

The background of the entire page is a close-up photograph of several indexable inserts. There are three yellow inserts and two grey inserts. The yellow inserts are triangular with a circular hole in the center. The grey inserts are rectangular with a circular hole. Some of the inserts have numbers like '35' and '36' engraved on them. The image is framed by a blue border with diagonal lines.

**KONRAD
TOOLS**

INDEXABLE INSERTS

STEEL
PAGE 1 - 74

C		CC	0602	09T3	1204	2509			PAGE 1 - 9
		CN	0903	1204	1606	1906	2507	2509	PAGE 10 - 19
D		DC	0702	11T3				PAGE 20 - 25	
		DN	1104	1504	1506			PAGE 26 - 32	
S		SC	09T3	1204	2509				PAGE 33 - 37
		SN	0903	1204	1506	1906	2507	2509	PAGE 38 - 44
T		TC	06T1	0902	1102	16T3			PAGE 45 - 50
		TN	1604	2204				PAGE 51 - 53	
		TP	1103	1603				PAGE 54 - 55	
V		VB	1604				PAGE 56		
		VC	0702	1103	1303	1604	2205	PAGE 57 - 64	
		VN	1604				PAGE 65 - 66		
W		WC	0201	0302	0402	06T3	0804	PAGE 67 - 71	
		WN	0604	0804				PAGE 72 - 74	

STAINLESS STEEL
PAGE 76 - 125

C		CC	0602	09T3	1204			Page 76 - 81
		CN	0903	1204	1606	1906		Page 82 - 87
D		DC	0702	11T3			Page 88 - 92	
		DN	1104	1504	1506		Page 93 - 97	
S		SC	09T3	1204			Page 98 - 99	
		SN	0903	1204	1506	1906		Page 100 - 104
T		TC	0902	1102	16T3			Page 105 - 107
		TN	1604	2204			Page 108 - 110	
V		VB	1604			Page 111		
		VC	0501	0702	1103	1303	1604	Page 112 - 118
		VN	1604			Page 119		
W		WC	0201	0402	06T3			Page 120 - 122
		WN	0604	0804			Page 123 - 125	

CAST IRON
PAGE 126 - 161

C		CC	0602	09T3	1204	2509		Page 126 - 129
		CN	0903	1204	1606	1906	2509	Page 130 - 133
D		DC	0702	11T3				Page 134 - 136
		DN	1104	1504	1506			Page 137 - 138
S		SC	09T3	1204	2509			Page 139 - 140
		SN	1204	1906	2507	2509		Page 141 - 143
T		TC	06T1	0902	1102	16T3		Page 144 - 147
		TN	1604	2204				Page 148 - 149
V		VC	0702	1103	1303	1604	2205	Page 150 - 156
		VN						
W		WC	0201	0402	06T3	0804		Page 157 - 160
		WN	0804					Page 161

NON-FERROUS METAL

PAGE 162 - 195

C		CC	0602	09T3	1204				Page 162 - 166
		CN	1204	1606	1906				Page 167 - 169
D		DC	0702	11T3					Page 170 - 173
		DN	1104	1506					Page 174 - 175
S		SC	09T3	1204					Page 176 - 177
		SN							
T		TC	06T1	0902	1102	16T3			Page 178 - 181
		TN							
V		VC	0501	0702	1103	1303	1604	2205	Page 182 - 189
		VN	1604						Page 190
W		WC	0201	0402	06T3	0804			Page 191 - 194
		WN	0804						Page 195

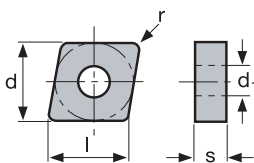
EXOTIC ALLOY

PAGE 196 - 229

C		CC	0602	09T3	1204				Page 196 - 200
		CN	1204	1906					Page 201 - 203
D		DC	0702	11T3					Page 204 - 208
		DN	1504	1506					Page 209 - 211
S		SC	09T3	1204					Page 212 - 213
		SN	1204						Page 214
T		TC	1102	16T3					Page 215 - 216
		TN	1604						Page 217
V		VC	0501	0702	1103	1303	1604		Page 218 - 223
		VN	1604						Page 224
W		WC	0201	0402	06T3				Page 225 - 227
		WN	0604	0804					Page 228 - 229

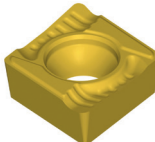
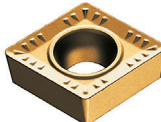
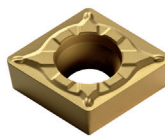
CARBIDE	CC 0602	80°	STEEL
		DIAMOND	
		7° POSITIVE	

6,35	d INSCRIBED CIRCLE
6,40	l CUTTING EDGE LENGTH
2,38	s THICKNESS



TOLERANCE CLASSES	CLASS	m	d	s
	E	± 0,025	± 0,025	± 0,025
	G	± 0,025	± 0,025	± 0,13
	H	± 0,013	± 0,013	± 0,025
	M	± 0,08	± 0,05	± 0,13
	U	± 0,13	± 0,08	± 0,13

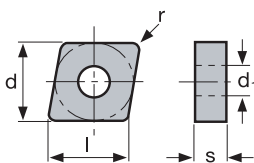
MACHINING MATERIAL	STEEL	P	TOLERANCE CLASSES	CLASS	m	d	s	MACHINING TYPES	SECONDARY USE	PRIMARY USE	CONTINUOUS CUTTING	GENERAL CUTTING	INTERRUPTED CUTTING
	STAINLESS STEEL	M											
	CAST IRON	K											
	NON-FERROUS METAL	N											
	EXOTIC ALLOY	S											
	STEEL	H											

		MACHINING MATERIAL GROUPE →	P1,2	P1,2,3	P1,2,3	P1,2	P1,2,3	P4	P1,2,3	P1,2,3	P1,2,3	P1,2,3	P1,2,3			Steel Groupe	
																P1 - Unalloyed P2 - Low alloyed P3 - High alloyed / Tool steel P4 - P1,2,3 up to 1000 N/mm²	
		Vc (M/MIN) CUTTING SPEED →	140-320	70-400	80-360	120-280	70-350	70-300	50-250	80-240	50-230	70-270	60-170				
GEOMETRY ↓	GRADE → DESIGNATION ↓	A22-A2	A22-F2	A31-A1	A32-B2	A42-G2	A42-I2	A51-B1	A52-C2	A72-D2	A72-H2	A81-C1					
		F (MM/REV) FEED RATE ↓	AP (MM) DEPTH OF CUT ↓														
M 	CCMT 060202-M			●				●									0,16 - 0,44 0,5 - 5,0
	CCMT 060204-M			●				●									0,16 - 0,44 0,5 - 5,0
	CCMT 060208-M			●				●									0,16 - 0,44 0,5 - 5,0
M1 	CCGT 060204 EL-M1							●				●					0,2 - 0,45 1,0 - 3,2
	CCGT 060204 ER-M1							●									0,2 - 0,45 1,0 - 3,2
	CCGT 060208 EL-M1							●				●					0,2 - 0,45 1,0 - 3,2
	CCGT 060208 ER-M1							●									0,2 - 0,45 1,0 - 3,2
M10 	CCMT 060202-M10		●			●											0,08 - 0,20 0,4 - 2,0
	CCMT 060204-M10					●					●						0,08 - 0,20 0,4 - 2,0
	CCMT 060208-M10					●					●						0,12 - 0,25 0,5 - 2,0
MF7 	CCMT 060202-MF7					●											0,05 - 0,12 0,30 - 2
	CCMT 060204-MF7		●			●											0,08 - 0,20 0,40 - 2

ORDER EXAMPLE: CCMT 09T304-M A31-A1

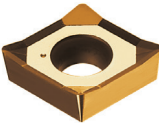
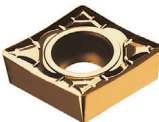
CARBIDE	CC 0602	80°	STEEL
		DIAMOND	
		7° POSITIVE	

6,35	d INSCRIBED CIRCLE
6,40	l CUTTING EDGE LENGTH
2,38	s THICKNESS

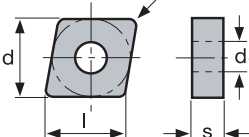


TOLERANCE CLASSES	CLASS	m	d	s
	E	± 0,025	± 0,025	± 0,025
	G	± 0,025	± 0,025	± 0,13
	H	± 0,013	± 0,013	± 0,025
	M	± 0,08	± 0,05	± 0,13
	U	± 0,13	± 0,08	± 0,13

MACHINING MATERIAL	STEEL	P	TOLERANCE CLASSES	CLASS	m	d	s	MACHINING TYPES	SECONDARY USE	PRIMARY USE	CONTINUOUS CUTTING	GENERAL CUTTING	INTERRUPTED CUTTING
	STAINLESS STEEL	M											
	CAST IRON	K											
	NON-FERROUS METAL	N											
	EXOTIC ALLOY	S											
	STEEL	H											

GEOMETRY ↓		MACHINING MATERIAL GROUPE → Vc (M/MIN) CUTTING SPEED →		P1,2	P1,2,3	P1,2,3	P1,2	P1,2,3	P4	P1,2,3	P1,2,3	P1,2,3	P1,2,3	P1,2,3			Steel Groupe	
				140-320	70-400	80-360	120-280	70-350	70-300	50-250	80-240	50-230	70-270	60-170			P1 - Unalloyed P2 - Low alloyed P3 - High alloyed / Tool steel P4 - P1,2,3 up to 1000 N/mm²	
				A22-A2	A22-F2	A31-A1	A32-B2	A42-G2	A42-I2	A51-B1	A52-C2	A72-D2	A72-H2	A81-C1			F (MM/REV) FEED RATE ↓	AP (MM) DEPTH OF CUT ↓
	MF17	CCGT 0602005-MF17	●			●											0,02 - 0,06	0,05 - 1,5
		CCGT 060201-MF17	●			●											0,02 - 0,06	0,5 - 1,5
		CCGT 060202-MF17	●			●											0,05 - 0,12	0,5 - 2,0
		CCGT 060204-MF17	●			●											0,08 - 0,25	0,6 - 3,0
	MF19	CCGT 060204-MF19	●			●											0,08 - 0,25	0,6 - 3,0
	F	CCMT 060202-F			●				●								0,05 - 0,2	0,25 - 2,0
		CCMT 060204-F			●				●								0,05 - 0,2	0,25 - 2,0
		CCMT 060208-F			●				●								0,05 - 0,2	0,25 - 2,0
	F10	CCMT 060202-F10		●			●										0,04 - 0,12	0,1 - 1,0
		CCMT 060204-F10					●										0,05 - 0,16	0,1 - 1,5

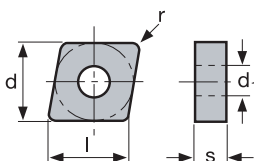
ORDER EXAMPLE: CCMT 09T304-M A31-A1

CARBIDE		CC 0602		80°		STEEL																					
				DIAMOND																							
				7° POSITIVE																							
6,35	d	INSCRIBED CIRCLE				TOLERANCE CLASSES		CLASS		m		d		s		SECONDARY USE		PRIMARY USE		MACHINING TYPES		CONTINUOUS CUTTING		GENERAL CUTTING		INTERRUPTED CUTTING	
6,40	l	CUTTING EDGE LENGTH						E		± 0,025		± 0,025		± 0,025													
2,38	s	THICKNESS						G		± 0,025		± 0,025		± 0,13													
					H			± 0,013		± 0,013		± 0,025															
					M			± 0,08		± 0,05		± 0,13															
					U			± 0,13		± 0,08		± 0,13															
MACHINING MATERIAL	STEEL		P		●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	
	STAINLESS STEEL		M		○		○	○			○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	
	CAST IRON		K		●		○	●			○	●			○			○									
	NON-FERROUS METAL		N																								
	EXOTIC ALLOY		S		○			○				○	○														
	STEEL		H																								

GEOMETRY ↓	DESIGNATION ↓	MACHINING MATERIAL GROUPE → VC (M/MIN) CUTTING SPEED →												Steel Groupe	
		GRADE →												F (MM/REV) FEED RATE ↓	AP (MM) DEPTH OF CUT ↓
		A22-A2	A22-F2	A31-A1	A32-B2	A42-G2	A42-I2	A51-B1	A52-C2	A72-D2	A72-H2	A81-C1			
F12 	CCGT 0602005-F12	●			●									0,02 - 0,06	0,1 - 1,5
	CCGT 060201-F12	●			●									0,02 - 0,06	0,1 - 1,5
	CCGT 060202-F12	●			●									0,05 - 0,12	0,2 - 2,0
	CCGT 060204-F12	●			●									0,08 - 0,25	0,2 - 2,5
W1 	CCGT 060202-W1	●												0,10 - 0,30	0,3 - 3,0
	CCGT 060204-W1	●												0,12 - 0,40	0,5 - 4,0
	CCGT 060208-W1	●												0,15 - 0,50	0,7 - 4,0

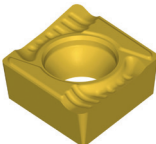
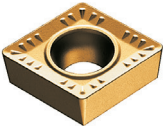
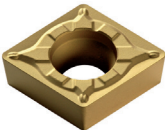
CARBIDE	CC 09T3	80°	STEEL
		DIAMOND	
		7° POSITIVE	

9,52	d INSCRIBED CIRCLE
9,70	l CUTTING EDGE LENGTH
3,97	s THICKNESS



TOLERANCE CLASSES	CLASS	m	d	s
	E	± 0,025	± 0,025	± 0,025
	G	± 0,025	± 0,025	± 0,13
	H	± 0,013	± 0,013	± 0,025
	M	± 0,08	± 0,05	± 0,13
	U	± 0,13	± 0,08	± 0,13

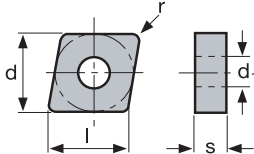
MACHINING MATERIAL	STEEL	P	●	●	●	●	◐	◑	◒	◓	◔	◕	◖	◗			MACHINING TYPES	○	●	CONTINUOUS CUTTING		
	STAINLESS STEEL	M	○		○	○			◐	◑	◒	◓	◔	◕				◐	◑	GENERAL CUTTING		
	CAST IRON	K	●		○	●			◐	◑				◒	◓				◐	◑	GENERAL CUTTING	
	NON-FERROUS METAL	N																	◐	◑	GENERAL CUTTING	
	EXOTIC ALLOY	S	○			○				◐	◑									◐	◑	GENERAL CUTTING
	STEEL	H									◐	◑								◐	◑	GENERAL CUTTING

GEOMETRY ↓		GRADE → DESIGNATION ↓		MACHINING MATERIAL GROUPE → VC (M/MIN) CUTTING SPEED →												Steel Groupe P1 - Unalloyed P2 - Low alloyed P3 - High alloyed / Tool steel P4 - P1,2,3 up to 1000 N/mm²		
				P1,2	P1,2,3	P1,2,3	P1,2	P1,2,3	P4	P1,2,3	P1,2,3	P1,2,3	P1,2,3	P1,2,3				
				A22-A2	A22-F2	A31-A1	A32-B2	A42-G2	A42-I2	A51-B1	A52-C2	A72-D2	A72-H2	A81-C1				
																	F (MM/REV) FEED RATE ↓	AP (MM) DEPTH OF CUT ↓
<i>M</i> 	CCMT 09T304-M			●				●									0,16 - 0,44	0,5 - 5,0
	CCMT 09T308-M			●				●									0,16 - 0,44	0,5 - 5,0
<i>M1</i> 	CCGT 09T304 EL-M1							●				●					0,2 - 0,45	1,0 - 3,2
	CCGT 09T304 ER-M1							●				●					0,2 - 0,45	1,0 - 3,2
	CCGT 09T308 EL-M1							●									0,2 - 0,45	1,0 - 3,2
	CCGT 09T308 ER-M1							●				●					0,2 - 0,45	1,0 - 3,2
<i>M10</i> 	CCMT 09T302-M10					●											0,06 - 0,20	0,3 - 2,5
	CCMT 09T304-M10					●						●					0,08 - 0,25	0,4 - 3,0
	CCMT 09T308-M10		●			●						●					0,12 - 0,32	0,5 - 3,0
<i>MF7</i> 	CCMT 09T302-MF7					●											0,05 - 0,12	0,3 - 2,0
	CCMT 09T304-MF7		●			●											0,08 - 0,25	0,4 - 3,0
	CCMT 09T308-MF7					●											0,12 - 0,32	0,5 - 3,0

ORDER EXAMPLE: CCMT 09T304-M A31-A1

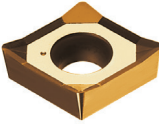
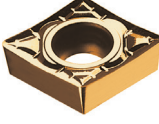
CARBIDE	CC 09T3	80°	STEEL
		DIAMOND	
		7° POSITIVE	

9,52	d INSCRIBED CIRCLE
9,70	l CUTTING EDGE LENGTH
3,97	s THICKNESS

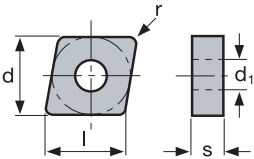


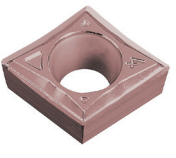
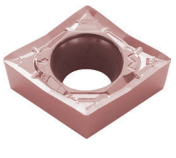
TOLERANCE CLASSES	CLASS	m	d	s
	E	± 0,025	± 0,025	± 0,025
	G	± 0,025	± 0,025	± 0,13
	H	± 0,013	± 0,013	± 0,025
	M	± 0,08	± 0,05	± 0,13
	U	± 0,13	± 0,08	± 0,13

MACHINING MATERIAL	STEEL	P	TOLERANCE CLASSES	CLASS	m	d	s	MACHINING TYPES	SECONDARY USE	PRIMARY USE	CONTINUOUS CUTTING	GENERAL CUTTING	INTERRUPTED CUTTING
	STAINLESS STEEL	M											
	CAST IRON	K											
	NON-FERROUS METAL	N											
	EXOTIC ALLOY	S											
	STEEL	H											

GEOMETRY ↓	MACHINING MATERIAL GROUPE → Vc (M/MIN) CUTTING SPEED →	GRADE → DESIGNATION	Steel Groupe												F (MM/REV) FEED RATE ↓	AP (MM) DEPTH OF CUT ↓
			P1,2	P1,2,3	P1,2,3	P1,2	P1,2,3	P4	P1,2,3	P1,2,3	P1,2,3	P1,2,3	P1,2,3	P1,2,3		
			A22-A2	A22-F2	A31-A1	A32-B2	A42-G2	A42-I2	A51-B1	A52-C2	A72-D2	A72-H2	A81-C1			
MF17 		CCGT 09T301-MF17	●			●									0,02 - 0,06	0,5 - 1,5
		CCGT 09T302-MF17	●			●									0,05 - 0,12	0,5 - 2,0
		CCGT 09T304-MF17	●			●									0,08 - 0,25	0,6 - 4,0
		CCGT 09T308-MF17	●			●									0,10 - 0,35	0,8 - 4,0
MF19 		CCGT 09T304-MF19	●			●									0,08 - 0,25	0,6 - 4,0
		CCGT 09T308-MF19	●			●									0,10 - 0,35	0,8 - 4,0
F 		CCMT 09T304-F			●				●						0,05 - 0,2	0,25 - 2,0
		CCMT 09T308-F			●				●						0,05 - 0,2	0,25 - 2,0
F10 		CCMT 09T302-F10		●			●								0,04 - 0,12	0,1 - 1,0
		CCMT 09T304-F10		●			●								0,05 - 0,16	0,1 - 1,5

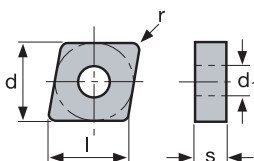
ORDER EXAMPLE: CCMT 09T304-M A31-A1

CARBIDE		CC 09T3		80°		STEEL																								
				DIAMOND																										
				7° POSITIVE																										
9,52	d	INSCRIBED CIRCLE			TOLERANCE CLASSES	CLASS	m		d		s		SECONDARY USE PRIMARY USE <table><tr><td>○</td><td>●</td><td colspan="2">CONTINUOUS CUTTING</td></tr><tr><td>◐</td><td>◑</td><td colspan="2">GENERAL CUTTING</td></tr><tr><td>◒</td><td>◓</td><td colspan="2">INTERRUPTED CUTTING</td></tr></table>						○	●	CONTINUOUS CUTTING		◐	◑	GENERAL CUTTING		◒	◓	INTERRUPTED CUTTING	
○	●	CONTINUOUS CUTTING																												
◐	◑	GENERAL CUTTING																												
◒	◓	INTERRUPTED CUTTING																												
9,70	l	CUTTING EDGE LENGTH		E		± 0,025	± 0,025	± 0,025																						
3,97	s	THICKNESS		G		± 0,025	± 0,025	± 0,13																						
						H	± 0,013	± 0,013	± 0,025																					
						M	± 0,08	± 0,05	± 0,13																					
						U	± 0,13	± 0,08	± 0,13																					
MACHINING MATERIAL	STEEL		P	●	●	●	●	◐	◐	◐	◐	◐	◐	◐	◐	◐	◐	◐	◐											
	STAINLESS STEEL		M	○		○	○			◐	◐	◐	◐	◐	◐	◐	◐	◐	◐											
	CAST IRON		K	●		○	●			◐	◐			◐																
	NON-FERROUS METAL		N																											
	EXOTIC ALLOY		S	○			○			◐	◐																			
	STEEL		H																											
				MACHINING TYPES																										
																○	●	CONTINUOUS CUTTING												
																◐	◑	GENERAL CUTTING												
																◒	◓	INTERRUPTED CUTTING												

GEOMETRY ↓	DESIGNATION ↓	GRADE → ↓	MACHINING MATERIAL GROUPE → VC (M/MIN) CUTTING SPEED →												Steel Groupe	
															F (MM/REV) FEED RATE ↓	AP (MM) DEPTH OF CUT ↓
			A22-A2	A22-F2	A31-A1	A32-B2	A42-G2	A42-I2	A51-B1	A52-C2	A72-D2	A72-H2	A81-C1			
F12 	CCGT 09T3005-F12	●			●										0,02 - 0,06	0,1 - 1,5
	CCGT 09T301-F12	●			●										0,02 - 0,06	0,1 - 1,5
	CCGT 09T302-F12	●			●										0,05 - 0,12	0,2 - 2,0
	CCGT 09T304-F12	●			●										0,08 - 0,25	0,2 - 2,5
	CCGT 09T308-F12	●			●										0,10 - 0,30	0,3 - 3,0
W1 	CCGT 09T302-W1	●													0,10 - 0,30	0,3 - 3,0
	CCGT 09T304-W1	●													0,12 - 0,40	0,5 - 4,0
	CCGT 09T308-W1	●													0,15 - 0,50	0,7 - 4,0

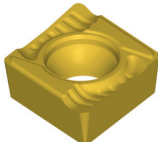
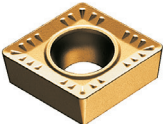
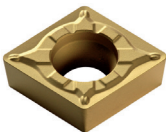
CARBIDE	CC 1204	80°	STEEL
		DIAMOND	
		7° POSITIVE	

12,70	d INSCRIBED CIRCLE
12,90	l CUTTING EDGE LENGTH
4,76	s THICKNESS



TOLERANCE CLASSES	CLASS	m	d	s
	E	± 0,025	± 0,025	± 0,025
	G	± 0,025	± 0,025	± 0,13
	H	± 0,013	± 0,013	± 0,025
	M	± 0,13	± 0,08	± 0,13
	U	± 0,20	± 0,13	± 0,13

