



DC

07 / 11 / 15

CARBIDE INSERTS

DCGT	DCMT	DCMW
86	87	92

CBN & PCD INSERTS

DCGW CBN	DCMW PCD
92	93

MATCH THE RIGHT SIZE (example)

Insert	Tool Holder
DCMT 070204E-UR	SDJCR 0808 D 07

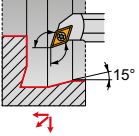
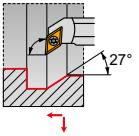
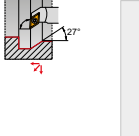
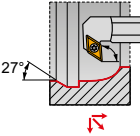
ISO TURNING – EXTERNAL

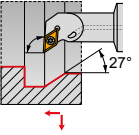
SDJC(RL) EXT	SDNCN EXT	C.-SDNCN EXT	C.-SDJC(RL) EXT
93° 08x08 25x25 94	62°30' 08x08 25x25 95	62°30' C4 C5 97	93° C3 C5 96
DC.. 07 11 15 86 – 93	DC.. 7 11 86 – 93	DC.. 11 86 – 93	DC.. 11 86 – 93

DC

07 / 11 / 15

ISO TURNING – INTERNAL

SDQC(RL) INT		SDUC(RL) INT		SDUC(RL)-E INT		SDZC(RL) INT	
107°30'		93°		93°		93°	
							
							
$\frac{13}{40}$		$\frac{13}{40}$		$\frac{13}{40}$		$\frac{27}{65}$	
							
98		99		100		101	
86 – 93		86 – 93		86 – 93		86 – 93	

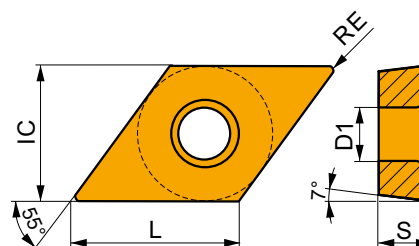
C.-SDUC(RL) INT	
93°	
	
	
$\frac{20}{32}$	
	
102	
86 – 93	



DCGT



	IC	D1	L	S
	[mm]	[mm]	[mm]	[mm]
0702	6.350	2.80	7.80	2.38
0702-SF3	6.350	2.80	7.80	2.58
11T3	9.525	4.40	11.60	3.97
11T3-SF3	9.525	4.40	11.60	4.22



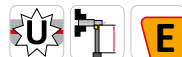
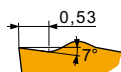
Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

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]



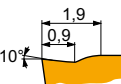
AL geometry with highly positive design for fine-finish to rough machining, and continuous to slightly interrupted cuts.

DCGT 070202F-AL	HF7	0.2	—	—	—	—	—	—	—	—	360	0.12	1.0	—	—	—	—	—	—
	T0315	0.2	—	—	—	—	—	—	—	—	510	0.12	1.0	—	—	—	—	—	—
DCGT 070204F-AL	HF7	0.4	—	—	—	—	—	—	—	—	285	0.24	1.0	—	—	—	—	—	—
	T0315	0.4	—	—	—	—	—	—	—	—	420	0.24	1.0	—	—	—	—	—	—
DCGT 11T302F-AL	HF7	0.2	—	—	—	—	—	—	—	—	345	0.12	1.5	—	—	—	—	—	—
	T0315	0.2	—	—	—	—	—	—	—	—	495	0.12	1.5	—	—	—	—	—	—
DCGT 11T304F-AL	HF7	0.4	—	—	—	—	—	—	—	—	270	0.24	1.5	—	—	—	—	—	—
	T0315	0.4	—	—	—	—	—	—	—	—	390	0.24	1.5	—	—	—	—	—	—
DCGT 11T308F-AL	HF7	0.8	—	—	—	—	—	—	—	—	255	0.48	1.5	—	—	—	—	—	—
	T0315	0.8	—	—	—	—	—	—	—	—	360	0.48	1.5	—	—	—	—	—	—



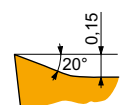
FF2 geometry with positive design for fine-finish to finish machining, and continuous to slightly interrupted cuts.

DCGT 11T302E-FF2	T7325	0.2	190	0.05	0.8	—	—	—	—	—	—	—	—	—	—	—	—	—	—
	T8330	0.2	165	0.05	0.8	—	—	—	155	0.05	0.8	—	—	—	—	—	—	—	—
	T8430	0.2	225	0.05	0.8	—	—	—	185	0.05	0.8	—	—	—	—	—	—	—	—
	T9325	0.2	280	0.05	0.8	—	—	—	265	0.05	0.8	—	—	—	—	—	—	—	—
	TT010	0.2	275	0.05	0.5	—	—	—	—	—	—	—	—	—	—	—	—	—	—



NF1 geometry with positive design for fine-finish to medium machining, and continuous cuts.

DCGT 11T304E-NF1	T6310	0.4	145	0.10	0.8	100	0.09	0.8	—	—	—	435	0.12	0.8	40	0.07	0.6	25	0.15	1.0
	T7325	0.4	165	0.10	0.8	125	0.09	0.8	—	—	—	—	—	—	50	0.07	0.6	—	—	—
DCGT 11T308E-NF1	T6310	0.8	155	0.14	0.8	110	0.13	0.8	—	—	—	465	0.17	0.8	45	0.13	0.6	30	0.15	1.0
	T7325	0.8	180	0.14	0.8	140	0.13	0.8	—	—	—	—	—	—	55	0.13	0.6	—	—	—



SF3 geometry with highly positive design for fine to finish machining, and continuous cuts.

