	—	—	—	—	—	—



SF geometry with positive design for fine-finish machining of thin walls and continuous cuts.

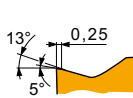
CNMG 120404E-SF	H07	0.4	—	—	—	90	0.14	1.0	145	0.15	1.0	470	0.18	1.0	45	0.12	0.8	—	—	—
	T6310	0.4	180	0.15	1.0	125	0.14	1.0	145	0.15	1.0	540	0.18	1.0	50	0.12	0.8	35	0.15	1.0
	T7325	0.4	205	0.17	1.0	155	0.15	1.0	—	—	—	—	—	—	65	0.15	0.8	—	—	—
	T7335	0.4	200	0.17	1.0	155	0.15	1.0	—	—	—	—	—	—	65	0.15	0.8	—	—	—
	T8315	0.4	195	0.15	1.0	115	0.14	1.0	185	0.15	1.0	585	0.18	1.0	45	0.12	0.8	35	0.15	1.0
	T8330	0.4	180	0.15	1.0	105	0.14	1.0	170	0.15	1.0	540	0.18	1.0	45	0.12	0.8	35	0.15	1.0
	T8430	0.4	220	0.15	1.0	120	0.14	1.0	180	0.15	1.0	600	0.18	1.0	45	0.12	0.8	35	0.15	1.0
	T9315	0.4	300	0.15	1.0	—	—	—	285	0.15	1.0	—	—	—	—	—	—	60	0.15	1.0
	T9325	0.4	255	0.17	1.0	150	0.15	1.0	240	0.17	1.0	—	—	—	55	0.15	0.8	—	—	—
CNMG 120408E-SF	H07	0.8	—	—	—	95	0.18	1.0	155	0.20	1.0	495	0.24	1.0	50	0.14	0.8	—	—	—
	T6310	0.8	200	0.20	1.0	140	0.18	1.0	160	0.20	1.0	600	0.24	1.0	60	0.14	0.8	40	0.15	1.0
	T7325	0.8	230	0.20	1.0	175	0.18	1.0	—	—	—	—	—	—	70	0.16	0.8	—	—	—
	T7335	0.8	220	0.20	1.0	170	0.18	1.0	—	—	—	—	—	—	70	0.16	0.8	—	—	—
	T8315	0.8	210	0.20	1.0	125	0.18	1.0	195	0.20	1.0	630	0.24	1.0	50	0.14	0.8	40	0.15	1.0
	T8330	0.8	200	0.20	1.0	120	0.18	1.0	190	0.20	1.0	600	0.24	1.0	50	0.14	0.8	40	0.15	1.0
	T8430	0.8	230	0.20	1.0	125	0.18	1.0	185	0.20	1.0	630	0.24	1.0	45	0.14	0.8	35	0.15	1.0
	T9315	0.8	315	0.20	1.0	—	—	—	295	0.20	1.0	—	—	—	—	—	—	60	0.15	1.0
	T9325	0.8	280	0.20	1.0	165	0.18	1.0	265	0.20	1.0	—	—	—	60	0.16	0.8	—	—	—
CNMG 120412E-SF	T6310	1.2	190	0.25	1.5	135	0.23	1.5	150	0.25	1.5	570	0.30	1.5	55	0.18	1.2	35	0.15	1.0
	T7325	1.2	220	0.25	1.5	170	0.23	1.5	—	—	—	—	—	—	70	0.18	1.2	—	—	—
	T8315	1.2	200	0.25	1.5	120	0.23	1.5	190	0.25	1.5	600	0.30	1.5	50	0.18	1.2	40	0.15	1.0
	T8430	1.2	210	0.25	1.5	115	0.23	1.5	175	0.25	1.5	585	0.30	1.5	45	0.18	1.2	35	0.15	1.0

CN	DN	KN	LN	RN	SN	TN	VN	WN
----	----	----	----	----	----	----	----	----



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 (mm)	P			M			K			N			S			H		
			vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
			[m/min]	[mm/rev]	[mm]	[m/min]	[mm/rev]	[mm]	[m/min]	[mm/rev]	[mm]	[m/min]	[mm/rev]	[mm]	[m/min]	[mm/rev]	[mm]	[m/min]	[mm/rev]	[mm]



SM geometry with positive design for medium machining, and continuous to interrupted cuts.