MACHINING MATERIAL	STEEL	P	TOLERANCE CLASSES	CLASS	m	d	s	MACHINING TYPES	SECONDARY USE	PRIMARY USE	CONTINUOUS CUTTING	GENERAL CUTTING	INTERRUPTED CUTTING
	STAINLESS STEEL	M											
	CAST IRON	K											
	NON-FERROUS METAL	N											
	EXOTIC ALLOY	S											
	STEEL	H											

		MACHINING MATERIAL GROUPE →														Steel Groupe		
		VC (M/MIN) CUTTING SPEED →		P1,2	P1,2,3	P1,2,3	P1,2	P1,2,3	P4	P1,2,3	P1,2,3	P1,2,3	P1,2,3	P1,2,3			P1 - Unalloyed P2 - Low alloyed P3 - High alloyed / Tool steel P4 - P1,2,3 up to 1000 N/mm²	
GEOMETRY ↓		GRADE → DESIGNATION ↓		A22-A2	A22-F2	A31-A1	A32-B2	A42-G2	A42-I2	A51-B1	A52-C2	A72-D2	A72-H2	A81-C1			F (MM/REV) FEED RATE ↓	AP (MM) DEPTH OF CUT ↓
<i>M</i> 	CCMT 120404-M			●						●							0,16 - 0,44	0,5 - 5,0
	CCMT 120408-M			●						●							0,16 - 0,44	0,5 - 5,0
<i>M1</i> 	CCGT 120408 EL-M1									●				●			0,2 - 0,45	1,0 - 3,2
	CCGT 120408 ER-M1									●				●			0,2 - 0,45	1,0 - 3,2
	CCGT 120412 EL-M1									●				●			0,2 - 0,45	1,0 - 3,2
	CCGT 120412 ER-M1									●				●			0,2 - 0,45	1,0 - 3,2
<i>M10</i> 	CCMT 120404-M10							●						●			0,12 - 0,25	0,4 - 3,5
	CCMT 120408-M10							●						●			0,12 - 0,32	0,5 - 3,5
<i>MF7</i> 	CCMT 120404-MF7							●									0,12 - 0,25	0,4 - 3,5
	CCMT 120408-MF7							●									0,12 - 0,32	0,5 - 3,5

ORDER EXAMPLE: CCMT 09T304-M A31-A1

CARBIDE	CC 1204		STEEL															
	80°																	
	DIAMOND																	
7° POSITIVE																		
12,70	d	INSCRIBED CIRCLE			TOLERANCE CLASSES	CLASS	m	d	s	SECONDARY USE PRIMARY USE		MACHINING TYPES ○ CONTINUOUS CUTTING ◐ GENERAL CUTTING ◑ INTERRUPTED CUTTING						
12,90	l	CUTTING EDGE LENGTH				E	± 0,025	± 0,025	± 0,025									
4,76	s	THICKNESS				G	± 0,025	± 0,025	± 0,13									
						H	± 0,013	± 0,013	± 0,025									
						M	± 0,13	± 0,08	± 0,13									
						U	± 0,20	± 0,13	± 0,13									
MACHINING MATERIAL	STEEL		P		●	●	●	●	●	●	●	●	●	●	●	●	●	
	STAINLESS STEEL		M		○	○	○	○	○	○	○	○	○	○	○	○	○	
	CAST IRON		K		●	○	○	○	○	○	○	○	○	○	○	○	○	
	NON-FERROUS METAL		N		○	○	○	○	○	○	○	○	○	○	○	○	○	
	EXOTIC ALLOY		S		○	○	○	○	○	○	○	○	○	○	○	○	○	
	STEEL		H		○	○	○	○	○	○	○	○	○	○	○	○	○	

GEOMETRY	DESIGNATION	GRADE →	MACHINING MATERIAL GROUPE →												Steel Groupe	
			Vc (M/MIN) CUTTING SPEED →												F (MM/REV) FEED RATE	AP (MM) DEPTH OF CUT
			P1,2	P1,2,3	P1,2,3	P1,2	P1,2,3	P4	P1,2,3	P1,2,3	P1,2,3	P1,2,3	P1,2,3	P1,2,3		
MF17		CCGT 120401-MF17	●												0,05 - 0,12	0,5 - 2,0
		CCGT 120402-MF17	●			●									0,05 - 0,12	0,5 - 2,0
		CCGT 120404-MF17	●			●									0,08 - 0,25	0,6 - 5,0
		CCGT 120408-MF17	●			●									0,10 - 0,35	0,8 - 5,0
MF19		CCGT 120404-MF19	●			●									0,08 - 0,25	0,6 - 5,0
		CCGT 120408-MF19	●			●									0,10 - 0,35	0,8 - 5,0
F		CCMT 120404-F						●							0,05 - 0,2	0,25 - 2,0
W1		CCGT 120404-W1	●												0,12 - 0,40	0,5 - 4,0
		CCGT 120408-W1	●												0,15 - 0,50	0,7 - 4,0

ORDER EXAMPLE: CCMT 09T304-M A31-A1

CARBIDE

CC
2509

80°

DIAMOND

7° POSITIVE

STEEL

25,40

d

INSCRIBED CIRCLE

25,80

I

CUTTING EDGE LENGTH

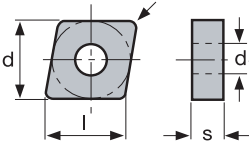
9,52

s

THICKNESS

</

[illegible]

CARBIDE		CN 0903		STEEL																
		80°																		
		DIAMOND																		
		0° NEGATIVE																		
9,52	d	INSCRIBED CIRCLE				TOLERANCE CLASSES	CLASS	m	d	s	SECONDARY USE PRIMARY USE								CONTINUOUS CUTTING GENERAL CUTTING INTERRUPTED CUTTING	
9,70	l	CUTTING EDGE LENGTH					E	± 0,025	± 0,025	± 0,025										
3,18	s	THICKNESS					G	± 0,025	± 0,025	± 0,13										
				H	± 0,013		± 0,013	± 0,025												
				M	± 0,08		± 0,05	± 0,13												
				U	± 0,13		± 0,08	± 0,13												
MACHINING MATERIAL	STEEL		P	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●		
	STAINLESS STEEL		M	○		○	○			○	○	○	○	○	○	○	○	○		
	CAST IRON		K	●		○	●			○	●			○						
	NON-FERROUS METAL		N																	
	EXOTIC ALLOY		S	○			○			○	○									
	STEEL		H																	

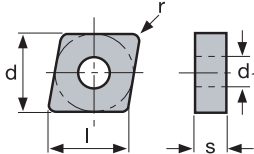
GEOMETRY ↓		GRADE → DESIGNATION ↓		MACHINING MATERIAL GROUPE →		Vc (M/MIN) CUTTING SPEED →		Steel Groupe																			
		A22-A2	A22-F2	A31-A1	A32-B2	A42-G2	A42-I2	A51-B1	A52-C2	A72-D2	A72-H2	A81-C1	F (MM/REV) FEED RATE ↓					AP (MM) DEPTH OF CUT ↓									
		P1,2	P1,2,3	P1,2,3	P1,2	P1,2,3	P4	P1,2,3	P1,2,3	P1,2,3	P1,2,3	P1,2,3															
		140-320	70-400	80-360	120-280	70-350	70-300	50-250	80-240	50-230	70-270	60-170															
M	CNMG 090308-M			●				●				●						0,16 - 0,4					0,8 - 5,0				
M6	CNMG 090304-M6								●									0,10 - 0,20					0,5 - 2,0				

[illegible][illegible]

ORDER EXAMPLE: CCMT 09T304-M A31-A1

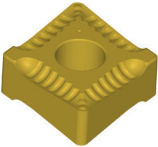
CARBIDE	CN 1204	80°	STEEL
		DIAMOND	
		0° NEGATIVE	

12,70	d INSCRIBED CIRCLE
12,90	l CUTTING EDGE LENGTH
4,76	s THICKNESS



TOLERANCE CLASSES	CLASS	m	d	s
	E	± 0,025	± 0,025	± 0,025
	G	± 0,025	± 0,025	± 0,13
	H	± 0,013	± 0,013	± 0,025
	M	± 0,13	± 0,08	± 0,13
	U	± 0,20	± 0,13	± 0,13

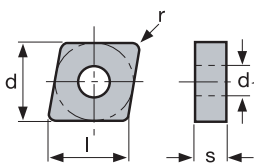
MACHINING MATERIAL	STEEL	P	TOLERANCE CLASSES	CLASS	m	d	s	MACHINING TYPES	SECONDARY USE	PRIMARY USE	CONTINUOUS CUTTING	GENERAL CUTTING	INTERRUPTED CUTTING
	STAINLESS STEEL	M											
	CAST IRON	K											
	NON-FERROUS METAL	N											
	EXOTIC ALLOY	S											
	STEEL	H											

GEOMETRY ↓		GRADE → DESIGNATION ↓		MACHINING MATERIAL GROUPE →		Vc (M/MIN) CUTTING SPEED →		Steel Groupe										F (MM/REV) FEED RATE ↓		AP (MM) DEPTH OF CUT ↓																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																														
								P1 - Unalloyed P2 - Low alloyed P3 - High alloyed / Tool steel P4 - P1,2,3 up to 1000 N/mm²																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																										
P1,2		P1,2,3		P1,2,3		P1,2		P1,2,3		P4		P1,2,3		P1,2,3		P1,2,3		P1,2,3																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																
140-320		70-400		80-360		120-280		70-350		70-300		50-250		80-240		50-230		70-270		60-170																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																														
A22-A2		A22-F2		A31-A1		A32-B2		A42-G2		A42-I2		A51-B1		A52-C2		A72-D2		A72-H2		A81-C1																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																														
		CNGG 120408-MR2				●						●																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																						

ORDER EXAMPLE: CCMT 09T304-M A31-A1

CARBIDE	CN 1204	80°	STEEL
		DIAMOND	
		0° NEGATIVE	

12,70	d INSCRIBED CIRCLE
12,90	l CUTTING EDGE LENGTH
4,76	s THICKNESS



TOLERANCE CLASSES	CLASS	m	d	s
	E	± 0,025	± 0,025	± 0,025
	G	± 0,025	± 0,025	± 0,13
	H	± 0,013	± 0,013	± 0,025
	M	± 0,13	± 0,08	± 0,13
	U	± 0,20	± 0,13	± 0,13

MACHINING MATERIAL	STEEL	P																	
	STAINLESS STEEL	M																	
	CAST IRON	K																	
	NON-FERROUS METAL	N																	
	EXOTIC ALLOY	S																	
	STEEL	H																	

MACHINING TYPES

SECONDARY USE

PRIMARY USE



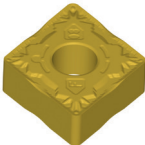
CONTINUOUS CUTTING

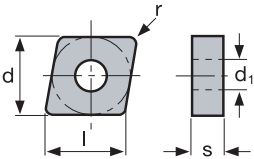


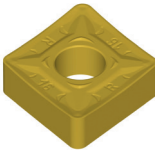
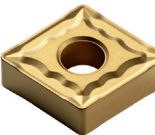
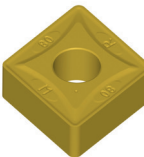
GENERAL CUTTING



INTERRUPTED CUTTING

GEOMETRY ↓		MACHINING MATERIAL GROUPE →		Vc (M/MIN) CUTTING SPEED →		Steel Groupe											
						P1 - Unalloyed		P2 - Low alloyed		P3 - High alloyed / Tool steel		P4 - P1,2,3 up to 1000 N/mm²					
GRADE →		DESIGNATION		A22-A2	A22-F2	A31-A1	A32-B2	A42-G2	A42-I2	A51-B1	A52-C2	A72-D2	A72-H2	A81-C1	F (MM/REV) FEED RATE ↓	AP (MM) DEPTH OF CUT ↓	
F 	CNMG 120404-F			●						●						0,05 - 0,2	0,12 - 1,9
	CNMG 120408-F			●						●						0,05 - 0,2	0,12 - 1,9

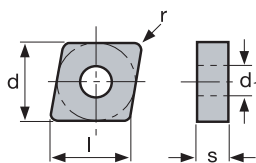
CARBIDE CN 1606		80°	STEEL																
		DIAMOND																	
		0° NEGATIVE																	
15,88	d	INSCRIBED CIRCLE																	
16,10	I	CUTTING EDGE LENGTH																	
6,35	s	THICKNESS																	
MACHINING MATERIAL	STEEL		P	●	●	●	●	●	●	●	●	●	●	○	○	○	○		
	STAINLESS STEEL		M	○	○	○	○	○	○	○	○	○	○	○	○	○	○		
	CAST IRON		K	●	○	○	○	○	○	○	○	○	○	○	○	○	○		
	NON-FERROUS METAL		N	○	○	○	○	○	○	○	○	○	○	○	○	○	○		
	EXOTIC ALLOY		S	○	○	○	○	○	○	○	○	○	○	○	○	○	○		
	STEEL		H	○	○	○	○	○	○	○	○	○	○	○	○	○	○		
				○	○	○	○	○	○	○	○	○	○	○	○	○	○		
			TOLERANCE CLASSES	CLASS		m		d		s		SECONDARY USE PRIMARY USE							
				E		± 0,025		± 0,025		± 0,025									
				G		± 0,025		± 0,025		± 0,13									
				H		± 0,013		± 0,013		± 0,025									
				M		± 0,15		± 0,10		± 0,13									
				U		± 0,27		± 0,18		± 0,13									
			MACHINING TYPES	○ ● ○</															

		MACHINING MATERIAL GROUPE →														Steel Groupe		
		Vc (M/MIN) CUTTING SPEED →		P1,2	P1,2,3	P1,2,3	P1,2	P1,2,3	P4	P1,2,3	P1,2,3	P1,2,3	P1,2,3	P1,2,3			P1 - Unalloyed P2 - Low alloyed P3 - High alloyed / Tool steel P4 - P1,2,3 up to 1000 N/mm²	
A22-A2	A22-F2			A31-A1	A32-B2	A42-G2	A42-I2	A51-B1	A52-C2	A72-D2	A72-H2	A81-C1			F (MM/REV) FEED RATE ↓	AP (MM) DEPTH OF CUT ↓		
GEOMETRY ↓		GRADE → DESIGNATION ↓																
R 	CNMM 160612-R			●				●						●			0,4 - 1,6	2,0 - 12,5
	CNMM 160616-R			●				●						●			0,4 - 1,6	2,0 - 12,5
R7 	CNMG 160612-R7					●	●						●				0,25 - 0,60	1,2 - 8,0
R8 	CNMM 160612-R8					●	●						●				0,35 - 0,7	1,2 - 9,0
	CNMM 160616-R8						●										0,40 - 0,9	1,6 - 9,0
MR 	CNMG 160608-MR			●				●									0,32 - 0,8	1,2 - 8,0
	CNMG 160612-MR			●				●					●				0,32 - 0,8	1,2 - 8,0
	CNMG 160616-MR			●				●					●				0,32 - 0,8	1,2 - 8,0

ORDER EXAMPLE: CCMT 09T304-M A31-A1

CARBIDE	CN 1606	80°	STEEL
		DIAMOND	
		0° NEGATIVE	

15,88	d INSCRIBED CIRCLE
16,10	l CUTTING EDGE LENGTH
6,35	s THICKNESS



TOLERANCE CLASSES	CLASS	m	d	s
	E	± 0,025	± 0,025	± 0,025
	G	± 0,025	± 0,025	± 0,13
	H	± 0,013	± 0,013	± 0,025
	M	± 0,15	± 0,10	± 0,13
	U	± 0,27	± 0,18	± 0,13

MACHINING MATERIAL	STEEL	P																
	STAINLESS STEEL	M																
	CAST IRON	K																
	NON-FERROUS METAL	N																
	EXOTIC ALLOY	S																
	STEEL	H																

MACHINING TYPES

SECONDARY USE

PRIMARY USE



CONTINUOUS CUTTING

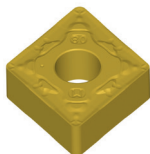


GENERAL CUTTING



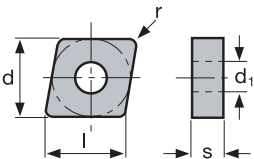
INTERRUPTED CUTTING

GEOMETRY ↓		GRADE → DESIGNATION ↓		MACHINING MATERIAL GROUPE → Vc (M/MIN) CUTTING SPEED →		Steel Groupe P1 - Unalloyed P2 - Low alloyed P3 - High alloyed / Tool steel P4 - P1,2,3 up to 1000 N/mm²										
						A22-A2	A22-F2	A31-A1	A32-B2	A42-G2	A42-I2	A51-B1	A52-C2	A72-D2	A72-H2	A81-C1
M 	CNMG 160608-M			●				●				●			0,16 - 0,4	0,8 - 5,0
	CNMG 160612-M			●				●				●			0,16 - 0,4	0,8 - 5,0
	CNMG 160616-M			●				●				●			0,16 - 0,4	0,8 - 5,0



[illegible][illegible]

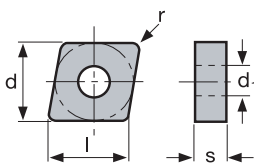
ORDER EXAMPLE: CCMT 09T304-M A31-A1

CARBIDE			CN 1906		80°		DIAMOND		0° NEGATIVE		STEEL																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																											
19,05		d INSCRIBED CIRCLE					TOLERANCE CLASSES		CLASS		m		d		s		SECONDARY USE PRIMARY USE																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																					
19,30		l CUTTING EDGE LENGTH							E		± 0,025		± 0,025		± 0,025																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																							
6,35		s THICKNESS							G		± 0,025		± 0,025		± 0,13																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																							
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					U				± 0,27		± 0,18		± 0,13																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																									
MACHINING MATERIAL	STEEL		P			●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●</

		MACHINING MATERIAL GROUPE →														Steel Groupe		
		Vc (M/MIN) CUTTING SPEED →		P1,2	P1,2,3	P1,2,3	P1,2	P1,2,3	P4	P1,2,3	P1,2,3	P1,2,3	P1,2,3	P1,2,3			P1 - Unalloyed P2 - Low alloyed P3 - High alloyed / Tool steel P4 - P1,2,3 up to 1000 N/mm²	
GEOMETRY ↓		GRADE → DESIGNATION ↓		A22-A2	A22-F2	A31-A1	A32-B2	A42-G2	A42-I2	A51-B1	A52-C2	A72-D2	A72-H2	A81-C1			F (MM/REV) FEED RATE ↓	AP (MM) DEPTH OF CUT ↓
MR 	CNMG 190612-MR					●				●				●			0,32 - 0,8	1,2 - 8,0
	CNMG 190616-MR					●				●				●			0,32 - 0,8	1,2 - 8,0
	CNMG 190624-MR					●				●				●			0,32 - 0,8	1,2 - 8,0
M 	CNMG 190612-M					●				●				●			0,16 - 0,4	0,8 - 5,0
	CNMG 190616-M					●				●				●			0,16 - 0,4	0,8 - 5,0

CARBIDE	CN 2507	80°	STEEL
		DIAMOND	
		0° NEGATIVE	

25,40	d INSCRIBED CIRCLE
25,80	l CUTTING EDGE LENGTH
7,94	s THICKNESS



TOLERANCE CLASSES	CLASS	m	d	s
	E	± 0,025	± 0,025	± 0,025
	G	± 0,025	± 0,025	± 0,13
	H	± 0,013	± 0,013	± 0,025
	M	± 0,18	± 0,13	± 0,13
	U	± 0,38	± 0,25	± 0,13

MACHINING MATERIAL	STEEL	P																		
	STAINLESS STEEL	M																		
	CAST IRON	K																		
	NON-FERROUS METAL	N																		
	EXOTIC ALLOY	S																		
	STEEL	H																		

MACHINING TYPES

SECONDARY USE

PRIMARY USE



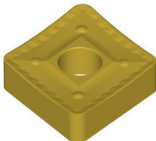
CONTINUOUS CUTTING

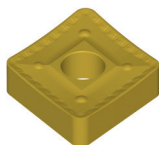


GENERAL CUTTING



INTERRUPTED CUTTING

GEOMETRY ↓	GRADE → DESIGNATION ↓	MACHINING MATERIAL GROUPE → Vc (M/MIN) CUTTING SPEED →										Steel Groupe P1 - Unalloyed P2 - Low alloyed P3 - High alloyed / Tool steel P4 - P1,2,3 up to 1000 N/mm²			
		A22-A2	A22-F2	A31-A1	A32-B2	A42-G2	A42-I2	A51-B1	A52-C2	A72-D2	A72-H2	A81-C1	F (MM/REV) FEED RATE ↓	AP (MM) DEPTH OF CUT ↓	
R2	CNMM 250724-R2			●				●			●			0,8 - 1,6	2,5 - 12,5
															



[illegible]

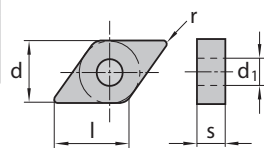
GEOMETRY ↓	GRADE → DESIGNATION ↓	MACHINING MATERIAL GROUPE →		Vc (M/MIN) CUTTING SPEED →		Steel Groupe										
		A22-A2	A22-F2	A31-A1	A32-B2	A42-G2	A42-I2	A51-B1	A52-C2	A72-D2	A72-H2	A81-C1			P1 - Unalloyed P2 - Low alloyed P3 - High alloyed / Tool steel P4 - P1,2,3 up to 1000 N/mm²	
R2	CNMM 250924-R2			●				●				●			0,8 - 1,6	2,5 - 12,5

[illegible][illegible]

ORDER EXAMPLE: CCMT 09T304-M A31-A1

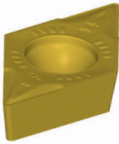
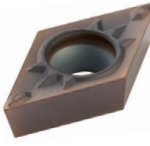
CARBIDE	DC 0702	55°	STEEL
		DIAMOND	
		7° POSITIVE	

6,35	d INSCRIBED CIRCLE
7,70	l CUTTING EDGE LENGTH
2,38	s THICKNESS



TOLERANCE CLASSES	CLASS	m	d	s
	E	± 0,025	± 0,025	± 0,025
	G	± 0,025	± 0,025	± 0,13
	H	± 0,013	± 0,013	± 0,025
	M	± 0,08	± 0,05	± 0,13
	U	± 0,13	± 0,08	± 0,13

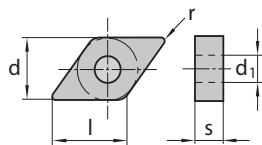
MACHINING MATERIAL	STEEL	P	●	●	●	●	◐	◑	◒	◓	◔	◕	◖	◗	◘			MACHINING TYPES	○	●	CONTINUOUS CUTTING	
	STAINLESS STEEL	M	○		○	○			◐	◑	◒	◓		◔					◐	◑	GENERAL CUTTING	
	CAST IRON	K	●		○	●			◐	◑				◔					◐	◑	GENERAL CUTTING	
	NON-FERROUS METAL	N																	◐	◑	GENERAL CUTTING	
	EXOTIC ALLOY	S	○			○				◐	◑									◐	◑	GENERAL CUTTING
	STEEL	H									◐	◑								◐	◑	GENERAL CUTTING

GEOMETRY ↓	MACHINING MATERIAL GROUPE → Vc (M/MIN) CUTTING SPEED →	GRADE → DESIGNATION ↓	Steel Groupe												F (MM/REV) FEED RATE ↓	AP (MM) DEPTH OF CUT ↓
			P1,2	P1,2,3	P1,2,3	P1,2	P1,2,3	P4	P1,2,3	P1,2,3	P1,2,3	P1,2,3	P1,2,3	P1,2,3		
			A22-A2	A22-F2	A31-A1	A32-B2	A42-G2	A42-I2	A51-B1	A52-C2	A72-D2	A72-H2	A81-C1			
MF17 	DCGT 0702005-MF17		●			●									0,02 - 0,06	0,5 - 1,5
			●			●									0,02 - 0,06	0,5 - 1,5
			●			●									0,05 - 0,12	0,5 - 2,0
			●			●									0,08 - 0,25	0,6 - 2,5
MF19 	DCGT 070204-MF19		●			●									0,08 - 0,25	0,6 - 2,5
F 	DCMT 070202-F			●					●						0,05 - 0,2	0,25 - 2,0
				●					●						0,05 - 0,2	0,25 - 2,0
F10 	DCMT 070202-F10						●								0,05 - 0,12	0,4 - 2,0
				●			●								0,08 - 0,20	0,4 - 2,0