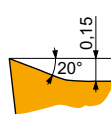
DCGT 070201E-SF3	T6310	0.1	160	0.05	0.5	115	0.05	0.5	125	0.05	0.5	480	0.06	0.5	45	0.04	0.4	30	0.15	1.0
DCGT 070202E-SF3	H07	0.2	—	—	—	95	0.05	0.8	150	0.05	0.8	485	0.06	0.8	45	0.04	0.6	—	—	—
	T6310	0.2	165	0.05	0.8	115	0.05	0.8	130	0.05	0.8	495	0.06	0.8	45	0.04	0.6	30	0.15	1.0
	T8315	0.2	175	0.05	0.8	105	0.05	0.8	165	0.05	0.8	525	0.06	0.8	40	0.04	0.6	35	0.15	1.0
	H07	0.4	—	—	—	75	0.09	0.8	120	0.10	0.8	390	0.12	0.8	35	0.07	0.6	—	—	—
DCGT 070204E-SF3	T6310	0.4	145	0.10	0.8	100	0.09	0.8	115	0.10	0.8	435	0.12	0.8	40	0.07	0.6	25	0.15	1.0
	T8315	0.4	155	0.10	0.8	90	0.09	0.8	145	0.10	0.8	465	0.12	0.8	35	0.07	0.6	30	0.15	1.0
	T6310	0.1	160	0.05	0.5	115	0.05	0.5	125	0.05	0.5	480	0.06	0.5	45	0.04	0.4	30	0.15	1.0

CC	CP	DC	EC	EP	RC	SC	SP	TC	TP	VB	VC	WC
----	----	----	----	----	----	----	----	----	----	----	----	----



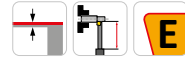
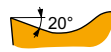
Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

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]



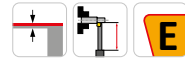
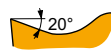
SF3 geometry with highly positive design for fine to finish machining, and continuous cuts.

DCGT 11T302E-SF3	H07	0.2	—	—	—	95	0.05	0.8	150	0.05	0.8	485	0.06	0.8	45	0.04	0.6	—	—	—
	T6310	0.2	165	0.05	0.8	115	0.05	0.8	130	0.05	0.8	495	0.06	0.8	45	0.04	0.6	30	0.15	1.0
DCGT 11T304E-SF3	H07	0.4	—	—	—	75	0.09	0.8	120	0.10	0.8	390	0.12	0.8	35	0.07	0.6	—	—	—
	T6310	0.4	145	0.10	0.8	100	0.09	0.8	115	0.10	0.8	435	0.12	0.8	40	0.07	0.6	25	0.15	1.0
DCGT 11T308E-SF3	T8315	0.4	155	0.10	0.8	90	0.09	0.8	145	0.10	0.8	465	0.12	0.8	35	0.07	0.6	30	0.15	1.0
	H07	0.8	—	—	—	90	0.09	0.8	145	0.10	0.8	455	0.12	0.8	45	0.08	0.6	—	—	—
	T6310	0.8	170	0.10	0.8	120	0.09	0.8	135	0.10	0.8	510	0.12	0.8	50	0.08	0.6	30	0.15	1.0
	T8315	0.8	180	0.10	0.8	105	0.09	0.8	170	0.10	0.8	540	0.12	0.8	45	0.08	0.6	35	0.15	1.0



ER-SI geometry with positive right-handed design for fine-finish machining, and continuous cuts.

DCGT 11T304ER-SI	T8330	0.4	170	0.12	0.8	100	0.11	0.8	160	0.12	0.8	—	—	—	40	0.10	0.6	—	—	—
	T8430	0.4	205	0.12	0.8	110	0.11	0.8	170	0.12	0.8	—	—	—	45	0.10	0.6	—	—	—
DCGT 11T308ER-SI	T8330	0.8	170	0.22	1.0	100	0.20	1.0	160	0.22	1.0	—	—	—	40	0.18	0.8	—	—	—
	T8430	0.8	190	0.22	1.0	105	0.20	1.0	155	0.22	1.0	—	—	—	40	0.18	0.8	—	—	—



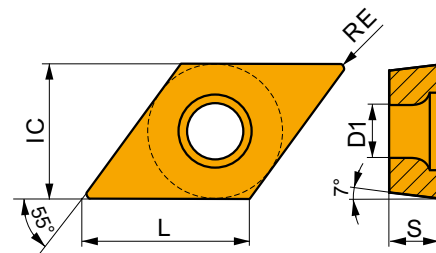
EL-SI geometry with positive left-handed design for fine-finish machining, and continuous cuts.

