



SC

09/ 12/ 25/ 38

CARBIDE INSERTS

SCGT



134

SCMT



135

SCMW



138

MATCH THE RIGHT SIZE (example)

Insert

SCMT 120408E-RM

Tool Holder

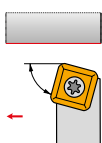
SSDCN 2020 K 12-M-A

ISO TURNING – EXTERNAL

SSBC(RL) EXT

75°

SC..

09
12
25
3812×12
60×60

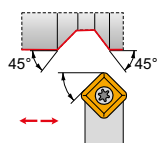
139

134 – 138

SSDCN EXT

45°

SC..

09
1212×12
25×25

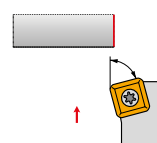
140

134 – 138

SSKC(RL) EXT

75°

SC..

09
1212×12
25×25

141

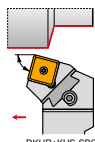
134 – 138

ISO TURNING – HEAVY ROUGHING – EXTERNAL

KHS-SBCR + DKH(RL)

75°

SC..

25
38

DKHR+KHS-SBC

40×50
60×80

142, 143

134 – 138

ISO TURNING – INTERNAL

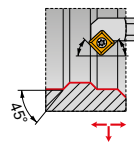
SSSC(RL) INT

45°

SC..



09

25
32

144

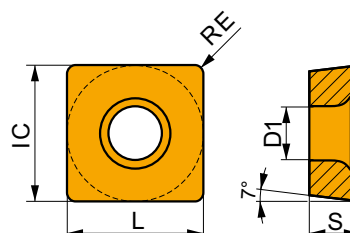
134 – 138



SCGT



	IC	D1	L	S
	[mm]	[mm]	[mm]	[mm]
09T3	9.525	4.40	9.53	3.97
09T3-SF3	9.525	4.40	9.53	4.22
1204	12.700	5.50	12.70	4.76



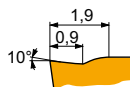
Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

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]



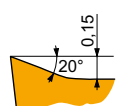
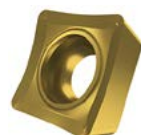
AL geometry with highly positive design for fine-finish to rough machining, and continuous to slightly interrupted cuts.

SCGT 120408F-AL	H07	0.8	—	—	—	—	—	—	—	—	315	0.48	2.0	—	—	—	—	—	—
	T0315	0.8	—	—	—	—	—	—	—	—	465	0.48	2.0	—	—	—	—	—	—



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

SCGT 09T308E-NF1	H07	0.8	—	—	—	100	0.13	1.2	—	—	510	0.17	1.2	50	0.13	1.0	—	—	—
	T6310	0.8	200	0.14	1.2	140	0.13	1.2	—	—	600	0.17	1.2	60	0.13	1.0	40	0.15	1.0
	T7325	0.8	225	0.14	1.2	175	0.13	1.2	—	—	—	—	—	70	0.13	1.0	—	—	—
SCGT 120408E-NF1	H07	0.8	—	—	—	90	0.16	1.4	—	—	455	0.22	1.4	45	0.16	1.1	—	—	—
	T6310	0.8	180	0.18	1.4	125	0.16	1.4	—	—	540	0.22	1.4	50	0.16	1.1	35	0.15	1.0
	T7325	0.8	205	0.18	1.4	155	0.16	1.4	—	—	—	—	—	65	0.16	1.1	—	—	—



