



TC

06/ 09/ 11/16

CARBIDE INSERTS

TCGT	TCMT	TCMW
		
 149	 150	 154

CBN INSERTS

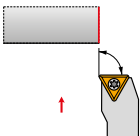
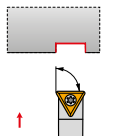
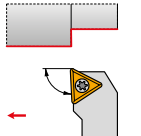
TCGW CBN

 154

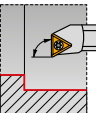
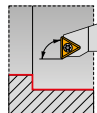
MATCH THE RIGHT SIZE (example)

Insert	Tool Holder
TCMT 110204E-FF2	STFCR 1616 H 11

ISO TURNING – EXTERNAL

STFC(RL) EXT	STFC(RL)-A EXT	STJC(RL) EXT
90°	90°	93°
		
TC..	TC..	TC..
11 16	11	11 16
 16×16 25×25	 20×20	 16×16 25×25
 155	 156	 157
 149 – 154	 149 – 154	 149 – 154

ISO TURNING – INTERNAL

STFC(RL) INT	STFC(RL)-E INT
90°	90°
	
TC..	TC..
06 09 11 16	06 09 11
 8,5 40	 8,5 20
 158	 160
 149 – 154	 149 – 154

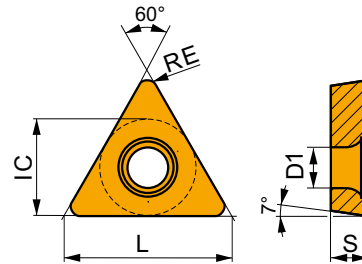
CC	CP	DC	EC	EP	RC	SC	SP	TC	TP	VB	VC	WC
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TCGT

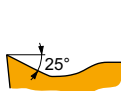
PRAMET

	IC	D1	L	S
	[mm]	[mm]	[mm]	[mm]
06T1	3.970	2.20	6.90	1.98
0902	5.560	2.50	9.60	2.38
1102	6.350	2.80	11.00	2.38
1102-SF3	6.350	2.80	11.00	2.58
16T3	9.525	4.40	16.50	3.97
16T3-SF3	9.525	4.40	16.50	4.22



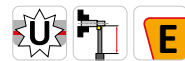
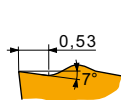
Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

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]



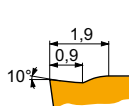
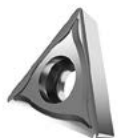
AL geometry with highly positive design for fine-finish to rough machining, and continuous to slightly interrupted cuts.

TCGT 090202F-AL	HF7	0.2	—	—	—	—	—	—	—	—	375	0.12	1.0	—	—	—	—	—	—
	T0315	0.2	—	—	—	—	—	—	—	—	555	0.12	1.0	—	—	—	—	—	—
TCGT 090204F-AL	HF7	0.4	—	—	—	—	—	—	—	—	300	0.24	1.0	—	—	—	—	—	—
	T0315	0.4	—	—	—	—	—	—	—	—	450	0.24	1.0	—	—	—	—	—	—
TCGT 110202F-AL	HF7	0.2	—	—	—	—	—	—	—	—	360	0.12	1.5	—	—	—	—	—	—
	T0315	0.2	—	—	—	—	—	—	—	—	525	0.12	1.5	—	—	—	—	—	—
TCGT 110204F-AL	HF7	0.4	—	—	—	—	—	—	—	—	285	0.24	1.5	—	—	—	—	—	—
	T0315	0.4	—	—	—	—	—	—	—	—	420	0.24	1.5	—	—	—	—	—	—
TCGT 110208F-AL	HF7	0.8	—	—	—	—	—	—	—	—	270	0.48	1.5	—	—	—	—	—	—
TCGT 16T304F-AL	HF7	0.4	—	—	—	—	—	—	—	—	285	0.24	2.4	—	—	—	—	—	—
	T0315	0.4	—	—	—	—	—	—	—	—	405	0.24	2.4	—	—	—	—	—	—
TCGT 16T308F-AL	HF7	0.8	—	—	—	—	—	—	—	—	255	0.48	2.4	—	—	—	—	—	—
	T0315	0.8	—	—	—	—	—	—	—	—	360	0.48	2.4	—	—	—	—	—	—



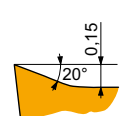
FF2 geometry with positive design for fine-finish to finish machining, and continuous to slightly interrupted cuts.