DCGT 11T304EL-SI	T8330	0.4	170	0.12	0.8	100	0.11	0.8	160	0.12	0.8	—	—	—	40	0.10	0.6	—	—	—
	T8430	0.4	205	0.12	0.8	110	0.11	0.8	170	0.12	0.8	—	—	—	45	0.10	0.6	—	—	—
DCGT 11T308EL-SI	T8330	0.8	170	0.22	1.0	100	0.20	1.0	160	0.22	1.0	—	—	—	40	0.18	0.8	—	—	—
	T8430	0.8	190	0.22	1.0	105	0.20	1.0	155	0.22	1.0	—	—	—	40	0.18	0.8	—	—	—

DCMT

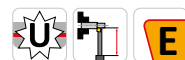
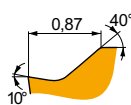


	IC	D1	L	S
	[mm]	[mm]	[mm]	[mm]
0702	6.350	2.80	7.80	2.38
11T3	9.525	4.40	11.60	3.97
1504	12.700	5.50	15.50	4.76



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 [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 positive design for fine-finish to finish machining, and continuous to slightly interrupted cuts.

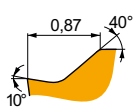
DCMT 11T302E-FF	T8315	0.2	160	0.10	0.8	95	0.09	0.8	—	—	—	—	—	—	—	—	—	—	—	—
	T8330	0.2	150	0.10	0.8	90	0.09	0.8	—	—	—	—	—	—	—	—	—	—	—	—
	T8430	0.2	185	0.10	0.8	100	0.09	0.8	—	—	—	—	—	—	—	—	—	—	—	—
	T9315	0.2	255	0.10	0.8	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—

CC	CP	DC	EC	EP	RC	SC	SP	TC	TP	VB	VC	WC
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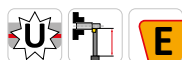
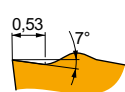
Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

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 positive design for fine-finish to finish machining, and continuous to slightly interrupted cuts.

DCMT 11T304E-FF	T8315	0.4	160	0.12	0.8	95	0.11	0.8	—	—	—	—	—	—	—	—	—	—	—	—
	T8330	0.4	150	0.12	0.8	90	0.11	0.8	—	—	—	—	—	—	—	—	—	—	—	—
	T8430	0.4	185	0.12	0.8	100	0.11	0.8	—	—	—	—	—	—	—	—	—	—	—	—
	T9315	0.4	255	0.12	0.8	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
DCMT 11T308E-FF	T8315	0.8	180	0.15	0.8	105	0.14	0.8	—	—	—	—	—	—	—	—	—	—	—	—
	T8330	0.8	170	0.15	0.8	100	0.14	0.8	—	—	—	—	—	—	—	—	—	—	—	—
	T8430	0.8	200	0.15	0.8	110	0.14	0.8	—	—	—	—	—	—	—	—	—	—	—	—
	T9315	0.8	270	0.15	0.8	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—



FF2 geometry with positive design for fine-finish to finish machining, and continuous to slightly interrupted cuts.

DCMT 070202E-FF2	T7325	0.2	190	0.05	0.8	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
	T8330	0.2	165	0.05	0.8	—	—	—	155	0.05	0.8	—	—	—	—	—	—	—	—	—
	T8430	0.2	225	0.05	0.8	—	—	—	185	0.05	0.8	—	—	—	—	—	—	—	—	—
	T9325	0.2	280	0.05	0.8	—	—	—	265	0.05	0.8	—	—	—	—	—	—	—	—	—
	TT010	0.2	275	0.05	0.5	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
DCMT 070204E-FF2	T7325	0.4	160	0.12	0.8	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
	T8330	0.4	135	0.12	0.8	—	—	—	125	0.12	0.8	—	—	—	—	—	—	—	—	—
	T8430	0.4	170	0.12	0.8	—	—	—	135	0.12	0.8	—	—	—	—	—	—	—	—	—
	T9315	0.4	230	0.12	0.8	—	—	—	215	0.12	0.8	—	—	—	—	—	—	—	—	—
	T9325	0.4	205	0.12	0.8	—	—	—	190	0.12	0.8	—	—	—	—	—	—	—	—	—
DCMT 070208E-FF2	T7325	0.8	170	0.17	0.8	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
	T8330	0.8	150	0.17	0.8	—	—	—	140	0.17	0.8	—	—	—	—	—	—	—	—	—
	T8430	0.8	175	0.17	0.8	—	—	—	140	0.17	0.8	—	—	—	—	—	—	—	—	—
	T9315	0.8	235	0.17	0.8	—	—	—	220	0.17	0.8	—	—	—	—	—	—	—	—	—
	T9325	0.8	215	0.17	0.8	—	—	—	200	0.17	0.8	—	—	—	—	—	—	—	—	—
DCMT 11T304E-FF2	T7325	0.4	160	0.12	0.8	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
	T8330	0.4	135	0.12	0.8	—	—	—	125	0.12	0.8	—	—	—	—	—	—	—	—	—
	T8430	0.4	170	0.12	0.8	—	—	—	135	0.12	0.8	—	—	—	—	—	—	—	—	—
	T9315	0.4	230	0.12	0.8	—	—	—	215	0.12	0.8	—	—	—	—	—	—	—	—	—
	T9325	0.4	205	0.12	0.8	—	—	—	190	0.12	0.8	—	—	—	—	—	—	—	—	—
DCMT 11T308E-FF2	T7325	0.8	170	0.17	0.8	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
	T8330	0.8	150	0.17	0.8	—	—	—	140	0.17	0.8	—	—	—	—	—	—	—	—	—
	T8430	0.8	175	0.17	0.8	—	—	—	140	0.17	0.8	—	—	—	—	—	—	—	—	—
	T9315	0.8	235	0.17	0.8	—	—	—	220	0.17	0.8	—	—	—	—	—	—	—	—	—
	T9325	0.8	215	0.17	0.8	—	—	—	200	0.17	0.8	—	—	—	—	—	—	—	—	—