CNMG 120404E-SM	T6310	0.4	155	0.22	2.0	110	0.20	2.0	125	0.22	2.0	465	0.26	2.0	45	0.20	1.6	30	0.15	1.0
	T7325	0.4	175	0.22	2.0	135	0.20	2.0	—	—	—	—	—	—	55	0.20	1.6	—	—	—
	T7335	0.4	170	0.22	2.0	130	0.20	2.0	—	—	—	—	—	—	55	0.20	1.6	—	—	—
	T8330	0.4	155	0.22	2.0	90	0.20	2.0	145	0.22	2.0	465	0.26	2.0	35	0.20	1.6	30	0.15	1.0
	T8430	0.4	170	0.22	2.0	90	0.20	2.0	135	0.22	2.0	465	0.26	2.0	35	0.20	1.6	25	0.15	1.0
	T9315	0.4	245	0.20	2.0	—	—	—	230	0.20	2.0	—	—	—	—	—	—	45	0.15	1.0
	T9325	0.4	210	0.22	2.0	125	0.20	2.0	195	0.22	2.0	—	—	—	45	0.20	1.6	—	—	—
	T6310	0.8	175	0.25	2.0	125	0.23	2.0	140	0.25	2.0	525	0.30	2.0	50	0.20	1.6	35	0.15	1.0
CNMG 120408E-SM	T7325	0.8	200	0.25	2.0	155	0.23	2.0	—	—	—	—	—	—	65	0.20	1.6	—	—	—
	T7335	0.8	190	0.25	2.0	145	0.23	2.0	—	—	—	—	—	—	60	0.20	1.6	—	—	—
	T8330	0.8	175	0.25	2.0	105	0.23	2.0	165	0.25	2.0	525	0.30	2.0	40	0.20	1.6	35	0.15	1.0
	T8430	0.8	195	0.25	2.0	105	0.23	2.0	160	0.25	2.0	540	0.30	2.0	40	0.20	1.6	30	0.15	1.0
	T9315	0.8	265	0.25	2.0	—	—	—	250	0.25	2.0	—	—	—	—	—	—	50	0.15	1.0
	T9325	0.8	235	0.25	2.0	140	0.23	2.0	220	0.25	2.0	—	—	—	50	0.20	1.6	—	—	—
	T6310	1.2	175	0.30	2.0	125	0.27	2.0	140	0.30	2.0	525	0.36	2.0	50	0.24	1.6	35	0.15	1.0
	T7325	1.2	195	0.30	2.0	150	0.27	2.0	—	—	—	—	—	—	60	0.24	1.6	—	—	—
CNMG 120412E-SM	T7335	1.2	190	0.30	2.0	145	0.27	2.0	—	—	—	—	—	—	60	0.24	1.6	—	—	—
	T8330	1.2	175	0.30	2.0	105	0.27	2.0	165	0.30	2.0	525	0.36	2.0	40	0.24	1.6	35	0.15	1.0
	T8430	1.2	190	0.30	2.0	105	0.27	2.0	155	0.30	2.0	525	0.36	2.0	40	0.24	1.6	30	0.15	1.0
	T9315	1.2	260	0.30	2.0	—	—	—	245	0.30	2.0	—	—	—	—	—	—	50	0.15	1.0
	T9325	1.2	235	0.30	2.0	140	0.27	2.0	220	0.30	2.0	—	—	—	50	0.24	1.6	—	—	—
	T7325	0.8	185	0.26	3.0	140	0.23	3.0	—	—	—	—	—	—	60	0.23	2.4	—	—	—
	T7335	0.8	180	0.26	3.0	140	0.23	3.0	—	—	—	—	—	—	55	0.23	2.4	—	—	—
	T8330	0.8	165	0.26	3.0	95	0.23	3.0	155	0.26	3.0	495	0.31	3.0	40	0.23	2.4	30	0.15	1.0
CNMG 160608E-SM	T8430	0.8	180	0.26	3.0	95	0.23	3.0	145	0.26	3.0	495	0.31	3.0	35	0.23	2.4	30	0.15	1.0
	T9325	0.8	225	0.26	3.0	135	0.23	3.0	210	0.26	3.0	—	—	—	50	0.23	2.4	—	—	—
	T6310	1.2	170	0.30	3.0	120	0.27	3.0	135	0.30	3.0	510	0.36	3.0	50	0.27	2.4	30	0.15	1.0
	T7325	1.2	190	0.30	3.0	145	0.27	3.0	—	—	—	—	—	—	60	0.27	2.4	—	—	—
	T7335	1.2	180	0.30	3.0	140	0.27	3.0	—	—	—	—	—	—	55	0.27	2.4	—	—	—
	T9315	1.2	250	0.30	3.0	—	—	—	235	0.30	3.0	—	—	—	—	—	—	50	0.15	1.0
	T9325	1.2	225	0.30	3.0	135	0.27	3.0	210	0.30	3.0	—	—	—	50	0.27	2.4	—	—	—
	T6310	1.2	165	0.30	4.0	115	0.27	4.0	130	0.30	4.0	495	0.36	4.0	45	0.27	3.2	30	0.15	1.0
CNMG 190612E-SM	T7325	1.2	185	0.30	4.0	140	0.27	4.0	—	—	—	—	—	—	60	0.27	3.2	—	—	—
	T7335	1.2	175	0.30	4.0	135	0.27	4.0	—	—	—	—	—	—	55	0.27	3.2	—	—	—
	T9315	1.2	245	0.30	4.0	—	—	—	230	0.30	4.0	—	—	—	—	—	—	45	0.15	1.0
	T9325	1.2	220	0.30	4.0	130	0.27	4.0	205	0.30	4.0	—	—	—	45	0.27	3.2	—	—	—
	T7325	0.8	185	0.26	3.0	140	0.23	3.0	—	—	—	—	—	—	60	0.23	2.4	—	—	—
	T7335	0.8	180	0.26	3.0	140	0.23	3.0	—	—	—	—	—	—	55	0.23	2.4	—	—	—
	T8330	0.8	165	0.26	3.0	95	0.23	3.0	155	0.26	3.0	495	0.31	3.0	40	0.23	2.4	30	0.15	1.0
	T8430	0.8	180	0.26	3.0	95	0.23	3.0	145	0.26	3.0	495	0.31	3.0	35	0.23	2.4	30	0.15	1.0