TCGT 06T102E-FF2	T8330	0.2	175	0.05	0.8	—	—	—	165	0.05	0.8	—	—	—	—	—	—	—	—
	T8430	0.2	235	0.05	0.8	—	—	—	190	0.05	0.8	—	—	—	—	—	—	—	—
TCGT 090202E-FF2	TT010	0.2	295	0.05	0.5	—	—	—	—	—	—	—	—	—	—	—	—	—	—
	TT010	0.2	295	0.05	0.5	—	—	—	—	—	—	—	—	—	—	—	—	—	—



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

TCGT 110204E-NF1	H07	0.4	—	—	—	80	0.09	0.8	—	—	415	0.12	0.8	40	0.08	0.6	—	—	—
	T6310	0.4	155	0.10	0.8	110	0.09	0.8	—	—	465	0.12	0.8	45	0.08	0.6	30	0.15	1.0
	T7325	0.4	180	0.10	0.8	140	0.09	0.8	—	—	—	—	—	55	0.08	0.6	—	—	—



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

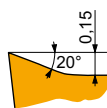
TCGT 110202E-SF3	T6310	0.2	175	0.05	0.8	125	0.05	0.8	140	0.05	0.8	525	0.06	0.8	50	0.04	0.6	35	0.15	1.0
	T8315	0.2	185	0.05	0.8	110	0.05	0.8	175	0.05	0.8	555	0.06	0.8	45	0.04	0.6	35	0.15	1.0
TCGT 110204E-SF3	H07	0.4	—	—	—	80	0.09	0.8	130	0.10	0.8	415	0.12	0.8	40	0.07	0.6	—	—	—
	T6310	0.4	155	0.10	0.8	110	0.09	0.8	125	0.10	0.8	465	0.12	0.8	45	0.07	0.6	30	0.15	1.0
	T8315	0.4	165	0.10	0.8	95	0.09	0.8	155	0.10	0.8	495	0.12	0.8	40	0.07	0.6	30	0.15	1.0

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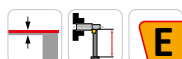
Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

Product	RE (mm)	P			M			K			N			S			H		
		vc [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]



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

TCGT 16T304E-SF3	H07	0.4	—	—	—	80	0.09	1.0	125	0.10	1.0	405	0.12	1.0	40	0.07	0.8	—	—	—
	T6310	0.4	150	0.10	1.0	105	0.09	1.0	120	0.10	1.0	450	0.12	1.0	45	0.07	0.8	30	0.15	1.0
	T8315	0.4	160	0.10	1.0	95	0.09	1.0	150	0.10	1.0	480	0.12	1.0	40	0.07	0.8	30	0.15	1.0
TCGT 16T308E-SF3	H07	0.8	—	—	—	90	0.09	1.2	145	0.10	1.2	470	0.12	1.2	45	0.08	1.0	—	—	—
	T6310	0.8	175	0.10	1.2	125	0.09	1.2	140	0.10	1.2	525	0.12	1.2	50	0.08	1.0	35	0.15	1.0
	T8315	0.8	185	0.10	1.2	110	0.09	1.2	175	0.10	1.2	555	0.12	1.2	45	0.08	1.0	35	0.15	1.0
TCGT 16T312E-SF3	T6310	1.2	150	0.20	1.2	105	0.18	1.2	120	0.20	1.2	450	0.24	1.2	45	0.14	1.0	30	0.15	1.0



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

TCGT 110202ER-SI	T8315	0.2	190	0.10	0.8	110	0.09	0.8	180	0.10	0.8	—	—	—	45	0.08	0.6	—	—	—
	T8330	0.2	180	0.10	0.8	105	0.09	0.8	170	0.10	0.8	—	—	—	45	0.08	0.6	—	—	—
	T8430	0.2	225	0.10	0.8	120	0.09	0.8	185	0.10	0.8	—	—	—	45	0.08	0.6	—	—	—
TCGT 110204ER-SI	T8330	0.4	180	0.12	0.8	105	0.11	0.8	170	0.12	0.8	—	—	—	45	0.10	0.6	—	—	—
	T8430	0.4	225	0.12	0.8	120	0.11	0.8	185	0.12	0.8	—	—	—	45	0.10	0.6	—	—	—