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

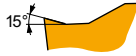
DCMT 070202E-FM	T7325	0.2	175	0.10	0.8	135	0.09	0.8	—	—	—	—	—	—	—	—	—	—	—	—
	T8315	0.2	160	0.10	0.8	95	0.09	0.8	150	0.10	0.8	480	0.12	0.8	—	—	—	—	—	—
	T8330	0.2	150	0.10	0.8	90	0.09	0.8	140	0.10	0.8	450	0.12	0.8	—	—	—	—	—	—
	T8430	0.2	185	0.10	0.8	100	0.09	0.8	150	0.10	0.8	510	0.12	0.8	—	—	—	—	—	—
	T9315	0.2	255	0.10	0.8	—	—	—	240	0.10	0.8	—	—	—	—	—	—	—	—	—
	T9325	0.2	230	0.10	0.8	135	0.09	0.8	215	0.10	0.8	—	—	—	—	—	—	—	—	—

CC	CP	DC	EC	EP	RC	SC	SP	TC	TP	VB	VC	WC
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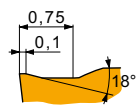
Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

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

DCMT 070204E-FM	T7325	0.4	155	0.17	0.8	120	0.15	0.8	—	—	—	—	—	—	—	—	—	—	—	—
	T7335	0.4	155	0.17	0.8	120	0.15	0.8	—	—	—	—	—	—	—	—	—	—	—	—
	T8315	0.4	160	0.12	0.8	95	0.11	0.8	150	0.12	0.8	480	0.14	0.8	—	—	—	—	—	—
	T8330	0.4	150	0.12	0.8	90	0.11	0.8	140	0.12	0.8	450	0.14	0.8	—	—	—	—	—	—
	T8430	0.4	185	0.12	0.8	100	0.11	0.8	150	0.12	0.8	510	0.14	0.8	—	—	—	—	—	—
	T9315	0.4	255	0.12	0.8	—	—	—	240	0.12	0.8	—	—	—	—	—	—	—	—	—
DCMT 11T302E-FM	T9325	0.4	190	0.18	0.8	110	0.16	0.8	180	0.18	0.8	—	—	—	—	—	—	—	—	—
	T7325	0.2	175	0.10	0.8	135	0.09	0.8	—	—	—	—	—	—	—	—	—	—	—	—
	T8315	0.2	160	0.10	0.8	95	0.09	0.8	150	0.10	0.8	480	0.12	0.8	—	—	—	—	—	—
	T8330	0.2	150	0.10	0.8	90	0.09	0.8	140	0.10	0.8	450	0.12	0.8	—	—	—	—	—	—
	T8430	0.2	185	0.10	0.8	100	0.09	0.8	150	0.10	0.8	510	0.12	0.8	—	—	—	—	—	—
	T9315	0.2	255	0.10	0.8	—	—	—	240	0.10	0.8	—	—	—	—	—	—	—	—	—
DCMT 11T304E-FM	T9325	0.2	230	0.10	0.8	135	0.09	0.8	215	0.10	0.8	—	—	—	—	—	—	—	—	—
	T7325	0.4	155	0.17	0.8	120	0.15	0.8	—	—	—	—	—	—	—	—	—	—	—	—
	T7335	0.4	155	0.17	0.8	120	0.15	0.8	—	—	—	—	—	—	—	—	—	—	—	—
	T8315	0.4	160	0.12	0.8	95	0.11	0.8	150	0.12	0.8	480	0.14	0.8	—	—	—	—	—	—
	T8330	0.4	135	0.17	0.8	80	0.15	0.8	125	0.17	0.8	405	0.20	0.8	—	—	—	—	—	—
	T8430	0.4	155	0.17	0.8	85	0.15	0.8	130	0.17	0.8	435	0.20	0.8	—	—	—	—	—	—
	T9310	0.4	285	0.12	0.8	—	—	—	270	0.12	0.8	—	—	—	—	—	—	—	—	—
	T9315	0.4	255	0.12	0.8	—	—	—	240	0.12	0.8	—	—	—	—	—	—	—	—	—
DCMT 11T308E-FM	T9325	0.4	190	0.18	0.8	110	0.16	0.8	180	0.18	0.8	—	—	—	—	—	—	—	—	—
	T7325	0.8	185	0.17	0.8	140	0.15	0.8	—	—	—	—	—	—	—	—	—	—	—	—
	T7335	0.8	180	0.17	0.8	140	0.15	0.8	—	—	—	—	—	—	—	—	—	—	—	—
	T8315	0.8	170	0.17	0.8	100	0.15	0.8	160	0.17	0.8	510	0.20	0.8	—	—	—	—	—	—
	T8330	0.8	165	0.17	0.8	95	0.15	0.8	155	0.17	0.8	495	0.20	0.8	—	—	—	—	—	—
	T8430	0.8	190	0.17	0.8	105	0.15	0.8	155	0.17	0.8	525	0.20	0.8	—	—	—	—	—	—
	T9310	0.8	285	0.17	0.8	—	—	—	270	0.17	0.8	—	—	—	—	—	—	—	—	—
	T9315	0.8	260	0.17	0.8	—	—	—	245	0.17	0.8	—	—	—	—	—	—	—	—	—
DCMT 11T312E-FM	T9325	0.8	235	0.17	0.8	140	0.15	0.8	220	0.17	0.8	—	—	—	—	—	—	—	—	—
	T8330	1.2	150	0.22	1.2	90	0.22	1.2	140	0.22	1.2	450	0.26	1.2	—	—	—	—	—	—
	T8430	1.2	175	0.22	1.2	95	0.22	1.2	140	0.22	1.2	480	0.26	1.2	—	—	—	—	—	—
	T9315	1.2	235	0.22	1.2	—	—	—	220	0.22	1.2	—	—	—	—	—	—	—	—	—
	T9325	1.2	210	0.22	1.2	125	0.22	1.2	195	0.22	1.2	—	—	—	—	—	—	—	—	—