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

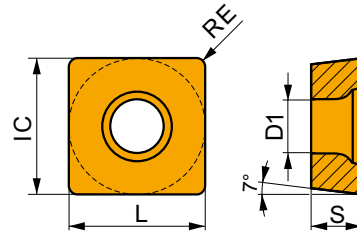
SCGT 09T304E-SF3	H07	0.4	—	—	—	95	0.09	1.0	155	0.10	495	0.12	1.0	50	0.07	0.8	—	—	—
	T6310	0.4	185	0.10	1.0	130	0.09	1.0	145	0.10	555	0.12	1.0	55	0.07	0.8	35	0.15	1.0
	T8315	0.4	200	0.10	1.0	120	0.09	1.0	190	0.10	600	0.12	1.0	50	0.07	0.8	40	0.15	1.0
SCGT 09T308E-SF3	T6310	0.8	210	0.12	1.0	150	0.12	1.0	165	0.12	630	0.14	1.0	60	0.11	0.8	40	0.15	1.0
	T8315	0.8	220	0.12	1.0	130	0.12	1.0	205	0.12	660	0.14	1.0	55	0.11	0.8	40	0.15	1.0



SCMT

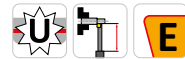
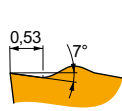


	IC	D1	L	S
	[mm]	[mm]	[mm]	[mm]
09T3	9.525	4.40	9.53	3.97
1204	12.700	5.50	12.70	4.76
2509	25.400	8.70	25.40	9.53
3809	38.100	8.70	38.10	9.53



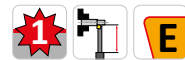
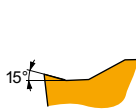
Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

Product	RE	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]



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

SCMT 09T304E-FF2	T8430	0.4	210	0.12	1.2	—	—	—	175	0.12	1.2	—	—	—	—	—	—	—	—
	T9325	0.4	260	0.12	1.2	—	—	—	245	0.12	1.2	—	—	—	—	—	—	—	—
SCMT 09T308E-FF2	T8330	0.8	185	0.17	1.2	—	—	—	175	0.17	1.2	—	—	—	—	—	—	—	—
	T8430	0.8	220	0.17	1.2	—	—	—	180	0.17	1.2	—	—	—	—	—	—	—	—
	T9325	0.8	265	0.17	1.2	—	—	—	250	0.17	1.2	—	—	—	—	—	—	—	—