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

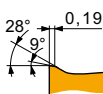
Product		RE (mm)	P			M			K			N			S			H		
			vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
			[m/min]	[mm/rev]	[mm]	[m/min]	[mm/rev]	[mm]	[m/min]	[mm/rev]	[mm]	[m/min]	[mm/rev]	[mm]	[m/min]	[mm/rev]	[mm]	[m/min]	[mm/rev]	[mm]
					EL-SI geometry with positive left-handed design for fine-finish to semi-rough machining, and continuous cuts.															
CNMG 120404EL-SI	T7325	0.4	220	0.20	1.7	170	0.18	1.7	—	—	—	—	—	—	70	0.18	1.4	—	—	—
	T7335	0.4	215	0.20	1.7	165	0.18	1.7	—	—	—	—	—	—	65	0.18	1.4	—	—	—
	T8330	0.4	195	0.20	1.7	115	0.18	1.7	—	—	—	585	0.24	1.7	45	0.18	1.4	—	—	—
	T8430	0.4	225	0.20	1.7	120	0.18	1.7	—	—	—	615	0.24	1.7	45	0.18	1.4	—	—	—
	T9325	0.4	270	0.20	1.7	160	0.18	1.7	—	—	—	—	—	—	60	0.18	1.4	—	—	—
CNMG 120408EL-SI	T7325	0.8	215	0.35	1.7	165	0.32	1.7	—	—	—	—	—	—	65	0.25	1.4	—	—	—
	T7335	0.8	205	0.35	1.7	155	0.32	1.7	—	—	—	—	—	—	65	0.25	1.4	—	—	—
	T8315	0.8	205	0.35	1.7	120	0.32	1.7	—	—	—	615	0.42	1.7	50	0.25	1.4	—	—	—
	T8330	0.8	195	0.35	1.7	115	0.32	1.7	—	—	—	585	0.42	1.7	45	0.25	1.4	—	—	—
	T8430	0.8	210	0.35	1.7	115	0.32	1.7	—	—	—	585	0.42	1.7	45	0.25	1.4	—	—	—
	T9325	0.8	255	0.35	1.7	150	0.32	1.7	—	—	—	—	—	—	55	0.25	1.4	—	—	—
CNMG 120412EL-SI	T8430	1.2	225	0.35	1.7	120	0.32	1.7	—	—	—	615	0.42	1.7	45	0.25	1.4	—	—	—
					W-F wiper geometry for fine to finish machining with increased feed rates and improved surface finish.															
CNMG 120408W-F	T9315	0.8	215	0.45	0.8	—	—	—	200	0.45	0.8	—	—	—	—	—	—	—	—	—
	T9325	0.8	190	0.45	0.8	—	—	—	180	0.45	0.8	—	—	—	—	—	—	—	—	—
					W-M wiper geometry for semi-rough to rough machining with increased feed rates and improved surface finish.															
CNMG 120408W-M	T5315	0.8	230	0.45	1.5	—	—	—	215	0.45	1.5	—	—	—	—	—	—	—	—	—
	T9315	0.8	200	0.45	1.5	—	—	—	190	0.45	1.5	—	—	—	—	—	—	—	—	—
	T9325	0.8	185	0.45	1.5	—	—	—	175	0.45	1.5	—	—	—	—	—	—	—	—	—
CNMG 120412W-M	T5315	1.2	230	0.55	1.5	—	—	—	215	0.55	1.5	—	—	—	—	—	—	—	—	—
	T9315	1.2	200	0.55	1.5	—	—	—	190	0.55	1.5	—	—	—	—	—	—	—	—	—
	T9325	1.2	180	0.55	1.5	—	—	—	170	0.55	1.5	—	—	—	—	—	—	—	—	—
					W-MR wiper geometry for finish to rough machining with increased feed rates and improved surface finish.															
CNMG 120404W-MR	T9315	0.4	200	0.30	1.5	—	—	—	190	0.30	1.5	—	—	—	—	—	—	—	—	—
	T9325	0.4	180	0.30	1.5	105	0.27	1.5	170	0.30	1.5	—	—	—	—	—	—	—	—	—
CNMG 120408W-MR	T5315	0.8	230	0.45	1.5	—	—	—	215	0.45	1.5	—	—	—	—	—	—	—	—	—
	T9310	0.8	215	0.45	1.5	—	—	—	200	0.45	1.5	—	—	—	—	—	—	—	—	—
	T9315	0.8	200	0.45	1.5	—	—	—	190	0.45	1.5	—	—	—	—	—	—	—	—	—
	T9325	0.8	185	0.45	1.5	110	0.41	1.5	175	0.45	1.5	—	—	—	—	—	—	—	—	—
CNMG 120412W-MR	T5315	1.2	230	0.55	1.5	—	—	—	215	0.55	1.5	—	—	—	—	—	—	—	—	—
	T9310	1.2	210	0.55	1.5	—	—	—	195	0.55	1.5	—	—	—	—	—	—	—	—	—
	T9315	1.2	200	0.55	1.5	—	—	—	190	0.55	1.5	—	—	—	—	—	—	—	—	—
	T9325	1.2	180	0.55	1.5	105	0.50	1.5	170	0.55	1.5	—	—	—	—	—	—	—	—	—
						W-NM wiper geometry for finish to rough machining with increased feed rates and improved surface finish.														
CNMG 120404W-NM	T7325	0.4	195	0.20	2.1	150	0.18	2.1	—	—	—	—	—	—	60	0.16	1.7	—	—	—
	T7335	0.4	190	0.20	2.1	145	0.18	2.1	—	—	—	—	—	—	60	0.16	1.7	—	—	—
	T9315	0.4	270	0.20	2.1	—	—	—	255	0.20	2.1	—	—	—	—	—	—	—	—	—
	T9325	0.4	240	0.20	2.1	140	0.18	2.1	225	0.20	2.1	—	—	—	50	0.16	1.7	—	—	—

CN	DN	KN	LN	RN	SN	TN	VN	WN
----	----	----	----	----	----	----	----	----



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 (mm)	P			M			K			N			S			H		
			vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
			[m/min]	[mm/rev]	[mm]	[m/min]	[mm/rev]	[mm]	[m/min]	[mm/rev]	[mm]	[m/min]	[mm/rev]	[mm]	[m/min]	[mm/rev]	[mm]	[m/min]	[mm/rev]	[mm]



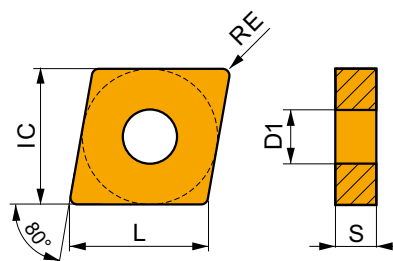
W-NM wiper geometry for finish to rough machining with increased feed rates and improved surface finish.