FM2 geometry for finish to medium machining, and continuous to interrupted cuts.

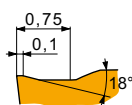
DCMT 070204E-FM2	T6310	0.4	135	0.12	0.8	95	0.11	0.8	105	0.12	0.8	—	—	—	—	—	—	—	—	—
	T7325	0.4	160	0.12	0.8	120	0.11	0.8	—	—	—	—	—	—	—	—	—	—	—	—
	T8330	0.4	135	0.12	0.8	80	0.11	0.8	125	0.12	0.8	—	—	—	—	—	—	—	—	—
	T8430	0.4	170	0.12	0.8	90	0.11	0.8	135	0.12	0.8	—	—	—	—	—	—	—	—	—
	T9315	0.4	230	0.12	0.8	—	—	—	215	0.12	0.8	—	—	—	—	—	—	—	—	—
DCMT 11T304E-FM2	T9325	0.4	205	0.12	0.8	120	0.11	0.8	190	0.12	0.8	—	—	—	—	—	—	—	—	—
	T6310	0.4	135	0.12	0.8	95	0.11	0.8	105	0.12	0.8	—	—	—	—	—	—	—	—	—
	T7325	0.4	160	0.12	0.8	120	0.11	0.8	—	—	—	—	—	—	—	—	—	—	—	—
	T8330	0.4	135	0.12	0.8	80	0.11	0.8	125	0.12	0.8	—	—	—	—	—	—	—	—	—
	T8430	0.4	170	0.12	0.8	90	0.11	0.8	135	0.12	0.8	—	—	—	—	—	—	—	—	—
	T9315	0.4	230	0.12	0.8	—	—	—	215	0.12	0.8	—	—	—	—	—	—	—	—	—
	T9325	0.4	205	0.12	0.8	120	0.11	0.8	190	0.12	0.8	—	—	—	—	—	—	—	—	—
	T9335	0.4	175	0.12	0.8	105	0.11	0.8	—	—	—	—	—	—	—	—	—	—	—	—

CC	CP	DC	EC	EP	RC	SC	SP	TC	TP	VB	VC	WC
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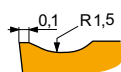
Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

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]



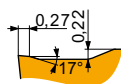
FM2 geometry for finish to medium machining, and continuous to interrupted cuts.

DCMT 11T308E-FM2	T6310	0.8	150	0.17	0.8	105	0.15	0.8	120	0.17	0.8	—	—	—	—	—	—	—	—	—
	T7325	0.8	170	0.17	0.8	130	0.15	0.8	—	—	—	—	—	—	—	—	—	—	—	—
	T8330	0.8	150	0.17	0.8	90	0.15	0.8	140	0.17	0.8	—	—	—	—	—	—	—	—	—
	T8430	0.8	175	0.17	0.8	95	0.15	0.8	140	0.17	0.8	—	—	—	—	—	—	—	—	—
	T9315	0.8	235	0.17	0.8	—	—	—	220	0.17	0.8	—	—	—	—	—	—	—	—	—
	T9325	0.8	215	0.17	0.8	125	0.15	0.8	200	0.17	0.8	—	—	—	—	—	—	—	—	—
	T9335	0.8	180	0.17	0.8	105	0.15	0.8	—	—	—	—	—	—	—	—	—	—	—	—
DCMT 11T312E-FM2	T8430	1.2	155	0.22	1.2	85	0.20	1.2	130	0.22	1.2	—	—	—	—	—	—	—	—	—
	T9325	1.2	190	0.22	1.2	110	0.20	1.2	180	0.22	1.2	—	—	—	—	—	—	—	—	—
DCMT 150408E-FM2	T9315	0.8	205	0.20	1.5	—	—	—	190	0.20	1.5	—	—	—	—	—	—	—	—	—
	T9325	0.8	185	0.20	1.5	110	0.18	1.5	175	0.20	1.5	—	—	—	—	—	—	—	—	—
	T9335	0.8	160	0.20	1.5	95	0.18	1.5	—	—	—	—	—	—	—	—	—	—	—	—