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

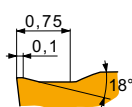
SCMT 09T304E-FM	T7325	0.4	205	0.15	1.2	155	0.15	1.2	—	—	—	—	—	—	—	—	—	—	—
	T7335	0.4	200	0.15	1.2	155	0.15	1.2	—	—	—	—	—	—	—	—	—	—	—
	T8315	0.4	190	0.15	1.2	110	0.14	1.2	180	0.15	1.2	570	0.18	1.2	—	—	—	—	—
	T8330	0.4	180	0.15	1.2	105	0.14	1.2	170	0.15	1.2	540	0.18	1.2	—	—	—	—	—
	T8430	0.4	210	0.15	1.2	115	0.14	1.2	175	0.15	1.2	585	0.18	1.2	—	—	—	—	—
	T9315	0.4	290	0.15	1.2	—	—	—	275	0.15	1.2	—	—	—	—	—	—	—	—
	T9325	0.4	260	0.15	1.2	155	0.15	1.2	245	0.15	1.2	—	—	—	—	—	—	—	—
SCMT 09T308E-FM	T7325	0.8	225	0.20	1.2	175	0.18	1.2	—	—	—	—	—	—	—	—	—	—	—
	T7335	0.8	215	0.20	1.2	165	0.18	1.2	—	—	—	—	—	—	—	—	—	—	—
	T8315	0.8	205	0.20	1.2	120	0.18	1.2	190	0.20	1.2	615	0.24	1.2	—	—	—	—	—
	T8330	0.8	195	0.20	1.2	115	0.18	1.2	185	0.20	1.2	585	0.24	1.2	—	—	—	—	—
	T8430	0.8	225	0.20	1.2	120	0.18	1.2	185	0.20	1.2	615	0.24	1.2	—	—	—	—	—
	T9315	0.8	305	0.20	1.2	—	—	—	285	0.20	1.2	—	—	—	—	—	—	—	—
	T9325	0.8	275	0.20	1.2	165	0.18	1.2	260	0.20	1.2	—	—	—	—	—	—	—	—
SCMT 120404E-FM	T7325	0.4	195	0.15	1.6	150	0.15	1.6	—	—	—	—	—	—	—	—	—	—	—
	T8315	0.4	185	0.15	1.6	110	0.14	1.6	175	0.15	1.6	555	0.18	1.6	—	—	—	—	—
	T8330	0.4	170	0.15	1.6	100	0.14	1.6	160	0.15	1.6	510	0.18	1.6	—	—	—	—	—
	T8430	0.4	205	0.15	1.6	110	0.14	1.6	170	0.15	1.6	570	0.18	1.6	—	—	—	—	—
	T9315	0.4	280	0.15	1.6	—	—	—	265	0.15	1.6	—	—	—	—	—	—	—	—
	T9325	0.4	250	0.15	1.6	150	0.15	1.6	235	0.15	1.6	—	—	—	—	—	—	—	—
SCMT 120408E-FM	T7325	0.8	215	0.20	1.6	165	0.18	1.6	—	—	—	—	—	—	—	—	—	—	—
	T7335	0.8	210	0.20	1.6	160	0.18	1.6	—	—	—	—	—	—	—	—	—	—	—
	T8315	0.8	200	0.20	1.6	120	0.18	1.6	190	0.20	1.6	600	0.24	1.6	—	—	—	—	—
	T8330	0.8	190	0.20	1.6	110	0.18	1.6	180	0.20	1.6	570	0.24	1.6	—	—	—	—	—
	T8430	0.8	220	0.20	1.6	120	0.18	1.6	180	0.20	1.6	600	0.24	1.6	—	—	—	—	—
	T9315	0.8	300	0.20	1.6	—	—	—	285	0.20	1.6	—	—	—	—	—	—	—	—
	T9325	0.8	265	0.20	1.6	155	0.18	1.6	250	0.20	1.6	—	—	—	—	—	—	—	—
	T9325	0.8	265	0.20	1.6	155	0.18	1.6	250	0.20	1.6	—	—	—	—	—	—	—	—
SCMT 120412E-FM	T7325	1.2	210	0.27	1.6	160	0.24	1.6	—	—	—	—	—	—	—	—	—	—	—
	T8330	1.2	185	0.27	1.6	110	0.24	1.6	175	0.27	1.6	555	0.32	1.6	—	—	—	—	—
	T8430	1.2	200	0.27	1.6	110	0.24	1.6	165	0.27	1.6	555	0.32	1.6	—	—	—	—	—
	T9315	1.2	275	0.27	1.6	—	—	—	260	0.27	1.6	—	—	—	—	—	—	—	—
	T9325	1.2	245	0.27	1.6	145	0.24	1.6	230	0.27	1.6	—	—	—	—	—	—	—	—

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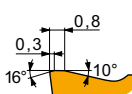
Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

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]



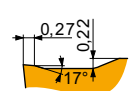
FM2 geometry for finish to medium machining, and continuous to interrupted cuts.

SCMT 09T304E-FM2	T7325	0.4	200	0.12	1.0	155	0.11	1.0	—	—	—	—	—	—	—	—	—	—	—	—
	T8430	0.4	220	0.12	1.0	120	0.11	1.0	180	0.12	1.0	—	—	—	—	—	—	—	—	—
	T9325	0.4	265	0.12	1.0	155	0.11	1.0	250	0.12	1.0	—	—	—	—	—	—	—	—	—
SCMT 09T308E-FM2	T8330	0.8	190	0.17	1.0	110	0.15	1.0	180	0.17	1.0	—	—	—	—	—	—	—	—	—
	T8430	0.8	225	0.17	1.0	120	0.15	1.0	185	0.17	1.0	—	—	—	—	—	—	—	—	—
	T9315	0.8	305	0.17	1.0	—	—	—	285	0.17	1.0	—	—	—	—	—	—	—	—	—
	T9325	0.8	270	0.17	1.0	160	0.15	1.0	255	0.17	1.0	—	—	—	—	—	—	—	—	—
	T9335	0.8	235	0.17	1.0	140	0.15	1.0	—	—	—	—	—	—	—	—	—	—	—	—



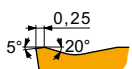
RF geometry for semi-rough to rough machining, and continuous to interrupted cuts.

