SN

09/ 12/ 15/ 19/ 25

CARBIDE INSERTS

SNMA

300

SNMG

301

SNMM

307

SNMX

311

CER INSERTS

SNGA CER

311

SNGN CER

312

MATCH THE RIGHT SIZE (example)

Insert	Tool Holder
SNMG 190616E-RM	DSDNN 3232 P 19

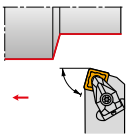
ISO TURNING – EXTERNAL

DSBN(RL) EXT

75°

SN..

12
15
19



20×20
40×40

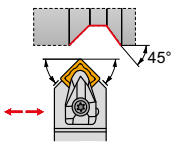
313 | 300 – 312

DSDNN EXT

45°

SN..

12
15
19
25



20×20
40×40

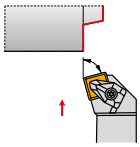
315 | 300 – 312

DSKN(RL) EXT

75°

SN..

12
19



25×25
32×32

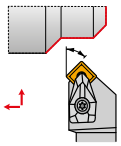
316 | 300 – 312

DSSN(RL) EXT

45°

SN..

12
15
19



20×20
40×40

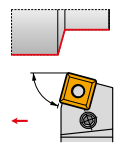
317 | 300 – 312

PSBN(RL) EXT

75°

SN..

12
15
19
25



20×20
50×50

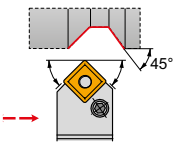
318 | 300 – 312

PSDNN EXT

45°

SN..

12
15
19
25



20×20
50×50

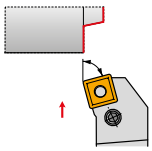
320 | 300 – 312

PSKN(RL) EXT

75°

SN..

12
15
19
25



20×20
50×50

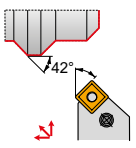
321 | 300 – 312

PSSN(RL) EXT

45°

SN..

19
25



40×40
50×50

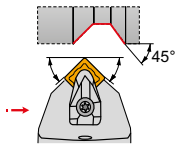
323 | 300 – 312

SN

09/ 12/ 15/ 19/ 25

C.-DSDNN EXT

45°



SN..

12
19

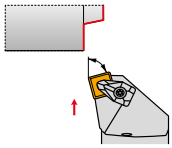
C4
C6

324

300 – 312

C.-DSKN(RL) EXT

75°



SN..

12

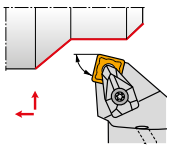
C4

325

300 – 312

C.-DSRN(RL) EXT

75°



SN..

12
19

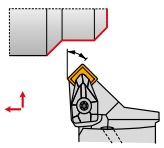
C4
C6

326

300 – 312

C.-DSSN(RL) EXT

45°



SN..

12

C4
C5

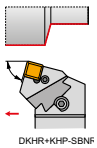
327

300 – 312

ISO TURNING – HEAVY ROUGHING – EXTERNAL

KHP-SBNR + DKH(RL)

75°



SN..

25

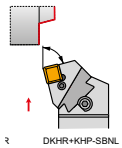
40×50
60×80

328, 330

300 – 312

KHP-SBNL + DKH(RL)

75°



SN..

25

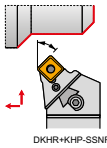
40×50
60×80

328, 330

300 – 312

KHP-SSNR/L + DKH(RL)

45°



SN..

19
25

40×50
60×80

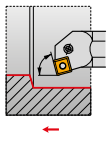
329, 330

300 – 312

ISO TURNING – INTERNAL

PSKN(RL) INT

93°



SN..

11
15

32
80

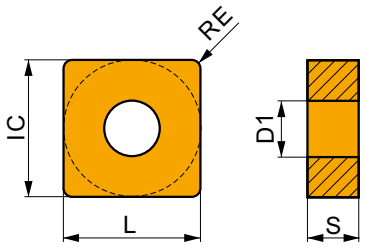
331

300 – 312

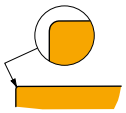
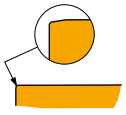
SNMA

PRAMET

	IC [mm]	D1 [mm]	L [mm]	S [mm]
1204	12.700	5.16	12.70	4.76
1506	15.875	6.35	15.875	6.35
1906	19.050	7.94	19.05	6.35
2507	25.400	9.12	25.40	7.94
2509	25.400	9.12	25.40	9.525



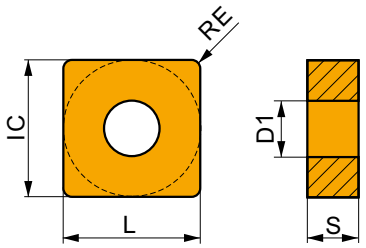
Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

Product		RE [mm]	P vc [m/min]	P f [mm/rev]	P ap [mm]	M vc [m/min]	M f [mm/rev]	M ap [mm]	K vc [m/min]	K f [mm/rev]	K ap [mm]	N vc [m/min]	N f [mm/rev]	N ap [mm]	S vc [m/min]	S f [mm/rev]	S ap [mm]	H vc [m/min]	H f [mm/rev]	H ap [mm]
			E																	
			For fine-finish to semi-rough machining, and continuous to slightly interrupted cuts.																	
SNMA 120408	**T5305**	0.8	–	–	–	–	–	–	230	0.20	4.0	–	–	–	–	–	–	45	0.15	1.0
	T5315	0.8	–	–	–	–	–	–	200	0.20	4.0	–	–	–	–	–	–	40	0.15	1.0
	T6310	0.8	–	–	–	–	–	–	100	0.20	4.0	–	–	–	–	–	–	25	0.15	1.0
SNMA 120412	**T5305**	1.2	–	–	–	–	–	–	205	0.30	4.0	–	–	–	–	–	–	40	0.15	1.0
	T5315	1.2	–	–	–	–	–	–	190	0.30	4.0	–	–	–	–	–	–	40	0.15	1.0
SNMA 150612	**T5305**	1.2	–	–	–	–	–	–	200	0.30	5.0	–	–	–	–	–	–	40	0.15	1.0
	T5315	1.2	–	–	–	–	–	–	185	0.30	5.0	–	–	–	–	–	–	35	0.15	1.0
SNMA 190612	**T5305**	1.2	–	–	–	–	–	–	195	0.30	6.0	–	–	–	–	–	–	40	0.15	1.0
	T5315	1.2	–	–	–	–	–	–	180	0.30	6.0	–	–	–	–	–	–	35	0.15	1.0
SNMA 190616	**T5305**	1.6	–	–	–	–	–	–	190	0.40	6.0	–	–	–	–	–	–	40	0.15	1.0
	T5315	1.6	–	–	–	–	–	–	170	0.40	6.0	–	–	–	–	–	–	35	0.15	1.0
SNMA 250724	**T5305**	2.4	–	–	–	–	–	–	95	0.60	8.0	–	–	–	–	–	–	20	0.15	1.0
	T5315	2.4	–	–	–	–	–	–	90	0.60	8.0	–	–	–	–	–	–	15	0.15	1.0
SNMA 250924	**T5305**	2.4	–	–	–	–	–	–	95	0.60	8.0	–	–	–	–	–	–	20	0.15	1.0
	T5315	2.4	–	–	–	–	–	–	90	0.60	8.0	–	–	–	–	–	–	15	0.15	1.0
			S																	
			For fine-finish to semi-rough machining, and continuous to slightly interrupted cuts.																	
SNMA 120412S	**T5305**	1.2	–	–	–	–	–	–	205	0.30	4.0	–	–	–	–	–	–	40	0.15	1.0
SNMA 190616S	**T5305**	1.6	–	–	–	–	–	–	195	0.30	6.0	–	–	–	–	–	–	40	0.15	1.0
SNMA 250724S	**T5305**	2.4	–	–	–	–	–	–	95	0.60	8.0	–	–	–	–	–	–	20	0.15	1.0
SNMA 250924S	**T5305**	2.4	–	–	–	–	–	–	95	0.60	8.0	–	–	–	–	–	–	20	0.15	1.0

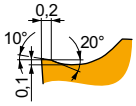
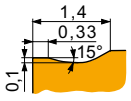
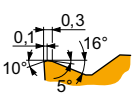
SNMG

PRAMET

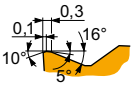
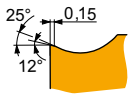
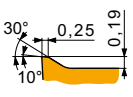
	IC [mm]	D1 [mm]	L [mm]	S [mm]
1204	12.700	5.16	12.70	4.76
1506	15.875	6.35	15.875	6.35
1906	19.050	7.94	19.05	6.35
2507	25.400	9.12	25.40	7.94
2509	25.400	9.12	25.40	9.525



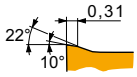
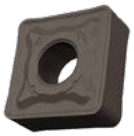
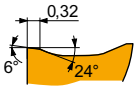
Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

Product		RE [mm]	P vc [m/min]	P f [mm/rev]	P ap [mm]	M vc [m/min]	M f [mm/rev]	M ap [mm]	K vc [m/min]	K f [mm/rev]	K ap [mm]	N vc [m/min]	N f [mm/rev]	N ap [mm]	S vc [m/min]	S f [mm/rev]	S ap [mm]	H vc [m/min]	H f [mm/rev]	H ap [mm]
																				