ORDER EXAMPLE: CCMT 09T304-M A31-A1

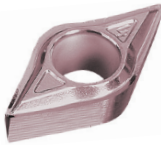
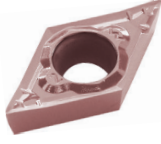
CARBIDE	DC 0702	55°	STEEL
		DIAMOND	
		7° POSITIVE	

6,35	d INSCRIBED CIRCLE
7,70	l CUTTING EDGE LENGTH
2,38	s THICKNESS



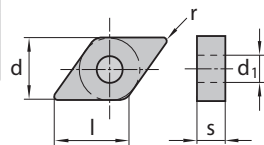
TOLERANCE CLASSES	CLASS	m	d	s
	E	± 0,025	± 0,025	± 0,025
	G	± 0,025	± 0,025	± 0,13
	H	± 0,013	± 0,013	± 0,025
	M	± 0,08	± 0,05	± 0,13
	U	± 0,13	± 0,08	± 0,13

MACHINING MATERIAL	STEEL	P	TOLERANCE CLASSES	CLASS	m	d	s	MACHINING TYPES	SECONDARY USE	PRIMARY USE	CUTTING TYPE
	STAINLESS STEEL	M									
	CAST IRON	K									
	NON-FERROUS METAL	N									
	EXOTIC ALLOY	S									
	STEEL	H									

GEOMETRY ↓		GRADE → DESIGNATION ↓		MACHINING MATERIAL GROUPE → Vc (M/MIN) CUTTING SPEED →		P1,2	P1,2,3	P1,2,3	P1,2	P1,2,3	P4	P1,2,3	P1,2,3	P1,2,3	P1,2,3			Steel Groupe		
						140-320	70-400	80-360	120-280	70-350	70-300	50-250	80-240	50-230	70-270	60-170			P1 - Unalloyed P2 - Low alloyed P3 - High alloyed / Tool steel P4 - P1,2,3 up to 1000 N/mm²	
						A22-A2	A22-F2	A31-A1	A32-B2	A42-G2	A42-I2	A51-B1	A52-C2	A72-D2	A72-H2	A81-C1			F (MM/REV) FEED RATE ↓	AP (MM) DEPTH OF CUT ↓
F12 	DCGT 0702005-F12	●			●													0,02 - 0,06	0,1 - 1,5	
	DCGT 070201-F12	●			●													0,02 - 0,06	0,1 - 1,5	
	DCGT 070202-F12	●			●													0,05 - 0,12	0,2 - 2,0	
	DCGT 070204-F12	●			●													0,08 - 0,25	0,2 - 2,5	
W1 	DCGT 070202-W1	●																0,10 - 0,30	0,3 - 3,0	
	DCGT 070204-W1	●																0,12 - 0,40	0,5 - 4,0	
	DCGT 070208-W1	●																0,15 - 0,50	0,5 - 4,0	

CARBIDE	DC 11T3	55°	STEEL
		DIAMOND	
		7° POSITIVE	

9,52	d INSCRIBED CIRCLE
11,60	l CUTTING EDGE LENGTH
3,97	s THICKNESS



TOLERANCE CLASSES	CLASS	m	d	s
	E	± 0,025	± 0,025	± 0,025
	G	± 0,025	± 0,025	± 0,13
	H	± 0,013	± 0,013	± 0,025
	M	± 0,08	± 0,05	± 0,13
	U	± 0,13	± 0,08	± 0,13

MACHINING MATERIAL	STEEL	P	TOLERANCE CLASSES	CLASS	m	d	s	MACHINING TYPES	SECONDARY USE	PRIMARY USE	CONTINUOUS CUTTING	GENERAL CUTTING	INTERRUPTED CUTTING
	STAINLESS STEEL	M											
	CAST IRON	K											
	NON-FERROUS METAL	N											
	EXOTIC ALLOY	S											
	STEEL	H											

GEOMETRY ↓		GRADE → DESIGNATION ↓		MACHINING MATERIAL GROUPE → Vc (M/MIN) CUTTING SPEED →		P1,2	P1,2,3	P1,2,3	P1,2	P1,2,3	P4	P1,2,3	P1,2,3	P1,2,3	P1,2,3			Steel Groupe				
						A22-A2	A22-F2	A31-A1	A32-B2	A42-G2	A42-I2	A51-B1	A52-C2	A72-D2	A72-H2	A81-C1						

ORDER EXAMPLE: CCMT 09T304-M A31-A1

[illegible][illegible]

ORDER EXAMPLE: CCMT 09T304-M A31-A1

[illegible][illegible]

CARBIDE		DN 1104	55°	STEEL															
			DIAMOND																
			0° NEGATIVE																

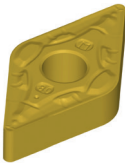
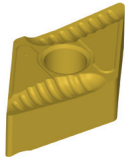
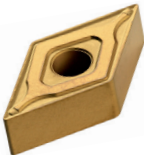
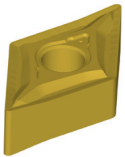
9,52	d	INSCRIBED CIRCLE
11,60	l	CUTTING EDGE LENGTH
4,76	s	THICKNESS

TOLERANCE CLASSES	CLASS	m	d	s
	E	± 0,025	± 0,025	± 0,025
	G	± 0,025	± 0,025	± 0,13
	H	± 0,013	± 0,013	± 0,025
	M	± 0,08	± 0,05	± 0,13
	U	± 0,13	± 0,08	± 0,13

SECONDARY USE		PRIMARY USE	
○	●	○	●
⊕	⊖	⊕	⊖
⊕	⊖	⊕	⊖

MACHINING MATERIAL	STEEL	P	●	●	●	●	⊕	⊖	⊕	⊖	⊕	⊖	⊕	⊖		
	STAINLESS STEEL	M	○		○	○		⊕	⊖	⊕		⊕				
	CAST IRON	K	●		○	●		⊕	●			⊕				
	NON-FERROUS METAL	N														
	EXOTIC ALLOY	S	○			○			⊕	⊕						
	STEEL	H														

MACHINING TYPES	○	●	CONTINUOUS CUTTING
	⊕	⊖	GENERAL CUTTING
	⊕	⊖	INTERRUPTED CUTTING
	⊕	⊖	INTERRUPTED CUTTING

		MACHINING MATERIAL GROUPE →												Steel Groupe				
		Vc (M/MIN) CUTTING SPEED →		P1,2	P1,2,3	P1,2,3	P1,2	P1,2,3	P4	P1,2,3	P1,2,3	P1,2,3	P1,2,3	P1,2,3			P1 - Unalloyed P2 - Low alloyed P3 - High alloyed / Tool steel P4 - P1,2,3 up to 1000 N/mm²	
		GRADE →		A22-A2	A22-F2	A31-A1	A32-B2	A42-G2	A42-I2	A51-B1	A52-C2	A72-D2	A72-H2	A81-C1			F (MM/REV) FEED RATE ↓	AP (MM) DEPTH OF CUT ↓
GEOMETRY ↓		DESIGNATION ↓																
M		DNMG 110408-M				●				●				●			0,16 - 0,4	0,8 - 5,0
E-M1		DNMG 110404 EL-M1				●				●				●			0,2 - 0,45	1,0 - 3,2
		DNMG 110404 ER-M1				●				●				●			0,2 - 0,45	1,0 - 3,2
		DNMG 110408 EL-M1				●				●				●			0,2 - 0,45	1,0 - 3,2
		DNMG 110408 ER-M1				●				●				●			0,2 - 0,45	1,0 - 3,2
M7		DNMG 110404-M7						●	●								0,10 - 0,18	0,5 - 2,0
		DNMG 110408-M7						●	●								0,15 - 0,25	0,8 - 3,0
MF		DNMG 110404-MF				●				●				●			0,08 - 0,32	0,5 - 4,0
		DNMG 110408-MF				●				●							0,08 - 0,32	0,5 - 4,0

ORDER EXAMPLE: CCMT 09T304-M A31-A1

CARBIDE

DN
1104

55°

DIAMOND

0° NEGATIVE

STEEL

9,52

d

INSCRIBED CIRCLE

11,60

I

CUTTING EDGE LENGTH

4,76

s

THICKNESS

TOLERANCE
CLASSES

CLASS	m	d	s
E	± 0,025	± 0,025	± 0,025
G	± 0,025	± 0,025	± 0,13
H	± 0,013	± 0,013	± 0,025
M	± 0,08	± 0,05	± 0,13
U	± 0,13	± 0,08	± 0,13

MACHINING
MATERIAL

STEEL	P	●	●	●	●	◐	◐	◐	◐	◐	◐	◐		
STAINLESS STEEL	M	○		○	○			◐	◐	◐	◐			
CAST IRON	K	●		○	●			◐	●		◐			
NON-FERROUS METAL	N													
EXOTIC ALLOY	S	○			○				◐	◐				
STEEL	H													

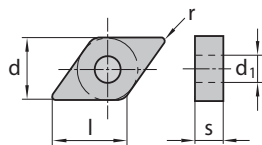
MACHINING
TYPES

SECONDARY USE	PRIMARY USE	CONTINUOUS CUTTING	GENERAL CUTTING	INTERRUPTED CUTTING
○	●			
◐	◐			
◐	◐			
◐	◐			

[illegible]

CARBIDE	DN 1504	55°	STEEL
		DIAMOND	
		0° NEGATIVE	

12,70	d INSCRIBED CIRCLE
15,50	l CUTTING EDGE LENGTH
4,76	s THICKNESS



TOLERANCE CLASSES	CLASS	m	d	s
	E	± 0,025	± 0,025	± 0,025
	G	± 0,025	± 0,025	± 0,13
	H	± 0,013	± 0,013	± 0,025
	M	± 0,13	± 0,08	± 0,13
	U	± 0,20	± 0,13	± 0,13

MACHINING MATERIAL	STEEL	P	MACHINING TYPES	SECONDARY USE	PRIMARY USE	CONTINUOUS CUTTING
	STAINLESS STEEL	M				
	CAST IRON	K				
	NON-FERROUS METAL	N				
	EXOTIC ALLOY	S				
	STEEL	H				

GEOMETRY	GRADE → DESIGNATION	MACHINING MATERIAL GROUPE → Vc (M/MIN) CUTTING SPEED →												Steel Groupe	
														F (MM/REV) FEED RATE ↓	AP (MM) DEPTH OF CUT ↓
		A22-A2	A22-F2	A31-A1	A32-B2	A42-G2	A42-I2	A51-B1	A52-C2	A72-D2	A72-H2	A81-C1			
MR	DNMG 150408-MR			●				●						0,32 - 0,8	1,2 - 8,0
	DNMG 150412-MR			●				●				●		0,32 - 0,8	1,2 - 8,0
M	DNMG 150408-M			●				●				●		0,16 - 0,4	0,8 - 5,0
	DNMG 150412-M			●				●				●		0,16 - 0,4	0,8 - 5,0
E-M1	DNMG 150404 EL-M1							●						0,2 - 0,45	1,0 - 3,2
	DNMG 150404 ER-M1							●						0,2 - 0,45	1,0 - 3,2
	DNMG 150408 EL-M1							●						0,2 - 0,45	1,0 - 3,2
	DNMG 150408 ER-M1							●						0,2 - 0,45	1,0 - 3,2
M7	DNMG 150408-M7						●							0,15 - 0,25	0,8 - 3,0

ORDER EXAMPLE: CCMT 09T304-M A31-A1

CARBIDE

DN1504

55°

DIAMOND

0° NEGATIVE

STEEL

12,70

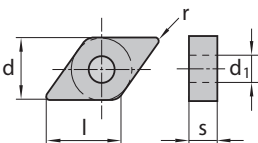
d INSCRIBED CIRCLE

15,50

l CUTTING EDGE LENGTH

4,76

s THICKNESS



TOLERANCE CLASSES

CLASS	m	d	s
E	± 0,025	± 0,025	± 0,025
G	± 0,025	± 0,025	± 0,13
H	± 0,013	± 0,013	± 0,025
M	± 0,13	± 0,08	± 0,13
U	± 0,20	± 0,13	± 0,13

SECONDARY USE

PRIMARY USE

CONTINUOUS CUTTING

GENERAL CUTTING

INTERRUPTED CUTTING

MACHINING MATERIAL

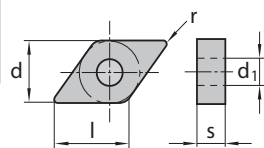
STEEL	P												
STAINLESS STEEL	M												
CAST IRON	K												
NON-FERROUS METAL	N												
EXOTIC ALLOY	S												
STEEL	H												
●	●	●	●	◐	◐	◐	◐	◐	◐	◐			
○		○	○			◐	◐	◐	◐	◐			
●		○	●			◐	●			◐			
○			○				◐	◐					

MACHINING TYPES

[illegible]

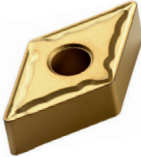
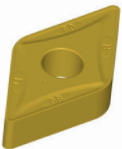
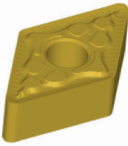
CARBIDE	DN 1506	55°	STEEL
		DIAMOND	
		0° NEGATIVE	

12,70	d INSCRIBED CIRCLE
15,50	l CUTTING EDGE LENGTH
6,35	s THICKNESS



TOLERANCE CLASSES	CLASS	m	d	s
	E	± 0,025	± 0,025	± 0,025
	G	± 0,025	± 0,025	± 0,13
	H	± 0,013	± 0,013	± 0,025
	M	± 0,13	± 0,08	± 0,13
	U	± 0,20	± 0,13	± 0,13

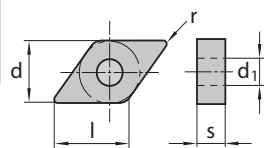
MACHINING MATERIAL	STEEL	P	MACHINING TYPES	SECONDARY USE	PRIMARY USE	CONTINUOUS CUTTING
	STAINLESS STEEL	M				
	CAST IRON	K				
	NON-FERROUS METAL	N				
	EXOTIC ALLOY	S				
	STEEL	H				

GEOMETRY	GRADE → DESIGNATION	MACHINING MATERIAL GROUPE → Vc (M/MIN) CUTTING SPEED →												Steel Groupe	
		P1,2	P1,2,3	P1,2,3	P1,2	P1,2,3	P4	P1,2,3	P1,2,3	P1,2,3	P1,2,3	P1,2,3	P1,2,3	F (MM/REV) FEED RATE ↓	AP (MM) DEPTH OF CUT ↓
		A22-A2	A22-F2	A31-A1	A32-B2	A42-G2	A42-I2	A51-B1	A52-C2	A72-D2	A72-H2	A81-C1			
R 	DNMM 150608-R		●					●				●		0,4 - 1,6	2,0 - 12,5
	DNMM 150612-R		●					●				●		0,4 - 1,6	2,0 - 12,5
	DNMM 150616-R		●					●				●		0,4 - 1,6	2,0 - 12,5
R7 	DNMG 150608-R7					●	●				●			0,15 - 0,35	0,8 - 5,0
	DNMG 150612-R7					●	●							0,20 - 0,55	1,0 - 5,0
MR 	DNMG 150608-MR		●					●						0,32 - 0,8	1,2 - 8,0
	DNMG 150612-MR		●					●				●		0,32 - 0,8	1,2 - 8,0
	DNMG 150616-MR		●					●				●		0,32 - 0,8	1,2 - 8,0
MR1 	DNMG 150612-MR1		●					●						0,19 - 0,8	1,4 - 4,0

ORDER EXAMPLE: CCMT 09T304-M A31-A1

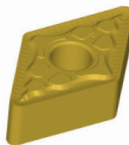
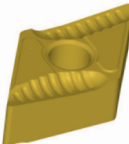
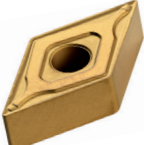
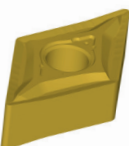
CARBIDE	DN 1506	55°	STEEL
		DIAMOND	
		0° NEGATIVE	

12,70	d INSCRIBED CIRCLE
15,50	l CUTTING EDGE LENGTH
6,35	s THICKNESS



TOLERANCE CLASSES	CLASS	m	d	s
	E	± 0,025	± 0,025	± 0,025
	G	± 0,025	± 0,025	± 0,13
	H	± 0,013	± 0,013	± 0,025
	M	± 0,13	± 0,08	± 0,13
	U	± 0,20	± 0,13	± 0,13

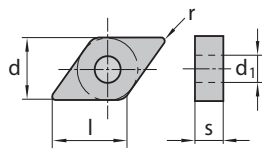
MACHINING MATERIAL	STEEL	P	TOLERANCE CLASSES	CLASS	m	d	s	MACHINING TYPES	SECONDARY USE	PRIMARY USE	CONTINUOUS CUTTING	GENERAL CUTTING	INTERRUPTED CUTTING
	STAINLESS STEEL	M											
	CAST IRON	K											
	NON-FERROUS METAL	N											
	EXOTIC ALLOY	S											
	STEEL	H											

GEOMETRY ↓		MACHINING MATERIAL GROUPE → VC (M/MIN) CUTTING SPEED →		Steel Groupe												F (MM/REV) FEED RATE ↓ AP (MM) DEPTH OF CUT ↓	
				P1 - Unalloyed P2 - Low alloyed P3 - High alloyed / Tool steel P4 - P1,2,3 up to 1000 N/mm²													
GRADE → DESIGNATION ↓		A22-A2	A22-F2	A31-A1	A32-B2	A42-G2	A42-I2	A51-B1	A52-C2	A72-D2	A72-H2	A81-C1					
M 	DNMG 150608-M			●				●				●				0,16 - 0,4 0,8 - 5,0	
	DNMG 150612-M			●				●				●				0,16 - 0,4 0,8 - 5,0	
	DNMG 150616-M			●				●								0,16 - 0,4 0,8 - 5,0	
E-M1 	DNMG 150604 EL-M1							●				●				0,2 - 0,45 1,0 - 3,2	
	DNMG 150604 ER-M1			●				●				●				0,2 - 0,45 1,0 - 3,2	
	DNMG 150608 EL-M1			●				●				●				0,2 - 0,45 1,0 - 3,2	
	DNMG 150608 ER-M1			●				●				●				0,2 - 0,45 1,0 - 3,2	
M7 	DNMG 150604-M7					●	●									0,10 - 0,18 0,5 - 2,5	
	DNMG 150608-M7					●	●									0,15 - 0,25 0,8 - 3,0	
MF 	DNMG 150604-MF			●				●				●				0,08 - 0,32 0,5 - 4,0	
	DNMG 150608-MF			●				●								0,08 - 0,32 0,5 - 4,0	

ORDER EXAMPLE: CCMT 09T304-M A31-A1

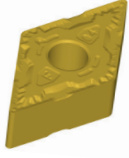
CARBIDE	DN 1506	55°	STEEL
		DIAMOND	
		0° NEGATIVE	

12,70	d INSCRIBED CIRCLE
15,50	l CUTTING EDGE LENGTH
6,35	s THICKNESS



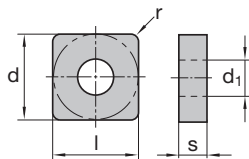
TOLERANCE CLASSES	CLASS	m	d	s
	E	± 0,025	± 0,025	± 0,025
	G	± 0,025	± 0,025	± 0,13
	H	± 0,013	± 0,013	± 0,025
	M	± 0,13	± 0,08	± 0,13
	U	± 0,20	± 0,13	± 0,13

MACHINING MATERIAL	STEEL	P	MACHINING TYPES	SECONDARY USE	PRIMARY USE	CONTINUOUS CUTTING
	STAINLESS STEEL	M				
	CAST IRON	K				
	NON-FERROUS METAL	N				
	EXOTIC ALLOY	S				
	STEEL	H				

GEOMETRY ↓	DESIGNATION ↓	MACHINING MATERIAL GROUPE → VC (M/MIN) CUTTING SPEED →												Steel Groupe	
		GRADE →												F (MM/REV) FEED RATE ↓	AP (MM) DEPTH OF CUT ↓
		A22-A2	A22-F2	A31-A1	A32-B2	A42-G2	A42-I2	A51-B1	A52-C2	A72-D2	A72-H2	A81-C1			
MF3 	DNMG 150604-MF3					●								0,22 - 0,40	1,0 - 3,5
	DNMG 150608-MF3					●								0,22 - 0,40	1,2 - 4,0
F 	DNMG 150604-F			●				●						0,05 - 0,2	0,12 - 1,9
	DNMG 150608-F			●				●						0,05 - 0,2	0,12 - 1,9
F5 	DNMG 150604-F5		●			●								0,05 - 0,12	0,2 - 1,0
	DNMG 150608-F5					●								0,07 - 0,16	0,4 - 1,5

CARBIDE	SC 09T3	90°	STEEL
		SQUARE	
		7° POSITIVE	

9,52	d	INSCRIBED CIRCLE
9,52	l	CUTTING EDGE LENGTH
3,97	s	THICKNESS



TOLERANCE CLASSES	CLASS	m	d	s
	E	± 0,025	± 0,025	± 0,025
	G	± 0,025	± 0,025	± 0,13
	H	± 0,013	± 0,013	± 0,025
	M	± 0,08	± 0,05	± 0,13
	U	± 0,13	± 0,08	± 0,13

MACHINING MATERIAL	STEEL	P																		
	STAINLESS STEEL	M																		
	CAST IRON	K																		
	NON-FERROUS METAL	N																		
	EXOTIC ALLOY	S																		
	STEEL	H																		

MACHINING TYPES

SECONDARY USE

PRIMARY USE



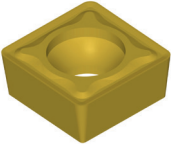
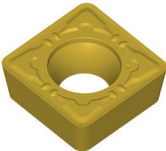
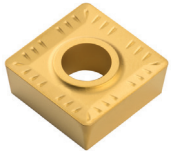
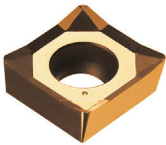
CONTINUOUS CUTTING



GENERAL CUTTING



INTERRUPTED CUTTING

GEOMETRY ↓	GRADE → DESIGNATION	MACHINING MATERIAL GROUPE → VC (M/MIN) CUTTING SPEED →												Steel Groupe	
		A22-A2	A22-F2	A31-A1	A32-B2	A42-G2	A42-I2	A51-B1	A52-C2	A72-D2	A72-H2	A81-C1		F (MM/REV) FEED RATE ↓	AP (MM) DEPTH OF CUT ↓
MR3	SCMT 09T308-MR3			●				●						0,20 - 0,50	0,5 - 6,0
															
M	SCMT 09T308-M			●				●						0,16 - 0,44	0,5 - 5,0
															
M10	SCMT 09T304-M10					●					●			0,08 - 0,25	0,4 - 3,0
	SCMT 09T308-M10					●					●			0,12 - 0,32	0,5 - 3,0
MF17	SCGT 09T304-MF17	●			●									0,08 - 0,25	0,6 - 4,0
	SCGT 09T308-MF17	●			●									0,10 - 0,35	0,7 - 4,0