SCMT 09T308E-RF	T5315	0.8	255	0.20	1.5	—	—	—	240	0.20	1.5	—	—	—	—	—	—	50	0.15	1.0
	T7335	0.8	170	0.20	1.5	130	0.18	1.5	—	—	—	—	—	—	—	—	—	—	—	—
	T9325	0.8	220	0.20	1.5	130	0.18	1.5	205	0.20	1.5	—	—	—	—	—	—	—	—	—
SCMT 120408E-RF	T5315	0.8	240	0.22	2.2	—	—	—	225	0.22	2.2	—	—	—	—	—	—	45	0.15	1.0
	T7335	0.8	160	0.22	2.2	120	0.22	2.2	—	—	—	—	—	—	—	—	—	—	—	—
	T9325	0.8	205	0.22	2.2	120	0.22	2.2	190	0.22	2.2	—	—	—	—	—	—	—	—	—



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

SCMT 09T308E-RM	T5315	0.8	275	0.30	2.0	—	—	—	260	0.30	2.0	—	—	—	—	—	—	55	0.15	1.0
	T7335	0.8	190	0.30	2.0	145	0.27	2.0	—	—	—	60	0.24	1.6	—	—	—	—	—	—
	T8330	0.8	175	0.30	2.0	105	0.27	2.0	165	0.30	2.0	40	0.24	1.6	35	0.15	1.0	—	—	—
	T8430	0.8	190	0.30	2.0	105	0.27	2.0	155	0.30	2.0	40	0.24	1.6	30	0.15	1.0	—	—	—
	T9315	0.8	255	0.30	2.0	—	—	—	240	0.30	2.0	—	—	—	50	0.15	1.0	—	—	—
	T9325	0.8	230	0.30	2.0	135	0.27	2.0	215	0.30	2.0	50	0.24	1.6	—	—	—	—	—	—
SCMT 120408E-RM	T5305	0.8	305	0.30	2.3	—	—	—	285	0.30	2.3	—	—	—	60	0.15	1.0	—	—	—
	T5315	0.8	275	0.30	2.3	—	—	—	260	0.30	2.3	—	—	—	55	0.15	1.0	—	—	—
	T7335	0.8	185	0.30	2.3	140	0.27	2.3	—	—	—	60	0.24	1.8	—	—	—	—	—	—
	T8330	0.8	175	0.30	2.3	105	0.27	2.3	165	0.30	2.3	40	0.24	1.8	35	0.15	1.0	—	—	—
	T8430	0.8	190	0.30	2.3	105	0.27	2.3	155	0.30	2.3	40	0.24	1.8	30	0.15	1.0	—	—	—
	T9315	0.8	250	0.30	2.3	—	—	—	235	0.30	2.3	—	—	—	50	0.15	1.0	—	—	—
	T9325	0.8	225	0.30	2.3	135	0.27	2.3	210	0.30	2.3	50	0.24	1.8	—	—	—	—	—	—



RM3 geometry for semi-rough to rough machining, and continuous to interrupted cuts.