			FM geometry with positive design for finish to semi-rough machining, and continuous to slightly interrupted cuts.																	
SNMG 120404E-FM	**T6310**	0.4	175	0.20	2.1	125	0.18	2.1	140	0.20	2.1	–	–	–	50	0.14	1.7	–	–	–
	T7325	0.4	195	0.20	2.1	150	0.18	2.1	–	–	–	–	–	–	60	0.16	1.7	–	–	–
	T8315	0.4	180	0.20	2.1	105	0.18	2.1	170	0.20	2.1	–	–	–	45	0.14	1.7	–	–	–
	T8330	0.4	175	0.20	2.1	105	0.18	2.1	165	0.20	2.1	–	–	–	40	0.14	1.7	–	–	–
	T8430	0.4	195	0.20	2.1	105	0.18	2.1	160	0.20	2.1	–	–	–	40	0.14	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	–	–	–
SNMG 120408E-FM	**T7325**	0.8	235	0.20	2.1	180	0.18	2.1	–	–	–	–	–	–	75	0.16	1.7	–	–	–
	T8315	0.8	215	0.20	2.1	125	0.18	2.1	200	0.20	2.1	–	–	–	50	0.16	1.7	–	–	–
	T8330	0.8	205	0.20	2.1	120	0.18	2.1	190	0.20	2.1	–	–	–	50	0.16	1.7	–	–	–
	T8430	0.8	235	0.20	2.1	125	0.18	2.1	190	0.20	2.1	–	–	–	50	0.16	1.7	–	–	–
	T9310	0.8	355	0.20	2.1	–	–	–	335	0.20	2.1	–	–	–	–	–	–	–	–	–
	T9315	0.8	320	0.20	2.1	–	–	–	300	0.20	2.1	–	–	–	–	–	–	–	–	–
	T9325	0.8	290	0.20	2.1	170	0.18	2.1	275	0.20	2.1	–	–	–	65	0.16	1.7	–	–	–
SNMG 120412E-FM	**T8330**	1.2	200	0.27	2.1	120	0.24	2.1	190	0.27	2.1	–	–	–	50	0.19	1.7	–	–	–
	T8430	1.2	220	0.27	2.1	120	0.24	2.1	180	0.27	2.1	–	–	–	45	0.19	1.7	–	–	–
	T9315	1.2	300	0.27	2.1	–	–	–	285	0.27	2.1	–	–	–	–	–	–	–	–	–
	T9325	1.2	270	0.27	2.1	160	0.24	2.1	255	0.27	2.1	–	–	–	60	0.19	1.7	–	–	–
SNMG 120416E-FM	**T8330**	1.6	200	0.32	2.1	120	0.29	2.1	190	0.32	2.1	–	–	–	50	0.22	1.7	–	–	–
	T8430	1.6	220	0.32	2.1	120	0.29	2.1	180	0.32	2.1	–	–	–	45	0.22	1.7	–	–	–
	T9325	1.6	260	0.32	2.1	155	0.29	2.1	245	0.32	2.1	–	–	–	55	0.22	1.7	–	–	–
																				
			KR geometry for semi-rough to rough machining, and continuous to interrupted cuts.																	
SNMG 120408E-KR	**T5305**	0.8	265	0.35	3.8	–	–	–	250	0.35	3.8	–	–	–	–	–	–	50	0.15	1.0
	T5315	0.8	235	0.35	3.8	–	–	–	220	0.35	3.8	–	–	–	–	–	–	45	0.15	1.0
SNMG 120412E-KR	**T5305**	1.2	265	0.40	3.8	–	–	–	250	0.40	3.8	–	–	–	–	–	–	50	0.15	1.0
	T5315	1.2	240	0.40	3.8	–	–	–	225	0.40	3.8	–	–	–	–	–	–	45	0.15	1.0
																				
			M geometry for finish to semi-rough machining, and continuous to interrupted cuts.																	
SNMG 120408E-M	**T5305**	0.8	290	0.32	2.1	–	–	–	275	0.32	2.1	–	–	–	–	–	–	55	0.15	1.0
	T5315	0.8	260	0.32	2.1	–	–	–	245	0.32	2.1	–	–	–	–	–	–	50	0.15	1.0
	T9310	0.8	255	0.32	2.1	–	–	–	240	0.32	2.1	–	–	–	–	–	–	50	0.15	1.0
	T9315	0.8	235	0.32	2.1	–	–	–	220	0.32	2.1	–	–	–	–	–	–	45	0.15	1.0
	T9325	0.8	210	0.32	2.1	–	–	–	195	0.32	2.1	–	–	–	–	–	–	–	–	–
	T9335	0.8	185	0.32	2.1	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–

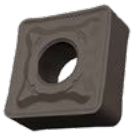
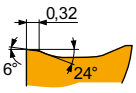
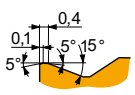
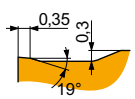
Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

Product		RE	P			M			K			N			S			H		
			vc [m/min]	f [mm/rev]	ap [mm]	vc [m/min]	f [mm/rev]	ap [mm]	vc [m/min]	f [mm/rev]	ap [mm]	vc [m/min]	f [mm/rev]	ap [mm]	vc [m/min]	f [mm/rev]	ap [mm]	vc [m/min]	f [mm/rev]	ap [mm]
																				
M geometry for finish to semi-rough machining, and continuous to interrupted cuts.																				
SNMG 120412E-M	**T9315**	1.2	■ 230	0.40	2.1	–	–	–	◪ 215	0.40	2.1	–	–	–	–	–	–	◪ 45	0.15	1.0
	T9325	1.2	■ 200	0.40	2.1	–	–	–	◪ 190	0.40	2.1	–	–	–	–	–	–	–	–	–
	T9335	1.2	■ 175	0.40	2.1	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
SNMG 120416E-M	**T9325**	1.6	■ 210	0.40	2.1	–	–	–	◪ 195	0.40	2.1	–	–	–	–	–	–	–	–	–
SNMG 150612E-M	**T9315**	1.2	■ 220	0.40	3.4	–	–	–	◪ 205	0.40	3.4	–	–	–	–	–	–	◪ 40	0.15	1.0
	T9325	1.2	■ 195	0.40	3.4	–	–	–	◪ 185	0.40	3.4	–	–	–	–	–	–	–	–	–
	T9335	1.2	■ 170	0.40	3.4	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
SNMG 190612E-M	**T9315**	1.2	■ 215	0.40	4.0	–	–	–	◪ 200	0.40	4.0	–	–	–	–	–	–	◪ 40	0.15	1.0
	T9325	1.2	■ 190	0.40	4.0	–	–	–	◪ 180	0.40	4.0	–	–	–	–	–	–	–	–	–
	T9335	1.2	■ 165	0.40	4.0	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
SNMG 190616E-M	**T9315**	1.6	■ 225	0.40	4.0	–	–	–	◪ 210	0.40	4.0	–	–	–	–	–	–	◪ 45	0.15	1.0
	T9325	1.6	■ 200	0.40	4.0	–	–	–	◪ 190	0.40	4.0	–	–	–	–	–	–	–	–	–
	T9335	1.6	■ 175	0.40	4.0	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
																				
NF geometry with highly positive design for fine-finish to medium machining, and continuous cuts.																				
SNMG 120404E-NF	**T6310**	0.4	■ 185	0.17	1.7	■ 130	0.15	1.7	◪ 145	0.17	1.7	◪ 555	0.20	1.7	◪ 55	0.14	1.4	–	–	–
	T7325	0.4	◪ 210	0.18	1.7	■ 160	0.16	1.7	–	–	–	–	–	–	◪ 65	0.16	1.4	–	–	–
	T7335	0.4	◪ 205	0.18	1.7	■ 155	0.16	1.7	–	–	–	–	–	–	◪ 65	0.16	1.4	–	–	–
	T8330	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	–	–	–
	T8430	0.4	■ 210	0.17	1.7	■ 115	0.15	1.7	◪ 175	0.17	1.7	◪ 585	0.20	1.7	◪ 45	0.14	1.4	–	–	–
	T9315	0.4	■ 300	0.17	1.7	–	–	–	◪ 285	0.17	1.7	–	–	–	–	–	–	–	–	–
	T9325	0.4	■ 260	0.18	1.7	■ 155	0.16	1.7	◪ 245	0.18	1.7	–	–	–	◪ 55	0.16	1.4	–	–	–
SNMG 120408E-NF	**HF7**	0.8	–	–	–	◪ 120	0.17	1.7	◪ 190	0.19	1.7	◪ 600	0.23	1.7	–	–	–	–	–	–
	T6310	0.8	■ 210	0.19	1.7	■ 150	0.17	1.7	◪ 165	0.19	1.7	◪ 630	0.23	1.7	◪ 60	0.15	1.4	–	–	–
	T7325	0.8	◪ 245	0.19	1.7	■ 190	0.17	1.7	–	–	–	–	–	–	◪ 75	0.15	1.4	–	–	–
	T7335	0.8	◪ 240	0.19	1.7	■ 185	0.17	1.7	–	–	–	–	–	–	◪ 75	0.15	1.4	–	–	–
	T8315	0.8	◪ 230	0.19	1.7	■ 135	0.17	1.7	◪ 215	0.19	1.7	◪ 690	0.23	1.7	◪ 55	0.15	1.4	–	–	–
	T8330	0.8	■ 210	0.19	1.7	■ 125	0.17	1.7	◪ 195	0.19	1.7	◪ 630	0.23	1.7	◪ 50	0.15	1.4	–	–	–
	T8430	0.8	■ 250	0.19	1.7	■ 135	0.17	1.7	◪ 205	0.19	1.7	◪ 690	0.23	1.7	◪ 50	0.15	1.4	–	–	–
	T9315	0.8	■ 340	0.19	1.7	–	–	–	◪ 320	0.19	1.7	–	–	–	–	–	–	–	–	–
	T9325	0.8	■ 300	0.19	1.7	■ 180	0.17	1.7	◪ 285	0.19	1.7	–	–	–	◪ 65	0.15	1.4	–	–	–
																				