ORDER EXAMPLE: CCMT 09T304-M A31-A1

CARBIDE

SC09T3

90°

SQUARE

7° POSITIVE

STEEL

9,52

d

INSCRIBED CIRCLE

9,52

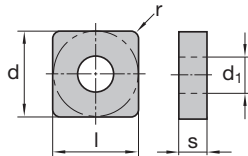
l

CUTTING EDGE LENGTH

3,97

s

THICKNESS



TOLERANCE CLASSES

CLASS	m	d	s
E	± 0,025	± 0,025	± 0,025
G	± 0,025	± 0,025	± 0,13
H	± 0,013	± 0,013	± 0,025
M	± 0,08	± 0,05	± 0,13
U	± 0,13	± 0,08	± 0,13

MACHINING MATERIAL

STEEL	P	●	●	●	●	◐	◐	◐	◐	◐	◐	◐				
STAINLESS STEEL	M	○		○	○			◐	◐	◐	◐	◐				
CAST IRON	K	●		○	●			◐	●			◐				
NON-FERROUS METAL	N															
EXOTIC ALLOY	S	○			○				◐	◐						
STEEL	H															

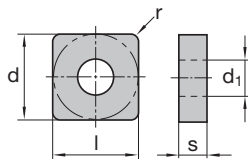
MACHINING TYPES

○	●	CONTINUOUS CUTTING
◐	◑	GENERAL CUTTING
◐◑	◑◐	INTERRUPTED CUTTING

[illegible]

CARBIDE	SC 1204	90°	STEEL
		SQUARE	
		7° POSITIVE	

12,70	d	INSCRIBED CIRCLE
12,70	l	CUTTING EDGE LENGTH
4,76	s	THICKNESS



TOLERANCE CLASSES	CLASS	m	d	s
	E	± 0,025	± 0,025	± 0,025
	G	± 0,025	± 0,025	± 0,13
	H	± 0,013	± 0,013	± 0,025
	M	± 0,13	± 0,08	± 0,13
	U	± 0,20	± 0,13	± 0,13

MACHINING MATERIAL	STEEL	P																		
	STAINLESS STEEL	M																		
	CAST IRON	K																		
	NON-FERROUS METAL	N																		
	EXOTIC ALLOY	S																		
	STEEL	H																		

MACHINING TYPES

SECONDARY USE

PRIMARY USE



CONTINUOUS CUTTING



GENERAL CUTTING



INTERRUPTED CUTTING

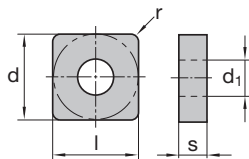
GEOMETRY ↓	DESIGNATION ↓	MACHINING MATERIAL GROUPE → Vc (M/MIN) CUTTING SPEED →												Steel Groupe	
														F (MM/REV) FEED RATE ↓	AP (MM) DEPTH OF CUT ↓
		A22-A2	A22-F2	A31-A1	A32-B2	A42-G2	A42-I2	A51-B1	A52-C2	A72-D2	A72-H2	A81-C1			
MR3	SCMT 120408-MR3			●				●						0,20 - 0,50	0,5 - 6,0
M2	SCMT 120408-M			●				●						0,16 - 0,44	0,5 - 5,0
	SCMT 120412-M			●				●						0,16 - 0,44	0,5 - 5,0
M10	SCMT 120404-M10									●				0,08 - 0,25	0,4 - 3,0
	SCMT 120408-M10		●			●					●			0,12 - 0,32	0,5 - 3,5
MF9	SCMT 120408-MF9									●				0,12 - 0,32	0,5 - 2,5
	SCMT 120412-MF9									●				0,12 - 0,32	0,5 - 2,5

ORDER EXAMPLE: CCMT 09T304-M A31-A1

[illegible][illegible]

CARBIDE	SC 2509	90°	STEEL
		SQUARE	
		7° POSITIVE	

25,40	d	INSCRIBED CIRCLE
25,40	l	CUTTING EDGE LENGTH
9,52	s	THICKNESS



TOLERANCE CLASSES	CLASS	m	d	s
	E	± 0,025	± 0,025	± 0,025
	G	± 0,025	± 0,025	± 0,13
	H	± 0,013	± 0,013	± 0,025
	M	± 0,18	± 0,13	± 0,13
	U	± 0,38	± 0,25	± 0,13

MACHINING MATERIAL	STEEL	P																		
	STAINLESS STEEL	M																		
	CAST IRON	K																		
	NON-FERROUS METAL	N																		
	EXOTIC ALLOY	S																		
	STEEL	H																		

MACHINING TYPES

SECONDARY USE

PRIMARY USE



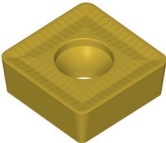
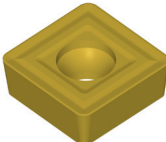
CONTINUOUS CUTTING

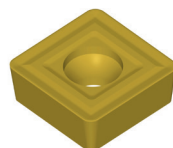
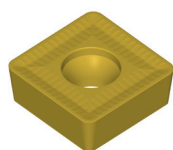


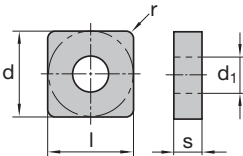
GENERAL CUTTING



INTERRUPTED CUTTING

		MACHINING MATERIAL GROUPE →														Steel Groupe		
		Vc (M/MIN) CUTTING SPEED →												P1 - Unalloyed P2 - Low alloyed P3 - High alloyed / Tool steel P4 - P1,2,3 up to 1000 N/mm²				
GEOMETRY ↓		GRADE → ↓		A22-A2	A22-F2	A31-A1	A32-B2	A42-G2	A42-I2	A51-B1	A52-C2	A72-D2	A72-H2	A81-C1			F (MM/REV) FEED RATE ↓	AP (MM) DEPTH OF CUT ↓
	SCMT 250916-R1					●				●				●			0,5 - 2,0	3,2 - 15,0
	SCMT 250924-R1					●				●							0,5 - 2,0	3,2 - 15,0
	SCMT 250924-R3					●				●							0,5 - 2,0	3,2 - 15,0



CARBIDE SN 0903		90°	STEEL																										
		SQUARE																											
		0° NEGATIVE																											
9,52	d INSCRIBED CIRCLE		TOLERANCE CLASSES	CLASS	m	d	s	SECONDARY USE PRIMARY USE <table><tr><td>○</td><td>●</td><td colspan="2">CONTINUOUS CUTTING</td></tr><tr><td>◐</td><td>◑</td><td colspan="2">GENERAL CUTTING</td></tr><tr><td>⊕</td><td>⊗</td><td colspan="2">INTERRUPTED CUTTING</td></tr></table>										○	●	CONTINUOUS CUTTING		◐	◑	GENERAL CUTTING		⊕	⊗	INTERRUPTED CUTTING	
○	●			CONTINUOUS CUTTING																									
◐	◑			GENERAL CUTTING																									
⊕	⊗	INTERRUPTED CUTTING																											
9,52	l CUTTING EDGE LENGTH	E		± 0,025	± 0,025	± 0,025																							
3,18	s THICKNESS	G		± 0,025	± 0,025	± 0,13																							
		H	± 0,013	± 0,013	± 0,025																								
		M	± 0,08	± 0,05	± 0,13																								
		U	± 0,13	± 0,08	± 0,13																								
MACHINING MATERIAL	STEEL	P	●	●	●	●	◐	◐	◐	◐	⊕	⊕	⊕																
	STAINLESS STEEL	M	○		○	○			◐	◐	⊕		⊕																
	CAST IRON	K	●		○	●			◐	●			⊕																
	NON-FERROUS METAL	N																											
	EXOTIC ALLOY	S	○			○				◐	⊕																		
	STEEL	H																											
			MACHINING TYPES																										

[illegible]

CARBIDE

SN1204

90°

SQUARE

0° NEGATIVE

STEEL

12,70	d	INSCRIBED CIRCLE
12,70	l	CUTTING EDGE LENGTH
4,76	s	THICKNESS

TOLERANCE CLASSES	CLASS	m	d	s
	E	± 0,025	± 0,025	± 0,025
	G	± 0,025	± 0,025	± 0,13
	H	± 0,013	± 0,013	± 0,025
	M	± 0,13	± 0,08	± 0,13
	U	± 0,20	± 0,13	± 0,13

SECONDARY USE

PRIMARY USE

CONTINUOUS CUTTING

GENERAL CUTTING

INTERRUPTED CUTTING

MACHINING MATERIAL

STEEL	P	●	●	●	●	◐	◐	◐	◐	◐	◐	◐			
STAINLESS STEEL	M	○		○	○			◐	◐	◐	◐	◐			
CAST IRON	K	●		○	●			◐	●			◐			
NON-FERROUS METAL	N														
EXOTIC ALLOY	S	○			○				◐	◐					
STEEL	H														

MACHINING TYPES

[illegible]

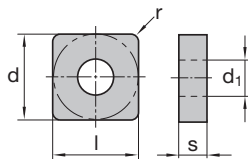
ORDER EXAMPLE: CCMT 09T304-M A31-A1

CARBIDE			STEEL														
			90°														
			SQUARE														
			0° NEGATIVE														
12,70			d INSCRIBED CIRCLE														
12,70			l CUTTING EDGE LENGTH														
4,76			s THICKNESS														
TOLERANCE CLASSES			CLASS			m			d			s					
			E			± 0,025			± 0,025			± 0,025					
			G			± 0,025			± 0,025			± 0,13					
			H			± 0,013			± 0,013			± 0,025					
			M			± 0,13			± 0,08			± 0,13					
			U			± 0,20			± 0,13			± 0,13					
MACHINING MATERIAL			STEEL			P											
			STAINLESS STEEL			M											
			CAST IRON			K											
			NON-FERROUS METAL			N											
			EXOTIC ALLOY			S											
			STEEL			H											

[illegible]

CARBIDE	SN 1506	90°	STEEL
		SQUARE	
		0° NEGATIVE	

15,88	d INSCRIBED CIRCLE
15,88	l CUTTING EDGE LENGTH
6,35	s THICKNESS



TOLERANCE CLASSES	CLASS	m	d	s
	E	± 0,025	± 0,025	± 0,025
	G	± 0,025	± 0,025	± 0,13
	H	± 0,013	± 0,013	± 0,025
	M	± 0,15	± 0,10	± 0,13
	U	± 0,27	± 0,18	± 0,13

MACHINING MATERIAL	STEEL	P																
	STAINLESS STEEL	M																
	CAST IRON	K																
	NON-FERROUS METAL	N																
	EXOTIC ALLOY	S																
	STEEL	H																

MACHINING TYPES

SECONDARY USE

PRIMARY USE



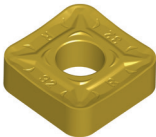
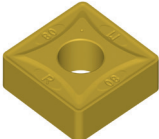
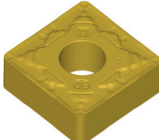
CONTINUOUS CUTTING



GENERAL CUTTING

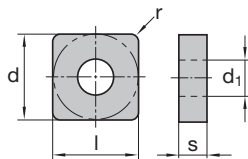


INTERRUPTED CUTTING

GEOMETRY ↓	GRADE → DESIGNATION	MACHINING MATERIAL GROUPE → Vc (M/MIN) CUTTING SPEED →												Steel Groupe	
		P1,2	P1,2,3	P1,2,3	P1,2	P1,2,3	P4	P1,2,3	P1,2,3	P1,2,3	P1,2,3	P1,2,3	P1,2,3		
		A22-A2	A22-F2	A31-A1	A32-B2	A42-G2	A42-I2	A51-B1	A52-C2	A72-D2	A72-H2	A81-C1		F (MM/REV) FEED RATE ↓	AP (MM) DEPTH OF CUT ↓
R 	SNMM 150612-R			●				●				●		0,4 - 1,6	2,0 - 12,5
	SNMM 150616-R			●				●				●		0,4 - 1,6	2,0 - 12,5
MR 	SNMG 150608-MR			●				●				●		0,32 - 0,8	1,2 - 8,0
	SNMG 150612-MR			●				●				●		0,32 - 0,8	1,2 - 8,0
	SNMG 150616-MR			●				●				●		0,32 - 0,8	1,2 - 8,0
M 	SNMG 150608-M			●				●				●		0,16 - 0,4	0,8 - 5,0

CARBIDE	SN 1906	90°	STEEL
		SQUARE	
		0° NEGATIVE	

19,05	d INSCRIBED CIRCLE
19,05	l CUTTING EDGE LENGTH
6,35	s THICKNESS



TOLERANCE CLASSES	CLASS	m	d	s
	E	± 0,025	± 0,025	± 0,025
	G	± 0,025	± 0,025	± 0,13
	H	± 0,013	± 0,013	± 0,025
	M	± 0,15	± 0,10	± 0,13
	U	± 0,27	± 0,18	± 0,13

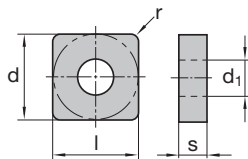
MACHINING MATERIAL	STEEL	P	TOLERANCE CLASSES	CLASS	m	d	s	MACHINING TYPES	SECONDARY USE	PRIMARY USE	CONTINUOUS CUTTING	GENERAL CUTTING	INTERRUPTED CUTTING
	STAINLESS STEEL	M											
	CAST IRON	K											
	NON-FERROUS METAL	N											
	EXOTIC ALLOY	S											
	STEEL	H											

GEOMETRY	GRADE → DESIGNATION	MACHINING MATERIAL GROUPE → Vc (M/MIN) CUTTING SPEED →												Steel Groupe	
		P1,2	P1,2,3	P1,2,3	P1,2	P1,2,3	P4	P1,2,3	P1,2,3	P1,2,3	P1,2,3	P1,2,3	P1,2,3	F (MM/REV) FEED RATE ↓	AP (MM) DEPTH OF CUT ↓
		A22-A2	A22-F2	A31-A1	A32-B2	A42-G2	A42-I2	A51-B1	A52-C2	A72-D2	A72-H2	A81-C1			
R	SNMM 190612-R		●					●				●		0,4 - 1,6	2,0 - 12,5
	SNMM 190616-R		●					●				●		0,4 - 1,6	2,0 - 12,5
	SNMM 190624-R		●					●				●		0,4 - 1,6	2,0 - 12,5
	SNMM 190632-R		●					●				●		0,4 - 1,6	2,0 - 12,5
R4	SNMM 190616-R4							●				●		0,4 - 1,6	1,5 - 12,0
	SNMM 190624-R4		●					●						0,4 - 1,6	1,5 - 12,0
MR	SNMG 190612-MR		●					●				●		0,32 - 0,8	1,2 - 8,0
	SNMG 190616-MR							●				●		0,32 - 0,8	1,2 - 8,0
M	SNMG 190612-M		●					●				●		0,16 - 0,4	0,8 - 5,0

ORDER EXAMPLE: CCMT 09T304-M A31-A1

CARBIDE	SN 2507	90°	STEEL
		SQUARE	
		0° NEGATIVE	

25,40	d	INSCRIBED CIRCLE
25,40	l	CUTTING EDGE LENGTH
7,94	s	THICKNESS



TOLERANCE CLASSES	CLASS	m	d	s
	E	± 0,025	± 0,025	± 0,025
	G	± 0,025	± 0,025	± 0,13
	H	± 0,013	± 0,013	± 0,025
	M	± 0,18	± 0,13	± 0,13
	U	± 0,38	± 0,25	± 0,13

MACHINING MATERIAL	STEEL	P																		
	STAINLESS STEEL	M																		
	CAST IRON	K																		
	NON-FERROUS METAL	N																		
	EXOTIC ALLOY	S																		
	STEEL	H																		

MACHINING TYPES

SECONDARY USE

PRIMARY USE



CONTINUOUS CUTTING



GENERAL CUTTING



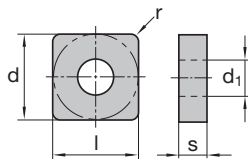
INTERRUPTED CUTTING

GEOMETRY ↓	GRADE → DESIGNATION	MACHINING MATERIAL GROUPE → Vc (M/MIN) CUTTING SPEED →												Steel Groupe	
		P1,2	P1,2,3	P1,2,3	P1,2	P1,2,3	P4	P1,2,3	P1,2,3	P1,2,3	P1,2,3	P1,2,3	P1,2,3	F (MM/REV) FEED RATE ↓	AP (MM) DEPTH OF CUT ↓
R	SNMM 250724-R													0,4 - 1,6	2,0 - 12,5
R2	SNMM 250724-R2													0,8 - 1,6	2,5 - 12,5
	SNMM 250732-R2													0,8 - 1,6	2,5 - 12,5
R4	SNMM 250724 -R4													0,4 - 1,6	1,5 - 12,0
-	SNMM 250716													0,05 - 0,3	0,4 - 2,0
	SNMM 250724													0,05 - 0,3	0,4 - 2,0

ORDER EXAMPLE: CCMT 09T304-M A31-A1

CARBIDE	SN 2509	90°	STEEL
		SQUARE	
		0° NEGATIVE	

25,40	d	INSCRIBED CIRCLE
25,40	l	CUTTING EDGE LENGTH
9,52	s	THICKNESS



TOLERANCE CLASSES	CLASS	m	d	s
	E	± 0,025	± 0,025	± 0,025
	G	± 0,025	± 0,025	± 0,13
	H	± 0,013	± 0,013	± 0,025
	M	± 0,18	± 0,13	± 0,13
	U	± 0,38	± 0,25	± 0,13

MACHINING MATERIAL	STEEL	P																
	STAINLESS STEEL	M																
	CAST IRON	K																
	NON-FERROUS METAL	N																
	EXOTIC ALLOY	S																
	STEEL	H																

MACHINING TYPES

SECONDARY USE

PRIMARY USE



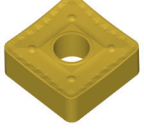
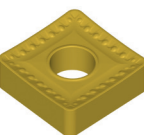
CONTINUOUS CUTTING



GENERAL CUTTING

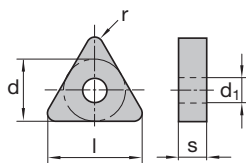


INTERRUPTED CUTTING

GEOMETRY ↓	DESIGNATION ↓	MACHINING MATERIAL GROUPE → VC (M/MIN) CUTTING SPEED →												Steel Groupe	
														F (MM/REV) FEED RATE ↓	AP (MM) DEPTH OF CUT ↓
		A22-A2	A22-F2	A31-A1	A32-B2	A42-G2	A42-I2	A51-B1	A52-C2	A72-D2	A72-H2	A81-C1			
R2 	SNMM 250924-R2			●				●				●		0,8 - 1,6	2,5 - 12,5
	SNMM 250932-R2			●				●				●		0,8 - 1,6	2,5 - 12,5
R4 	SNMM 250924 -R4							●				●		0,4 - 1,6	1,5 - 12,0

CARBIDE	TC 06T1	60°	STEEL
		TRIANGLE	
		7° POSITIVE	

3,97	d INSCRIBED CIRCLE
6,40	l CUTTING EDGE LENGTH
1,98	s THICKNESS



TOLERANCE CLASSES	CLASS	m	d	s
	E	± 0,025	± 0,025	± 0,025
	G	± 0,025	± 0,025	± 0,13
	H	± 0,013	± 0,013	± 0,025
	M	± 0,08	± 0,05	± 0,13
	U	± 0,13	± 0,08	± 0,13

MACHINING MATERIAL	STEEL	P																		
	STAINLESS STEEL	M																		
	CAST IRON	K																		
	NON-FERROUS METAL	N																		
	EXOTIC ALLOY	S																		
	STEEL	H																		

MACHINING TYPES

SECONDARY USE

PRIMARY USE



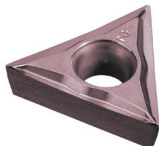
CONTINUOUS CUTTING



GENERAL CUTTING

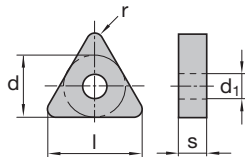


INTERRUPTED CUTTING

GEOMETRY ↓	DESIGNATION ↓	MACHINING MATERIAL GROUPE → VC (M/MIN) CUTTING SPEED →													Steel Groupe	
															F (MM/REV) FEED RATE ↓	AP (MM) DEPTH OF CUT ↓
		A22-A2	A22-F2	A31-A1	A32-B2	A42-G2	A42-I2	A51-B1	A52-C2	A72-D2	A72-H2	A81-C1				
MF17 	TCGT 06T101-MF17	●			●										0,02 - 0,06	0,5 - 1,0
	TCGT 06T102-MF17	●			●										0,05 - 0,12	0,6 - 1,2
F12 	TCGT 06T102-F12	●			●										0,05 - 0,12	0,2 - 2,0

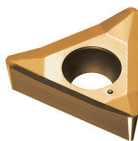
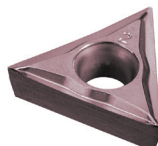
CARBIDE	TC 0902	60°	STEEL
		TRIANGLE	
		7° POSITIVE	

5,56	d INSCRIBED CIRCLE
9,60	l CUTTING EDGE LENGTH
2,38	s THICKNESS



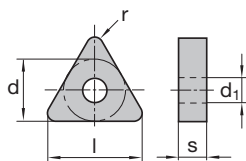
TOLERANCE CLASSES	CLASS	m	d	s
	E	± 0,025	± 0,025	± 0,025
	G	± 0,025	± 0,025	± 0,13
	H	± 0,013	± 0,013	± 0,025
	M	± 0,08	± 0,05	± 0,13
	U	± 0,13	± 0,08	± 0,13

MACHINING MATERIAL	STEEL	P	TOLERANCE CLASSES	CLASS	m	d	s	MACHINING TYPES	SECONDARY USE	PRIMARY USE	CONTINUOUS CUTTING	GENERAL CUTTING	INTERRUPTED CUTTING
	STAINLESS STEEL	M											
	CAST IRON	K											
	NON-FERROUS METAL	N											
	EXOTIC ALLOY	S											
	STEEL	H											

		MACHINING MATERIAL GROUPE →		Steel Groupe												
				P1 - Unalloyed P2 - Low alloyed P3 - High alloyed / Tool steel P4 - P1,2,3 up to 1000 N/mm²												
GEOMETRY ↓		GRADE → DESIGNATION ↓		Vc (M/MIN) CUTTING SPEED →												
				P1,2	P1,2,3	P1,2,3	P1,2	P1,2,3	P4	P1,2,3	P1,2,3	P1,2,3	P1,2,3			
		A22-A2	A22-F2	A31-A1	A32-B2	A42-G2	A42-I2	A51-B1	A52-C2	A72-D2	A72-H2	A81-C1			F (MM/REV) FEED RATE ↓	AP (MM) DEPTH OF CUT ↓
MF17		TCGT 090202-MF17	●		●										0,05 - 0,12	0,6 - 1,6
		TCGT 090204-MF17	●		●										0,08 - 0,16	0,6 - 1,6
F12		TCGT 090202-F12	●		●										0,05 - 0,12	0,2 - 2,0
																

CARBIDE	TC 1102	60°	STEEL
		TRIANGLE	
		7° POSITIVE	

6,35	d INSCRIBED CIRCLE
11,00	l CUTTING EDGE LENGTH
2,38	s THICKNESS



TOLERANCE CLASSES	CLASS	m	d	s
	E	± 0,025	± 0,025	± 0,025
	G	± 0,025	± 0,025	± 0,13
	H	± 0,013	± 0,013	± 0,025
	M	± 0,08	± 0,05	± 0,13
	U	± 0,13	± 0,08	± 0,13