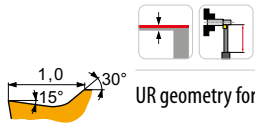
SCMT 120408E-RM3	T6310	0.8	155	0.27	2.3	110	0.27	2.3	125	0.27	2.3	—	—	—	30	0.15	1.0	—	—	—
	T8330	0.8	155	0.27	2.3	90	0.27	2.3	145	0.27	2.3	—	—	—	30	0.15	1.0	—	—	—
	T8430	0.8	170	0.27	2.3	90	0.27	2.3	135	0.27	2.3	—	—	—	25	0.15	1.0	—	—	—
	T9315	0.8	225	0.27	2.3	—	—	—	210	0.27	2.3	—	—	—	45	0.15	1.0	—	—	—
	T9325	0.8	205	0.27	2.3	120	0.27	2.3	190	0.27	2.3	—	—	—	—	—	—	—	—	—
	T9335	0.8	175	0.27	2.3	105	0.27	2.3	—	—	—	—	—	—	—	—	—	—	—	—
SCMT 120412E-RM3	T7325	1.2	175	0.30	2.3	135	0.27	2.3	—	—	—	—	—	—	—	—	—	—	—	—
	T9325	1.2	205	0.30	2.3	120	0.27	2.3	190	0.30	2.3	—	—	—	—	—	—	—	—	—

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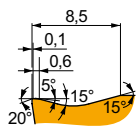
Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

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]



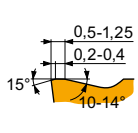
UR geometry for fine to finish machining, and continuous to slightly interrupted cuts.

SCMT 09T304E-UR	T7325	0.4	175	0.15	1.2	135	0.15	1.2	—	—	—	—	—	—	—	—	—	—	—	—
	T8330	0.4	155	0.15	1.2	90	0.14	1.2	145	0.15	1.2	—	—	—	—	—	—	—	—	—
	T8430	0.4	180	0.15	1.2	95	0.14	1.2	145	0.15	1.2	—	—	—	—	—	—	—	—	—
	T9315	0.4	250	0.15	1.2	—	—	—	235	0.15	1.2	—	—	—	—	—	—	—	—	—
	T9325	0.4	225	0.15	1.2	135	0.15	1.2	210	0.15	1.2	—	—	—	—	—	—	—	—	—
SCMT 09T308E-UR	T5315	0.8	280	0.20	1.2	—	—	—	265	0.20	1.2	—	—	—	—	—	—	—	—	—
	T7325	0.8	195	0.20	1.2	150	0.18	1.2	—	—	—	—	—	—	—	—	—	—	—	—
	T8330	0.8	170	0.20	1.2	100	0.18	1.2	160	0.20	1.2	—	—	—	—	—	—	—	—	—
	T8430	0.8	190	0.20	1.2	105	0.18	1.2	155	0.20	1.2	—	—	—	—	—	—	—	—	—
	T9315	0.8	260	0.20	1.2	—	—	—	245	0.20	1.2	—	—	—	—	—	—	—	—	—
	T9325	0.8	235	0.20	1.2	140	0.18	1.2	220	0.20	1.2	—	—	—	—	—	—	—	—	—
SCMT 120408E-UR	TT310	0.8	270	0.20	1.2	160	0.18	1.2	—	—	—	—	—	—	—	—	—	—	—	—
	T5315	0.8	270	0.20	1.6	—	—	—	255	0.20	1.6	—	—	—	—	—	—	—	—	—
	T7325	0.8	185	0.20	1.6	140	0.18	1.6	—	—	—	—	—	—	—	—	—	—	—	—
	T8330	0.8	165	0.20	1.6	95	0.18	1.6	155	0.20	1.6	—	—	—	—	—	—	—	—	—
	T8430	0.8	185	0.20	1.6	100	0.18	1.6	150	0.20	1.6	—	—	—	—	—	—	—	—	—
	T9315	0.8	260	0.20	1.6	—	—	—	245	0.20	1.6	—	—	—	—	—	—	—	—	—
SCMT 120412E-UR	T9325	0.8	230	0.20	1.6	135	0.18	1.6	215	0.20	1.6	—	—	—	—	—	—	—	—	—
	T8330	1.2	160	0.27	1.6	95	0.24	1.6	150	0.27	1.6	—	—	—	—	—	—	—	—	—
	T8430	1.2	175	0.27	1.6	95	0.24	1.6	140	0.27	1.6	—	—	—	—	—	—	—	—	—
	T9325	1.2	215	0.27	1.6	125	0.24	1.6	200	0.27	1.6	—	—	—	—	—	—	—	—	—



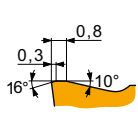
DR4 geometry for rough to heavy-rough machining, and continuous to interrupted cuts.