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

DCMT 11T304E-RF	T5315	0.4	175	0.20	0.8	—	—	—	165	0.20	0.8	—	—	—	—	—	—	35	0.15	1.0
	T7335	0.4	115	0.20	0.8	85	0.18	0.8	—	—	—	—	—	—	—	—	—	—	—	—
	T9325	0.4	150	0.20	0.8	90	0.18	0.8	140	0.20	0.8	—	—	—	—	—	—	—	—	—
DCMT 11T308E-RF	T5315	0.8	205	0.20	0.8	—	—	—	190	0.20	0.8	—	—	—	—	—	—	40	0.15	1.0
	T7335	0.8	140	0.20	0.8	105	0.18	0.8	—	—	—	—	—	—	—	—	—	—	—	—
	T9325	0.8	175	0.20	0.8	105	0.18	0.8	165	0.20	0.8	—	—	—	—	—	—	—	—	—



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

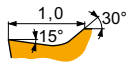
DCMT 11T304E-RM	T5305	0.4	225	0.27	0.8	—	—	—	210	0.27	0.8	—	—	—	—	—	—	45	0.15	1.0
	T5315	0.4	205	0.27	0.8	—	—	—	190	0.27	0.8	—	—	—	—	—	—	40	0.15	1.0
	T7335	0.4	135	0.27	0.8	105	0.24	0.8	—	—	—	40	0.19	0.6	—	—	—	—	—	—
	T8330	0.4	125	0.27	0.8	75	0.24	0.8	115	0.27	0.8	30	0.19	0.6	25	0.15	1.0	—	—	—
	T8430	0.4	135	0.27	0.8	75	0.24	0.8	110	0.27	0.8	25	0.19	0.6	20	0.15	1.0	—	—	—
	T9315	0.4	185	0.27	0.8	—	—	—	175	0.27	0.8	—	—	—	35	0.15	1.0	—	—	—
	T9325	0.4	165	0.27	0.8	95	0.24	0.8	155	0.27	0.8	35	0.19	0.6	—	—	—	—	—	—
DCMT 11T308E-RM	T5305	0.8	270	0.27	0.8	—	—	—	255	0.27	0.8	—	—	—	50	0.15	1.0	—	—	—
	T5315	0.8	240	0.27	0.8	—	—	—	225	0.27	0.8	—	—	—	45	0.15	1.0	—	—	—
	T7335	0.8	165	0.27	0.8	125	0.24	0.8	—	—	—	50	0.19	0.6	—	—	—	—	—	—
	T8330	0.8	150	0.27	0.8	90	0.24	0.8	140	0.27	0.8	35	0.19	0.6	30	0.15	1.0	—	—	—
	T8430	0.8	165	0.27	0.8	90	0.24	0.8	135	0.27	0.8	35	0.19	0.6	25	0.15	1.0	—	—	—
	T9315	0.8	220	0.27	0.8	—	—	—	205	0.27	0.8	—	—	—	40	0.15	1.0	—	—	—
	T9325	0.8	200	0.27	0.8	120	0.24	0.8	190	0.27	0.8	45	0.19	0.6	—	—	—	—	—	—
DCMT 11T312E-RM	T7335	1.2	165	0.27	1.2	125	0.24	1.2	—	—	—	50	0.19	1.2	—	—	—	—	—	—
	T8330	1.2	150	0.27	1.2	90	0.24	1.2	140	0.27	1.2	35	0.19	1.2	30	0.15	1.0	—	—	—
	T8430	1.2	170	0.27	1.2	90	0.24	1.2	135	0.27	1.2	35	0.19	1.2	25	0.15	1.0	—	—	—
	T9315	1.2	225	0.27	1.2	—	—	—	210	0.27	1.2	—	—	—	45	0.15	1.0	—	—	—
	T9325	1.2	200	0.27	1.2	120	0.24	1.2	190	0.27	1.2	45	0.19	1.2	—	—	—	—	—	—
DCMT 150408E-RM	T8330	0.8	135	0.27	1.9	80	0.24	1.9	125	0.27	1.9	30	0.22	1.5	25	0.15	1.0	—	—	—
	T8430	0.8	150	0.27	1.9	80	0.24	1.9	125	0.27	1.9	30	0.22	1.5	25	0.15	1.0	—	—	—
	T9315	0.8	200	0.27	1.9	—	—	—	190	0.27	1.9	—	—	—	40	0.15	1.0	—	—	—
	T9325	0.8	180	0.27	1.9	105	0.24	1.9	170	0.27	1.9	40	0.22	1.5	—	—	—	—	—	—

CC	CP	DC	EC	EP	RC	SC	SP	TC	TP	VB	VC	WC
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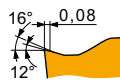
Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

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]



UR geometry for fine to finish machining, and continuous to slightly interrupted cuts.