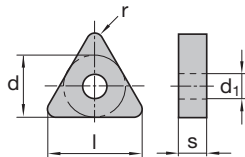
MACHINING MATERIAL	STEEL	P	●	●	●	●	◐	◑	◒	◓	◔	◕	◖	◗	◘			MACHINING TYPES	○	●	CONTINUOUS CUTTING																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																	
	STAINLESS STEEL	M	○			○	○			◐	◑	◒	◓	◔	◕					◐	◑	GENERAL CUTTING																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																
	CAST IRON	K	●			○	●			◐	◑					◒	◓			◔	◕	GENERAL CUTTING																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																
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	EXOTIC ALLOY	S	○				○					◐	◑																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																									
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GEOMETRY	DESIGNATION	MACHINING MATERIAL GROUPE →												Steel Groupe	
		Vc (M/MIN) CUTTING SPEED →												F (MM/REV) FEED RATE	AP (MM) DEPTH OF CUT
		A22-A2	A22-F2	A31-A1	A32-B2	A42-G2	A42-I2	A51-B1	A52-C2	A72-D2	A72-H2	A81-C1			
M	TCMT 110204-M			●				●						0,16 - 0,44	0,5 - 5,0
	TCMT 110208-M			●				●						0,16 - 0,44	0,5 - 5,0
M1	TCGT 110204 EL-M1							●				●		0,2 - 0,45	1,0 - 3,2
	TCGT 110204 ER-M1							●						0,2 - 0,45	1,0 - 3,2
M10	TCMT 110204-M10		●			●					●			0,08 - 0,20	0,4 - 2,0
MF7	TCMT 110202-MF7					●								0,08 - 0,20	0,4 - 1,5
	TCMT 110204-MF7					●								0,08 - 0,20	0,4 - 2,0

ORDER EXAMPLE: CCMT 09T304-M A31-A1

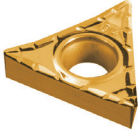
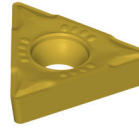
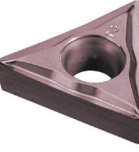
CARBIDE	TC 1102	60°	STEEL
		TRIANGLE	
		7° POSITIVE	

6,35	d INSCRIBED CIRCLE
11,00	l CUTTING EDGE LENGTH
2,38	s THICKNESS



TOLERANCE CLASSES	CLASS	m	d	s
	E	± 0,025	± 0,025	± 0,025
	G	± 0,025	± 0,025	± 0,13
	H	± 0,013	± 0,013	± 0,025
	M	± 0,08	± 0,05	± 0,13
	U	± 0,13	± 0,08	± 0,13

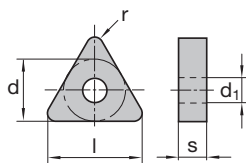
MACHINING MATERIAL	STEEL	P															MACHINING TYPES			CONTINUOUS CUTTING	
	STAINLESS STEEL	M																		GENERAL CUTTING	
	CAST IRON	K																		GENERAL CUTTING	
	NON-FERROUS METAL	N																		GENERAL CUTTING	
	EXOTIC ALLOY	S																			GENERAL CUTTING
	STEEL	H																			GENERAL CUTTING

GEOMETRY ↓	DESIGNATION ↓	MACHINING MATERIAL GROUPE →												Steel Groupe	
		Vc (M/MIN) CUTTING SPEED →												F (MM/REV) FEED RATE ↓	AP (MM) DEPTH OF CUT ↓
		A22-A2	A22-F2	A31-A1	A32-B2	A42-G2	A42-I2	A51-B1	A52-C2	A72-D2	A72-H2	A81-C1			
MF17 	TCGT 110201-MF17	●			●									0,02 - 0,06	0,5 - 1,5
	TCGT 110202-MF17	●			●									0,05 - 0,12	0,6 - 2,0
	TCGT 110204-MF17	●			●									0,08 - 0,25	0,6 - 3,0
MF19 	TCGT 110204-MF19				●									0,08 - 0,25	0,6 - 3,0
F 	TCMT 110202-F			●				●						0,05 - 0,2	0,25 - 2,0
	TCMT 110204-F			●				●						0,05 - 0,2	0,25 - 2,0
F12 	TCGT 110201-F12	●			●									0,02 - 0,06	0,1 - 1,5
	TCGT 110202-F12	●			●									0,05 - 0,12	0,2 - 2,0
	TCGT 110204-F12	●			●									0,08 - 0,25	0,2 - 2,5

ORDER EXAMPLE: CCMT 09T304-M A31-A1

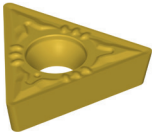
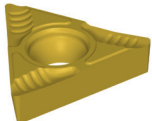
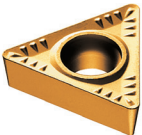
CARBIDE	TC 16T3	60°	STEEL
		TRIANGLE	
		7° POSITIVE	

9,52	d INSCRIBED CIRCLE
16,50	l CUTTING EDGE LENGTH
3,97	s THICKNESS

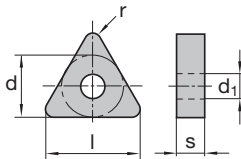


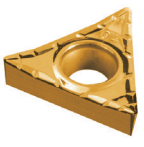
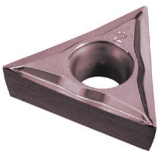
TOLERANCE CLASSES	CLASS	m	d	s
	E	± 0,025	± 0,025	± 0,025
	G	± 0,025	± 0,025	± 0,13
	H	± 0,013	± 0,013	± 0,025
	M	± 0,08	± 0,05	± 0,13
	U	± 0,13	± 0,08	± 0,13

MACHINING MATERIAL	STEEL	P	TOLERANCE CLASSES	CLASS	m	d	s	MACHINING TYPES	SECONDARY USE	PRIMARY USE	CONTINUOUS CUTTING
	STAINLESS STEEL	M									
	CAST IRON	K									
	NON-FERROUS METAL	N									
	EXOTIC ALLOY	S									
	STEEL	H									

GEOMETRY ↓		GRADE → DESIGNATION ↓		MACHINING MATERIAL GROUPE → Vc (M/MIN) CUTTING SPEED →		P1,2	P1,2,3	P1,2,3	P1,2	P1,2,3	P4	P1,2,3	P1,2,3	P1,2,3	P1,2,3	P1,2,3			Steel Groupe			
																						P1 - Unalloyed P2 - Low alloyed P3 - High alloyed / Tool steel P4 - P1,2,3 up to 1000 N/mm²
						A22-A2	A22-F2	A31-A1	A32-B2	A42-G2	A42-I2	A51-B1	A52-C2	A72-D2	A72-H2	A81-C1						
M 	TCMT 16T304-M			●				●											0,2 - 0,45	1,0 - 3,2		
	TCMT 16T308-M			●				●											0,2 - 0,45	1,0 - 3,2		
M1 	TCGT 16T304 EL-M1							●							●				0,16 - 0,44	0,5 - 5,0		
	TCGT 16T304 ER-M1							●							●				0,16 - 0,44	0,5 - 5,0		
	TCGT 16T308 EL-M1							●							●				0,16 - 0,44	0,5 - 5,0		
	TCGT 16T308 ER-M1							●							●				0,16 - 0,44	0,5 - 5,0		
M10 	TCMT 16T304-M10					●								●					0,08 - 0,25	0,4 - 3,0		
	TCMT 16T308-M10					●								●					0,12 - 0,32	0,5 - 3,0		
MF7 	TCMT 16T304-MF7					●													0,08 - 0,25	0,4 - 3,0		
	TCMT 16T308-MF7					●													0,12 - 0,32	0,5 - 3,0		

ORDER EXAMPLE: CCMT 09T304-M A31-A1

CARBIDE		TC 16T3		60°		STEEL															
				TRIANGLE																	
				7° POSITIVE																	
9,52	d	INSCRIBED CIRCLE			TOLERANCE CLASSES	CLASS	m		d		s		SECONDARY USE PRIMARY USE ○ ● CONTINUOUS CUTTING ◐ ◑ GENERAL CUTTING ◒ ◓ INTERRUPTED CUTTING								
16,50	I	CUTTING EDGE LENGTH				E	± 0,025	± 0,025	± 0,025												
3,97	s	THICKNESS				G	± 0,025	± 0,025	± 0,13												
						H	± 0,013	± 0,013	± 0,025												
						M	± 0,08	± 0,05	± 0,13												
						U	± 0,13	± 0,08	± 0,13												
MACHINING MATERIAL	STEEL		P	●	●	●	●	◐	◐	◐	◐	◒	◒	◒							
	STAINLESS STEEL		M	○		○	○			◐	◐	◒	◒								
	CAST IRON		K	●		○	●			◐	◑			◒							
	NON-FERROUS METAL		N																		
	EXOTIC ALLOY		S	○			○				◐	◒									
	STEEL		H																		
				MACHINING TYPES																	

GEOMETRY ↓	DESIGNATION ↓	GRADE → ↓	MACHINING MATERIAL GROUPE → VC (M/MIN) CUTTING SPEED →												Steel Groupe	
			P1,2	P1,2,3	P1,2,3	P1,2	P1,2,3	P4	P1,2,3	P1,2,3	P1,2,3	P1,2,3	P1,2,3	P1,2,3		
			A22-A2	A22-F2	A31-A1	A32-B2	A42-G2	A42-I2	A51-B1	A52-C2	A72-D2	A72-H2	A81-C1		F (MM/REV) FEED RATE ↓	AP (MM) DEPTH OF CUT ↓
MF17 	TCGT 16T302-MF17	●			●										0,05 - 0,12	0,5 - 2,0
	TCGT 16T304-MF17	●			●										0,08 - 0,25	0,6 - 4,0
	TCGT 16T308-MF17	●			●										0,10 - 0,35	0,8 - 4,0
MF19 	TCGT 16T304-MF19	●			●										0,08 - 0,25	0,6 - 4,0
F12 	TCGT 16T301-F12	●													0,02 - 0,06	0,1 - 1,5
	TCGT 16T302-F12				●										0,05 - 0,12	0,2 - 2,0
	TCGT 16T304-F12				●										0,08 - 0,25	0,2 - 2,5

CARBIDE

TN1604

60°

TRIANGLE

0° NEGATIVE

STEEL

9,52d INSCRIBED CIRCLE

16,50l CUTTING EDGE LENGTH

4,76s THICKNESS

TOLERANCE CLASSES

CLASS	m	d	s
E	± 0,025	± 0,025	± 0,025
G	± 0,025	± 0,025	± 0,13
H	± 0,013	± 0,013	± 0,025
M	± 0,08	± 0,05	± 0,13
U	± 0,13	± 0,08	± 0,13

MACHINING MATERIAL

STEEL	P	●●●●●●●●●●●●
STAINLESS STEEL	M	○●●●●●●●●●●●●
CAST IRON	K	●●●●●●●●●●●●
NON-FERROUS METAL	N	○●●●●●●●●●●●●
EXOTIC ALLOY	S	○●●●●●●●●●●●●
STEEL	H	○●●●●●●●●●●●●

MACHINING TYPES

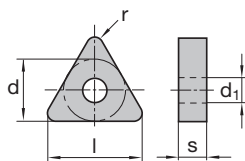
○	●	CONTINUOUS CUTTING
◐	◑	GENERAL CUTTING
◒	◓	INTERRUPTED CUTTING

[illegible]

ORDER EXAMPLE: CCMT 09T304-M A31-A1

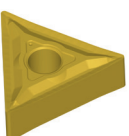
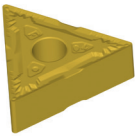
CARBIDE	TN 1604	60°	STEEL
		TRIANGLE	
		0° NEGATIVE	

9,52	d INSCRIBED CIRCLE
16,50	l CUTTING EDGE LENGTH
4,76	s THICKNESS



TOLERANCE CLASSES	CLASS	m	d	s
	E	± 0,025	± 0,025	± 0,025
	G	± 0,025	± 0,025	± 0,13
	H	± 0,013	± 0,013	± 0,025
	M	± 0,08	± 0,05	± 0,13
	U	± 0,13	± 0,08	± 0,13

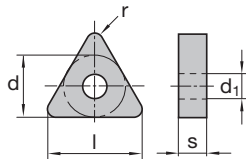
MACHINING MATERIAL	STEEL	P	TOLERANCE CLASSES	CLASS	m	d	s	SECONDARY USE	PRIMARY USE	MACHINING TYPES	CONTINUOUS CUTTING	GENERAL CUTTING	INTERRUPTED CUTTING
	STAINLESS STEEL	M											
	CAST IRON	K											
	NON-FERROUS METAL	N											
	EXOTIC ALLOY	S											
	STEEL	H											

GEOMETRY ↓	GRADE → DESIGNATION	MACHINING MATERIAL GROUPE → VC (M/MIN) CUTTING SPEED →	Steel Groupe												F (MM/REV) FEED RATE ↓	AP (MM) DEPTH OF CUT ↓
			P1,2	P1,2,3	P1,2,3	P1,2	P1,2,3	P4	P1,2,3	P1,2,3	P1,2,3	P1,2,3	P1,2,3	P1,2,3		
			A22-A2	A22-F2	A31-A1	A32-B2	A42-G2	A42-I2	A51-B1	A52-C2	A72-D2	A72-H2	A81-C1			
M7 	TNMG 160404-M7						●	●							0,10 - 0,18	0,5 - 2,0
	TNMG 160408-M7						●	●							0,15 - 0,25	0,8 - 3,0
MF 	TNMG 160404-MF				●				●				●		0,08 - 0,32	0,5 - 4,0
	TNMG 160408-MF				●				●				●		0,08 - 0,32	0,5 - 4,0
	TNMG 160412-MF								●						0,08 - 0,32	0,5 - 4,0
F 	TNMG 160404-F				●				●						0,05 - 0,2	0,12 - 1,9
	TNMG 160408-F				●				●						0,05 - 0,2	0,12 - 1,9
F5 	TNMG 160408-F5						●								0,07 - 0,16	0,4 - 1,5

ORDER EXAMPLE: CCMT 09T304-M A31-A1

CARBIDE	TN 2204	60°	STEEL
		TRIANGLE	
		0° NEGATIVE	

12,70	d INSCRIBED CIRCLE
22,00	l CUTTING EDGE LENGTH
4,76	s THICKNESS



TOLERANCE CLASSES	CLASS	m	d	s
	E	± 0,025	± 0,025	± 0,025
	G	± 0,025	± 0,025	± 0,13
	H	± 0,013	± 0,013	± 0,025
	M	± 0,13	± 0,08	± 0,13
	U	± 0,20	± 0,13	± 0,13

MACHINING MATERIAL	STEEL	P																		
	STAINLESS STEEL	M																		
	CAST IRON	K																		
	NON-FERROUS METAL	N																		
	EXOTIC ALLOY	S																		
	STEEL	H																		

MACHINING TYPES

SECONDARY USE

PRIMARY USE



CONTINUOUS CUTTING



GENERAL CUTTING

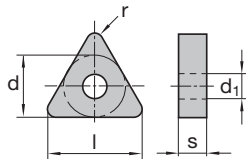


INTERRUPTED CUTTING

GEOMETRY ↓	GRADE → DESIGNATION ↓	MACHINING MATERIAL GROUPE → Vc (M/MIN) CUTTING SPEED →												Steel Groupe	
		P1,2	P1,2,3	P1,2,3	P1,2	P1,2,3	P4	P1,2,3	P1,2,3	P1,2,3	P1,2,3	P1,2,3	P1,2,3		
		140-320	70-400	80-360	120-280	70-350	70-300	50-250	80-240	50-230	70-270	60-170			
R	TNMM 220408-R TNMM 220412-R	A22-A2	A22-F2	A31-A1	A32-B2	A42-G2	A42-I2	A51-B1	A52-C2	A72-D2	A72-H2	A81-C1		F (MM/REV) FEED RATE ↓	AP (MM) DEPTH OF CUT ↓
				●				●				●		0,4 - 1,6	2,0 - 12,5
				●				●				●		0,4 - 1,6	2,0 - 12,5
M	TNMG 220408-M TNMG 220412-M														
				●				●				●		0,16 - 0,4	0,8 - 5,0
								●						0,16 - 0,4	0,8 - 5,0

CARBIDE	TP 1103	60°	STEEL
		TRIANGLE	
		11° POSITIVE	

6,35	d INSCRIBED CIRCLE
11,00	l CUTTING EDGE LENGTH
3,18	s THICKNESS



TOLERANCE CLASSES	CLASS	m	d	s
	E	± 0,025	± 0,025	± 0,025
	G	± 0,025	± 0,025	± 0,13
	H	± 0,013	± 0,013	± 0,025
	M	± 0,08	± 0,05	± 0,13
	U	± 0,13	± 0,08	± 0,13

MACHINING MATERIAL	STEEL	P																		
	STAINLESS STEEL	M																		
	CAST IRON	K																		
	NON-FERROUS METAL	N																		
	EXOTIC ALLOY	S																		
	STEEL	H																		

MACHINING TYPES

SECONDARY USE

PRIMARY USE



CONTINUOUS CUTTING

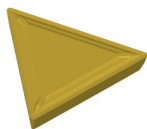


GENERAL CUTTING



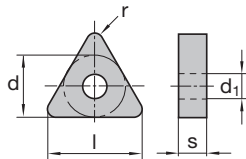
INTERRUPTED CUTTING

GEOMETRY ↓	DESIGNATION ↓	MACHINING MATERIAL GROUPE → VC (M/MIN) CUTTING SPEED →												Steel Groupe	
														F (MM/REV) FEED RATE ↓	AP (MM) DEPTH OF CUT ↓
		A22-A2	A22-F2	A31-A1	A32-B2	A42-G2	A42-I2	A51-B1	A52-C2	A72-D2	A72-H2	A81-C1			
F	TPMR 110304-F			●				●				●		0,05 - 0,2	0,25 - 2,0
	TPMR 110308-F			●				●				●		0,05 - 0,2	0,25 - 2,0



CARBIDE	TP 1603	60°	STEEL
		TRIANGLE	
		11° POSITIVE	

9,52	d INSCRIBED CIRCLE
16,50	l CUTTING EDGE LENGTH
3,18	s THICKNESS



TOLERANCE CLASSES	CLASS	m	d	s
	E	± 0,025	± 0,025	± 0,025
	G	± 0,025	± 0,025	± 0,13
	H	± 0,013	± 0,013	± 0,025
	M	± 0,08	± 0,05	± 0,13
	U	± 0,13	± 0,08	± 0,13

MACHINING MATERIAL	STEEL	P																
	STAINLESS STEEL	M																
	CAST IRON	K																
	NON-FERROUS METAL	N																
	EXOTIC ALLOY	S																
	STEEL	H																

MACHINING TYPES

SECONDARY USE

PRIMARY USE



CONTINUOUS CUTTING

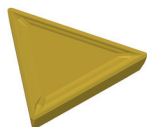


GENERAL CUTTING



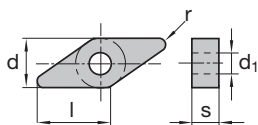
INTERRUPTED CUTTING

GEOMETRY ↓	DESIGNATION ↓	MACHINING MATERIAL GROUPE → VC (M/MIN) CUTTING SPEED →												Steel Groupe	
														F (MM/REV) FEED RATE ↓	AP (MM) DEPTH OF CUT ↓
		A22-A2	A22-F2	A31-A1	A32-B2	A42-G2	A42-I2	A51-B1	A52-C2	A72-D2	A72-H2	A81-C1			
F	TPMR 160304-F			●				●				●		0,05 - 0,2	0,25 - 2,0
	TPMR 160308-F			●				●				●		0,05 - 0,2	0,25 - 2,0



CARBIDE	VB 1604	35°	STEEL
		DIAMOND	
		5° POSITIVE	

9,52	d INSCRIBED CIRCLE
16,60	l CUTTING EDGE LENGTH
4,76	s THICKNESS



TOLERANCE CLASSES	CLASS	m	d	s
	E	± 0,025	± 0,025	± 0,025
	G	± 0,025	± 0,025	± 0,13
	H	± 0,013	± 0,013	± 0,025
	M	± 0,08	± 0,05	± 0,13
	U	± 0,13	± 0,08	± 0,13

MACHINING MATERIAL	STEEL	P	MACHINING TYPES	SECONDARY USE	PRIMARY USE	CONTINUOUS CUTTING
	STAINLESS STEEL	M				
	CAST IRON	K				
	NON-FERROUS METAL	N				
	EXOTIC ALLOY	S				
	STEEL	H				

GEOMETRY ↓	GRADE → DESIGNATION ↓	MACHINING MATERIAL GROUPE →		Vc (M/MIN) CUTTING SPEED →										Steel Groupe	
												P1 - Unalloyed P2 - Low alloyed P3 - High alloyed / Tool steel P4 - P1,2,3 up to 1000 N/mm²			
		A22-A2	A22-F2	A31-A1	A32-B2	A42-G2	A42-I2	A51-B1	A52-C2	A72-D2	A72-H2	A81-C1	F (MM/REV) FEED RATE ↓	AP (MM) DEPTH OF CUT ↓	
	VBMT 160404			●				●						0,05 - 0,3	0,4 - 2,0
	VBMT 160408			●				●						0,05 - 0,3	0,4 - 2,0
	VBMT 160412			●				●						0,05 - 0,3	0,4 - 2,0

CARBIDE	VC 0702	35°	STEEL
		DIAMOND	
		7° POSITIVE	

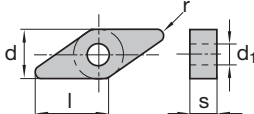
3,97	d INSCRIBED CIRCLE
6,85	l CUTTING EDGE LENGTH
2,38	s THICKNESS

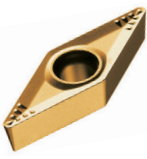
Technical drawing of a turning insert (VC 0702) showing dimensions: d (inscribed circle), l (cutting edge length), s (thickness), d1 (width), and r (radius).