NM geometry with highly positive design for fine-finish, medium and rough machining, in continuous cuts.																				
SNMG 120408E-NM	**T7325**	0.8	◪ 225	0.25	2.1	■ 175	0.23	2.1	–	–	–	–	–	–	■ 70	0.20	1.7	–	–	–
	T7335	0.8	◪ 220	0.25	2.1	■ 170	0.23	2.1	–	–	–	–	–	–	■ 70	0.20	1.7	–	–	–
	T8315	0.8	◪ 215	0.25	2.1	■ 125	0.23	2.1	–	–	–	◪ 645	0.30	2.1	◪ 50	0.20	1.7	–	–	–
	T8330	0.8	■ 205	0.25	2.1	■ 120	0.23	2.1	–	–	–	◪ 615	0.30	2.1	◪ 50	0.20	1.7	–	–	–
	T8430	0.8	■ 225	0.25	2.1	■ 120	0.23	2.1	–	–	–	◪ 615	0.30	2.1	◪ 45	0.20	1.7	–	–	–
	T9325	0.8	■ 275	0.25	2.1	■ 165	0.23	2.1	–	–	–	–	–	–	◪ 60	0.20	1.7	–	–	–
SNMG 120412E-NM	**T7325**	1.2	◪ 225	0.30	2.1	■ 175	0.27	2.1	–	–	–	–	–	–	■ 70	0.24	1.7	–	–	–
	T7335	1.2	◪ 220	0.30	2.1	■ 170	0.27	2.1	–	–	–	–	–	–	■ 70	0.24	1.7	–	–	–
	T8315	1.2	◪ 215	0.30	2.1	■ 125	0.27	2.1	–	–	–	◪ 645	0.36	2.1	◪ 50	0.24	1.7	–	–	–
	T9325	1.2	■ 270	0.30	2.1	■ 160	0.27	2.1	–	–	–	–	–	–	◪ 60	0.24	1.7	–	–	–

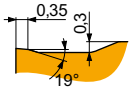
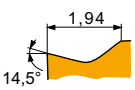
Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

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.																				
SNMG 120408E-NMR	**T6310**	0.8	■	155	0.35	2.6	■	110	0.32	2.6	–	–	–	–	–	–	■	45	0.25	2.1	–	–	–
	T7325	0.8	◪	175	0.35	2.6	■	135	0.32	2.6	–	–	–	–	–	–	■	55	0.25	2.1	–	–	–
	T7335	0.8	◪	165	0.35	2.6	■	125	0.32	2.6	–	–	–	–	–	–	■	50	0.25	2.1	–	–	–
	T8330	0.8	■	155	0.35	2.6	■	90	0.32	2.6	–	–	–	–	–	–	◪	35	0.25	2.1	–	–	–
	T8430	0.8	■	165	0.35	2.6	■	90	0.32	2.6	–	–	–	–	–	–	◪	35	0.25	2.1	–	–	–
	T9315	0.8	■	225	0.35	2.6		–	–	–	–	–	–	–	–	–		–	–	–	–	–	–
	T9325	0.8	■	200	0.35	2.6	■	120	0.32	2.6	–	–	–	–	–	–	◪	45	0.25	2.1	–	–	–
SNMG 120412E-NMR	**T6310**	1.2	■	160	0.40	2.6	■	115	0.36	2.6	–	–	–	–	–	–	■	45	0.28	2.1	–	–	–
	T7325	1.2	◪	175	0.40	2.6	■	135	0.36	2.6	–	–	–	–	–	–	■	55	0.28	2.1	–	–	–
	T7335	1.2	◪	165	0.40	2.6	■	125	0.36	2.6	–	–	–	–	–	–	■	50	0.28	2.1	–	–	–
	T9315	1.2	■	225	0.40	2.6		–	–	–	–	–	–	–	–	–		–	–	–	–	–	–
	T9325	1.2	■	200	0.40	2.6	■	120	0.36	2.6	–	–	–	–	–	–	◪	45	0.28	2.1	–	–	–
SNMG 120416E-NMR	**T7325**	1.6	◪	180	0.45	2.6	■	140	0.41	2.6	–	–	–	–	–	–	■	55	0.32	2.1	–	–	–
	T7335	1.6	◪	170	0.45	2.6	■	130	0.41	2.6	–	–	–	–	–	–	■	55	0.32	2.1	–	–	–
	T9325	1.6	■	200	0.45	2.6	■	120	0.41	2.6	–	–	–	–	–	–	◪	45	0.32	2.1	–	–	–
SNMG 150612E-NMR	**T6310**	1.2	■	150	0.40	3.8	■	105	0.36	3.8	–	–	–	–	–	–	■	45	0.28	3.0	–	–	–
	T7325	1.2	◪	170	0.40	3.8	■	130	0.36	3.8	–	–	–	–	–	–	■	55	0.28	3.0	–	–	–
	T9315	1.2	■	215	0.40	3.8		–	–	–	–	–	–	–	–	–		–	–	–	–	–	–
	T9325	1.2	■	190	0.40	3.8	■	110	0.36	3.8	–	–	–	–	–	–	◪	40	0.28	3.0	–	–	–
SNMG 190612E-NMR	**T6310**	1.2	■	145	0.40	5.2	■	100	0.36	5.2	–	–	–	–	–	–	■	40	0.28	4.2	–	–	–
	T7325	1.2	◪	165	0.40	5.2	■	125	0.36	5.2	–	–	–	–	–	–	■	50	0.28	4.2	–	–	–
	T7335	1.2	◪	155	0.40	5.2	■	120	0.36	5.2	–	–	–	–	–	–	■	50	0.28	4.2	–	–	–
	T9315	1.2	■	210	0.40	5.2		–	–	–	–	–	–	–	–	–		–	–	–	–	–	–
	T9325	1.2	■	185	0.40	5.2	■	110	0.36	5.2	–	–	–	–	–	–	◪	40	0.28	4.2	–	–	–
SNMG 190616E-NMR	**T6310**	1.6	■	150	0.45	5.2	■	105	0.41	5.2	–	–	–	–	–	–	■	45	0.32	4.2	–	–	–
	T7325	1.6	◪	170	0.45	5.2	■	130	0.41	5.2	–	–	–	–	–	–	■	55	0.32	4.2	–	–	–
	T7335	1.6	◪	155	0.45	5.2	■	120	0.41	5.2	–	–	–	–	–	–	■	50	0.32	4.2	–	–	–
	T9315	1.6	■	205	0.45	5.2		–	–	–	–	–	–	–	–	–		–	–	–	–	–	–
	T9325	1.6	■	185	0.45	5.2	■	110	0.41	5.2	–	–	–	–	–	–	◪	40	0.32	4.2	–	–	–
																				
NRM geometry with positive design for semi-rough to rough machining, and continuous to moderate interrupted cuts.																				
SNMG 120408-NRM	**T7325**	0.8	◪	175	0.35	2.6	■	135	0.32	2.6	–	–	–	–	–	–	■	55	0.28	2.1	–	–	–
	T7335	0.8	◪	165	0.35	2.6	■	125	0.32	2.6	–	–	–	–	–	–	■	50	0.28	2.1	–	–	–
	T9315	0.8	■	225	0.35	2.6		–	–	–	–	–	–	–	–	–		–	–	–	–	–	–
SNMG 120412-NRM	**T7325**	1.2	◪	175	0.40	3.0	■	135	0.36	3.0	–	–	–	–	–	–	■	55	0.28	2.4	–	–	–
	T7335	1.2	◪	165	0.40	3.0	■	125	0.36	3.0	–	–	–	–	–	–	■	50	0.28	2.4	–	–	–
	T9315	1.2	■	220	0.40	3.0		–	–	–	–	–	–	–	–	–		–	–	–	–	–	–
SNMG 150612-NRM	**T7325**	1.2	◪	170	0.40	4.0	■	130	0.36	4.0	–	–	–	–	–	–	■	55	0.32	3.2	–	–	–
	T7335	1.2	◪	160	0.40	4.0	■	120	0.36	4.0	–	–	–	–	–	–	■	50	0.32	3.2	–	–	–
	T9315	1.2	■	215	0.40	4.0		–	–	–	–	–	–	–	–	–		–	–	–	–	–	–
SNMG 150616-NRM	**T7325**	1.6	◪	170	0.45	5.0	■	130	0.41	5.0	–	–	–	–	–	–	■	55	0.36	4.0	–	–	–
	T7335	1.6	◪	155	0.45	5.0	■	120	0.41	5.0	–	–	–	–	–	–	■	50	0.36	4.0	–	–	–
	T9315	1.6	■	205	0.45	5.0		–	–	–	–	–	–	–	–	–		–	–	–	–	–	–
SNMG 190612-NRM	**T7325**	1.2	◪	165	0.40	5.2	■	125	0.36	5.2	–	–	–	–	–	–	■	50	0.32	4.2	–	–	–
	T7335	1.2	◪	155	0.40	5.2	■	120	0.36	5.2	–	–	–	–	–	–	■	50	0.32	4.2	–	–	–
	T9315	1.2	■	210	0.40	5.2		–	–	–	–	–	–	–	–	–		–	–	–	–	–	–
SNMG 190616-NRM	**T7325**	1.6	◪	170	0.45	5.2	■	130	0.41	5.2	–	–	–	–	–	–	■	55	0.36	4.2	–	–	–
	T7335	1.6	◪	155	0.45	5.2	■	120	0.41	5.2	–	–	–	–	–	–	■	50	0.36	4.2	–	–	–
	T9315	1.6	■	205	0.45	5.2		–	–	–	–	–	–	–	–	–		–	–	–	–	–	–
SNMG 250724-NRM	**T7325**	2.4	◪	105	0.65	9.0	■	80	0.59	9.0	–	–	–	–	–	–	■	30	0.46	7.2	–	–	–
	T7335	2.4	◪	100	0.65	9.0	■	75	0.59	9.0	–	–	–	–	–	–	■	30	0.46	7.2	–	–	–
	T9315	2.4	■	120	0.65	9.0		–	–	–	◪	110	0.65	9.0	–	–	–	–	–	–	–	–	–