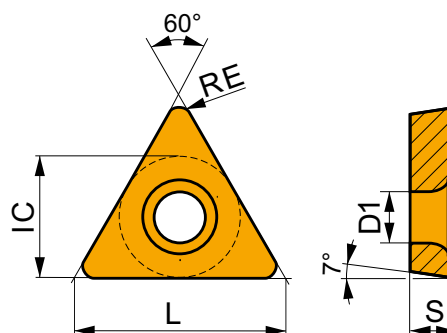
EL-SI geometry with positive left-handed design for fine-finish machining, and continuous cuts.

TCGT 110202EL-SI	T8315	0.2	190	0.10	0.8	110	0.09	0.8	180	0.10	0.8	—	—	—	45	0.08	0.6	—	—	—
	T8330	0.2	180	0.10	0.8	105	0.09	0.8	170	0.10	0.8	—	—	—	45	0.08	0.6	—	—	—
	T8430	0.2	225	0.10	0.8	120	0.09	0.8	185	0.10	0.8	—	—	—	45	0.08	0.6	—	—	—
TCGT 110204EL-SI	T8315	0.4	195	0.12	0.8	115	0.11	0.8	185	0.12	0.8	—	—	—	45	0.10	0.6	—	—	—
	T8330	0.4	180	0.12	0.8	105	0.11	0.8	170	0.12	0.8	—	—	—	45	0.10	0.6	—	—	—
	T8430	0.4	225	0.12	0.8	120	0.11	0.8	185	0.12	0.8	—	—	—	45	0.10	0.6	—	—	—

TCMT

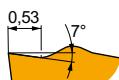
PRAMET

	IC [mm]	D1 [mm]	L [mm]	S [mm]
06T1	3.970	2.20	6.90	1.98
0902	5.560	2.50	9.60	2.38
1102	6.350	2.80	11.00	2.38
16T3	9.525	4.40	16.50	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 (mm)	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]



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

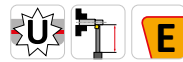
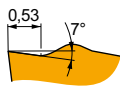
TCMT 06T102E-FF2	T8330	0.2	175	0.05	0.8	—	—	—	165	0.05	0.8	—	—	—	—	—	—	—	—
	T8430	0.2	235	0.05	0.8	—	—	—	190	0.05	0.8	—	—	—	—	—	—	—	—
	T9315	0.2	335	0.05	0.8	—	—	—	315	0.05	0.8	—	—	—	—	—	—	—	—

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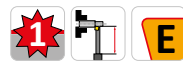
Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

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]



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

TCMT 06T104E-FF2	T7325	0.4	170	0.12	0.8															
	T8330	0.4	145	0.12	0.8															
	T8430	0.4	180	0.12	0.8															
	T9315	0.4	245	0.12	0.8															
	T9325	0.4	220	0.12	0.8															
TCMT 090204E-FF2	T5315	0.4	240	0.12	1.0															
	T7325	0.4	165	0.12	1.0															
	T8330	0.4	140	0.12	1.0															
	T8430	0.4	175	0.12	1.0															
	T9315	0.4	240	0.12	1.0															
TCMT 110204E-FF2	T9325	0.4	215	0.12	1.0															
	T7325	0.4	170	0.12	0.8															
	T8330	0.4	145	0.12	0.8															
	T8430	0.4	180	0.12	0.8															
	T9315	0.4	245	0.12	0.8															
TCMT 110208E-FF2	T9325	0.4	220	0.12	0.8															
	T9335	0.4	185	0.12	0.8															
	T7325	0.8	180	0.17	0.8															
	T8330	0.8	155	0.17	0.8															
	T8430	0.8	185	0.17	0.8															
TCMT 16T304E-FF2	T9315	0.8	250	0.17	0.8															
	T9325	0.8	225	0.17	0.8															
	T7325	0.4	170	0.12	0.8															
	T8330	0.4	145	0.12	0.8															
	T8430	0.4	180	0.12	0.8															
TCMT 16T308E-FF2	T9315	0.4	245	0.12	0.8															
	T9325	0.4	220	0.12	0.8															
	T9335	0.4	185	0.12	0.8															
	TT010	0.4	295	0.06	0.5															
	T7325	0.8	180	0.17	0.8															
TCMT 16T308E-FF2	T8330	0.8	155	0.17	0.8															
	T8430	0.8	185	0.17	0.8															
	T9315	0.8	250	0.17	0.8															
	T9325	0.8	225	0.17	0.8															
	T9335	0.8	195	0.17	0.8															