CNMG 120408W-NM	T7325	0.8	215	0.25	2.1	165	0.23	2.1	—	—	—	—	—	—	65	0.20	1.7	—	—	—
	T7335	0.8	210	0.25	2.1	160	0.23	2.1	—	—	—	—	—	—	65	0.20	1.7	—	—	—
	T9315	0.8	290	0.25	2.1	—	—	—	275	0.25	2.1	—	—	—	—	—	—	—	—	—
	T9325	0.8	260	0.25	2.1	155	0.23	2.1	245	0.25	2.1	—	—	—	55	0.20	1.7	—	—	—
CNMG 120412W-NM	T7325	1.2	215	0.30	2.1	165	0.27	2.1	—	—	—	—	—	—	65	0.24	1.7	—	—	—
	T7335	1.2	210	0.30	2.1	160	0.27	2.1	—	—	—	—	—	—	65	0.24	1.7	—	—	—
	T9315	1.2	285	0.30	2.1	—	—	—	270	0.30	2.1	—	—	—	—	—	—	—	—	—
	T9325	1.2	255	0.30	2.1	150	0.27	2.1	240	0.30	2.1	—	—	—	55	0.24	1.7	—	—	—

CNMM

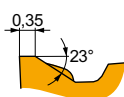


	IC	D1	L	S
	[mm]	[mm]	[mm]	[mm]
1204	12.700	5.16	12.90	4.76
1606	15.875	6.35	16.10	6.35
1906	19.050	7.94	19.30	6.35
2509	25.400	9.12	25.80	9.53



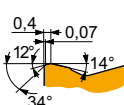
Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

Product		RE (mm)	P			M			K			N			S			H		
			vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
			[m/min]	[mm/rev]	[mm]	[m/min]	[mm/rev]	[mm]	[m/min]	[mm/rev]	[mm]	[m/min]	[mm/rev]	[mm]	[m/min]	[mm/rev]	[mm]	[m/min]	[mm/rev]	[mm]



DR geometry for semi-rough to rough machining, and continuous to interrupted cuts.

CNMM 160612E-DR	T9315	1.2	225	0.45	6.0	—	—	—	210	0.45	6.0	—	—	—	—	—	—	—	—	—
	T9325	1.2	200	0.45	6.0	120	0.41	6.0	190	0.45	6.0	—	—	—	—	—	—	—	—	—
	T9335	1.2	170	0.45	6.0	100	0.41	6.0	—	—	—	—	—	—	—	—	—	—	—	—
CNMM 190608E-DR	T9315	0.8	215	0.40	8.0	—	—	—	200	0.40	8.0	—	—	—	—	—	—	—	—	—
	T9325	0.8	190	0.40	8.0	110	0.36	8.0	180	0.40	8.0	—	—	—	—	—	—	—	—	—
CNMM 190612E-DR	T9315	1.2	220	0.45	8.0	—	—	—	205	0.45	8.0	—	—	—	—	—	—	—	—	—
	T9325	1.2	195	0.45	8.0	115	0.41	8.0	185	0.45	8.0	—	—	—	—	—	—	—	—	—
	T9335	1.2	170	0.45	8.0	100	0.41	8.0	—	—	—	—	—	—	—	—	—	—	—	—
CNMM 190616E-DR	T9325	1.6	195	0.50	9.0	115	0.45	9.0	185	0.50	9.0	—	—	—	—	—	—	—	—	—
	T9335	1.6	170	0.50	9.0	100	0.45	9.0	—	—	—	—	—	—	—	—	—	—	—	—



HR geometry for rough to heavy-rough machining, and continuous to interrupted cuts.

CNMM 190616E-HR	6640	1.6	75	0.60	10.0	45	0.54	10.0	70	0.60	10.0	—	—	—	—	—	—	—	—	—
	T8345	1.6	55	0.60	10.0	30	0.54	10.0	50	0.60	10.0	—	—	—	—	—	—	—	—	—
	T9325	1.6	105	0.60	10.0	60	0.54	10.0	95	0.60	10.0	—	—	—	—	—	—	—	—	—
	T9335	1.6	80	0.60	10.0	45	0.54	10.0	—	—	—	—	—	—	—	—	—	—	—	—
CNMM 190624E-HR	T8345	2.4	60	0.65	10.0	35	0.59	10.0	55	0.65	10.0	—	—	—	—	—	—	—	—	—
	T9315	2.4	115	0.65	10.0	—	—	—	105	0.65	10.0	—	—	—	—	—	—	—	—	—
	T9325	2.4	100	0.65	10.0	60	0.59	10.0	95	0.65	10.0	—	—	—	—	—	—	—	—	—
	T9335	2.4	85	0.65	10.0	50	0.59	10.0	—	—	—	—	—	—	—	—	—	—	—	—