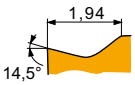
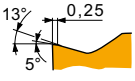
Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

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
		[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]
																				
			NRM geometry with positive design for semi-rough to rough machining, and continuous to moderate interrupted cuts.																	
SNMG 250924-NRM	**T7325**	2.4	105	0.70	9.0	80	0.63	9.0	–	–	–	–	–	–	30	0.49	7.2	–	–	–
	T7335	2.4	95	0.70	9.0	70	0.63	9.0	–	–	–	–	–	–	30	0.49	7.2	–	–	–
	T9315	2.4	120	0.70	9.0	–	–	–	110	0.70	9.0	–	–	–	–	–	–	–	–	–
																				
			R geometry for semi-rough to rough machining, and continuous to interrupted cuts.																	
SNMG 120408E-R	**6640**	0.8	145	0.40	3.8	–	–	–	135	0.40	3.8	–	–	–	–	–	–	–	–	–
	T5305	0.8	250	0.40	3.8	–	–	–	235	0.40	3.8	–	–	–	–	–	–	50	0.15	1.0
	T9315	0.8	200	0.40	3.8	–	–	–	190	0.40	3.8	–	–	–	–	–	–	40	0.15	1.0
	T9325	0.8	180	0.40	3.8	–	–	–	170	0.40	3.8	–	–	–	–	–	–	–	–	–
	T9335	0.8	155	0.40	3.8	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
SNMG 120412E-R	**T5305**	1.2	255	0.45	3.8	–	–	–	240	0.45	3.8	–	–	–	–	–	–	50	0.15	1.0
	T9310	1.2	220	0.45	3.8	–	–	–	205	0.45	3.8	–	–	–	–	–	–	40	0.15	1.0
	T9325	1.2	180	0.45	3.8	–	–	–	170	0.45	3.8	–	–	–	–	–	–	–	–	–
	T9335	1.2	160	0.45	3.8	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
SNMG 120416E-R	**T9315**	1.6	205	0.50	3.8	–	–	–	190	0.50	3.8	–	–	–	–	–	–	40	0.15	1.0
	T9325	1.6	185	0.50	3.8	–	–	–	175	0.50	3.8	–	–	–	–	–	–	–	–	–
SNMG 150612E-R	**T5305**	1.2	250	0.45	4.5	–	–	–	235	0.45	4.5	–	–	–	–	–	–	50	0.15	1.0
	T5315	1.2	230	0.45	4.5	–	–	–	215	0.45	4.5	–	–	–	–	–	–	45	0.15	1.0
	T9315	1.2	200	0.45	4.5	–	–	–	190	0.45	4.5	–	–	–	–	–	–	40	0.15	1.0
	T9325	1.2	180	0.45	4.5	–	–	–	170	0.45	4.5	–	–	–	–	–	–	–	–	–
SNMG 150616E-R	**T5315**	1.6	230	0.50	4.5	–	–	–	215	0.50	4.5	–	–	–	–	–	–	45	0.15	1.0
	T9325	1.6	180	0.50	4.5	–	–	–	170	0.50	4.5	–	–	–	–	–	–	–	–	–
SNMG 190612E-R	**6640**	1.2	140	0.45	6.0	–	–	–	130	0.45	6.0	–	–	–	–	–	–	–	–	–
	T9310	1.2	210	0.45	6.0	–	–	–	195	0.45	6.0	–	–	–	–	–	–	40	0.15	1.0
	T9315	1.2	195	0.45	6.0	–	–	–	185	0.45	6.0	–	–	–	–	–	–	35	0.15	1.0
	T9325	1.2	175	0.45	6.0	–	–	–	165	0.45	6.0	–	–	–	–	–	–	–	–	–
SNMG 190616E-R	**T9310**	1.6	205	0.50	6.0	–	–	–	190	0.50	6.0	–	–	–	–	–	–	40	0.15	1.0
	T9315	1.6	195	0.50	6.0	–	–	–	185	0.50	6.0	–	–	–	–	–	–	35	0.15	1.0
	T9325	1.6	175	0.50	6.0	–	–	–	165	0.50	6.0	–	–	–	–	–	–	–	–	–
	T9335	1.6	150	0.50	6.0	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
																				
			RM geometry for semi-rough to rough machining, and continuous to interrupted cuts.																	
SNMG 120408E-RM	**T5305**	0.8	290	0.40	4.0	–	–	–	275	0.40	4.0	–	–	–	–	–	–	–	–	–
	T5315	0.8	260	0.40	4.0	–	–	–	245	0.40	4.0	–	–	–	–	–	–	–	–	–
	T6310	0.8	165	0.40	4.0	115	0.36	4.0	130	0.40	4.0	–	–	–	–	–	–	–	–	–
	T7325	0.8	185	0.40	4.0	140	0.36	4.0	–	–	–	–	–	–	–	–	–	–	–	–
	T7335	0.8	175	0.40	4.0	135	0.36	4.0	–	–	–	–	–	–	–	–	–	–	–	–
	T8315	0.8	175	0.40	4.0	105	0.36	4.0	165	0.40	4.0	–	–	–	–	–	–	–	–	–
	T8330	0.8	165	0.40	4.0	95	0.36	4.0	155	0.40	4.0	–	–	–	–	–	–	–	–	–
	T8430	0.8	175	0.40	4.0	95	0.36	4.0	140	0.40	4.0	–	–	–	–	–	–	–	–	–
	T9310	0.8	250	0.40	4.0	–	–	–	235	0.40	4.0	–	–	–	–	–	–	–	–	–
	T9315	0.8	235	0.40	4.0	–	–	–	220	0.40	4.0	–	–	–	–	–	–	–	–	–
	T9325	0.8	210	0.40	4.0	125	0.36	4.0	195	0.40	4.0	–	–	–	–	–	–	–	–	–
	T9335	0.8	180	0.40	4.0	105	0.36	4.0	–	–	–	–	–	–	–	–	–	–	–	–

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
		[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]
																				
			RM geometry for semi-rough to rough machining, and continuous to interrupted cuts.																	
SNMG 120412E-RM	**T5305**	1.2	295	0.45	4.0	–	–	–	280	0.45	4.0	–	–	–	–	–	–	–	–	–
	T5315	1.2	265	0.45	4.0	–	–	–	250	0.45	4.0	–	–	–	–	–	–	–	–	–
	T6310	1.2	165	0.45	4.0	115	0.41	4.0	130	0.45	4.0	–	–	–	–	–	–	–	–	–
	T7325	1.2	190	0.45	4.0	145	0.41	4.0	–	–	–	–	–	–	–	–	–	–	–	–
	T7335	1.2	180	0.45	4.0	140	0.41	4.0	–	–	–	–	–	–	–	–	–	–	–	–
	T9310	1.2	250	0.45	4.0	–	–	–	235	0.45	4.0	–	–	–	–	–	–	–	–	–
	T9315	1.2	235	0.45	4.0	–	–	–	220	0.45	4.0	–	–	–	–	–	–	–	–	–
	T9325	1.2	210	0.45	4.0	125	0.41	4.0	195	0.45	4.0	–	–	–	–	–	–	–	–	–
	T9335	1.2	185	0.45	4.0	110	0.41	4.0	–	–	–	–	–	–	–	–	–	–	–	–
SNMG 120416E-RM	**T5315**	1.6	270	0.50	4.0	–	–	–	255	0.50	4.0	–	–	–	–	–	–	–	–	–
	T7335	1.6	180	0.50	4.0	140	0.45	4.0	–	–	–	–	–	–	–	–	–	–	–	–
	T8330	1.6	170	0.50	4.0	100	0.45	4.0	160	0.50	4.0	–	–	–	–	–	–	–	–	–
	T8430	1.6	175	0.50	4.0	95	0.45	4.0	140	0.50	4.0	–	–	–	–	–	–	–	–	–
	T9315	1.6	230	0.50	4.0	–	–	–	215	0.50	4.0	–	–	–	–	–	–	–	–	–
	T9325	1.6	215	0.50	4.0	125	0.45	4.0	200	0.50	4.0	–	–	–	–	–	–	–	–	–
	T9335	1.6	180	0.50	4.0	105	0.45	4.0	–	–	–	–	–	–	–	–	–	–	–	–
SNMG 150612E-RM	**T5315**	1.2	255	0.45	5.0	–	–	–	240	0.45	5.0	–	–	–	–	–	–	–	–	–
	T6310	1.2	165	0.45	5.0	115	0.41	5.0	130	0.45	5.0	–	–	–	–	–	–	–	–	–
	T7325	1.2	185	0.45	5.0	140	0.41	5.0	–	–	–	–	–	–	–	–	–	–	–	–
	T7335	1.2	175	0.45	5.0	135	0.41	5.0	–	–	–	–	–	–	–	–	–	–	–	–
	T9310	1.2	245	0.45	5.0	–	–	–	230	0.45	5.0	–	–	–	–	–	–	–	–	–
	T9315	1.2	225	0.45	5.0	–	–	–	210	0.45	5.0	–	–	–	–	–	–	–	–	–
	T9325	1.2	205	0.45	5.0	120	0.41	5.0	190	0.45	5.0	–	–	–	–	–	–	–	–	–
	T9335	1.2	180	0.45	5.0	105	0.41	5.0	–	–	–	–	–	–	–	–	–	–	–	–
SNMG 150616E-RM	**T7335**	1.6	175	0.50	5.0	135	0.45	5.0	–	–	–	–	–	–	–	–	–	–	–	–
	T9315	1.6	230	0.50	5.0	–	–	–	215	0.50	5.0	–	–	–	–	–	–	–	–	–
	T9325	1.6	205	0.50	5.0	120	0.45	5.0	190	0.50	5.0	–	–	–	–	–	–	–	–	–
	T9335	1.6	180	0.50	5.0	105	0.45	5.0	–	–	–	–	–	–	–	–	–	–	–	–
SNMG 190612E-RM	**T5305**	1.2	275	0.45	7.0	–	–	–	260	0.45	7.0	–	–	–	–	–	–	–	–	–
	T5315	1.2	250	0.45	7.0	–	–	–	235	0.45	7.0	–	–	–	–	–	–	–	–	–
	T7325	1.2	180	0.45	7.0	140	0.41	7.0	–	–	–	–	–	–	–	–	–	–	–	–
	T7335	1.2	165	0.45	7.0	125	0.41	7.0	–	–	–	–	–	–	–	–	–	–	–	–
	T9310	1.2	240	0.45	7.0	–	–	–	225	0.45	7.0	–	–	–	–	–	–	–	–	–
	T9315	1.2	220	0.45	7.0	–	–	–	205	0.45	7.0	–	–	–	–	–	–	–	–	–
	T9325	1.2	195	0.45	7.0	115	0.41	7.0	185	0.45	7.0	–	–	–	–	–	–	–	–	–
	T9335	1.2	175	0.45	7.0	105	0.41	7.0	–	–	–	–	–	–	–	–	–	–	–	–
SNMG 190616E-RM	**T5305**	1.6	285	0.50	7.0	–	–	–	270	0.50	7.0	–	–	–	–	–	–	–	–	–
	T5315	1.6	250	0.50	7.0	–	–	–	235	0.50	7.0	–	–	–	–	–	–	–	–	–
	T6310	1.6	160	0.50	7.0	115	0.45	7.0	125	0.50	7.0	–	–	–	–	–	–	–	–	–
	T7335	1.6	170	0.50	7.0	130	0.45	7.0	–	–	–	–	–	–	–	–	–	–	–	–
	T9310	1.6	240	0.50	7.0	–	–	–	225	0.50	7.0	–	–	–	–	–	–	–	–	–
	T9315	1.6	220	0.50	7.0	–	–	–	205	0.50	7.0	–	–	–	–	–	–	–	–	–
	T9325	1.6	200	0.50	7.0	120	0.45	7.0	190	0.50	7.0	–	–	–	–	–	–	–	–	–
	T9335	1.6	175	0.50	7.0	105	0.45	7.0	–	–	–	–	–	–	–	–	–	–	–	–
SNMG 250924E-RM	**T7325**	2.4	110	0.80	12.0	85	0.72	12.0	–	–	–	–	–	–	–	–	–	–	–	–
	T7335	2.4	105	0.80	12.0	80	0.72	12.0	–	–	–	–	–	–	–	–	–	–	–	–
	T9226	2.4	95	0.80	12.0	55	0.72	12.0	90	0.80	12.0	–	–	–	–	–	–	–	–	–
	T9315	2.4	125	0.80	12.0	–	–	–	115	0.80	12.0	–	–	–	–	–	–	–	–	–
	T9325	2.4	110	0.80	12.0	65	0.72	12.0	100	0.80	12.0	–	–	–	–	–	–	–	–	–
	T9335	2.4	90	0.80	12.0	50	0.72	12.0	–	–	–	–	–	–	–	–	–	–	–	–
																				