SCMT 380932E-DR4	T9335	3.2	50	1.33	16.0	30	1.20	16.0	—	—	—	—	—	—	—	—	—	—	—	—
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OR geometry for rough to heavy-rough machining, and continuous to interrupted cuts.

SCMT 250924E-OR	T9226	2.4	80	1.00	10.0	45	0.90	10.0	75	1.00	10.0	—	—	—	15	0.70	8.0	—	—	—
	T9325	2.4	90	1.00	10.0	50	0.90	10.0	85	1.00	10.0	—	—	—	20	0.70	8.0	—	—	—
	T9335	2.4	70	1.00	10.0	40	0.90	10.0	—	—	—	—	—	—	15	0.70	8.0	—	—	—
SCMT 380932E-OR	6635	3.2	60	1.20	18.0	35	1.08	18.0	—	—	—	—	—	—	15	1.08	9.9	—	—	—
	T9226	3.2	65	1.20	18.0	35	1.08	18.0	60	1.20	18.0	—	—	—	10	1.08	9.9	—	—	—
	T9315	3.2	85	1.20	18.0	—	—	—	80	1.20	18.0	—	—	—	—	—	—	—	—	—
	T9325	3.2	80	1.20	18.0	45	1.08	18.0	75	1.20	18.0	—	—	—	15	1.08	9.9	—	—	—
	T9335	3.2	60	1.20	18.0	35	1.08	18.0	—	—	—	—	—	—	10	1.08	9.9	—	—	—



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

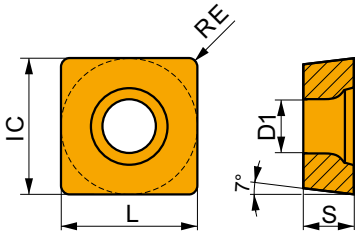
SCMT 250924E-SR	T9325	2.4	70	1.00	14.0	40	0.90	14.0	65	1.00	14.0	—	—	—	—	—	—	—	—	—
	T9335	2.4	60	1.00	14.0	35	0.90	14.0	—	—	—	—	—	—	—	—	—	—	—	—
SCMT 380932E-SR	T9335	3.2	50	1.30	20.0	30	1.30	20.0	—	—	—	—	—	—	—	—	—	—	—	—



SCMW

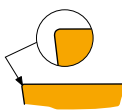


	IC	D1	L	S
	[mm]	[mm]	[mm]	[mm]
09T3	9.525	4.40	9.53	3.97
1204	12.700	5.50	12.70	4.76



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

SCMW 09T304	T5305	0.4	—	—	—	—	—	—	240	0.10	2.0	—	—	—	—	—	—	50	0.15	1.0
	T5315	0.4	—	—	—	—	—	—	205	0.10	2.0	—	—	—	—	—	—	40	0.15	1.0
SCMW 09T308	T5305	0.8	—	—	—	—	—	—	220	0.20	2.0	—	—	—	—	—	—	45	0.15	1.0
	T5315	0.8	—	—	—	—	—	—	190	0.20	2.0	—	—	—	—	—	—	40	0.15	1.0
SCMW 120408	T5305	0.8	—	—	—	—	—	—	205	0.20	4.0	—	—	—	—	—	—	40	0.15	1.0
	T5315	0.8	—	—	—	—	—	—	185	0.20	4.0	—	—	—	—	—	—	35	0.15	1.0