TOLERANCE CLASSES	CLASS	m	d	s
	E	± 0,025	± 0,025	± 0,025
	G	± 0,025	± 0,025	± 0,13
	H	± 0,013	± 0,013	± 0,025
	M	± 0,08	± 0,05	± 0,13
	U	± 0,13	± 0,08	± 0,13

MACHINING MATERIAL	STEEL	P	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●
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GEOMETRY ↓	DESIGNATION ↓	MACHINING MATERIAL GROUPE → VC (M/MIN) CUTTING SPEED →												Steel Groupe	
		GRADE →												F (MM/REV) FEED RATE ↓	AP (MM) DEPTH OF CUT ↓
		A22-A2	A22-F2	A31-A1	A32-B2	A42-G2	A42-I2	A51-B1	A52-C2	A72-D2	A72-H2	A81-C1			
MF17 	VCGT 0702005-MF17	●			●									0,02 - 0,06	0,2 - 1,0
	VCGT 070201-MF17	●			●									0,02 - 0,06	0,2 - 1,0
	VCGT 070202-MF17	●			●									0,05 - 0,08	0,2 - 1,0
	VCGT 070204-MF17	●			●									0,08 - 0,12	0,2 - 1,0
F 	VCMT 070202-F			●				●						0,05 - 0,2	0,25 - 2,0
	VCMT 070204-F			●				●						0,05 - 0,2	0,25 - 2,0
F12 	VCGT 0702005-F12				●									0,02 - 0,06	0,1 - 1,0
	VCGT 070201-F12	●			●									0,02 - 0,06	0,1 - 1,0
	VCGT 070202-F12	●			●									0,05 - 0,08	0,2 - 1,0
	VCGT 070204-F12	●			●									0,08 - 1,20	0,2 - 1,0

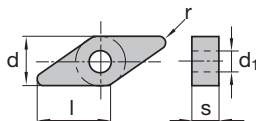
CARBIDE		VC 1103	35°		STEEL																	
			DIAMOND																			
			7° POSITIVE																			
6,35	d	INSCRIBED CIRCLE			TOLERANCE CLASSES	CLASS	m	d	s	SECONDARY USE PRIMARY USE												
11,10	l	CUTTING EDGE LENGTH				E	± 0,025	± 0,025	± 0,025													
3,18	s	THICKNESS				G	± 0,025	± 0,025	± 0,13													
						H	± 0,013	± 0,013	± 0,025													
						M	± 0,08	± 0,05	± 0,13													
						U	± 0,13	± 0,08	± 0,13													
MACHINING MATERIAL	STEEL		P	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●				
	STAINLESS STEEL		M	○		○	○			○	○	○	○	○	○	○	○	○				
	CAST IRON		K	●		○	●			○	●			○								
	NON-FERROUS METAL		N																			
	EXOTIC ALLOY		S	○			○				○	○										
	STEEL		H																			
				MACHINING TYPES																		

GEOMETRY ↓		GRADE → DESIGNATION ↓		MACHINING MATERIAL GROUPE → Vc (M/MIN) CUTTING SPEED →														Steel Groupe			
																		P1 - Unalloyed P2 - Low alloyed P3 - High alloyed / Tool steel P4 - P1,2,3 up to 1000 N/mm²			
				P1,2	P1,2,3	P1,2,3	P1,2	P1,2,3	P4	P1,2,3	P1,2,3	P1,2,3	P1,2,3	P1,2,3							
		A22-A2	A22-F2	A31-A1	A32-B2	A42-G2	A42-I2	A51-B1	A52-C2	A72-D2	A72-H2	A81-C1					F (MM/REV) FEED RATE ↓	AP (MM) DEPTH OF CUT ↓			
		VCMT 110302-M10					●					●					0,05 - 0,15	0,4 - 1,5			
		VCMT 110304-M10					●					●					0,08 - 0,20	0,4 - 1,5			
		VCMT 110308-M10								●	●						0,12 - 0,25	0,5 - 1,5			
		VCMT 110304-MF7		●			●										0,08 - 0,20	0,4 - 1,5			
		VCGT 1103005-MF17	●			●											0,02 - 0,06	0,5 - 1,5			
		VCGT 110301-MF17	●			●											0,02 - 0,06	0,5 - 1,5			
		VCGT 110302-MF17	●			●											0,05 - 0,12	0,5 - 2,0			
		VCGT 110304-MF17	●			●											0,08 - 0,25	0,6 - 2,5			
		VCGT 110308-MF17	●			●											0,10 - 0,35	0,8 - 3,0			
		VCGT 110304-MF19	●			●											0,08 - 0,25	0,6 - 2,5			
		VCGT 110308-MF19				●											0,10 - 0,35	0,8 - 3,0			

ORDER EXAMPLE: CCMT 09T304-M A31-A1

CARBIDE	VC 1103	35°	STEEL
		DIAMOND	
		7° POSITIVE	

6,35	d INSCRIBED CIRCLE
11,10	l CUTTING EDGE LENGTH
3,18	s THICKNESS



TOLERANCE CLASSES	CLASS	m	d	s
	E	± 0,025	± 0,025	± 0,025
	G	± 0,025	± 0,025	± 0,13
	H	± 0,013	± 0,013	± 0,025
	M	± 0,08	± 0,05	± 0,13
	U	± 0,13	± 0,08	± 0,13

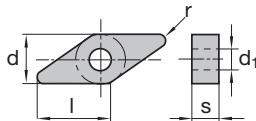
MACHINING MATERIAL	STEEL	P	TOLERANCE CLASSES	CLASS	m	d	s	MACHINING TYPES	SECONDARY USE	PRIMARY USE	CONTINUOUS CUTTING	GENERAL CUTTING	INTERRUPTED CUTTING
	STAINLESS STEEL	M											
	CAST IRON	K											
	NON-FERROUS METAL	N											
	EXOTIC ALLOY	S											
	STEEL	H											

GEOMETRY	DESIGNATION	GRADE →	MACHINING MATERIAL GROUPE →	VC (M/MIN) CUTTING SPEED →	Steel Groupe	
					F (MM/REV) FEED RATE	AP (MM) DEPTH OF CUT
F	VCMT 110302-F				0,05 - 0,2	0,25 - 2,0
	VCMT 110304-F				0,05 - 0,2	0,25 - 2,0
F10	VCMT 110302-F10				0,04 - 0,12	0,1 - 1,0
	VCMT 110304-F10				0,05 - 0,16	0,1 - 1,5
F12	VCGT 1103005-F12				0,02 - 0,06	0,1 - 1,5
	VCGT 110301-F12				0,02 - 0,06	0,1 - 1,5
	VCGT 110302-F12				0,05 - 0,12	0,2 - 2,0
	VCGT 110304-F12				0,08 - 0,25	0,2 - 2,5
W1	VCGT 110302-W1				0,10 - 0,30	0,3 - 3,0
	VCGT 110304-W1				0,12 - 0,40	0,5 - 4,0

ORDER EXAMPLE: CCMT 09T304-M A31-A1

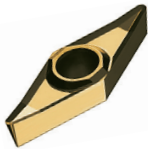
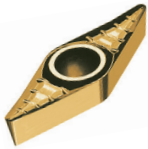
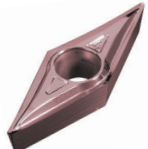
CARBIDE	VC 1303	35°	STEEL
		DIAMOND	
		7° POSITIVE	

7,94	d INSCRIBED CIRCLE
13,10	l CUTTING EDGE LENGTH
3,18	s THICKNESS



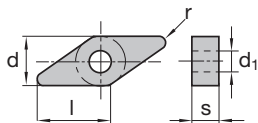
TOLERANCE CLASSES	CLASS	m	d	s
	E	± 0,025	± 0,025	± 0,025
	G	± 0,025	± 0,025	± 0,13
	H	± 0,013	± 0,013	± 0,025
	M	± 0,08	± 0,05	± 0,13
	U	± 0,13	± 0,08	± 0,13

MACHINING MATERIAL	STEEL	P	MACHINING TYPES	SECONDARY USE	PRIMARY USE	CONTINUOUS CUTTING
	STAINLESS STEEL	M				
	CAST IRON	K				
	NON-FERROUS METAL	N				
	EXOTIC ALLOY	S				
	STEEL	H				

GEOMETRY ↓	DESIGNATION ↓	MACHINING MATERIAL GROUPE → VC (M/MIN) CUTTING SPEED →												Steel Groupe	
		GRADE →												F (MM/REV) FEED RATE ↓	AP (MM) DEPTH OF CUT ↓
		A22-A2	A22-F2	A31-A1	A32-B2	A42-G2	A42-I2	A51-B1	A52-C2	A72-D2	A72-H2	A81-C1			
MF17 	VCGT 1303005-MF17	●												0,02 - 0,06	0,5 - 1,5
	VCGT 130301-MF17	●												0,02 - 0,06	0,5 - 1,5
	VCGT 130302-MF17	●			●									0,05 - 0,12	0,5 - 2,0
	VCGT 130304-MF17	●			●									0,08 - 0,25	0,6 - 3,0
	VCGT 130308-MF17	●			●									0,08 - 0,25	0,6 - 3,0
MF19 	VCGT 130304-MF19	●												0,08 - 0,25	0,6 - 3,0
	VCGT 130308-MF19				●									0,08 - 0,25	0,6 - 3,0
F12 	VCGT 130301-F12	●			●									0,05 - 0,12	0,2 - 2,0
	VCGT 130302-F12	●			●									0,05 - 0,12	0,2 - 2,0
	VCGT 130304-F12	●			●									0,08 - 0,25	0,2 - 2,5

CARBIDE	VC 1604	35°	STEEL
		DIAMOND	
		7° POSITIVE	

9,52	d INSCRIBED CIRCLE
16,60	l CUTTING EDGE LENGTH
4,76	s THICKNESS



TOLERANCE CLASSES	CLASS	m	d	s
	E	± 0,025	± 0,025	± 0,025
	G	± 0,025	± 0,025	± 0,13
	H	± 0,013	± 0,013	± 0,025
	M	± 0,08	± 0,05	± 0,13
	U	± 0,13	± 0,08	± 0,13

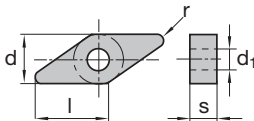
MACHINING MATERIAL	STEEL	P	MACHINING TYPES	SECONDARY USE	PRIMARY USE	CONTINUOUS CUTTING
	STAINLESS STEEL	M				
	CAST IRON	K				
	NON-FERROUS METAL	N				
	EXOTIC ALLOY	S				
	STEEL	H				

GEOMETRY	DESIGNATION	GRADE →	MACHINING MATERIAL GROUPE →	VC (M/MIN) CUTTING SPEED →	Steel Groupe	
					F (MM/REV) FEED RATE	AP (MM) DEPTH OF CUT
M	VCMT 160404-M				0,16 - 0,44	0,5 - 5,0
	VCMT 160408-M				0,16 - 0,44	0,5 - 5,0
M10	VCMT 160404-M10				0,08 - 0,20	0,4 - 2,0
	VCMT 160408-M10				0,12 - 0,30	0,5 - 2,0
	VCMT 160412-M10				0,12 - 0,32	0,5 - 2,0
MF7	VCMT 160404-MF7				0,08 - 0,20	0,4 - 2,0
	VCMT 160408-MF7				0,12 - 0,30	0,5 - 2,0
MF17	VCGT 160401-MF17				0,02 - 0,06	0,5 - 1,5
	VCGT 160402-MF17				0,05 - 0,12	0,2 - 2,0
	VCGT 160404-MF17				0,08 - 0,25	0,6 - 3,5
	VCGT 160408-MF17				0,10 - 0,35	0,8 - 3,5

ORDER EXAMPLE: CCMT 09T304-M A31-A1

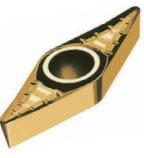
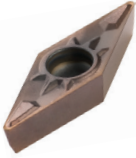
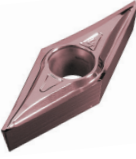
CARBIDE	VC 1604	35°	STEEL
		DIAMOND	
		7° POSITIVE	

9,52	d INSCRIBED CIRCLE
16,60	l CUTTING EDGE LENGTH
4,76	s THICKNESS



TOLERANCE CLASSES	CLASS	m	d	s
	E	± 0,025	± 0,025	± 0,025
	G	± 0,025	± 0,025	± 0,13
	H	± 0,013	± 0,013	± 0,025
	M	± 0,08	± 0,05	± 0,13
	U	± 0,13	± 0,08	± 0,13

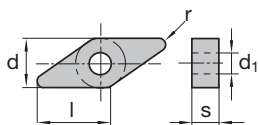
MACHINING MATERIAL	STEEL	P	MACHINING TYPES	SECONDARY USE	PRIMARY USE	CONTINUOUS CUTTING
	STAINLESS STEEL	M				
	CAST IRON	K				
	NON-FERROUS METAL	N				
	EXOTIC ALLOY	S				
	STEEL	H				

GEOMETRY ↓	DESIGNATION ↓	MACHINING MATERIAL GROUPE → VC (M/MIN) CUTTING SPEED →												Steel Groupe	
		GRADE →												F (MM/REV) FEED RATE ↓	AP (MM) DEPTH OF CUT ↓
		A22-A2	A22-F2	A31-A1	A32-B2	A42-G2	A42-I2	A51-B1	A52-C2	A72-D2	A72-H2	A81-C1			
MF19 	VCGT 160404-MF19	●			●									0,08 - 0,25	0,6 - 3,5
	VCGT 160408-MF19	●			●									0,10 - 0,35	0,8 - 3,5
	VCGT 160412-MF19	●			●									0,10 - 0,45	1,0 - 3,5
F 	VCMT 160404-F			●				●						0,05 - 0,2	0,25 - 2,0
	VCMT 160408-F			●				●						0,05 - 0,2	0,25 - 2,0
F10 	VCMT 160404-F10		●			●								0,05 - 0,16	0,1 - 1,5
F12 	VCGT 160401-F12	●			●									0,05 - 0,12	0,2 - 2,0
	VCGT 160402-F12	●			●									0,05 - 0,12	0,2 - 2,0
	VCGT 160404-F12	●			●									0,08 - 0,25	0,2 - 2,5
	VCGT 160408-F12	●			●									0,10 - 0,30	0,3 - 3,0

ORDER EXAMPLE: CCMT 09T304-M A31-A1

CARBIDE	VC 1604	35°	STEEL
		DIAMOND	
		7° POSITIVE	

9,52	d	INSCRIBED CIRCLE
16,60	l	CUTTING EDGE LENGTH
4,76	s	THICKNESS



TOLERANCE CLASSES	CLASS	m	d	s
	E	± 0,025	± 0,025	± 0,025
	G	± 0,025	± 0,025	± 0,13
	H	± 0,013	± 0,013	± 0,025
	M	± 0,08	± 0,05	± 0,13
	U	± 0,13	± 0,08	± 0,13

MACHINING MATERIAL	STEEL	P																
	STAINLESS STEEL	M																
	CAST IRON	K																
	NON-FERROUS METAL	N																
	EXOTIC ALLOY	S																
	STEEL	H																

MACHINING TYPES

SECONDARY USE

PRIMARY USE



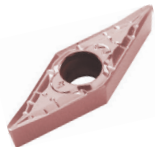
CONTINUOUS CUTTING

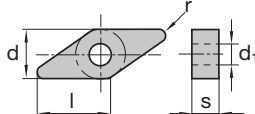


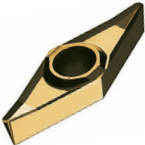
GENERAL CUTTING



INTERRUPTED CUTTING

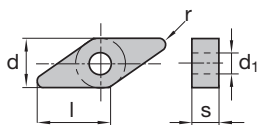
GEOMETRY ↓	DESIGNATION ↓	MACHINING MATERIAL GROUPE → VC (M/MIN) CUTTING SPEED →												Steel Groupe	
		A22-A2	A22-F2	A31-A1	A32-B2	A42-G2	A42-I2	A51-B1	A52-C2	A72-D2	A72-H2	A81-C1		F (MM/REV) FEED RATE ↓	AP (MM) DEPTH OF CUT ↓
W1 	VC160404-W1	●												0,12 - 0,40	0,5 - 4,0
	VC160408-W1	●												0,15 - 0,50	0,7 - 4,0

CARBIDE		VC 2205		35°		STEEL															
				DIAMOND																	
				7° POSITIVE																	
12,70	d	INSCRIBED CIRCLE				TOLERANCE CLASSES	CLASS	m	d	s	SECONDARY USE PRIMARY USE										
22,10	l	CUTTING EDGE LENGTH					E	± 0,025	± 0,025	± 0,025											
5,56	s	THICKNESS					G	± 0,025	± 0,025	± 0,13											
							H	± 0,013	± 0,013	± 0,025											
							M	± 0,13	± 0,08	± 0,13											
							U	± 0,20	± 0,13	± 0,13											
MACHINING MATERIAL	STEEL		P	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●			
	STAINLESS STEEL		M	○		○	○			○	○	○	○	○	○	○	○	○			
	CAST IRON		K	●		○	●			○	●			○							
	NON-FERROUS METAL		N																		
	EXOTIC ALLOY		S	○			○				○	○									
	STEEL		H																		
				MACHINING TYPES										○ ●		○ ●		○ ●			
														CONTINUOUS CUTTING		GENERAL CUTTING		INTERRUPTED CUTTING			

		MACHINING MATERIAL GROUPE →												Steel Groupe P1 - Unalloyed P2 - Low alloyed P3 - High alloyed / Tool steel P4 - P1,2,3 up to 1000 N/mm²		
		Vc (M/MIN) CUTTING SPEED →														
GEOMETRY ↓		GRADE → DESIGNATION ↓														F (MM/REV) FEED RATE ↓
MF17 	VC GT 220520-MF17	●													0,10 - 0,45	1,0 - 3,5
	VC GT 220530-MF17	●			●										0,10 - 0,45	1,0 - 3,5
MF19 	VC GT 220530-MF19				●										0,10 - 0,45	1,0 - 3,5

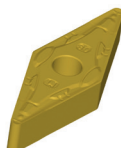
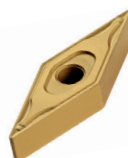
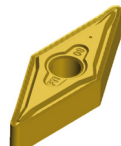
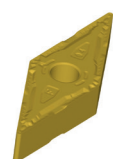
CARBIDE	VN 1604	35°	STEEL
		DIAMOND	
		0° NEGATIVE	

9,52	d INSCRIBED CIRCLE
16,60	l CUTTING EDGE LENGTH
4,76	s THICKNESS



TOLERANCE CLASSES	CLASS	m	d	s
	E	± 0,025	± 0,025	± 0,025
	G	± 0,025	± 0,025	± 0,13
	H	± 0,013	± 0,013	± 0,025
	M	± 0,08	± 0,05	± 0,13
	U	± 0,13	± 0,08	± 0,13

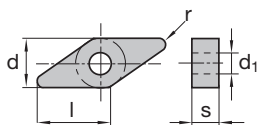
MACHINING MATERIAL	STEEL	P	TOLERANCE CLASSES	CLASS	m	d	s	MACHINING TYPES	SECONDARY USE	PRIMARY USE	CONTINUOUS CUTTING	GENERAL CUTTING	INTERRUPTED CUTTING
	STAINLESS STEEL	M											
	CAST IRON	K											
	NON-FERROUS METAL	N											
	EXOTIC ALLOY	S											
	STEEL	H											

GEOMETRY ↓		MACHINING MATERIAL GROUPE → VC (M/MIN) CUTTING SPEED →		Steel Groupe												
				P1 - Unalloyed P2 - Low alloyed P3 - High alloyed / Tool steel P4 - P1,2,3 up to 1000 N/mm²												
GRADE → DESIGNATION ↓		A22-A2	A22-F2	A31-A1	A32-B2	A42-G2	A42-I2	A51-B1	A52-C2	A72-D2	A72-H2	A81-C1			F (MM/REV) FEED RATE ↓	AP (MM) DEPTH OF CUT ↓
M 	VNMG 160408-M			●				●				●			0,16 - 0,4	0,8 - 5,0
	VNMG 160412-M			●				●				●			0,16 - 0,4	0,8 - 5,0
M7 	VNMG 160404-M7					●									0,10 - 0,18	0,5 - 2,0
MF 	VNMG 160408-MF			●				●							0,08 - 0,32	0,5 - 4,0
F 	VNMG 160404-F			●				●							0,05 - 0,2	0,12 - 1,9
	VNMG 160408-F			●				●							0,05 - 0,2	0,12 - 1,9

ORDER EXAMPLE: CCMT 09T304-M A31-A1

CARBIDE	VN 1604	35°	STEEL
		DIAMOND	
		0° NEGATIVE	

9,52	d INSCRIBED CIRCLE
16,60	l CUTTING EDGE LENGTH
4,76	s THICKNESS



TOLERANCE CLASSES	CLASS	m	d	s
	E	± 0,025	± 0,025	± 0,025
	G	± 0,025	± 0,025	± 0,13
	H	± 0,013	± 0,013	± 0,025
	M	± 0,13	± 0,08	± 0,13
	U	± 0,20	± 0,13	± 0,13

MACHINING MATERIAL	STEEL	P																		
	STAINLESS STEEL	M																		
	CAST IRON	K																		
	NON-FERROUS METAL	N																		
	EXOTIC ALLOY	S																		
	STEEL	H																		

MACHINING TYPES

SECONDARY USE

PRIMARY USE



CONTINUOUS CUTTING



GENERAL CUTTING



INTERRUPTED CUTTING

GEOMETRY ↓	DESIGNATION ↓	MACHINING MATERIAL GROUPE →														Steel Groupe			
		Vc (M/MIN) CUTTING SPEED →														P1 - Unalloyed P2 - Low alloyed P3 - High alloyed / Tool steel P4 - P1,2,3 up to 1000 N/mm²			
		A22-A2	A22-F2	A31-A1	A32-B2	A42-G2	A42-I2	A51-B1	A52-C2	A72-D2	A72-H2	A81-C1							
	F5	VNMG 160404-F5					●												

[illegible][illegible]

CARBIDE

WC
0302

80°

TRIGON

7° POSITIVE

STEEL

5,56

d INSCRIBED CIRCLE

3,80

l CUTTING EDGE LENGTH

2,38

s THICKNESS

d

l

r

d₁

s

TOLERANCE CLASSES

CLASS	m	d	s
E	± 0,025	± 0,025	± 0,025
G	± 0,025	± 0,025	± 0,13
H	± 0,013	± 0,013	± 0,025
M	± 0,08	± 0,05	± 0,13
U	± 0,13	± 0,08	± 0,13

MACHINING MATERIAL

STEEL	P	●	●	●	●	◐	◐	◐	◐	◐	◐	◐		
STAINLESS STEEL	M	○		○	○			◐	◐	◐	◐			
CAST IRON	K	●		○	●			◐	●		◐			
NON-FERROUS METAL	N													
EXOTIC ALLOY	S	○			○			◐	◐					
STEEL	H													

MACHINING TYPES

○	●	CONTINUOUS CUTTING
◐	◑	GENERAL CUTTING
◐◑	◐◑	INTERRUPTED CUTTING

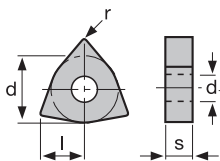
SECONDARY USE

PRIMARY USE

[illegible]

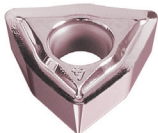
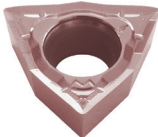
CARBIDE	WC 0402	80°	STEEL
		TRIGON	
		7° POSITIVE	

6,35	d INSCRIBED CIRCLE
4,30	l CUTTING EDGE LENGTH
2,38	s THICKNESS



TOLERANCE CLASSES	CLASS	m	d	s
	E	± 0,025	± 0,025	± 0,025
	G	± 0,025	± 0,025	± 0,13
	H	± 0,013	± 0,013	± 0,025
	M	± 0,08	± 0,05	± 0,13
	U	± 0,13	± 0,08	± 0,13

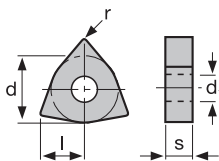
MACHINING MATERIAL	STEEL	P	TOLERANCE CLASSES	CLASS	m	d	s	MACHINING TYPES	SECONDARY USE	PRIMARY USE	CONTINUOUS CUTTING	GENERAL CUTTING	INTERRUPTED CUTTING
	STAINLESS STEEL	M											
	CAST IRON	K											
	NON-FERROUS METAL	N											
	EXOTIC ALLOY	S											
	STEEL	H											

		MACHINING MATERIAL GROUPE →														Steel Groupe		
		P1,2	P1,2,3	P1,2,3	P1,2	P1,2,3	P4	P1,2,3	P1,2,3	P1,2,3	P1,2,3	P1,2,3			P1 - Unalloyed P2 - Low alloyed P3 - High alloyed / Tool steel P4 - P1,2,3 up to 1000 N/mm²			
		VC (M/MIN) CUTTING SPEED →		140-320	70-400	80-360	120-280	70-350	70-300	50-250	80-240	50-230	70-270	60-170				
GEOMETRY ↓		GRADE → DESIGNATION ↓		A22-A2	A22-F2	A31-A1	A32-B2	A42-G2	A42-I2	A51-B1	A52-C2	A72-D2	A72-H2	A81-C1				
				F (MM/REV) FEED RATE ↓													AP (MM) DEPTH OF CUT ↓	
M10		WCMT 040204-M10											●				0,08 - 0,25	0,4 - 2,0
																		
MF17		WCGT 040202-MF17					●										0,05 - 0,12	0,5 - 2,0
		WCGT 040204-MF17		●													0,08 - 0,25	0,6 - 2,5
F12		WCGT 040202-F12		●			●										0,05 - 0,12	0,2 - 2,0
		WCGT 040204-F12		●													0,08 - 0,25	0,2 - 2,5
W1		WCGT 040204-W1		●													0,08 - 0,20	0,2 - 1,2
																		