			SF geometry with positive design for fine-finish machining of thin walls and continuous cuts.																	
SNMG 120404E-SF	**T7325**	0.4	215	0.17	1.0	165	0.15	1.0	–	–	–	–	–	–	65	0.15	0.8	–	–	–
	T9325	0.4	265	0.17	1.0	155	0.15	1.0	250	0.17	1.0	–	–	–	55	0.15	0.8	–	–	–

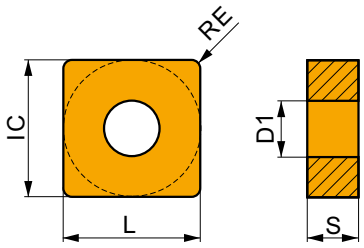
Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

Product		RE	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 and continuous cuts.																	
SNMG 120408E-SF	**H07**	0.8	–	–	–	105	0.18	1.0	165	0.20	1.0	525	0.24	1.0	50	0.14	0.8	–	–	–
	T6310	0.8	210	0.20	1.0	150	0.18	1.0	165	0.20	1.0	630	0.24	1.0	60	0.14	0.8	40	0.15	1.0
	T7325	0.8	245	0.20	1.0	190	0.18	1.0	–	–	–	–	–	–	75	0.16	0.8	–	–	–
	T7335	0.8	235	0.20	1.0	180	0.18	1.0	–	–	–	–	–	–	75	0.16	0.8	–	–	–
	T8315	0.8	225	0.20	1.0	135	0.18	1.0	210	0.20	1.0	675	0.24	1.0	55	0.14	0.8	45	0.15	1.0
	T8330	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
	T8430	0.8	245	0.20	1.0	135	0.18	1.0	200	0.20	1.0	675	0.24	1.0	50	0.14	0.8	40	0.15	1.0
	T9325	0.8	295	0.20	1.0	175	0.18	1.0	280	0.20	1.0	–	–	–	65	0.16	0.8	–	–	–
SNMG 120412E-SF	**T6310**	1.2	200	0.25	1.5	140	0.23	1.5	160	0.25	1.5	600	0.30	1.5	60	0.18	1.2	40	0.15	1.0
	T7325	1.2	230	0.25	1.5	175	0.23	1.5	–	–	–	–	–	–	70	0.18	1.2	–	–	–
	T8330	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	225	0.25	1.5	120	0.23	1.5	185	0.25	1.5	615	0.30	1.5	45	0.18	1.2	35	0.15	1.0
																				
			SM geometry with positive design for medium machining and continuous to interrupted cuts.																	
SNMG 120408E-SM	**T6310**	0.8	185	0.25	1.8	130	0.23	1.8	145	0.25	1.8	555	0.30	1.8	55	0.20	1.4	35	0.15	1.0
	T7325	0.8	210	0.25	1.8	160	0.23	1.8	–	–	–	–	–	–	65	0.20	1.4	–	–	–
	T7335	0.8	205	0.25	1.8	155	0.23	1.8	–	–	–	–	–	–	65	0.20	1.4	–	–	–
	T8330	0.8	185	0.25	1.8	110	0.23	1.8	175	0.25	1.8	555	0.30	1.8	45	0.20	1.4	35	0.15	1.0
	T8430	0.8	205	0.25	1.8	110	0.23	1.8	170	0.25	1.8	570	0.30	1.8	45	0.20	1.4	35	0.15	1.0
	T9315	0.8	280	0.25	1.8	–	–	–	265	0.25	1.8	–	–	–	–	–	–	55	0.15	1.0
	T9325	0.8	255	0.25	1.8	150	0.23	1.8	240	0.25	1.8	–	–	–	55	0.20	1.4	–	–	–
SNMG 120412E-SM	**T7325**	1.2	210	0.30	1.8	160	0.27	1.8	–	–	–	–	–	–	65	0.24	1.4	–	–	–
	T7335	1.2	200	0.30	1.8	155	0.27	1.8	–	–	–	–	–	–	65	0.24	1.4	–	–	–
	T9315	1.2	275	0.30	1.8	–	–	–	260	0.30	1.8	–	–	–	–	–	–	55	0.15	1.0
	T9325	1.2	245	0.30	1.8	145	0.27	1.8	230	0.30	1.8	–	–	–	55	0.24	1.4	–	–	–
SNMG 190612E-SM	**T6310**	1.2	175	0.30	4.0	125	0.27	4.0	140	0.30	4.0	525	0.36	4.0	50	0.27	3.2	35	0.15	1.0
	T7325	1.2	195	0.30	4.0	150	0.27	4.0	–	–	–	–	–	–	60	0.27	3.2	–	–	–
	T7335	1.2	185	0.30	4.0	140	0.27	4.0	–	–	–	–	–	–	60	0.27	3.2	–	–	–
	T9325	1.2	230	0.30	4.0	135	0.27	4.0	215	0.30	4.0	–	–	–	50	0.27	3.2	–	–	–
SNMG 190616E-SM	**T7325**	1.6	190	0.40	4.0	145	0.36	4.0	–	–	–	–	–	–	60	0.32	3.2	–	–	–
	T7335	1.6	175	0.40	4.0	135	0.36	4.0	–	–	–	–	–	–	55	0.32	3.2	–	–	–
	T9325	1.6	210	0.40	4.0	125	0.36	4.0	195	0.40	4.0	–	–	–	45	0.32	3.2	–	–	–

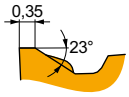
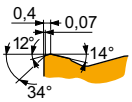
SNMM

PRAMET

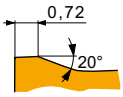
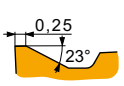
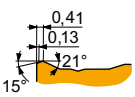
	IC [mm]	D1 [mm]	L [mm]	S [mm]
1204	12.700	5.16	12.70	4.76
1506	15.875	6.35	15.875	6.35
1906	19.050	7.94	19.05	6.35
2507	25.400	9.12	25.40	7.94
2509	25.400	9.12	25.40	9.525



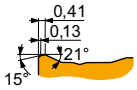
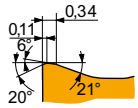
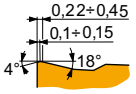
Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

Product		RE [mm]	P vc [m/min]	P f [mm/rev]	P ap [mm]	M vc [m/min]	M f [mm/rev]	M ap [mm]	K vc [m/min]	K f [mm/rev]	K ap [mm]	N vc [m/min]	N f [mm/rev]	N ap [mm]	S vc [m/min]	S f [mm/rev]	S ap [mm]	H vc [m/min]	H f [mm/rev]	H ap [mm]
																				