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

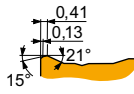
Product		RE [mm]	P			M			K			N			S			H			
			vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	
			[m/min]	[mm/rev]	[mm]	[m/min]	[mm/rev]	[mm]	[m/min]	[mm/rev]	[mm]	[m/min]	[mm/rev]	[mm]	[m/min]	[mm/rev]	[mm]	[m/min]	[mm/rev]	[mm]	
HR geometry for rough to heavy-rough machining, and continuous to interrupted cuts.																					
CNMM 250924E-HR	6640	2.4	■	75	0.65	14.0	■	45	0.59	14.0	■	70	0.65	14.0	—	—	—	—	—	—	
	T8345	2.4	■	55	0.65	14.0	■	30	0.59	14.0	■	50	0.65	14.0	—	—	—	—	—	—	
	T9315	2.4	■	110	0.65	14.0	—	—	—	■	100	0.65	14.0	—	—	—	—	—	—	—	
	T9325	2.4	■	100	0.65	14.0	■	60	0.59	14.0	■	95	0.65	14.0	—	—	—	—	—	—	
	T9335	2.4	■	80	0.65	14.0	■	45	0.59	14.0	—	—	—	—	—	—	—	—	—	—	
HR2 geometry for rough to heavy-rough machining, and continuous to interrupted cuts.																					
CNMM 190616-HR2	T9226	1.6	■	85	0.65	10.0	■	50	0.59	10.0	■	80	0.65	10.0	—	—	—	—	—	—	
	T9315	1.6	■	110	0.65	10.0	—	—	—	■	100	0.65	10.0	—	—	—	—	—	—	—	
	T9335	1.6	■	80	0.65	10.0	■	45	0.59	10.0	—	—	—	—	—	—	—	—	—	—	
CNMM 190624-HR2	T9226	2.4	■	80	0.85	10.0	■	45	0.77	10.0	■	75	0.85	10.0	—	—	—	—	—	—	
	T9315	2.4	■	100	0.85	10.0	—	—	—	■	95	0.85	10.0	—	—	—	—	—	—	—	
	T9335	2.4	■	75	0.85	10.0	■	45	0.77	10.0	—	—	—	—	—	—	—	—	—	—	
CNMM 250924-HR2	T9315	2.4	■	100	0.85	12.0	—	—	—	■	95	0.85	12.0	—	—	—	—	—	—	—	
	T9335	2.4	■	75	0.85	12.0	■	45	0.77	12.0	—	—	—	—	—	—	—	—	—	—	
NR geometry for semi-rough to rough machining, and continuous to interrupted cuts.																					
CNMM 120408E-NR	6640	0.8	■	155	0.40	3.0	■	90	0.36	3.0	■	145	0.40	3.0	—	—	—	—	—	—	
	T7325	0.8	■	175	0.40	3.0	■	135	0.36	3.0	—	—	—	■	55	0.28	2.4	—	—	—	
	T7335	0.8	■	165	0.40	3.0	■	125	0.36	3.0	—	—	—	■	50	0.28	2.4	—	—	—	
	T8330	0.8	■	155	0.40	3.0	■	90	0.36	3.0	■	145	0.40	3.0	—	—	—	■	35	0.28	2.4
	T8430	0.8	■	165	0.40	3.0	■	90	0.36	3.0	■	135	0.40	3.0	—	—	—	■	35	0.28	2.4
	T9315	0.8	■	215	0.40	3.0	—	—	—	■	200	0.40	3.0	—	—	—	—	—	—	—	
	T9325	0.8	■	195	0.40	3.0	■	115	0.36	3.0	■	185	0.40	3.0	—	—	—	■	40	0.28	2.4
	T9335	0.8	■	175	0.40	3.0	■	135	0.36	3.0	—	—	—	■	60	0.28	2.4	—	—	—	
CNMM 120412E-NR	T7325	1.2	■	185	0.40	3.0	■	140	0.36	3.0	—	—	—	■	60	0.28	2.4	—	—	—	
	T7335	1.2	■	175	0.40	3.0	■	135	0.36	3.0	—	—	—	■	55	0.28	2.4	—	—	—	
	T8330	1.2	■	165	0.40	3.0	■	95	0.36	3.0	■	155	0.40	3.0	—	—	—	■	40	0.28	2.4
	T8430	1.2	■	170	0.40	3.0	■	90	0.36	3.0	■	135	0.40	3.0	—	—	—	■	35	0.28	2.4
	T9325	1.2	■	205	0.40	3.0	■	120	0.36	3.0	■	190	0.40	3.0	—	—	—	■	45	0.28	2.4
NR2 geometry for semi-rough to rough machining, and continuous to interrupted cuts.																					
CNMM 120408E-NR2	T7325	0.8	■	165	0.40	5.0	■	125	0.36	5.0	—	—	—	—	■	50	0.28	4.0	—	—	—
	T7335	0.8	■	155	0.40	5.0	■	120	0.36	5.0	—	—	—	—	■	50	0.28	4.0	—	—	—
	T8330	0.8	■	150	0.40	5.0	■	90	0.36	5.0	■	140	0.40	5.0	—	—	—	■	35	0.28	4.0
	T8430	0.8	■	150	0.40	5.0	■	80	0.36	5.0	■	125	0.40	5.0	—	—	—	■	30	0.28	4.0
	T9315	0.8	■	205	0.40	5.0	—	—	—	■	190	0.40	5.0	—	—	—	—	—	—	—	—
	T9325	0.8	■	185	0.40	5.0	■	110	0.36	5.0	■	175	0.40	5.0	—	—	—	■	40	0.28	4.0
CNMM 120412E-NR2	T7335	1.2	■	155	0.45	5.0	■	120	0.41	5.0	—	—	—	—	■	50	0.32	4.0	—	—	—
	T8330	1.2	■	150	0.45	5.0	■	90	0.41	5.0	■	140	0.45	5.0	—	—	—	■	35	0.32	4.0
	T8430	1.2	■	150	0.45	5.0	■	80	0.41	5.0	■	125	0.45	5.0	—	—	—	■	30	0.32	4.0
	T9315	1.2	■	205	0.45	5.0	—	—	—	■	190	0.45	5.0	—	—	—	—	—	—	—	—
	T9325	1.2	■	185	0.45	5.0	■	110	0.41	5.0	■	175	0.45	5.0	—	—	—	■	40	0.32	4.0
CNMM 160608E-NR2	T8330	0.8	■	145	0.40	6.0	■	85	0.36	6.0	■	135	0.40	6.0	—	—	—	■	35	0.32	4.8
	T8430	0.8	■	150	0.40	6.0	■	80	0.36	6.0	■	125	0.40	6.0	—	—	—	■	30	0.32	4.8
	T9325	0.8	■	180	0.40	6.0	■	105	0.36	6.0	■	170	0.40	6.0	—	—	—	■	40	0.32	4.8