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

TCMT 110202E-FM	T7325	0.2	185	0.10	0.8		140	0.09	0.8											
	T7335	0.2	185	0.10	0.8		140	0.09	0.8											
	T8315	0.2	170	0.10	0.8		100	0.09	0.8		160	0.10	0.8	510	0.12	0.8				
	T8330	0.2	160	0.10	0.8		95	0.09	0.8		150	0.10	0.8	480	0.12	0.8				
	T8430	0.2	195	0.10	0.8		105	0.09	0.8		160	0.10	0.8	540	0.12	0.8				
TCMT 110204E-FM	T9315	0.2	270	0.10	0.8						255	0.10	0.8							
	T9325	0.2	245	0.10	0.8		145	0.09	0.8		230	0.10	0.8							
	T7325	0.4	160	0.19	0.8		120	0.17	0.8											
	T7335	0.4	155	0.19	0.8		120	0.17	0.8											
	T8315	0.4	170	0.12	0.8		100	0.11	0.8		160	0.12	0.8	510	0.14	0.8				
TCMT 110204E-FM	T8330	0.4	160	0.12	0.8		95	0.11	0.8		150	0.12	0.8	480	0.14	0.8				
	T8430	0.4	195	0.12	0.8		105	0.11	0.8		160	0.12	0.8	540	0.14	0.8				
	T9315	0.4	270	0.12	0.8						255	0.12	0.8							
	T9325	0.4	205	0.18	0.8		120	0.16	0.8		190	0.18	0.8							

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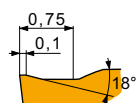
Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

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]



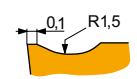
FM geometry for finish to semi-rough machining, and continuous to slightly interrupted cuts.

TCMT 110208E-FM	T7325	0.8	195	0.17	0.8	150	0.15	0.8	—	—	—	—	—	—	—	—	—	—	—	—
	T8330	0.8	175	0.17	0.8	105	0.15	0.8	165	0.17	0.8	525	0.20	0.8	—	—	—	—	—	—
	T8430	0.8	200	0.17	0.8	110	0.15	0.8	165	0.17	0.8	555	0.20	0.8	—	—	—	—	—	—
	T9315	0.8	275	0.17	0.8	—	—	—	260	0.17	0.8	—	—	—	—	—	—	—	—	—
	T9325	0.8	250	0.17	0.8	150	0.15	0.8	235	0.17	0.8	—	—	—	—	—	—	—	—	—
TCMT 16T304E-FM	T7325	0.4	150	0.19	1.7	115	0.17	1.7	—	—	—	—	—	—	—	—	—	—	—	—
	T7335	0.4	145	0.19	1.7	110	0.17	1.7	—	—	—	—	—	—	—	—	—	—	—	—
	T8315	0.4	155	0.12	1.7	90	0.11	1.7	145	0.12	1.7	465	0.14	1.7	—	—	—	—	—	—
	T8330	0.4	150	0.12	1.7	90	0.11	1.7	140	0.12	1.7	450	0.14	1.7	—	—	—	—	—	—
	T8430	0.4	180	0.12	1.7	95	0.11	1.7	145	0.12	1.7	495	0.14	1.7	—	—	—	—	—	—
	T9315	0.4	250	0.12	1.7	—	—	—	235	0.12	1.7	—	—	—	—	—	—	—	—	—
	T9325	0.4	190	0.18	1.7	110	0.16	1.7	180	0.18	1.7	—	—	—	—	—	—	—	—	—
TCMT 16T308E-FM	T7325	0.8	180	0.17	1.7	140	0.15	1.7	—	—	—	—	—	—	—	—	—	—	—	—
	T7335	0.8	175	0.17	1.7	135	0.15	1.7	—	—	—	—	—	—	—	—	—	—	—	—
	T8315	0.8	170	0.17	1.7	100	0.15	1.7	160	0.17	1.7	510	0.20	1.7	—	—	—	—	—	—
	T8330	0.8	160	0.17	1.7	95	0.15	1.7	150	0.17	1.7	480	0.20	1.7	—	—	—	—	—	—
	T8430	0.8	185	0.17	1.7	100	0.15	1.7	150	0.17	1.7	510	0.20	1.7	—	—	—	—	—	—
	T9315	0.8	255	0.17	1.7	—	—	—	240	0.17	1.7	—	—	—	—	—	—	—	—	—
	T9325	0.8	230	0.17	1.7	135	0.15	1.7	215	0.17	1.7	—	—	—	—	—	—	—	—	—