ORDER EXAMPLE: CCMT 09T304-M A31-A1

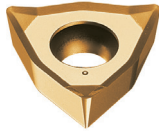
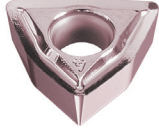
CARBIDE	WC 06T3	80°	STEEL
		TRIGON	
		7° POSITIVE	

9,52	d INSCRIBED CIRCLE
6,50	l CUTTING EDGE LENGTH
3,97	s THICKNESS



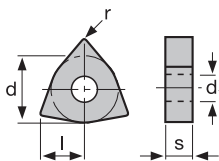
TOLERANCE CLASSES	CLASS	m	d	s
	E	± 0,025	± 0,025	± 0,025
	G	± 0,025	± 0,025	± 0,13
	H	± 0,013	± 0,013	± 0,025
	M	± 0,08	± 0,05	± 0,13
	U	± 0,13	± 0,08	± 0,13

MACHINING MATERIAL	STEEL	P	TOLERANCE CLASSES	CLASS	m	d	s	MACHINING TYPES	SECONDARY USE	PRIMARY USE	CONTINUOUS CUTTING	GENERAL CUTTING	INTERRUPTED CUTTING
	STAINLESS STEEL	M											
	CAST IRON	K											
	NON-FERROUS METAL	N											
	EXOTIC ALLOY	S											
	STEEL	H											

GEOMETRY ↓	DESIGNATION ↓	GRADE → ↓	MACHINING MATERIAL GROUPE → ↓	Vc (M/MIN) CUTTING SPEED →	Steel Groupe	F (MM/REV) FEED RATE ↓	AP (MM) DEPTH OF CUT ↓
M10 	WCMT 06T304-M10	●	P1,2	140-320	P1 - Unalloyed	0,08 - 0,25	0,4 - 2,5
	WCMT 06T308-M10	●	P1,2,3	70-400	P2 - Low alloyed	0,12 - 0,32	0,5 - 2,5
			P1,2,3	80-360	P3 - High alloyed / Tool steel		
MF17 	WCGT 06T302-MF17	●	P1,2	120-280	P4 - P1,2,3 up to 1000 N/mm²	0,05 - 0,12	0,6 - 2,0
	WCGT 06T304-MF17	●	P1,2,3	70-350		0,08 - 0,25	0,6 - 3,0
			P4	70-300			
F12 	WCGT 06T304-F12	●	P1,2,3	50-250		0,08 - 0,25	0,20 - 2,5
			P1,2,3	80-240			
			P1,2,3	50-230			

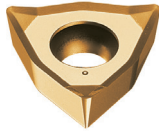
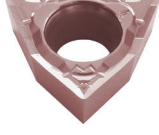
CARBIDE	WC 0804	80°	STEEL
		TRIGON	
		7° POSITIVE	

12,70	d INSCRIBED CIRCLE
8,72	l CUTTING EDGE LENGTH
4,76	s THICKNESS



TOLERANCE CLASSES	CLASS	m	d	s
	E	± 0,025	± 0,025	± 0,025
	G	± 0,025	± 0,025	± 0,13
	H	± 0,013	± 0,013	± 0,025
	M	± 0,13	± 0,08	± 0,13
	U	± 0,20	± 0,13	± 0,13

MACHINING MATERIAL	STEEL	P													MACHINING TYPES	SECONDARY USE	PRIMARY USE	CONTINUOUS CUTTING
	STAINLESS STEEL	M																
	CAST IRON	K																
	NON-FERROUS METAL	N																
	EXOTIC ALLOY	S																
	STEEL	H																

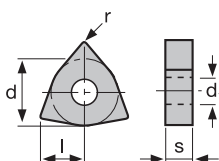
GEOMETRY ↓	DESIGNATION ↓	MACHINING MATERIAL GROUPE →												Steel Groupe	
		Vc (M/MIN) CUTTING SPEED →												F (MM/REV) FEED RATE ↓	AP (MM) DEPTH OF CUT ↓
		A22-A2	A22-F2	A31-A1	A32-B2	A42-G2	A42-I2	A51-B1	A52-C2	A72-D2	A72-H2	A81-C1			
M10 	WCMT 080404-M10									●				0,08 - 0,25	0,5 - 3,0
	WCMT 080408-M10									●				0,10 - 0,35	0,6 - 3,0
MF17 	WCGT 080404-MF17	●			●									0,08 - 0,25	0,6 - 4,0
	WCGT 080408-MF17	●												0,10 - 0,35	0,8 - 4,0
MF19 	WCGT 080404-MF19				●									0,08 - 0,25	0,6 - 4,0
W1 	WCGT 080404-W1	●												0,12 - 0,40	0,5 - 4,0

ORDER EXAMPLE: CCMT 09T304-M A31-A1

[illegible][illegible]

CARBIDE	WN 0804	80°	STEEL
		TRIGON	
		0° NEGATIVE	

12,70	d INSCRIBED CIRCLE
8,60	l CUTTING EDGE LENGTH
4,76	s THICKNESS



TOLERANCE CLASSES	CLASS	m	d	s
	E	± 0,025	± 0,025	± 0,025
	G	± 0,025	± 0,025	± 0,13
	H	± 0,013	± 0,013	± 0,025
	M	± 0,13	± 0,08	± 0,13
	U	± 0,20	± 0,13	± 0,13

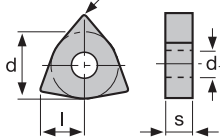
MACHINING MATERIAL	STEEL	P	●	●	●	●	◐	◐	◐	◐	◐	◐	◐	◐	◐	◐	◐	MACHINING TYPES			CONTINUOUS CUTTING
	STAINLESS STEEL	M	○			○	○			◐	◐	◐	◐	◐	◐	◐					
	CAST IRON	K	●			○	●			◐	●			◐							
	NON-FERROUS METAL	N																			
	EXOTIC ALLOY	S	○				○					◐	◐								
	STEEL	H																			

GEOMETRY	DESIGNATION	MACHINING MATERIAL GROUPE →												Steel Groupe	
		Vc (M/MIN) CUTTING SPEED →												F (MM/REV) FEED RATE	AP (MM) DEPTH OF CUT
		A22-A2	A22-F2	A31-A1	A32-B2	A42-G2	A42-I2	A51-B1	A52-C2	A72-D2	A72-H2	A81-C1			
R7	WNMG 080408-R7					●	●				●			0,20 - 0,40	0,8 - 6,0
	WNMG 080412-R7					●	●				●			0,25 - 0,60	1,0 - 6,0
MR	WNMG 080408-MR			●				●				●		0,32 - 0,80	1,2 - 8,0
	WNMG 080412-MR			●				●				●		0,32 - 0,80	1,2 - 8,0
	WNMG 080416-MR			●				●				●		0,32 - 0,80	1,2 - 8,0
MR1	WNMG 080408-MR1			●				●						0,19 - 0,80	1,4 - 4,0
	WNMG 080412-MR1			●				●						0,19 - 0,80	1,4 - 4,0
M	WNMG 080408-M			●				●				●		0,16 - 0,40	0,8 - 5,0
	WNMG 080412-M			●				●				●		0,16 - 0,40	0,8 - 5,0
	WNMG 080416-M			●				●						0,16 - 0,40	0,8 - 5,0

ORDER EXAMPLE: CCMT 09T304-M A31-A1

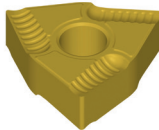
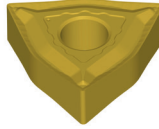
CARBIDE	WN 0804	80°	STEEL
		TRIGON	
		0° NEGATIVE	

12,70	d INSCRIBED CIRCLE
8,60	l CUTTING EDGE LENGTH
4,76	s THICKNESS



TOLERANCE CLASSES	CLASS	m	d	s
	E	± 0,025	± 0,025	± 0,025
	G	± 0,025	± 0,025	± 0,13
	H	± 0,013	± 0,013	± 0,025
	M	± 0,13	± 0,08	± 0,13
	U	± 0,20	± 0,13	± 0,13

MACHINING MATERIAL	STEEL	P	MACHINING TYPES	SECONDARY USE	PRIMARY USE	CONTINUOUS CUTTING
	STAINLESS STEEL	M				
	CAST IRON	K				
	NON-FERROUS METAL	N				
	EXOTIC ALLOY	S				
	STEEL	H				

GEOMETRY	DESIGNATION	MACHINING MATERIAL GROUPE → Vc (M/MIN) CUTTING SPEED →												Steel Groupe	
		GRADE →												F (MM/REV) FEED RATE ↓	AP (MM) DEPTH OF CUT ↓
		A22-A2	A22-F2	A31-A1	A32-B2	A42-G2	A42-I2	A51-B1	A52-C2	A72-D2	A72-H2	A81-C1			
M1 	WNMG 080404 ER-M1			●				●				●		0,2 - 0,45	1,0 - 3,2
	WNMG 080408 EL-M1			●				●				●		0,2 - 0,45	1,0 - 3,2
	WNMG 080408 ER-M1			●				●				●		0,2 - 0,45	1,0 - 3,2
	WNMG 080412 EL-M1							●				●		0,2 - 0,45	1,0 - 3,2
	WNMG 080412 ER-M1							●				●		0,2 - 0,45	1,0 - 3,2
M7 	WNMG 080404-M7					●								0,10 - 0,20	0,5 - 3,0
	WNMG 080408-M7					●	●							0,15 - 0,32	0,8 - 3,0
	WNMG 080412-M7		●			●	●							0,15 - 0,35	0,8 - 3,5
MF 	WNMG 080404-MF			●				●				●		0,08 - 0,32	0,5 - 4,0
	WNMG 080408-MF			●				●				●		0,08 - 0,32	0,5 - 4,0

CARBIDE	CC 0602	80°	STAINLESS STEEL																	
		DIAMOND																		
		7° POSITIVE																		
6,35	d	INSCRIBED CIRCLE			TOLERANCE CLASSES	CLASS	m	d	s	SECONDARY USE PRIMARY USE										
6,40	l	CUTTING EDGE LENGTH				E	± 0,025	± 0,025	± 0,025											
2,38	s	THICKNESS				G	± 0,025	± 0,025	± 0,13											
						H	± 0,013	± 0,013	± 0,025											
						M	± 0,08	± 0,05	± 0,13											
						U	± 0,13	± 0,08	± 0,13											
MACHINING MATERIAL	STEEL P		○	●	○	○	☉	☉	○	☉	☉	☉	☉	☉	☉	☉	☉	SECONDARY USE PRIMARY USE	CONTINUOUS CUTTING GENERAL CUTTING INTERRUPTED CUTTING	
	STAINLESS STEEL M		●	●	●	●	☉	☉	●	☉	☉	☉	☉	☉	☉	☉				
	CAST IRON K		○	○			☉		○	☉										
	NON-FERROUS METAL N		○	○			☉			☉										
	EXOTIC ALLOY S		●	●			☉	●	☉	☉										
	STEEL H		○	○			☉			☉										

		MACHINING MATERIAL GROUPE →												Stainless steel Groupe	
		Vc (M/MIN) CUTTING SPEED →													
		GRADE →													
GEOMETRY ↓		DESIGNATION ↓												F (MM/REV) FEED RATE ↓	
														AP (MM) DEPTH OF CUT ↓	
M1		CCMT 060202-M1			●			●				●		0,13 - 0,63	1,0 - 4,0
		CCMT 060204-M1			●			●				●		0,13 - 0,63	1,0 - 4,0
E-M1		CCGT 060204 EL-M1										●		0,13 - 0,63	1,0 - 4,0
		CCGT 060204 ER-M1										●		0,13 - 0,63	1,0 - 4,0
		CCGT 060208 EL-M1										●		0,13 - 0,63	1,0 - 4,0
		CCGT 060208 ER-M1										●		0,13 - 0,63	1,0 - 4,0
M10		CCMT 060202-M10					●			●				0,05 - 0,12	0,3 - 2,0
		CCMT 060204-M10					●			●				0,08 - 0,20	0,4 - 2,0
		CCMT 060208-M10					●			●				0,10 - 0,25	0,5 - 2,0
MF7		CCMT 060202-MF7					●			●				0,05 - 0,12	0,3 - 2,0
		CCMT 060204-MF7	●				●			●				0,08 - 0,20	0,4 - 2,0

ORDER EXAMPLE: CCMT 09T304-M A31-A1

CARBIDE

CC
0602

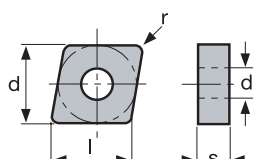
80°

DIAMOND

7° POSITIVE

STAINLESS STEEL

6,35	d	INSCRIBED CIRCLE
6,40	l	CUTTING EDGE LENGTH
2,38	s	THICKNESS



TOLERANCE CLASSES	CLASS	m	d	s
	E	± 0,025	± 0,025	± 0,025
	G	± 0,025	± 0,025	± 0,13
	H	± 0,013	± 0,013	± 0,025
	M	± 0,08	± 0,05	± 0,13
	U	± 0,13	± 0,08	± 0,13

MACHINING MATERIAL

STEEL	P
STAINLESS STEEL	M
CAST IRON	K
NON-FERROUS METAL	N
EXOTIC ALLOY	S
STEEL	H

○	●	○	○	☉	☉	○	☉	☉	☉	☉	☉	☉
●	●	●	●	☉	☉	●	☉	☉	☉	☉	☉	☉
○	○			☉		○	☉					
○	○			☉			☉					
●	●			☉	●	☉	☉					
○	○			☉			☉					

MACHINING TYPES

SECONDARY USE
○

PRIMARY USE
●

○

☉

☉

○

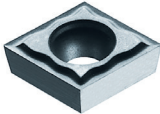
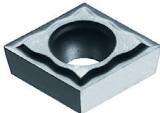
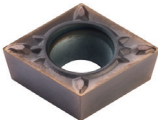
☉

☉

CONTINUOUS CUTTING

GENERAL CUTTING

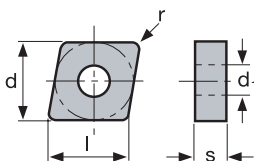
INTERRUPTED CUTTING

		MACHINING MATERIAL GROUPE →												Stainless steel Groupe		
		Vc (M/MIN) CUTTING SPEED →														
GEOMETRY ↓		GRADE →												F (MM/REV) FEED RATE ↓	AP (MM) DEPTH OF CUT ↓	
		DESIGNATION ↓														
		B22-V2	B32-S2	B41-D1	B42-T2	B42-W2	B51-E1	B52-U2	B62-O2	B62-Y2	B71-G1	B72-R2	B81-F1			
MF10 	CCGT 060201-MF10				●										0,02 - 0,06	0,1 - 0,5
	CCGT 060202-MF10				●										0,04 - 0,10	0,1 - 0,6
	CCGT 060204-MF10				●										0,06 - 0,12	0,2 - 0,6
MF15 	CCGT 060201-MF15				●										0,02 - 0,06	0,1 - 0,5
	CCGT 060202-MF15				●										0,04 - 0,10	0,1 - 0,6
	CCGT 060204-MF15				●										0,06 - 0,12	0,2 - 0,6
F 	CCMT 060202-F						●						●		0,05 - 0,20	0,1 - 2,0
	CCMT 060204-F						●						●		0,05 - 0,20	0,1 - 2,0
F10 	CCMT 060202-F10	●				●			●						0,04 - 0,12	0,1 - 1,0
	CCMT 060204-F10	●				●			●						0,05 - 0,16	0,1 - 1,5

ORDER EXAMPLE: CCMT 09T304-M A31-A1

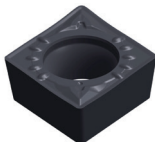
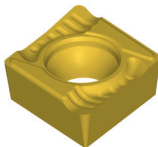
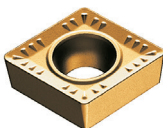
CARBIDE	CC 09T3	80°	STAINLESS STEEL
		DIAMOND	
		7° POSITIVE	

9,52	d	INSCRIBED CIRCLE
9,70	l	CUTTING EDGE LENGTH
3,97	s	THICKNESS



TOLERANCE CLASSES	CLASS	m	d	s
	E	± 0,025	± 0,025	± 0,025
	G	± 0,025	± 0,025	± 0,13
	H	± 0,013	± 0,013	± 0,025
	M	± 0,08	± 0,05	± 0,13
	U	± 0,13	± 0,08	± 0,13

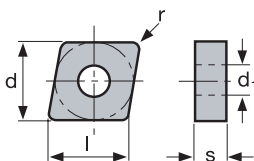
MACHINING MATERIAL	STEEL	P	TOLERANCE CLASSES	MACHINING TYPES									
	STAINLESS STEEL	M		SECONDARY USE									
	CAST IRON	K		PRIMARY USE									
	NON-FERROUS METAL	N		CONTINUOUS CUTTING									
	EXOTIC ALLOY	S		GENERAL CUTTING									
	STEEL	H		INTERRUPTED CUTTING									

		MACHINING MATERIAL GROUPE →	M1,2,3	M1,2,3	M1,2,3	M1,2,3	M1,2,3	M1,2,3	M1,2,3	M1,2,3	M1,2,3	M1,2,3	M1,2,3		Stainless steel Groupe		
															M1 - Ferritic M2 - Martensitic M3 - Austenitic (Hardened - reduce 30%)		
GEOMETRY ↓	DESIGNATION ↓	GRADE →													F (MM/REV) FEED RATE ↓	AP (MM) DEPTH OF CUT ↓	
MR1 	CCMT 09T304-MR1												●			0,20 - 0,50	0,5 - 9,1
	CCMT 09T308-MR1												●			0,20 - 0,50	0,5 - 9,1
M1 	CCMT 09T304-M1			●			●									0,13 - 0,63	1,0 - 4,0
	CCMT 09T308-M1			●			●									0,13 - 0,63	1,0 - 4,0
E-M1 	CCGT 09T304 EL-M1											●					
	CCGT 09T308 ER-M1											●					
	CCGT 09T308 ER-M1											●					
M10 	CCMT 09T302-M10					●										0,05 - 0,12	0,3 - 2,0
	CCMT 09T304-M10					●			●							0,08 - 0,25	0,4 - 3,0
	CCMT 09T308-M10					●			●							0,12 - 0,32	0,5 - 3,0

ORDER EXAMPLE: CCMT 09T304-M A31-A1

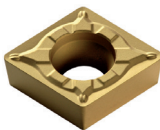
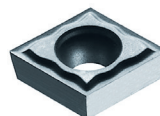
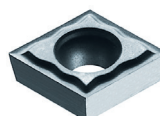
CARBIDE	CC 09T3	80°	STAINLESS STEEL
		DIAMOND	
		7° POSITIVE	

9,52	d	INSCRIBED CIRCLE
9,70	l	CUTTING EDGE LENGTH
3,97	s	THICKNESS



TOLERANCE CLASSES	CLASS	m	d	s
	E	± 0,025	± 0,025	± 0,025
	G	± 0,025	± 0,025	± 0,13
	H	± 0,013	± 0,013	± 0,025
	M	± 0,08	± 0,05	± 0,13
	U	± 0,13	± 0,08	± 0,13

MACHINING MATERIAL	STEEL	P	TOLERANCE CLASSES	CLASS	m	d	s	MACHINING TYPES	SECONDARY USE	PRIMARY USE	CONTINUOUS CUTTING	GENERAL CUTTING	INTERRUPTED CUTTING
	STAINLESS STEEL	M											
	CAST IRON	K											
	NON-FERROUS METAL	N											
	EXOTIC ALLOY	S											
	STEEL	H											

GEOMETRY ↓		GRADE → DESIGNATION ↓		MACHINING MATERIAL GROUPE → Vc (M/MIN) CUTTING SPEED →		Stainless steel Groupe										
						M1 - Ferritic M2 - Martensitic M3 - Austenitic (Hardened - reduce 30%)										
						M1,2,3	M1,2,3	M1,2,3	M1,2,3	M1,2,3	M1,2,3	M1,2,3	M1,2,3	M1,2,3	M1,2,3	
		B22-V2	B32-S2	B41-D1	B42-T2	B42-W2	B51-E1	B52-U2	B62-O2	B62-Y2	B71-G1	B72-R2	B81-F1		F (MM/REV) FEED RATE ↓	AP (MM) DEPTH OF CUT ↓
	MF7	CCMT 09T302-MF7				●			●						0,05 - 0,12	0,3 - 2,0
		CCMT 09T304-MF7				●			●						0,08 - 0,25	0,4 - 3,0
		CCMT 09T308-MF7				●			●						0,12 - 0,32	0,5 - 3,0
	MF10	CCGT 09T301-MF10			●										0,02 - 0,06	0,1 - 0,5
		CCGT 09T302-MF10			●										0,04 - 0,10	0,1 - 1,0
		CCGT 09T304-MF10			●										0,06 - 0,12	0,2 - 1,0
	MF15	CCGT 09T3005-MF15			●										0,02 - 0,06	0,1 - 0,5
		CCGT 09T301-MF15			●										0,02 - 0,06	0,1 - 0,5
		CCGT 09T302-MF15			●										0,04 - 0,10	0,1 - 1,0
		CCGT 09T304-MF15			●										0,06 - 0,12	0,2 - 1,0
	F	CCMT 09T304-F		●		●					●				0,05 - 0,20	0,1 - 2,0

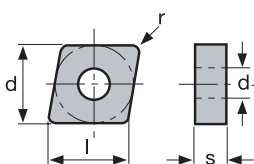
ORDER EXAMPLE: CCMT 09T304-M A31-A1

CARBIDE

CC 09T3

STAINLESS STEEL

d INSCRIBED CIRCLE
l CUTTING EDGE LENGTH
s THICKNESS



TOLERANCE CLASSES	CLASS	m	d	s
	E	± 0,025	± 0,025	± 0,025
	G	± 0,025	± 0,025	± 0,13
	H	± 0,013	± 0,013	± 0,025
	M	± 0,08	± 0,05	± 0,13
	U	± 0,13	± 0,08	± 0,13

SECONDARY USE

PRIMARY USE

MACHINING TYPES



CONTINUOUS CUTTING



GENERAL CUTTING



INTERRUPTED CUTTING

MACHINING MATERIAL	STEEL	P	○	●	○	○	☉	☉	○	☉	☉	☉	☉	☉	☉
	STAINLESS STEEL	M	●	●	●	●	☉	☉	●	☉	☉	☉	☉	☉	☉
	CAST IRON	K	○	○			☉		○	☉					
	NON-FERROUS METAL	N	○	○			☉			☉					
	EXOTIC ALLOY	S	●	●			☉	●	☉	☉					
	STEEL	H	○	○			☉			☉					

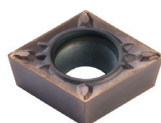
MACHINING MATERIAL GROUPE →

 Vc (M/MIN)
CUTTING SPEED →

 GRADE →
DESIGNATION

GEOMETRY ↓

F10



CCMT 09T302-F10

CCMT 09T304-F10

Stainless steel Groupe

M1 - Ferritic
M2 - Martensitic
M3 - Austenitic
(Hardened - reduce 30%)

 F (MM/REV)
FEED RATE
↓

 AP (MM)
DEPTH OF CUT
↓

0,04 - 0,12

0,1 - 1,0

0,05 - 0,16

0,1 - 1,5

CARBIDE

CC
1204

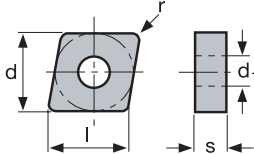
80°

DIAMOND

7° POSITIVE

STAINLESS STEEL

12,70	d	INSCRIBED CIRCLE
12,90	l	CUTTING EDGE LENGTH
4,76	s	THICKNESS



TOLERANCE CLASSES	CLASS	m	d	s
	E	± 0,025	± 0,025	± 0,025
	G	± 0,025	± 0,025	± 0,13
	H	± 0,013	± 0,013	± 0,025
	M	± 0,13	± 0,08	± 0,13
	U	± 0,20	± 0,13	± 0,13