CN	DN	KN	LN	RN	SN	TN	VN	WN
----	----	----	----	----	----	----	----	----



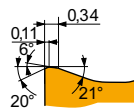
Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

Product		RE (mm)	P			M			K			N			S			H		
			vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
			[m/min]	[mm/rev]	[mm]	[m/min]	[mm/rev]	[mm]	[m/min]	[mm/rev]	[mm]	[m/min]	[mm/rev]	[mm]	[m/min]	[mm/rev]	[mm]	[m/min]	[mm/rev]	[mm]



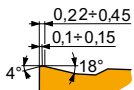
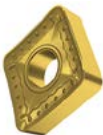
NR2 geometry for semi-rough to rough machining, and continuous to interrupted cuts.

CNMM 160612E-NR2	T7325	1.2	165	0.45	6.0	125	0.41	6.0	—	—	—	—	—	—	50	0.36	4.8	—	—	—
	T7335	1.2	155	0.45	6.0	120	0.41	6.0	—	—	—	—	—	—	50	0.36	4.8	—	—	—
	T8330	1.2	145	0.45	6.0	85	0.41	6.0	135	0.45	6.0	—	—	—	35	0.36	4.8	—	—	—
	T8430	1.2	150	0.45	6.0	80	0.41	6.0	125	0.45	6.0	—	—	—	30	0.36	4.8	—	—	—
	T9315	1.2	205	0.45	6.0	—	—	—	190	0.45	6.0	—	—	—	—	—	—	—	—	—
	T9325	1.2	185	0.45	6.0	110	0.41	6.0	175	0.45	6.0	—	—	—	40	0.36	4.8	—	—	—
CNMM 160616E-NR2	T7325	1.6	165	0.50	6.0	125	0.45	6.0	—	—	—	—	—	—	50	0.40	4.8	—	—	—
	T7335	1.6	160	0.50	6.0	120	0.45	6.0	—	—	—	—	—	—	50	0.40	4.8	—	—	—
	T9325	1.6	180	0.50	6.0	105	0.45	6.0	170	0.50	6.0	—	—	—	40	0.40	4.8	—	—	—
CNMM 190612E-NR2	T7325	1.2	155	0.45	9.0	120	0.41	9.0	—	—	—	—	—	—	50	0.36	7.2	—	—	—
	T7335	1.2	145	0.45	9.0	110	0.41	9.0	—	—	—	—	—	—	45	0.36	7.2	—	—	—
	T8330	1.2	140	0.45	9.0	80	0.41	9.0	130	0.45	9.0	—	—	—	35	0.36	7.2	—	—	—
	T8430	1.2	140	0.45	9.0	75	0.41	9.0	115	0.45	9.0	—	—	—	30	0.36	7.2	—	—	—
CNMM 190616E-NR2	T9325	1.2	175	0.45	9.0	105	0.41	9.0	165	0.45	9.0	—	—	—	35	0.36	7.2	—	—	—
	T7325	1.6	160	0.50	9.0	120	0.45	9.0	—	—	—	—	—	—	50	0.40	7.2	—	—	—
	T7335	1.6	150	0.50	9.0	115	0.45	9.0	—	—	—	—	—	—	45	0.40	7.2	—	—	—
	T8330	1.6	140	0.50	9.0	80	0.45	9.0	130	0.50	9.0	—	—	—	35	0.40	7.2	—	—	—
	T8430	1.6	140	0.50	9.0	75	0.45	9.0	115	0.50	9.0	—	—	—	30	0.40	7.2	—	—	—
	T9315	1.6	195	0.50	9.0	—	—	—	185	0.50	9.0	—	—	—	—	—	—	—	—	—
CNMM 190624E-NR2	T9325	1.6	175	0.50	9.0	105	0.45	9.0	165	0.50	9.0	—	—	—	35	0.40	7.2	—	—	—
	T7335	2.4	130	0.80	9.0	100	0.72	9.0	—	—	—	—	—	—	40	0.56	7.2	—	—	—
	T9325	2.4	150	0.80	9.0	90	0.72	9.0	140	0.80	9.0	—	—	—	30	0.56	7.2	—	—	—
CNMM 250924E-NR2	T7325	2.4	100	0.80	12.0	75	0.72	12.0	—	—	—	—	—	—	30	0.56	9.6	—	—	—
	T7335	2.4	95	0.80	12.0	70	0.72	12.0	—	—	—	—	—	—	30	0.56	9.6	—	—	—
	T8430	2.4	80	0.80	12.0	45	0.72	12.0	65	0.80	12.0	—	—	—	15	0.56	9.6	—	—	—
	T9315	2.4	110	0.80	12.0	—	—	—	100	0.80	12.0	—	—	—	—	—	—	—	—	—
	T9325	2.4	100	0.80	12.0	60	0.72	12.0	95	0.80	12.0	—	—	—	20	0.56	9.6	—	—	—



NRM geometry with positive design for semi-rough to rough machining, and continuous to interrupted cuts.

CNMM 250924-NRM	T7325	2.4	95	0.70	10.0	70	0.63	10.0	—	—	—	—	—	—	30	0.49	8.0	—	—	—
	T7335	2.4	90	0.70	10.0	70	0.63	10.0	—	—	—	—	—	—	25	0.49	8.0	—	—	—
	T9315	2.4	115	0.70	10.0	—	—	—	105	0.70	10.0	—	—	—	—	—	—	—	—	—



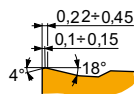
OR geometry for semi-rough to rough machining, and continuous to interrupted cuts.