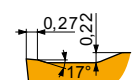
FM2 geometry for finish to medium machining, and continuous to interrupted cuts.

TCMT 110204E-FM2	T8330	0.4	145	0.12	0.8	85	0.11	0.8	135	0.12	0.8	—	—	—	—	—	—	—	—	—
	T8430	0.4	180	0.12	0.8	95	0.11	0.8	145	0.12	0.8	—	—	—	—	—	—	—	—	—
	T9325	0.4	220	0.12	0.8	130	0.11	0.8	205	0.12	0.8	—	—	—	—	—	—	—	—	—
TCMT 110208E-FM2	T8330	0.8	155	0.17	0.8	90	0.15	0.8	145	0.17	0.8	—	—	—	—	—	—	—	—	—
	T8430	0.8	185	0.17	0.8	100	0.15	0.8	150	0.17	0.8	—	—	—	—	—	—	—	—	—
	T9325	0.8	225	0.17	0.8	135	0.15	0.8	210	0.17	0.8	—	—	—	—	—	—	—	—	—
	T9335	0.8	195	0.17	0.8	115	0.15	0.8	—	—	—	—	—	—	—	—	—	—	—	—
TCMT 16T308E-FM2	T7325	0.8	170	0.20	1.0	130	0.18	1.0	—	—	—	—	—	—	—	—	—	—	—	—
	T8330	0.8	145	0.20	1.0	85	0.18	1.0	135	0.20	1.0	—	—	—	—	—	—	—	—	—
	T8430	0.8	170	0.20	1.0	90	0.18	1.0	135	0.20	1.0	—	—	—	—	—	—	—	—	—
	T9325	0.8	205	0.20	1.0	120	0.18	1.0	190	0.20	1.0	—	—	—	—	—	—	—	—	—
	T9335	0.8	175	0.20	1.0	105	0.18	1.0	—	—	—	—	—	—	—	—	—	—	—	—



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

TCMT 16T308E-RF	T9325	0.8	175	0.20	1.5	105	0.18	1.5	165	0.20	1.5	—	—	—	—	—	—	—	—	—
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RM geometry for semi-rough to rough machining, and continuous to interrupted cuts.

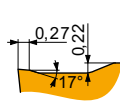
TCMT 16T308E-RM	T5305	0.8	265	0.27	1.9	—	—	—	250	0.27	1.9	—	—	—	—	—	—	50	0.15	1.0
	T5315	0.8	235	0.27	1.9	—	—	—	220	0.27	1.9	—	—	—	—	—	—	45	0.15	1.0
	T7335	0.8	155	0.27	1.9	120	0.24	1.9	—	—	—	—	—	—	50	0.19	1.5	—	—	—
	T8330	0.8	145	0.27	1.9	85	0.24	1.9	135	0.27	1.9	—	—	—	35	0.19	1.5	25	0.15	1.0
	T8430	0.8	165	0.27	1.9	90	0.24	1.9	135	0.27	1.9	—	—	—	35	0.19	1.5	25	0.15	1.0
	T9315	0.8	215	0.27	1.9	—	—	—	200	0.27	1.9	—	—	—	—	—	—	40	0.15	1.0
	T9325	0.8	195	0.27	1.9	115	0.24	1.9	185	0.27	1.9	—	—	—	40	0.19	1.5	—	—	—