DCMT 070202E-UR	T7325	0.2	✓	150	0.10	0.8	✓	115	0.09	0.8	—	—	—	—	—	—	—	—	—	—
	T8315	0.2	✓	135	0.10	0.8	✓	80	0.09	0.8	■	125	0.10	0.8	—	—	—	—	—	—
	T8330	0.2	■	130	0.10	0.8	■	75	0.09	0.8	■	120	0.10	0.8	—	—	—	—	—	—
	T8430	0.2	■	155	0.10	0.8	✓	85	0.09	0.8	✓	130	0.10	0.8	—	—	—	—	—	—
	T9315	0.2	■	220	0.10	0.8	—	—	—	—	✓	205	0.10	0.8	—	—	—	—	—	—
	T9325	0.2	■	200	0.10	0.8	✓	120	0.09	0.8	✓	190	0.10	0.8	—	—	—	—	—	—
DCMT 070204E-UR	T7325	0.4	✓	135	0.17	0.8	✓	105	0.15	0.8	—	—	—	—	—	—	—	—	—	—
	T8315	0.4	✓	135	0.12	0.8	✓	80	0.11	0.8	■	125	0.12	0.8	—	—	—	—	—	—
	T8330	0.4	■	130	0.12	0.8	✓	75	0.11	0.8	■	120	0.12	0.8	—	—	—	—	—	—
	T8430	0.4	■	155	0.12	0.8	✓	85	0.11	0.8	✓	130	0.12	0.8	—	—	—	—	—	—
	T9315	0.4	■	220	0.12	0.8	—	—	—	—	✓	205	0.12	0.8	—	—	—	—	—	—
	T9325	0.4	■	165	0.18	0.8	✓	95	0.16	0.8	✓	155	0.18	0.8	—	—	—	—	—	—
DCMT 11T302E-UR	TT310	0.4	■	210	0.12	0.8	✓	125	0.11	0.8	—	—	—	—	—	—	—	—	—	—
	T7325	0.2	✓	150	0.10	0.8	✓	115	0.09	0.8	—	—	—	—	—	—	—	—	—	—
	T8330	0.2	■	130	0.10	0.8	✓	75	0.09	0.8	■	120	0.10	0.8	—	—	—	—	—	—
	T8430	0.2	■	155	0.10	0.8	✓	85	0.09	0.8	✓	130	0.10	0.8	—	—	—	—	—	—
	T9315	0.2	■	220	0.10	0.8	—	—	—	—	✓	205	0.10	0.8	—	—	—	—	—	—
	T9325	0.2	■	200	0.10	0.8	✓	120	0.09	0.8	✓	190	0.10	0.8	—	—	—	—	—	—
DCMT 11T304E-UR	TT310	0.2	■	210	0.10	0.8	✓	125	0.09	0.8	—	—	—	—	—	—	—	—	—	—
	T5315	0.4	✓	220	0.12	0.8	—	—	—	—	■	205	0.12	0.8	—	—	—	—	—	—
	T7325	0.4	✓	135	0.17	0.8	✓	105	0.15	0.8	—	—	—	—	—	—	—	—	—	—
	T7335	0.4	✓	130	0.17	0.8	✓	100	0.15	0.8	—	—	—	—	—	—	—	—	—	—
	T8315	0.4	✓	135	0.12	0.8	✓	80	0.11	0.8	■	125	0.12	0.8	—	—	—	—	—	—
	T8330	0.4	■	130	0.12	0.8	✓	75	0.11	0.8	■	120	0.12	0.8	—	—	—	—	—	—
DCMT 11T308E-UR	T8430	0.4	■	155	0.12	0.8	✓	85	0.11	0.8	✓	130	0.12	0.8	—	—	—	—	—	—
	T9315	0.4	■	220	0.12	0.8	—	—	—	—	✓	205	0.12	0.8	—	—	—	—	—	—
	T9325	0.4	■	165	0.18	0.8	✓	95	0.16	0.8	✓	155	0.18	0.8	—	—	—	—	—	—
	TT310	0.4	■	210	0.12	0.8	✓	125	0.11	0.8	—	—	—	—	—	—	—	—	—	—
	T5315	0.8	✓	230	0.17	0.8	—	—	—	—	■	215	0.17	0.8	—	—	—	—	—	—
	T7325	0.8	✓	160	0.17	0.8	✓	120	0.15	0.8	—	—	—	—	—	—	—	—	—	—
DCMT 11T312E-UR	T7335	0.8	✓	155	0.17	0.8	✓	120	0.15	0.8	—	—	—	—	—	—	—	—	—	—
	T8315	0.8	✓	145	0.17	0.8	✓	85	0.15	0.8	■	135	0.17	0.8	—	—	—	—	—	—
	T8330	0.8	■	140	0.17	0.8	✓	80	0.15	0.8	■	130	0.17	0.8	—	—	—	—	—	—
	T8430	0.8	■	165	0.17	0.8	✓	90	0.15	0.8	✓	135	0.17	0.8	—	—	—	—	—	—
	T9315	0.8	■	225	0.17	0.8	—	—	—	—	✓	210	0.17	0.8	—	—	—	—	—	—
	T9325	0.8	■	200	0.17	0.8	✓	120	0.15	0.8	✓	190	0.17	0.8	—	—	—	—	—	—
DCMT 11T312E-UR	TT310	0.8	■	225	0.17	0.8	✓	135	0.15	0.8	—	—	—	—	—	—	—	—	—	—
	T9315	1.2	■	205	0.22	1.2	—	—	—	—	✓	190	0.22	1.2	—	—	—	—	—	—
	T9325	1.2	■	180	0.22	1.2	✓	105	0.20	1.2	✓	170	0.22	1.2	—	—	—	—	—	—