CNMM 120408E-OR	T8330	0.8	150	0.40	5.0	90	0.36	5.0	140	0.40	5.0	—	—	—	35	0.28	4.0	—	—	—
	T8430	0.8	150	0.40	5.0	80	0.36	5.0	125	0.40	5.0	—	—	—	30	0.28	4.0	—	—	—
	T9315	0.8	205	0.40	5.0	—	—	—	190	0.40	5.0	—	—	—	—	—	—	—	—	—
	T9325	0.8	185	0.40	5.0	110	0.36	5.0	175	0.40	5.0	—	—	—	40	0.28	4.0	—	—	—
CNMM 120412E-OR	T9335	0.8	160	0.40	5.0	95	0.36	5.0	—	—	—	—	—	—	35	0.28	4.0	—	—	—
	T9315	1.2	205	0.45	5.0	—	—	—	190	0.45	5.0	—	—	—	—	—	—	—	—	—
	T9325	1.2	185	0.45	5.0	110	0.41	5.0	175	0.45	5.0	—	—	—	40	0.36	4.0	—	—	—
CNMM 120416E-OR	T9335	1.2	165	0.45	5.0	95	0.41	5.0	—	—	—	—	—	—	35	0.36	4.0	—	—	—
	T9325	1.6	190	0.50	5.0	110	0.45	5.0	180	0.50	5.0	—	—	—	40	0.40	4.0	—	—	—
CNMM 160608E-OR	T9335	1.6	165	0.50	5.0	95	0.45	5.0	—	—	—	—	—	—	35	0.40	4.0	—	—	—
	T9315	0.8	205	0.40	6.0	—	—	—	190	0.40	6.0	—	—	—	—	—	—	—	—	—
	T9325	0.8	180	0.40	6.0	105	0.36	6.0	170	0.40	6.0	—	—	—	40	0.32	4.8	—	—	—
CNMM 160612E-OR	T9335	0.8	160	0.40	6.0	95	0.36	6.0	—	—	—	—	—	—	35	0.32	4.8	—	—	—
	T8430	1.2	150	0.45	6.0	80	0.41	6.0	125	0.45	6.0	—	—	—	30	0.36	4.8	—	—	—
	T9315	1.2	205	0.45	6.0	—	—	—	190	0.45	6.0	—	—	—	—	—	—	—	—	—
	T9325	1.2	185	0.45	6.0	110	0.41	6.0	175	0.45	6.0	—	—	—	40	0.36	4.8	—	—	—



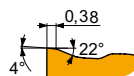
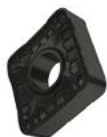
Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

Product		RE (mm)	P			M			K			N			S			H		
			vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
			[m/min]	[mm/rev]	[mm]	[m/min]	[mm/rev]	[mm]	[m/min]	[mm/rev]	[mm]	[m/min]	[mm/rev]	[mm]	[m/min]	[mm/rev]	[mm]	[m/min]	[mm/rev]	[mm]



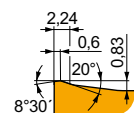
OR geometry for semi-rough to rough machining, and continuous to interrupted cuts.

CNMM 160616E-OR	T9315	1.6	■	205	0.50	6.0	■	—	—	—	■	190	0.50	6.0	■	—	—	—	■	—	—	—
	T9325	1.6	■	180	0.50	6.0	■	105	0.45	6.0	■	170	0.50	6.0	■	—	—	—	■	40	0.40	4.8
CNMM 190612E-OR	T8330	1.2	■	140	0.45	9.0	■	80	0.41	9.0	■	130	0.45	9.0	■	—	—	—	■	35	0.36	7.2
	T8430	1.2	■	140	0.45	9.0	■	75	0.41	9.0	■	115	0.45	9.0	■	—	—	—	■	30	0.36	7.2
	T9315	1.2	■	195	0.45	9.0	■	—	—	—	■	185	0.45	9.0	■	—	—	—	■	—	—	—
	T9325	1.2	■	175	0.45	9.0	■	105	0.41	9.0	■	165	0.45	9.0	■	—	—	—	■	35	0.36	7.2
CNMM 190616E-OR	T9335	1.2	■	150	0.45	9.0	■	90	0.41	9.0	■	—	—	—	■	—	—	—	■	30	0.36	7.2
	T8330	1.6	■	140	0.50	9.0	■	80	0.45	9.0	■	130	0.50	9.0	■	—	—	—	■	35	0.40	7.2
	T8345	1.6	■	120	0.50	9.0	■	70	0.45	9.0	■	110	0.50	9.0	■	—	—	—	■	30	0.40	7.2
	T8430	1.6	■	140	0.50	9.0	■	75	0.45	9.0	■	115	0.50	9.0	■	—	—	—	■	30	0.40	7.2
	T9315	1.6	■	195	0.50	9.0	■	—	—	—	■	185	0.50	9.0	■	—	—	—	■	—	—	—
	T9325	1.6	■	175	0.50	9.0	■	105	0.45	9.0	■	165	0.50	9.0	■	—	—	—	■	35	0.40	7.2
CNMM 190624E-OR	T9335	1.6	■	155	0.50	9.0	■	90	0.45	9.0	■	—	—	—	■	—	—	—	■	30	0.40	7.2
	T9315	2.4	■	165	0.80	9.0	■	—	—	—	■	155	0.80	9.0	■	—	—	—	■	—	—	—
	T9325	2.4	■	150	0.80	9.0	■	90	0.72	9.0	■	140	0.80	9.0	■	—	—	—	■	30	0.56	7.2
CNMM 250924E-OR	T8330	2.4	■	75	1.00	12.0	■	45	0.90	12.0	■	70	1.00	12.0	■	—	—	—	■	15	0.70	9.6
	T8430	2.4	■	75	1.00	12.0	■	40	0.90	12.0	■	60	1.00	12.0	■	—	—	—	■	15	0.70	9.6
	T9315	2.4	■	100	1.00	12.0	■	—	—	—	■	95	1.00	12.0	■	—	—	—	■	—	—	—
	T9325	2.4	■	95	1.00	12.0	■	55	0.90	12.0	■	90	1.00	12.0	■	—	—	—	■	20	0.70	9.6
	T9335	2.4	■	75	1.00	12.0	■	45	0.90	12.0	■	—	—	—	■	—	—	—	■	15	0.70	9.6



OR1 geometry for semi-rough to heavy-rough machining, and continuous to interrupted cuts.