			DR geometry for semi-rough to rough machining, and continuous to interrupted cuts.																	
SNMM 120412E-DR	**T9315**	1.2	245	0.45	4.7	–	–	–	230	0.45	4.7	–	–	–	–	–	–	–	–	–
	T9325	1.2	220	0.45	4.7	130	0.41	4.7	205	0.45	4.7	–	–	–	–	–	–	–	–	–
	T9335	1.2	185	0.45	4.7	110	0.41	4.7	–	–	–	–	–	–	–	–	–	–	–	–
SNMM 150612E-DR	**T9325**	1.2	210	0.45	6.0	125	0.41	6.0	195	0.45	6.0	–	–	–	–	–	–	–	–	–
	T9335	1.2	180	0.45	6.0	105	0.41	6.0	–	–	–	–	–	–	–	–	–	–	–	–
SNMM 190612E-DR	**6640**	1.2	170	0.45	6.0	100	0.41	6.0	160	0.45	6.0	–	–	–	–	–	–	–	–	–
	T9325	1.2	210	0.45	6.0	125	0.41	6.0	195	0.45	6.0	–	–	–	–	–	–	–	–	–
	T9335	1.2	180	0.45	6.0	105	0.41	6.0	–	–	–	–	–	–	–	–	–	–	–	–
SNMM 190616E-DR	**T9325**	1.6	210	0.50	6.0	125	0.45	6.0	195	0.50	6.0	–	–	–	–	–	–	–	–	–
	T9335	1.6	185	0.50	6.0	110	0.45	6.0	–	–	–	–	–	–	–	–	–	–	–	–
																				
			HR geometry for rough to heavy-rough machining, and continuous to interrupted cuts.																	
SNMM 190616E-HR	**T8345**	1.6	60	0.60	9.0	35	0.54	9.0	55	0.60	9.0	–	–	–	–	–	–	–	–	–
	T9325	1.6	110	0.60	9.0	65	0.54	9.0	100	0.60	9.0	–	–	–	–	–	–	–	–	–
	T9335	1.6	85	0.60	9.0	50	0.54	9.0	–	–	–	–	–	–	–	–	–	–	–	–
SNMM 190624E-HR	**T8345**	2.4	60	0.65	9.0	35	0.59	9.0	55	0.65	9.0	–	–	–	–	–	–	–	–	–
	T9315	2.4	120	0.65	9.0	–	–	–	110	0.65	9.0	–	–	–	–	–	–	–	–	–
	T9325	2.4	115	0.65	9.0	65	0.59	9.0	105	0.65	9.0	–	–	–	–	–	–	–	–	–
	T9335	2.4	90	0.65	9.0	50	0.59	9.0	–	–	–	–	–	–	–	–	–	–	–	–
SNMM 250716E-HR	**T8345**	1.6	60	0.60	13.0	35	0.54	13.0	55	0.60	13.0	–	–	–	–	–	–	–	–	–
	T9325	1.6	100	0.60	13.0	60	0.54	13.0	95	0.60	13.0	–	–	–	–	–	–	–	–	–
	T9335	1.6	85	0.60	13.0	50	0.54	13.0	–	–	–	–	–	–	–	–	–	–	–	–
SNMM 250724E-HR	**6640**	2.4	80	0.65	13.0	45	0.59	13.0	75	0.65	13.0	–	–	–	–	–	–	–	–	–
	T8345	2.4	55	0.65	13.0	30	0.59	13.0	50	0.65	13.0	–	–	–	–	–	–	–	–	–
	T9315	2.4	120	0.65	13.0	–	–	–	110	0.65	13.0	–	–	–	–	–	–	–	–	–
	T9325	2.4	105	0.65	13.0	60	0.59	13.0	95	0.65	13.0	–	–	–	–	–	–	–	–	–
	T9335	2.4	85	0.65	13.0	50	0.59	13.0	–	–	–	–	–	–	–	–	–	–	–	–
SNMM 250732E-HR	**T9325**	3.2	95	0.80	13.0	55	0.72	13.0	90	0.80	13.0	–	–	–	–	–	–	–	–	–
SNMM 250924E-HR	**T8345**	2.4	55	0.65	13.0	30	0.59	13.0	50	0.65	13.0	–	–	–	–	–	–	–	–	–
	T9315	2.4	120	0.65	13.0	–	–	–	110	0.65	13.0	–	–	–	–	–	–	–	–	–
	T9325	2.4	105	0.65	13.0	60	0.59	13.0	95	0.65	13.0	–	–	–	–	–	–	–	–	–
	T9335	2.4	85	0.65	13.0	50	0.59	13.0	–	–	–	–	–	–	–	–	–	–	–	–
SNMM 250932E-HR	**T9325**	3.2	95	0.80	13.0	55	0.72	13.0	90	0.80	13.0	–	–	–	–	–	–	–	–	–

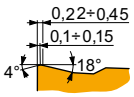
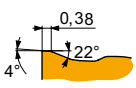
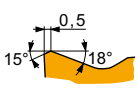
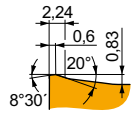
Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

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
		[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]
																				
HR2 geometry for rough to heavy-rough machining, and continuous to interrupted cuts.																				
SNMM 190616-HR2	**T9315**	1.6	115	0.65	8.9	–	–	–	105	0.65	8.9	–	–	–	–	–	–	–	–	–
	T9335	1.6	85	0.65	8.9	50	0.59	8.9	–	–	–	–	–	–	–	–	–	–	–	–
SNMM 190624-HR2	**T9315**	2.4	105	0.85	8.9	–	–	–	95	0.85	8.9	–	–	–	–	–	–	–	–	–
	T9335	2.4	80	0.85	8.9	45	0.77	8.9	–	–	–	–	–	–	–	–	–	–	–	–
SNMM 250724-HR2	**T9226**	2.4	85	0.85	11.0	50	0.77	11.0	80	0.85	11.0	–	–	–	–	–	–	–	–	–
	T9315	2.4	105	0.85	11.0	–	–	–	95	0.85	11.0	–	–	–	–	–	–	–	–	–
	T9335	2.4	80	0.85	11.0	45	0.77	11.0	–	–	–	–	–	–	–	–	–	–	–	–
SNMM 250732-HR2	**T9315**	3.2	95	1.00	11.0	–	–	–	90	1.00	11.0	–	–	–	–	–	–	–	–	–
SNMM 250924-HR2	**T9226**	2.4	85	0.85	11.0	50	0.77	11.0	80	0.85	11.0	–	–	–	–	–	–	–	–	–
	T9315	2.4	105	0.85	11.0	–	–	–	95	0.85	11.0	–	–	–	–	–	–	–	–	–
	T9335	2.4	80	0.85	11.0	45	0.77	11.0	–	–	–	–	–	–	–	–	–	–	–	–
SNMM 250932-HR2	**T9315**	3.2	95	1.00	11.0	–	–	–	90	1.00	11.0	–	–	–	–	–	–	–	–	–
	T9335	3.2	75	1.00	11.0	45	0.90	11.0	–	–	–	–	–	–	–	–	–	–	–	–
																				
NR geometry for semi-rough to rough machining, and continuous to interrupted cuts.																				
SNMM 120408E-NR	**T7325**	0.8	185	0.40	3.0	140	0.36	3.0	–	–	–	–	–	–	60	0.28	2.4	–	–	–
	T7335	0.8	175	0.40	3.0	135	0.36	3.0	–	–	–	–	–	–	55	0.28	2.4	–	–	–
	T8330	0.8	160	0.40	3.0	95	0.36	3.0	150	0.40	3.0	–	–	–	40	0.28	2.4	–	–	–
	T8430	0.8	170	0.40	3.0	90	0.36	3.0	135	0.40	3.0	–	–	–	35	0.28	2.4	–	–	–
	T9325	0.8	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.																				
SNMM 120408E-NR2	**T7325**	0.8	175	0.40	4.7	135	0.36	4.7	–	–	–	–	–	–	55	0.32	3.8	–	–	–
	T7335	0.8	170	0.40	4.7	130	0.36	4.7	–	–	–	–	–	–	55	0.32	3.8	–	–	–
	T8330	0.8	155	0.40	4.7	90	0.36	4.7	145	0.40	4.7	–	–	–	35	0.32	3.8	–	–	–
	T8430	0.8	165	0.40	4.7	90	0.36	4.7	135	0.40	4.7	–	–	–	35	0.32	3.8	–	–	–
	T9325	0.8	195	0.40	4.7	115	0.36	4.7	185	0.40	4.7	–	–	–	40	0.32	3.8	–	–	–
SNMM 120412E-NR2	**T7335**	1.2	165	0.45	4.7	125	0.41	4.7	–	–	–	–	–	–	50	0.36	3.8	–	–	–
	T8330	1.2	160	0.45	4.7	95	0.41	4.7	150	0.45	4.7	–	–	–	40	0.36	3.8	–	–	–
	T8430	1.2	165	0.45	4.7	90	0.41	4.7	135	0.45	4.7	–	–	–	35	0.36	3.8	–	–	–
	T9325	1.2	200	0.45	4.7	120	0.41	4.7	190	0.45	4.7	–	–	–	45	0.36	3.8	–	–	–
SNMM 150612E-NR2	**T7325**	1.2	170	0.45	6.0	130	0.41	6.0	–	–	–	–	–	–	55	0.36	4.8	–	–	–
	T7335	1.2	165	0.45	6.0	125	0.41	6.0	–	–	–	–	–	–	50	0.36	4.8	–	–	–
	T8330	1.2	155	0.45	6.0	90	0.41	6.0	145	0.45	6.0	–	–	–	35	0.36	4.8	–	–	–
	T8430	1.2	165	0.45	6.0	90	0.41	6.0	135	0.45	6.0	–	–	–	35	0.36	4.8	–	–	–
	T9325	1.2	195	0.45	6.0	115	0.41	6.0	185	0.45	6.0	–	–	–	40	0.36	4.8	–	–	–
SNMM 150616E-NR2	**T7335**	1.6	165	0.50	6.0	125	0.45	6.0	–	–	–	–	–	–	50	0.40	4.8	–	–	–
	T9325	1.6	190	0.50	6.0	110	0.45	6.0	180	0.50	6.0	–	–	–	40	0.40	4.8	–	–	–
SNMM 190612E-NR2	**T7335**	1.2	160	0.45	8.0	120	0.41	8.0	–	–	–	–	–	–	50	0.36	6.4	–	–	–
	T9325	1.2	190	0.45	8.0	110	0.41	8.0	180	0.45	8.0	–	–	–	40	0.36	6.4	–	–	–
SNMM 190616E-NR2	**T7325**	1.6	175	0.50	8.0	135	0.45	8.0	–	–	–	–	–	–	55	0.40	6.4	–	–	–
	T7335	1.6	160	0.50	8.0	120	0.45	8.0	–	–	–	–	–	–	50	0.40	6.4	–	–	–
	T8330	1.6	155	0.50	8.0	90	0.45	8.0	145	0.50	8.0	–	–	–	35	0.40	6.4	–	–	–
	T8430	1.6	155	0.50	8.0	85	0.45	8.0	130	0.50	8.0	–	–	–	30	0.40	6.4	–	–	–
	T9315	1.6	210	0.50	8.0	–	–	–	195	0.50	8.0	–	–	–	–	–	–	–	–	–
	T9325	1.6	185	0.50	8.0	110	0.45	8.0	175	0.50	8.0	–	–	–	40	0.40	6.4	–	–	–
SNMM 190624E-NR2	**T7325**	2.4	155	0.80	8.0	120	0.72	8.0	–	–	–	–	–	–	50	0.56	6.4	–	–	–
	T7335	2.4	145	0.80	8.0	110	0.72	8.0	–	–	–	–	–	–	45	0.56	6.4	–	–	–
	T9325	2.4	165	0.80	8.0	95	0.72	8.0	155	0.80	8.0	–	–	–	35	0.56	6.4	–	–	–