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



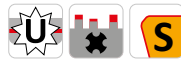
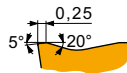
Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

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]



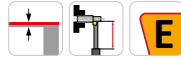
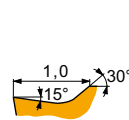
RM geometry for semi-rough to rough machining, and continuous to interrupted cuts.

TCMT 16T312E-RM	T5305	1.2	280	0.27	1.9	—	—	—	265	0.27	1.9	—	—	—	—	—	—	55	0.15	1.0
	T5315	1.2	250	0.27	1.9	—	—	—	235	0.27	1.9	—	—	—	—	—	—	50	0.15	1.0
	T8330	1.2	150	0.27	1.9	90	0.24	1.9	140	0.27	1.9	—	—	—	35	0.19	1.5	30	0.15	1.0
	T8430	1.2	170	0.27	1.9	90	0.24	1.9	135	0.27	1.9	—	—	—	35	0.19	1.5	25	0.15	1.0
	T9315	1.2	225	0.27	1.9	—	—	—	210	0.27	1.9	—	—	—	—	—	—	45	0.15	1.0
	T9325	1.2	205	0.27	1.9	120	0.24	1.9	190	0.27	1.9	—	—	—	45	0.19	1.5	—	—	—



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

TCMT 16T304E-RM3	T6310	0.4	110	0.25	2.0	75	0.25	2.0	85	0.25	2.0	—	—	—	—	—	—	20	0.15	1.0
	T7325	0.4	125	0.25	2.0	95	0.25	2.0	—	—	—	—	—	—	—	—	—	—	—	—
	T8330	0.4	110	0.25	2.0	65	0.25	2.0	100	0.25	2.0	—	—	—	—	—	—	20	0.15	1.0
	T8430	0.4	120	0.25	2.0	65	0.25	2.0	95	0.25	2.0	—	—	—	—	—	—	20	0.15	1.0
	T9315	0.4	165	0.25	2.0	—	—	—	155	0.25	2.0	—	—	—	—	—	—	30	0.15	1.0
	T9325	0.4	145	0.25	2.0	85	0.25	2.0	135	0.25	2.0	—	—	—	—	—	—	—	—	—
	T9335	0.4	125	0.25	2.0	75	0.25	2.0	—	—	—	—	—	—	—	—	—	—	—	—
TCMT 16T308E-RM3	T6310	0.8	125	0.27	2.0	90	0.27	2.0	100	0.27	2.0	—	—	—	—	—	—	25	0.15	1.0
	T7325	0.8	145	0.27	2.0	110	0.27	2.0	—	—	—	—	—	—	—	—	—	—	—	—
	T8330	0.8	125	0.27	2.0	75	0.27	2.0	115	0.27	2.0	—	—	—	—	—	—	25	0.15	1.0
	T8430	0.8	135	0.27	2.0	75	0.27	2.0	110	0.27	2.0	—	—	—	—	—	—	20	0.15	1.0
	T9315	0.8	185	0.27	2.0	—	—	—	175	0.27	2.0	—	—	—	—	—	—	35	0.15	1.0
	T9325	0.8	170	0.27	2.0	100	0.27	2.0	160	0.27	2.0	—	—	—	—	—	—	—	—	—
	T9335	0.8	145	0.27	2.0	85	0.27	2.0	—	—	—	—	—	—	—	—	—	—	—	—