CNMM 190616E-OR1	T9325	1.6	■	175	0.50	9.0	■	105	0.45	9.0	■	165	0.50	9.0	—	—	—	■	35	0.35	7.2
	T9335	1.6	■	155	0.50	9.0	■	90	0.45	9.0	■	150	0.50	9.0	—	—	—	■	30	0.35	7.2



Geometry 923 for semi-rough to heavy-rough machining, and continuous to heavy interrupted cuts.

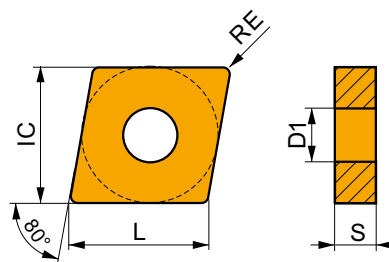
CNMM 250924S-923	T8330	2.4	■	75	0.85	12.0	■	45	0.77	12.0	■	70	0.85	12.0	—	—	—	■	15	0.60	9.6
	T8430	2.4	■	75	0.85	12.0	■	40	0.77	12.0	■	60	0.85	12.0	—	—	—	■	15	0.60	9.6
	T9335	2.4	■	75	0.85	12.0	■	45	0.77	12.0	■	—	—	—	—	—	—	■	15	0.60	9.6



CNGA CER

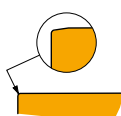
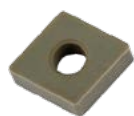


	IC	D1	L	S
	[mm]	[mm]	[mm]	[mm]
1204	12.700	5.16	12.90	4.76



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		
		vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
	[mm]	[m/min]	[mm/rev]	[mm]	[m/min]	[mm/rev]	[mm]	[m/min]	[mm/rev]	[mm]	[m/min]	[mm/rev]	[mm]	[m/min]	[mm/rev]	[mm]	[m/min]	[mm/rev]	[mm]



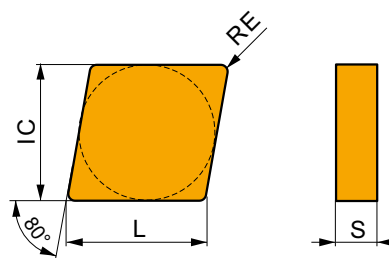
For machining with high speeds and continuous cuts.

CNGA 120404 T02020	TC100	0.4	—	—	—	—	—	—	590	0.10	2.0	—	—	—	—	—	—	—	—
CNGA 120408 T01020	TC100	0.8	—	—	—	—	—	—	550	0.20	2.0	—	—	—	—	—	—	—	—
CNGA 120412 T01020	TC100	1.2	—	—	—	—	—	—	540	0.25	2.0	—	—	—	—	—	—	—	—

CNGN CER

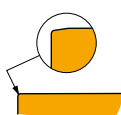


	IC	L	S
	[mm]	[mm]	[mm]
1204	12.700	12.90	4.76
1207	12.700	12.90	7.94



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		
		vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
	[mm]	[m/min]	[mm/rev]	[mm]	[m/min]	[mm/rev]	[mm]	[m/min]	[mm/rev]	[mm]	[m/min]	[mm/rev]	[mm]	[m/min]	[mm/rev]	[mm]	[m/min]	[mm/rev]	[mm]



For machining with high speeds and continuous cuts.

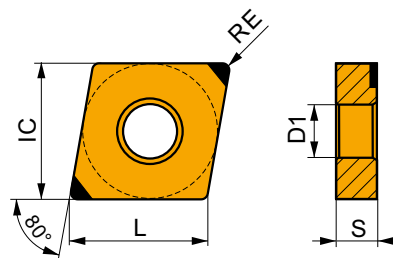
CNGN 120408 T01020	TC100	0.8	—	—	—	—	—	—	550	0.20	2.0	—	—	—	—	—	—	—	—
CNGN 120708 T01020	TC100	0.8	—	—	—	—	—	—	550	0.20	2.0	—	—	—	—	—	—	—	—
CNGN 120712 T01020	TC100	1.2	—	—	—	—	—	—	540	0.25	2.0	—	—	—	—	—	—	—	—



CNGA CBN

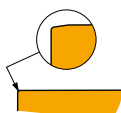


	IC	D1	L	S
	[mm]	[mm]	[mm]	[mm]
1204	12.700	5.16	12.90	4.76



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		
			vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
		[mm]	[m/min]	[mm/rev]	[mm]	[m/min]	[mm/rev]	[mm]	[m/min]	[mm/rev]	[mm]	[m/min]	[mm/rev]	[mm]	[m/min]	[mm/rev]	[mm]	[m/min]	[mm/rev]	[mm]



For finish machining and continuous cuts.

CNGA 120404S01020B	TB310	0.4	—	—	—	—	—	—	510	0.10	0.4	—	—	—	135	0.07	0.3	105	0.15	1.0
CNGA 120408S01020B	TB310	0.8	—	—	—	—	—	—	530	0.15	0.6	—	—	—	140	0.11	0.5	110	0.15	1.0