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 [m/min]	f [mm/rev]	ap [mm]	vc [m/min]	f [mm/rev]	ap [mm]	vc [m/min]	f [mm/rev]	ap [mm]	vc [m/min]	f [mm/rev]	ap [mm]	vc [m/min]	f [mm/rev]	ap [mm]	vc [m/min]	f [mm/rev]	ap [mm]
			NR2 geometry for semi-rough to rough machining, and continuous to interrupted cuts.																	
SNMM 250724E-NR2	**T7335**	2.4	◪ 100	0.80	12.0	■ 75	0.72	12.0		–	–	–	–	–	–	◪ 30	0.56	9.6	–	–	–
	T8330	2.4	■ 85	0.80	12.0	■ 50	0.72	12.0	◪ 80	0.80	12.0	–	–	–	◪ 20	0.56	9.6	–	–	–
	T8430	2.4	■ 85	0.80	12.0	■ 45	0.72	12.0	◪ 70	0.80	12.0	–	–	–	◪ 15	0.56	9.6	–	–	–
	T9226	2.4	■ 95	0.80	12.0	■ 55	0.72	12.0	◪ 90	0.80	12.0	–	–	–	◪ 20	0.56	9.6	–	–	–
	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	–	–	–	◪ 20	0.56	9.6	–	–	–
SNMM 250924E-NR2	**T7325**	2.4	◪ 105	0.80	12.0	■ 80	0.72	12.0		–	–	–	–	–	–	◪ 30	0.56	9.6	–	–	–
	T7335	2.4	◪ 100	0.80	12.0	■ 75	0.72	12.0		–	–	–	–	–	–	◪ 30	0.56	9.6	–	–	–
	T9226	2.4	■ 95	0.80	12.0	■ 55	0.72	12.0	◪ 90	0.80	12.0	–	–	–	◪ 20	0.56	9.6	–	–	–
	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	–	–	–	◪ 20	0.56	9.6	–	–	–
			NRM geometry with positive design for semi-rough to rough machining, and continuous to moderate interrupted cuts.																	
SNMM 250716-NRM	**T7325**	1.6	◪ 115	0.45	9.0	■ 85	0.41	9.0		–	–	–	–	–	–	■ 35	0.36	7.2	–	–	–
	T7335	1.6	◪ 110	0.45	9.0	■ 85	0.41	9.0		–	–	–	–	–	–	■ 35	0.36	7.2	–	–	–
	T9315	1.6	■ 135	0.45	9.0	–	–	–	◪ 125	0.45	9.0	–	–	–	–	–	–	–	–	–
SNMM 250724-NRM	**T7325**	2.4	◪ 105	0.65	9.0	■ 80	0.59	9.0		–	–	–	–	–	–	■ 30	0.46	7.2	–	–	–
	T7335	2.4	◪ 100	0.65	9.0	■ 75	0.59	9.0		–	–	–	–	–	–	■ 30	0.46	7.2	–	–	–
	T9315	2.4	■ 120	0.65	9.0	–	–	–	◪ 110	0.65	9.0	–	–	–	–	–	–	–	–	–
SNMM 250924-NRM	**T7325**	2.4	◪ 105	0.70	9.0	■ 80	0.63	9.0		–	–	–	–	–	–	■ 30	0.49	7.2	–	–	–
	T7335	2.4	◪ 95	0.70	9.0	■ 70	0.63	9.0		–	–	–	–	–	–	■ 30	0.49	7.2	–	–	–
	T9315	2.4	■ 120	0.70	9.0	–	–	–	◪ 110	0.70	9.0	–	–	–	–	–	–	–	–	–
			OR geometry for semi-rough to rough machining, and continuous to interrupted cuts.																	
SNMM 120408E-OR	**T9315**	0.8	■ 220	0.40	4.7	–	–	–	◪ 205	0.40	4.7	–	–	–	–	–	–	–	–	–
	T9325	0.8	■ 195	0.40	4.7	◪ 115	0.36	4.7	◪ 185	0.40	4.7	–	–	–	◪ 40	0.32	3.8	–	–	–
	T9335	0.8	■ 175	0.40	4.7	◪ 105	0.36	4.7	–	–	–	–	–	–	◪ 35	0.32	3.8	–	–	–
SNMM 120412E-OR	**T9315**	1.2	■ 225	0.45	4.7	–	–	–	◪ 210	0.45	4.7	–	–	–	–	–	–	–	–	–
	T9325	1.2	■ 200	0.45	4.7	◪ 120	0.41	4.7	◪ 190	0.45	4.7	–	–	–	◪ 45	0.36	3.8	–	–	–
SNMM 120416E-OR	**T9325**	1.6	■ 200	0.50	4.7	◪ 120	0.45	4.7	◪ 190	0.50	4.7	–	–	–	◪ 45	0.40	3.8	–	–	–
SNMM 150608E-OR	**T9325**	0.8	■ 185	0.45	6.0	◪ 110	0.41	6.0	◪ 175	0.45	6.0	–	–	–	◪ 40	0.41	4.8	–	–	–
	T9335	0.8	■ 170	0.40	6.0	◪ 100	0.36	6.0	–	–	–	–	–	–	◪ 35	0.36	4.8	–	–	–
SNMM 150612E-OR	**T9325**	1.2	■ 195	0.45	6.0	◪ 115	0.41	6.0	◪ 185	0.45	6.0	–	–	–	◪ 40	0.36	4.8	–	–	–
	T9335	1.2	■ 165	0.45	6.0	◪ 95	0.41	6.0	–	–	–	–	–	–	◪ 35	0.36	4.8	–	–	–
SNMM 150616E-OR	**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	–	–	–	◪ 40	0.40	4.8	–	–	–
SNMM 190612E-OR	**T8330**	1.2	■ 150	0.45	8.0	◪ 90	0.41	8.0	■ 140	0.45	8.0	–	–	–	◪ 35	0.36	6.4	–	–	–
	T8430	1.2	■ 150	0.45	8.0	◪ 80	0.41	8.0	◪ 125	0.45	8.0	–	–	–	◪ 30	0.36	6.4	–	–	–
	T9315	1.2	■ 210	0.45	8.0	–	–	–	◪ 195	0.45	8.0	–	–	–	–	–	–	–	–	–
	T9325	1.2	■ 190	0.45	8.0	◪ 110	0.41	8.0	◪ 180	0.45	8.0	–	–	–	◪ 40	0.36	6.4	–	–	–
	T9335	1.2	■ 165	0.45	8.0	◪ 95	0.41	8.0	–	–	–	–	–	–	◪ 35	0.36	6.4	–	–	–
SNMM 190616E-OR	**T8330**	1.6	■ 155	0.50	8.0	◪ 90	0.45	8.0	■ 145	0.50	8.0	–	–	–	◪ 35	0.40	6.4	–	–	–
	T8345	1.6	■ 125	0.50	8.0	◪ 75	0.45	8.0	◪ 115	0.50	8.0	–	–	–	◪ 30	0.40	6.4	–	–	–
	T8430	1.6	■ 155	0.50	8.0	◪ 85	0.45	8.0	◪ 130	0.50	8.0	–	–	–	◪ 30	0.40	6.4	–	–	–
	T9315	1.6	■ 210	0.50	8.0	–	–	–	◪ 195	0.50	8.0	–	–	–	–	–	–	–	–	–
	T9325	1.6	■ 185	0.50	8.0	◪ 110	0.45	8.0	◪ 175	0.50	8.0	–	–	–	◪ 40	0.40	6.4	–	–	–
	T9335	1.6	■ 160	0.50	8.0	◪ 95	0.45	8.0	–	–	–	–	–	–	◪ 35	0.40	6.4	–	–	–
SNMM 190624E-OR	**T9315**	2.4	■ 180	0.80	8.0	–	–	–	◪ 170	0.80	8.0	–	–	–	–	–	–	–	–	–
	T9325	2.4	■ 165	0.80	8.0	◪ 95	0.72	8.0	◪ 155	0.80	8.0	–	–	–	◪ 35	0.56	6.4	–	–	–
SNMM 250716E-OR	**T9226**	1.6	■ 115	0.50	12.0	◪ 65	0.45	12.0	◪ 105	0.50	12.0	–	–	–	◪ 20	0.45	9.6	–	–	–
	T9325	1.6	■ 120	0.55	12.0	◪ 70	0.50	12.0	◪ 110	0.55	12.0	–	–	–	◪ 25	0.50	9.6	–	–	–