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

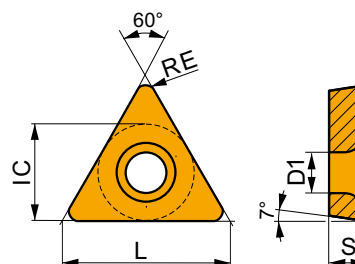
TCMT 110204E-UR	T7325	0.4	135	0.19	0.8	105	0.17	0.8	—	—	—	—	—	—	—	—	—	—	—	—
	T8330	0.4	135	0.12	0.8	80	0.11	0.8	125	0.12	0.8	—	—	—	—	—	—	—	—	—
	T8430	0.4	170	0.12	0.8	90	0.11	0.8	135	0.12	0.8	—	—	—	—	—	—	—	—	—
	T9315	0.4	235	0.12	0.8	—	—	—	220	0.12	0.8	—	—	—	—	—	—	—	—	—
	T9325	0.4	175	0.18	0.8	105	0.16	0.8	165	0.18	0.8	—	—	—	—	—	—	—	—	—
TCMT 16T304E-UR	T7325	0.4	135	0.19	0.8	105	0.17	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	235	0.12	0.8	—	—	—	220	0.12	0.8	—	—	—	—	—	—	—	—	—
	T9325	0.4	175	0.18	0.8	105	0.16	0.8	165	0.18	0.8	—	—	—	—	—	—	—	—	—
	TT310	0.4	225	0.12	0.8	135	0.11	0.8	—	—	—	—	—	—	—	—	—	—	—	—
TCMT 16T308E-UR	T5315	0.8	245	0.17	0.8	—	—	—	230	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	240	0.17	0.8	—	—	—	225	0.17	0.8	—	—	—	—	—	—	—	—	—
	T9325	0.8	215	0.17	0.8	125	0.15	0.8	200	0.17	0.8	—	—	—	—	—	—	—	—	—



TCMW

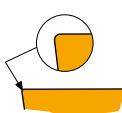


	IC	D1	L	S
	[mm]	[mm]	[mm]	[mm]
1102	6.350	2.80	11.00	2.38
16T3	9.525	4.40	16.50	3.97



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]



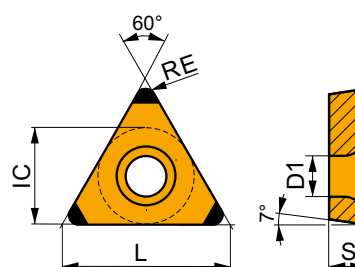
For fine-finish to semi-rough machining, and continuous to slightly interrupted cuts.

TCMW 110204	T5305	0.4	—	—	—	—	—	—	200	0.10	1.2	—	—	—	—	—	40	0.15	1.0
	T5315	0.4	—	—	—	—	—	—	180	0.10	1.2	—	—	—	—	—	35	0.15	1.0
TCMW 16T304	T5305	0.4	—	—	—	—	—	—	195	0.10	1.5	—	—	—	—	—	40	0.15	1.0
	T5315	0.4	—	—	—	—	—	—	175	0.10	1.5	—	—	—	—	—	35	0.15	1.0
	T6310	0.4	—	—	—	—	—	—	85	0.10	1.5	—	—	—	—	—	20	0.15	1.0
TCMW 16T308	T5305	0.8	—	—	—	—	—	—	190	0.18	1.5	—	—	—	—	—	40	0.15	1.0
	T5315	0.8	—	—	—	—	—	—	165	0.18	1.5	—	—	—	—	—	35	0.15	1.0
	T6310	0.8	—	—	—	—	—	—	85	0.18	1.5	—	—	—	—	—	20	0.15	1.0

TCGW CBN

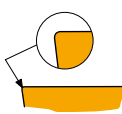


	IC	D1	L	S
	[mm]	[mm]	[mm]	[mm]
1102	6.350	2.90	11.00	2.38



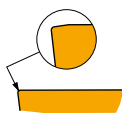
Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

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



For finish machining, and continuous cuts.

TCGW 110204E-C	TB310	0.4	—	—	—	—	—	—	390	0.10	0.4	—	—	—	100	0.07	0.3	80	0.15	1.0
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For finish machining, and continuous cuts.

TCGW 110204S01020C	TB310	0.4	—	—	—	—	—	—	390	0.10	0.4	—	—	—	100	0.07	0.3	80	0.15	1.0
TCGW 110208S01020C	TB310	0.8	—	—	—	—	—	—	400	0.15	0.6	—	—	—	105	0.11	0.5	85	0.15	1.0