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

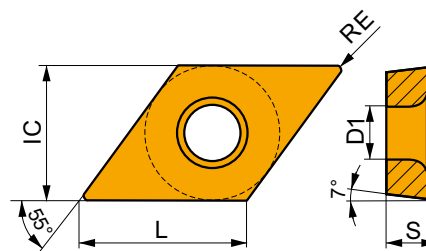
DCMX 11T304W-FM	T7325	0.4	✓	130	0.30	0.8	■	100	0.27	0.8	—	—	—	—	—	—	—	—	—	—
	T8330	0.4	■	115	0.30	0.8	■	65	0.27	0.8	■	105	0.30	0.8	—	—	—	—	—	—
	T8430	0.4	■	130	0.30	0.8	■	70	0.27	0.8	✓	105	0.30	0.8	—	—	—	—	—	—
	T9315	0.4	■	170	0.30	0.8	—	—	—	—	✓	160	0.30	0.8	—	—	—	—	—	—
	T9325	0.4	■	155	0.30	0.8	■	90	0.27	0.8	✓	145	0.30	0.8	—	—	—	—	—	—
DCMX 11T308W-FM	T7325	0.8	✓	140	0.40	1.0	■	105	0.36	1.0	—	—	—	—	—	—	—	—	—	—
	T8430	0.8	■	130	0.40	1.0	■	70	0.36	1.0	✓	105	0.40	1.0	—	—	—	—	—	—
	T9315	0.8	■	175	0.40	1.0	—	—	—	—	✓	165	0.40	1.0	—	—	—	—	—	—
	T9325	0.8	■	160	0.40	1.0	■	95	0.36	1.0	✓	150	0.40	1.0	—	—	—	—	—	—



DCMW



	IC	D1	L	S
	[mm]	[mm]	[mm]	[mm]
0702	6.350	2.80	7.80	2.38
11T3	9.525	4.40	11.60	3.97



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]



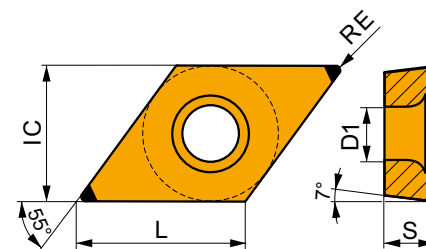
For fine-finish to semi-rough machining, and continuous to slightly interrupted cuts.

DCMW 070202	T5305	0.2	—	—	—	—	—	—	200	0.08	0.8	—	—	—	—	—	—	40	0.15	1.0
	T6310	0.2	—	—	—	—	—	—	80	0.08	0.8	—	—	—	—	—	—	20	0.15	1.0
DCMW 070204	T5305	0.4	—	—	—	—	—	—	195	0.10	0.8	—	—	—	—	—	—	40	0.15	1.0
	T5315	0.4	—	—	—	—	—	—	175	0.10	0.8	—	—	—	—	—	—	35	0.15	1.0
	T6310	0.4	—	—	—	—	—	—	85	0.10	0.8	—	—	—	—	—	—	20	0.15	1.0
DCMW 11T304	T5305	0.4	—	—	—	—	—	—	190	0.10	1.2	—	—	—	—	—	—	40	0.15	1.0
	T5315	0.4	—	—	—	—	—	—	165	0.10	1.2	—	—	—	—	—	—	35	0.15	1.0
	T6310	0.4	—	—	—	—	—	—	80	0.10	1.2	—	—	—	—	—	—	20	0.15	1.0
DCMW 11T308	T5305	0.8	—	—	—	—	—	—	185	0.18	1.2	—	—	—	—	—	—	35	0.15	1.0
	T5315	0.8	—	—	—	—	—	—	160	0.18	1.2	—	—	—	—	—	—	30	0.15	1.0
	T6310	0.8	—	—	—	—	—	—	80	0.18	1.2	—	—	—	—	—	—	20	0.15	1.0

DCGW CBN

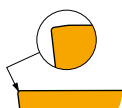
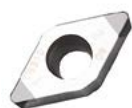


	IC	D1	L	S
	[mm]	[mm]	[mm]	[mm]
11T3	9.525	4.50	11.60	3.97



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.

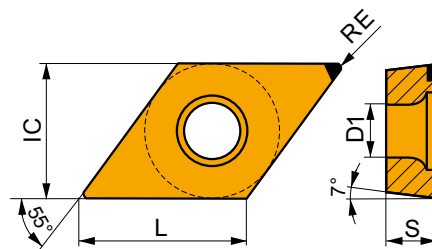
DCGW 11T304S01020B	TB310	0.4	—	—	—	—	—	—	370	0.10	0.4	—	—	—	95	0.07	0.3	75	0.15	1.0
DCGW 11T308S01020B	TB310	0.8	—	—	—	—	—	—	380	0.15	0.6	—	—	—	100	0.11	0.5	80	0.15	1.0



DCMW PCD

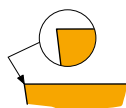


	IC	D1	L	S
	(mm)	(mm)	(mm)	(mm)
11T3	9.525	4.40	11.60	3.97



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, high speeds and stable cutting conditions.

DCMW 11T304FN	PD1	0.4	—	—	—	—	—	—	—	—	1035	0.12	0.5	—	—	—	—	—	—
DCMW 11T308FN	PD1	0.8	—	—	—	—	—	—	—	—	1200	0.12	1.0	—	—	—	—	—	—