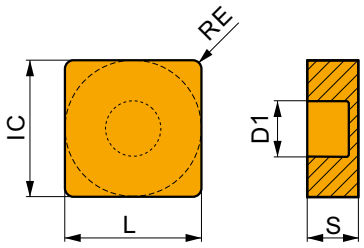
Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

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]
			OR geometry for semi-rough to rough machining, and continuous to interrupted cuts.																	
SNMM 250724E-OR	**T8330**	2.4	80	1.00	12.0	45	0.90	12.0	75	1.00	12.0	–	–	–	20	0.70	9.6	–	–	–
	T8345	2.4	55	1.00	12.0	30	0.90	12.0	50	1.00	12.0	–	–	–	10	0.70	9.6	–	–	–
	T8430	2.4	80	1.00	12.0	45	0.90	12.0	65	1.00	12.0	–	–	–	15	0.70	9.6	–	–	–
	T9315	2.4	105	1.00	12.0	–	–	–	95	1.00	12.0	–	–	–	–	–	–	–	–	–
	T9325	2.4	100	1.00	12.0	60	0.90	12.0	95	1.00	12.0	–	–	–	20	0.70	9.6	–	–	–
	T9335	2.4	80	1.00	12.0	45	0.90	12.0	–	–	–	–	–	–	15	0.70	9.6	–	–	–
SNMM 250924E-OR	**T8430**	2.4	80	1.00	12.0	45	0.90	12.0	65	1.00	12.0	–	–	–	15	0.70	9.6	–	–	–
	T9226	2.4	85	1.00	12.0	50	0.90	12.0	80	1.00	12.0	–	–	–	15	0.70	9.6	–	–	–
	T9315	2.4	105	1.00	12.0	–	–	–	95	1.00	12.0	–	–	–	–	–	–	–	–	–
	T9325	2.4	100	1.00	12.0	60	0.90	12.0	95	1.00	12.0	–	–	–	20	0.70	9.6	–	–	–
	T9335	2.4	80	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.																	
SNMM 190616E-OR1	**T9325**	1.6	185	0.50	8.0	110	0.45	8.0	175	0.50	8.0	–	–	–	40	0.35	6.4	–	–	–
	T9335	1.6	160	0.50	8.0	95	0.45	8.0	–	–	–	–	–	–	35	0.35	6.4	–	–	–
			SR geometry for rough to heavy-rough machining, and continuous to interrupted cuts.																	
SNMM 250724S-SR	**6640**	2.4	60	1.00	12.0	35	0.90	12.0	55	1.00	12.0	–	–	–	–	–	–	–	–	–
	T9226	2.4	70	1.00	12.0	40	0.90	12.0	65	1.00	12.0	–	–	–	–	–	–	–	–	–
	T9325	2.4	80	1.00	12.0	45	0.90	12.0	75	1.00	12.0	–	–	–	–	–	–	–	–	–
SNMM 250924S-SR	**T9335**	2.4	65	1.00	14.0	35	0.90	14.0	–	–	–	–	–	–	–	–	–	–	–	–
			Geometry 923 for semi-rough to heavy-rough machining, and continuous to heavy interrupted cuts.																	
SNMM 190616S-923	**T8330**	1.6	125	0.65	8.9	75	0.59	8.9	115	0.65	8.9	–	–	–	30	0.52	7.1	–	–	–
	T8345	1.6	100	0.65	8.9	60	0.59	8.9	95	0.65	8.9	–	–	–	25	0.52	7.1	–	–	–
	T8430	1.6	125	0.65	8.9	65	0.59	8.9	100	0.65	8.9	–	–	–	25	0.52	7.1	–	–	–
	T9335	1.6	130	0.65	8.9	75	0.59	8.9	–	–	–	–	–	–	25	0.52	7.1	–	–	–
SNMM 250724S-923	**T8330**	2.4	80	0.85	11.0	45	0.77	11.0	75	0.85	11.0	–	–	–	20	0.60	8.8	–	–	–
	T8430	2.4	80	0.85	11.0	45	0.77	11.0	65	0.85	11.0	–	–	–	15	0.60	8.8	–	–	–
	T9335	2.4	80	0.85	11.0	45	0.77	11.0	–	–	–	–	–	–	15	0.60	8.8	–	–	–
SNMM 250924S-923	**T8345**	2.4	55	0.85	11.0	30	0.77	11.0	50	0.85	11.0	–	–	–	10	0.60	8.8	–	–	–
	T8430	2.4	80	0.85	11.0	45	0.77	11.0	65	0.85	11.0	–	–	–	15	0.60	8.8	–	–	–
	T9226	2.4	85	0.85	11.0	50	0.77	11.0	80	0.85	11.0	–	–	–	15	0.60	8.8	–	–	–
	T9315	2.4	105	0.85	11.0	–	–	–	95	0.85	11.0	–	–	–	–	–	–	–	–	–
	T9335	2.4	80	0.85	11.0	45	0.77	11.0	–	–	–	–	–	–	15	0.60	8.8	–	–	–
SNMM 250932S-923	**T9226**	3.2	80	1.00	11.0	45	0.90	11.0	75	1.00	11.0	–	–	–	15	0.70	8.8	–	–	–

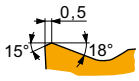
SNMX

PRAMET

	IC [mm]	D1 [mm]	L [mm]	S [mm]
2512	25.400	9.17	25.40	12.00



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

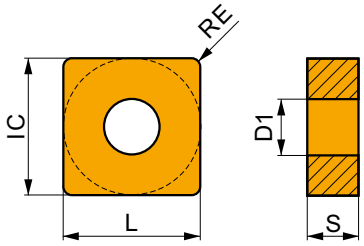
Product		RE [mm]	P vc [m/min]	P f [mm/rev]	P ap [mm]	M vc [m/min]	M f [mm/rev]	M ap [mm]	K vc [m/min]	K f [mm/rev]	K ap [mm]	N vc [m/min]	N f [mm/rev]	N ap [mm]	S vc [m/min]	S f [mm/rev]	S ap [mm]	H vc [m/min]	H f [mm/rev]	H ap [mm]
																				
SNMX 251224S-SR	T8345	2.4	45	1.00	14.0	25	0.90	14.0	40	1.00	14.0	–	–	–	–	–	–	–	–	–
	T9325	2.4	80	1.00	14.0	45	0.90	14.0	75	1.00	14.0	–	–	–	–	–	–	–	–	–
	T9335	2.4	65	1.00	14.0	35	0.90	14.0	–	–	–	–	–	–	–	–	–	–	–	–

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

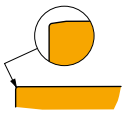
SNGA CER

PRAMET

	IC [mm]	D1 [mm]	L [mm]	S [mm]
1204	12.700	5.16	12.70	4.76



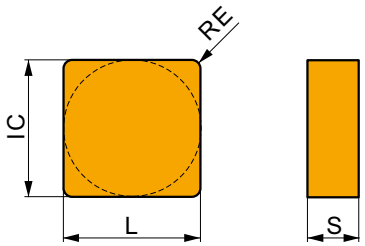
Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

Product		RE [mm]	P vc [m/min]	P f [mm/rev]	P ap [mm]	M vc [m/min]	M f [mm/rev]	M ap [mm]	K vc [m/min]	K f [mm/rev]	K ap [mm]	N vc [m/min]	N f [mm/rev]	N ap [mm]	S vc [m/min]	S f [mm/rev]	S ap [mm]	H vc [m/min]	H f [mm/rev]	H ap [mm]
																				
SNGA 120408 T01025	TC100	0.8	–	–	–	–	–	–	575	0.20	2.0	–	–	–	–	–	–	–	–	–
SNGA 120412 T01020	TC100	1.2	–	–	–	–	–	–	565	0.25	2.0	–	–	–	–	–	–	–	–	–

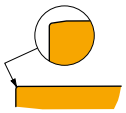
For machining with high speeds and continuous cuts.

SNGN CER

	IC [mm]	L [mm]	S [mm]
0903	9.525	9.525	3.18
1204	12.700	12.70	4.76
1207	12.700	12.70	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 [mm]	P vc [m/min]	P f [mm/rev]	P ap [mm]	M vc [m/min]	M f [mm/rev]	M ap [mm]	K vc [m/min]	K f [mm/rev]	K ap [mm]	N vc [m/min]	N f [mm/rev]	N ap [mm]	S vc [m/min]	S f [mm/rev]	S ap [mm]	H vc [m/min]	H f [mm/rev]	H ap [mm]
			HSC		T															
			For machining with high speeds and continuous cuts.																	
SNGN 090308 T01020	**TC100**	0.8	–	–	–	–	–	–	☑ 580	0.20	1.8	–	–	–	–	–	–	–	–	–
SNGN 090312 T01020	**TC100**	1.2	–	–	–	–	–	–	☑ 565	0.25	1.8	–	–	–	–	–	–	–	–	–
SNGN 120404 T01020	**TC100**	0.4	–	–	–	–	–	–	☑ 620	0.10	2.0	–	–	–	–	–	–	–	–	–
SNGN 120408 T01020	**TC100**	0.8	–	–	–	–	–	–	☑ 575	0.20	2.0	–	–	–	–	–	–	–	–	–
SNGN 120708 T01020	**TC100**	0.8	–	–	–	–	–	–	☑ 575	0.20	2.0	–	–	–	–	–	–	–	–	–
SNGN 120712 T01020	**TC100**	1.2	–	–	–	–	–	–	☑ 565	0.25	2.0	–	–	–	–	–	–	–	–	–