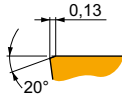




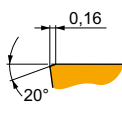
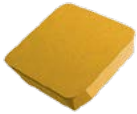
Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

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/tooth]	[mm]	[m/min]	[mm/tooth]	[mm]	[m/min]	[mm/tooth]	[mm]	[m/min]	[mm/tooth]	[mm]	[m/min]	[mm/tooth]	[mm]	[m/min]	[mm/tooth]	[mm]



EDSR edge preparation with zero rake angle geometry for medium machining.

SPKN 1203EDSR	8215	—	240	0.20	4.0	—	—	—	225	0.20	4.0	—	—	—	—	—	—	45	0.15	1.0
	H10	—	—	—	—	—	—	—	100	0.20	4.0	—	—	—	—	—	—	—	—	—
	M8330	—	240	0.20	4.0	—	—	—	225	0.20	4.0	—	—	—	—	—	—	45	0.15	1.0
	M8340	—	215	0.20	4.0	—	—	—	200	0.20	4.0	—	—	—	—	—	—	—	—	—
	M9325	—	290	0.20	4.0	—	—	—	275	0.20	4.0	—	—	—	—	—	—	55	0.15	1.0
	S26	—	95	0.20	4.0	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—



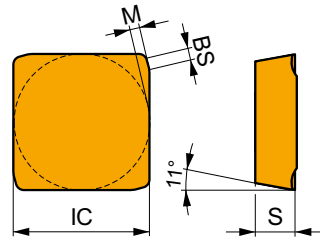
EDSR (right-hand cut) / EDLS (left-hand cut) edge preparation with zero rake angle geometry for medium machining.

SPKN 1504EDSL	M8340	—	205	0.25	5.0	—	—	—	190	0.25	5.0	—	—	—	—	—	—	—	—	—
SPKN 1504EDSR	8215	—	220	0.25	5.0	—	—	—	205	0.25	5.0	—	—	—	—	—	—	40	0.15	1.0
	H10	—	—	—	—	—	—	—	95	0.25	5.0	—	—	—	—	—	—	—	—	—
	M8330	—	220	0.25	5.0	—	—	—	205	0.25	5.0	—	—	—	—	—	—	40	0.15	1.0
	M8340	—	205	0.25	5.0	—	—	—	190	0.25	5.0	—	—	—	—	—	—	—	—	—
	M9315	—	285	0.25	5.0	—	—	—	270	0.25	5.0	—	—	—	—	—	—	55	0.15	1.0
	M9325	—	270	0.25	5.0	—	—	—	255	0.25	5.0	—	—	—	—	—	—	50	0.15	1.0
	S26	—	90	0.25	5.0	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—

SPKR

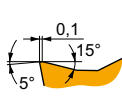
PRAMET

	IC	L	M	S
	(mm)	(mm)	(mm)	(mm)
1203	12.700	12.70	1	3.18
1504	15.875	15.88	1	4.76



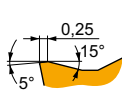
Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

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/tooth]	[mm]	[m/min]	[mm/tooth]	[mm]	[m/min]	[mm/tooth]	[mm]	[m/min]	[mm/tooth]	[mm]	[m/min]	[mm/tooth]	[mm]	[m/min]	[mm/tooth]	[mm]



EDSR edge preparation, chipbreaker geometry for medium to heavy machining.

SPKR 1203EDSR	M8330	—	265	0.20	4.0	155	0.18	4.0	250	0.20	4.0	—	—	—	—	—	—	—	—	—
	M8340	—	240	0.20	4.0	140	0.18	4.0	225	0.20	4.0	—	—	—	—	—	—	—	—	—
	M9340	—	295	0.20	4.0	175	0.18	4.0	—	—	—	—	—	—	—	—	—	—	—	—



EDSR edge preparation, chipbreaker geometry for medium to heavy machining.

SPKR 1504EDSR	M8330	—	245	0.25	5.0	145	0.25	5.0	230	0.25	5.0	—	—	—	—	—	—	—	—	—
	M8340	—	225	0.25	5.0	135	0.25	5.0	210	0.25	5.0	—	—	—	—	—	—	—	—	—