MACHINING MATERIAL	STEEL	P												
	STAINLESS STEEL	M												
	CAST IRON	K												
	NON-FERROUS METAL	N												
	EXOTIC ALLOY	S												
	STEEL	H												

MACHINING TYPES

SECONDARY USE

PRIMARY USE



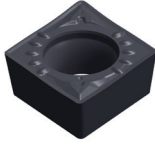
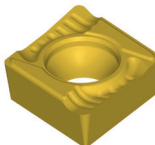
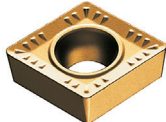
CONTINUOUS CUTTING



GENERAL CUTTING



INTERRUPTED CUTTING

GEOMETRY ↓		GRADE → DESIGNATION ↓		MACHINING MATERIAL GROUPE → Vc (M/MIN) CUTTING SPEED →												Stainless steel Groupe M1 - Ferritic M2 - Martensitic M3 - Austenitic (Hardened - reduce 30%)		
		B22-V2	B32-S2	B41-D1	B42-T2	B42-W2	B51-E1	B52-U2	B62-O2	B62-Y2	B71-G1	B72-R2	B81-F1		F (MM/REV) FEED RATE ↓	AP (MM) DEPTH OF CUT ↓		
		CCMT 120404-MR1										●				0,20 - 0,50	0,5 - 9,1	
		CCMT 120408-MR1											●				0,20 - 0,50	0,5 - 9,1
		CCMT 120404-M1						●								0,13 - 0,63	1,0 - 4,0	
		CCMT 120408-M1						●								0,13 - 0,63	1,0 - 4,0	
		CCGT 120408 ER-M1										●				0,13 - 0,63	1,0 - 4,0	
		CCGT 120412 EL-M1										●				0,13 - 0,63	1,0 - 4,0	
		CCMT 120404-M10					●			●						0,12 - 0,25	0,4 - 3,5	
		CCMT 120408-M10					●			●						0,12 - 0,32	0,5 - 3,5	

ORDER EXAMPLE: CCMT 09T304-M A31-A1

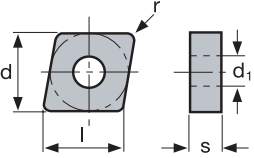
CARBIDE

CC
1204

80°
DIAMOND
7° POSITIVE

STAINLESS STEEL

12,70	d	INSCRIBED CIRCLE
12,90	l	CUTTING EDGE LENGTH
4,76	s	THICKNESS



TOLERANCE CLASSES	CLASS	m	d	s
	E	± 0,025	± 0,025	± 0,025
	G	± 0,025	± 0,025	± 0,13
	H	± 0,013	± 0,013	± 0,025
	M	± 0,13	± 0,08	± 0,13
	U	± 0,20	± 0,13	± 0,13

MACHINING MATERIAL

STEEL	P
STAINLESS STEEL	M
CAST IRON	K
NON-FERROUS METAL	N
EXOTIC ALLOY	S
STEEL	H

MACHINING TYPES

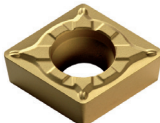
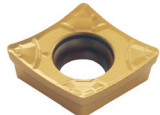
SECONDARY USE
○

PRIMARY USE
●

CONTINUOUS CUTTING
○

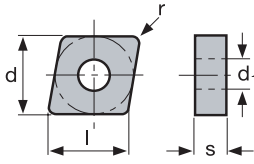
GENERAL CUTTING
◐

INTERRUPTED CUTTING
◑

		MACHINING MATERIAL GROUPE →														Stainless steel Groupe	
		Vc (M/MIN) CUTTING SPEED →															
GEOMETRY ↓		GRADE →														F (MM/REV) FEED RATE ↓	AP (MM) DEPTH OF CUT ↓
		DESIGNATION ↓															
		B22-V2	B32-S2	B41-D1	B42-T2	B42-W2	B51-E1	B52-U2	B62-O2	B62-Y2	B71-G1	B72-R2	B81-F1				
	CCMT 120404-MF7								●							0,12 - 0,25	0,4 - 3,5
	CCMT 120408-MF7					●			●							0,12 - 0,32	0,5 - 3,5
	CCXT 120404-F6				●											0,08 - 0,25	0,6 - 5,0

CARBIDE	CN 0903	80°	STAINLESS STEEL
		DIAMOND	
		0° NEGATIVE	

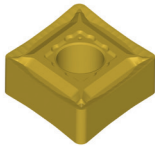
9,52	d	INSCRIBED CIRCLE
9,70	l	CUTTING EDGE LENGTH
3,18	s	THICKNESS



TOLERANCE CLASSES	CLASS	m	d	s
	E	± 0,025	± 0,025	± 0,025
	G	± 0,025	± 0,025	± 0,13
	H	± 0,013	± 0,013	± 0,025
	M	± 0,08	± 0,05	± 0,13
	U	± 0,13	± 0,08	± 0,13

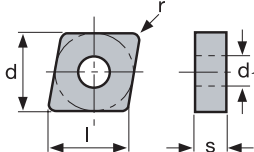
MACHINING MATERIAL	STEEL	P	MACHINING TYPES	SECONDARY USE	PRIMARY USE	CONTINUOUS CUTTING
	STAINLESS STEEL	M				
	CAST IRON	K				
	NON-FERROUS METAL	N				
	EXOTIC ALLOY	S				
	STEEL	H				

GEOMETRY	DESIGNATION	MACHINING MATERIAL GROUPE →												Stainless steel Groupe	
		Vc (M/MIN) CUTTING SPEED →												F (MM/REV) FEED RATE	AP (MM) DEPTH OF CUT
MF	CNMG 090304-MF	B22-V2	B32-S2	B41-D1	B42-T2	B42-W2	B51-E1	B52-U2	B62-O2	B62-Y2	B71-G1	B72-R2	B81-F1		
				●			●				●			0,10 - 0,30	0,5 - 3,5



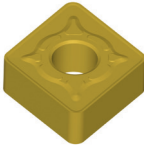
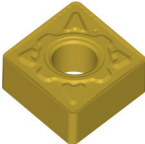
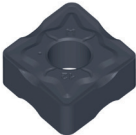
CARBIDE	CN 1204	80°	STAINLESS STEEL
		DIAMOND	
		0° NEGATIVE	

12,70	d	INSCRIBED CIRCLE
12,90	l	CUTTING EDGE LENGTH
4,76	s	THICKNESS



TOLERANCE CLASSES	CLASS	m	d	s
	E	± 0,025	± 0,025	± 0,025
	G	± 0,025	± 0,025	± 0,13
	H	± 0,013	± 0,013	± 0,025
	M	± 0,13	± 0,08	± 0,13
	U	± 0,20	± 0,13	± 0,13

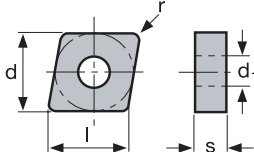
MACHINING MATERIAL	STEEL	P	MACHINING TYPES	SECONDARY USE	PRIMARY USE	CONTINUOUS CUTTING
	STAINLESS STEEL	M				
	CAST IRON	K				
	NON-FERROUS METAL	N				
	EXOTIC ALLOY	S				
	STEEL	H				

		MACHINING MATERIAL GROUPE →		Vc (M/MIN) CUTTING SPEED →												Stainless steel Groupe		
		GRADE →																
GEOMETRY ↓		DESIGNATION ↓		B22-V2	B32-S2	B41-D1	B42-T2	B42-W2	B51-E1	B52-U2	B62-O2	B62-Y2	B71-G1	B72-R2	B81-F1	F (MM/REV) FEED RATE ↓	AP (MM) DEPTH OF CUT ↓	
	R8	CNMM 120408-R8									●						0,30 - 0,50	0,8 - 7,0
		CNMM 120412-R8									●						0,35 - 0,70	1,2 - 7,0
	MR	CNMG 120408-MR							●				●		●		0,35 - 0,60	1,2 - 7,2
		CNMG 120412-MR							●				●		●		0,35 - 0,60	1,2 - 7,2
	M	CNMG 120408-M											●				0,16 - 0,40	1,0 - 5,5
		CNMG 120412-M											●				0,16 - 0,40	1,0 - 5,5
	M1	CNMG 120408-M1		●				●							●		0,16 - 0,40	1,0 - 4,0
		CNMG 120412-M1		●				●							●		0,16 - 0,40	1,0 - 4,0

ORDER EXAMPLE: CCMT 09T304-M A31-A1

CARBIDE	CN 1204	80°	STAINLESS STEEL
		DIAMOND	
		0° NEGATIVE	

12,70	d	INSCRIBED CIRCLE
12,90	l	CUTTING EDGE LENGTH
4,76	s	THICKNESS



TOLERANCE CLASSES	CLASS	m	d	s
	E	± 0,025	± 0,025	± 0,025
	G	± 0,025	± 0,025	± 0,13
	H	± 0,013	± 0,013	± 0,025
	M	± 0,13	± 0,08	± 0,13
	U	± 0,20	± 0,13	± 0,13

MACHINING MATERIAL	STEEL	P	TOLERANCE CLASSES	CLASS	m	d	s	MACHINING TYPES	SECONDARY USE	PRIMARY USE	CONTINUOUS CUTTING	GENERAL CUTTING	INTERRUPTED CUTTING
	STAINLESS STEEL	M											
	CAST IRON	K											
	NON-FERROUS METAL	N											
	EXOTIC ALLOY	S											
	STEEL	H											

GEOMETRY ↓	GRADE → DESIGNATION	MACHINING MATERIAL GROUPE → Vc (M/MIN) CUTTING SPEED →													Stainless steel Groupe	
															F (MM/REV) FEED RATE ↓	AP (MM) DEPTH OF CUT ↓
		M1,2,3	M1,2,3	M1,2,3	M1,2,3	M1,2,3	M1,2,3	M1,2,3	M1,2,3	M1,2,3	M1,2,3	M1,2,3	M1,2,3	M1,2,3		
E-M1	CNMG 120404 EL-M1														0,20 - 0,45	1,0 - 4,0
															0,20 - 0,45	1,0 - 4,0
															0,20 - 0,45	1,0 - 4,0
															0,20 - 0,45	1,0 - 4,0
M7	CNMG 120404-M7														0,10 - 0,20	0,5 - 3,0
															0,15 - 0,32	0,8 - 3,0
															0,15 - 0,35	0,8 - 3,5
MF	CNMG 120404-MF														0,10 - 0,30	0,5 - 3,5
															0,10 - 0,30	0,5 - 3,5
															0,10 - 0,30	0,5 - 3,5
F4	CNMG 120404-F4														0,08 - 0,17	0,4 - 1,5
															0,10 - 0,20	0,5 - 2,0

ORDER EXAMPLE: CCMT 09T304-M A31-A1

CARBIDE

CN 1204

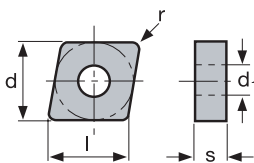
80°

DIAMOND

0° NEGATIVE

STAINLESS STEEL

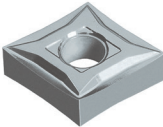
12,70	d	INSCRIBED CIRCLE
12,90	l	CUTTING EDGE LENGTH
4,76	s	THICKNESS



TOLERANCE CLASSES	CLASS	m	d	s
	E	± 0,025	± 0,025	± 0,025
	G	± 0,025	± 0,025	± 0,13
	H	± 0,013	± 0,013	± 0,025
	M	± 0,13	± 0,08	± 0,13
	U	± 0,20	± 0,13	± 0,13

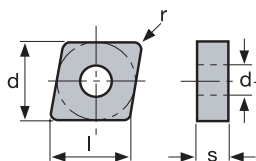
MACHINING TYPES	SECONDARY USE		PRIMARY USE	
			CONTINUOUS CUTTING	
			GENERAL CUTTING	
			INTERRUPTED CUTTING	

MACHINING MATERIAL	STEEL	P
	STAINLESS STEEL	M
	CAST IRON	K
	NON-FERROUS METAL	N
	EXOTIC ALLOY	S
	STEEL	H

GEOMETRY ↓	DESIGNATION ↓	MACHINING MATERIAL GROUPE → Vc (M/MIN) CUTTING SPEED →												Stainless steel Groupe		
		GRADE →												F (MM/REV) FEED RATE ↓	AP (MM) DEPTH OF CUT ↓	
		B22-V2	B32-S2	B41-D1	B42-T2	B42-W2	B51-E1	B52-U2	B62-O2	B62-Y2	B71-G1	B72-R2	B81-F1			
	CNGP 120402-F14							●							0,05 - 0,25	0,03 - 3,0
	CNGP 120404-F14							●							0,05 - 0,25	0,05 - 3,5
	CNGP 120408-F14							●							0,05 - 0,25	0,05 - 4,0

CARBIDE	CN 1606	80°	STAINLESS STEEL
		DIAMOND	
		0° NEGATIVE	

15,88	d	INSCRIBED CIRCLE
16,10	l	CUTTING EDGE LENGTH
6,35	s	THICKNESS



TOLERANCE CLASSES	CLASS	m	d	s
	E	± 0,025	± 0,025	± 0,025
	G	± 0,025	± 0,025	± 0,13
	H	± 0,013	± 0,013	± 0,025
	M	± 0,15	± 0,10	± 0,13
	U	± 0,27	± 0,18	± 0,13

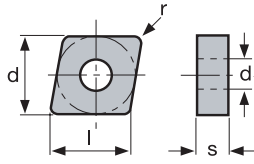
MACHINING MATERIAL	STEEL	P	MACHINING TYPES	SECONDARY USE	PRIMARY USE	CONTINUOUS CUTTING
	STAINLESS STEEL	M				
	CAST IRON	K				
	NON-FERROUS METAL	N				
	EXOTIC ALLOY	S				
	STEEL	H				

GEOMETRY	DESIGNATION	MACHINING MATERIAL GROUPE → Vc (M/MIN) CUTTING SPEED →												Stainless steel Groupe	
		GRADE →												F (MM/REV) FEED RATE ↓	AP (MM) DEPTH OF CUT ↓
		B22-V2	B32-S2	B41-D1	B42-T2	B42-W2	B51-E1	B52-U2	B62-O2	B62-Y2	B71-G1	B72-R2	B81-F1		
R8	CNMM 160612-R8								●					0,35 - 0,70	1,2 - 9,0
MR															
	CNMG 160612-MR						●				●		●	0,35 - 0,60	1,2 - 7,2
	CNMG 160616-MR						●						●	0,35 - 0,60	1,2 - 7,2
M															
	CNMG 160612-M										●			0,16 - 0,40	1,0 - 5,5
M1															
	CNMG 160612-M1		●			●							●	0,16 - 0,40	1,0 - 4,0
	CNMG 160616-M1		●			●							●	0,16 - 0,40	1,0 - 4,0

ORDER EXAMPLE: CCMT 09T304-M A31-A1

CARBIDE	CN 1606	80°	STAINLESS STEEL
		DIAMOND	
		0° NEGATIVE	

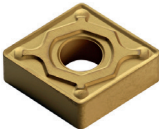
15,88	d INSCRIBED CIRCLE
16,10	l CUTTING EDGE LENGTH
6,35	s THICKNESS



TOLERANCE CLASSES	CLASS	m	d	s
	E	± 0,025	± 0,025	± 0,025
	G	± 0,025	± 0,025	± 0,13
	H	± 0,013	± 0,013	± 0,025
	M	± 0,15	± 0,10	± 0,13
	U	± 0,27	± 0,18	± 0,13

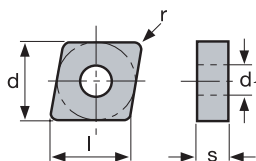
MACHINING TYPES	SECONDARY USE		PRIMARY USE	

MACHINING MATERIAL	STEEL	P													
	STAINLESS STEEL	M													
	CAST IRON	K													
	NON-FERROUS METAL	N													
	EXOTIC ALLOY	S													
	STEEL	H													

GEOMETRY ↓	DESIGNATION ↓	MACHINING MATERIAL GROUPE → VC (M/MIN) CUTTING SPEED →												Stainless steel Groupe M1 - Ferritic M2 - Martensitic M3 - Austenitic (Hardened - reduce 30%)					
		GRADE →																	
		B22-V2	B32-S2	B41-D1	B42-T2	B42-W2	B51-E1	B52-U2	B62-O2	B62-Y2	B71-G1	B72-R2	B81-F1						
	M7	CNMG 160608-M7							●										

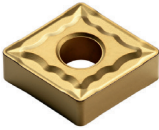
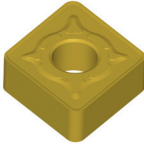
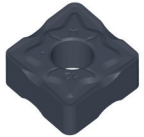
CARBIDE	CN 1906	80°	STAINLESS STEEL
		DIAMOND	
		0° NEGATIVE	

19,05	d	INSCRIBED CIRCLE
19,30	l	CUTTING EDGE LENGTH
6,35	s	THICKNESS



TOLERANCE CLASSES	CLASS	m	d	s
	E	± 0,025	± 0,025	± 0,025
	G	± 0,025	± 0,025	± 0,13
	H	± 0,013	± 0,013	± 0,025
	M	± 0,15	± 0,10	± 0,13
	U	± 0,27	± 0,18	± 0,13

MACHINING MATERIAL	STEEL	P	TOLERANCE CLASSES	CLASS	m	d	s	MACHINING TYPES	SECONDARY USE	PRIMARY USE	CONTINUOUS CUTTING	GENERAL CUTTING	INTERRUPTED CUTTING
	STAINLESS STEEL	M											
	CAST IRON	K											
	NON-FERROUS METAL	N											
	EXOTIC ALLOY	S											
	STEEL	H											

GEOMETRY ↓	GRADE → DESIGNATION	MACHINING MATERIAL GROUPE → Vc (M/MIN) CUTTING SPEED →	Stainless steel Groupe												F (MM/REV) FEED RATE ↓	AP (MM) DEPTH OF CUT ↓
			M1,2,3	M1,2,3	M1,2,3	M1,2,3	M1,2,3	M1,2,3	M1,2,3	M1,2,3	M1,2,3	M1,2,3	M1,2,3	M1,2,3		
R7 	CNMG 190612-R7														0,25 - 0,65	1,2 - 10,0
	CNMG 190616-R7														0,35 - 0,80	1,6 - 10,0
R8 	CNMM 190616-R8														0,40 - 0,90	1,6 - 10,0
MR 	CNMG 190612-MR														0,35 - 0,60	1,2 - 7,2
M1 	CNMG 190612-M1														0,16 - 0,40	1,0 - 4,0
	CNMG 190616-M1														0,16 - 0,40	1,0 - 4,0

ORDER EXAMPLE: CCMT 09T304-M A31-A1

[illegible]

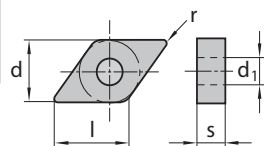
ORDER EXAMPLE: CCMT 09T304-M A31-A1

CARBIDE
DC
0702

 55°
DIAMOND
7° POSITIVE

STAINLESS STEEL

6,35	d INSCRIBED CIRCLE
7,70	l CUTTING EDGE LENGTH
2,38	s THICKNESS



TOLERANCE CLASSES	CLASS	m	d	s
	E	± 0,025	± 0,025	± 0,025
	G	± 0,025	± 0,025	± 0,13
	H	± 0,013	± 0,013	± 0,025
	M	± 0,08	± 0,05	± 0,13
	U	± 0,13	± 0,08	± 0,13

MACHINING MATERIAL	STEEL	P												
	STAINLESS STEEL	M												
	CAST IRON	K												
	NON-FERROUS METAL	N												
	EXOTIC ALLOY	S												
	STEEL	H												

MACHINING TYPES

SECONDARY USE

PRIMARY USE



CONTINUOUS CUTTING



GENERAL CUTTING



INTERRUPTED CUTTING

GEOMETRY ↓	GRADE → DESIGNATION	MACHINING MATERIAL GROUPE → Vc (M/MIN) CUTTING SPEED →												Stainless steel Groupe	
		M1,2,3	M1,2,3	M1,2,3	M1,2,3	M1,2,3	M1,2,3	M1,2,3	M1,2,3	M1,2,3	M1,2,3	M1,2,3	M1,2,3		
		60-180	60-160	150-230	100-200	60-160	100-200	100-200	90-140	70-150	120-180	100-170	70-180		
E-M1	DCGT 070204 EL-M1 DCGT 070204 ER-M1	B22-V2	B32-S2	B41-D1	B42-T2	B42-W2	B51-E1	B52-U2	B62-O2	B62-Y2	B71-G1	B72-R2	B81-F1	F (MM/REV) FEED RATE ↓	AP (MM) DEPTH OF CUT ↓
											●			0,10 - 0,52	0,8 - 3,5
											●			0,10 - 0,52	0,8 - 3,5
F	DCMT 070202-F DCMT 070204-F			●		●					●			0,05 - 0,20	0,1 - 2,0
						●						●		0,05 - 0,20	0,1 - 2,0
F10	DCMT 070202-F10 DCMT 070204-F10	●				●			●					0,04 - 0,12	0,10 - 1,0
		●				●			●					0,05 - 0,16	0,10 - 1,5
F12	DCGT 0702008-F12 DCGT 0702015-F12 DCGT 070202-F12 DCGT 070204-F12				●									0,02 - 0,06	0,1 - 1,5
					●									0,05 - 0,12	0,2 - 2,0
					●									0,05 - 0,12	0,2 - 2,0
					●									0,08 - 0,25	0,2 - 2,5

ORDER EXAMPLE: CCMT 09T304-M A31-A1

CARBIDE

DC
11T3

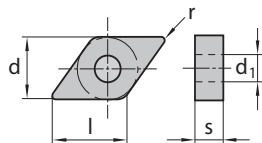
55°

DIAMOND

7° POSITIVE

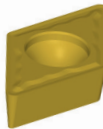
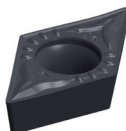
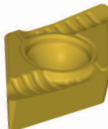
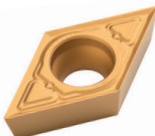
STAINLESS STEEL

9,52	d	INSCRIBED CIRCLE
11,60	l	CUTTING EDGE LENGTH
3,97	s	THICKNESS



TOLERANCE CLASSES	CLASS	m	d	s
	E	± 0,025	± 0,025	± 0,025
	G	± 0,025	± 0,025	± 0,13
	H	± 0,013	± 0,013	± 0,025
	M	± 0,08	± 0,05	± 0,13
	U	± 0,13	± 0,08	± 0,13

MACHINING MATERIAL	STEEL	P														MACHINING TYPES			CONTINUOUS CUTTING
	STAINLESS STEEL	M																	GENERAL CUTTING
	CAST IRON	K																	GENERAL CUTTING
	NON-FERROUS METAL	N																	GENERAL CUTTING
	EXOTIC ALLOY	S																	INTERRUPTED CUTTING
	STEEL	H																	INTERRUPTED CUTTING

GEOMETRY ↓		GRADE → DESIGNATION ↓		MACHINING MATERIAL GROUPE → Vc (M/MIN) CUTTING SPEED →													Stainless steel Groupe M1 - Ferritic M2 - Martensitic M3 - Austenitic (Hardened - reduce 30%)	
				M1,2,3	M1,2,3	M1,2,3	M1,2,3	M1,2,3	M1,2,3	M1,2,3	M1,2,3	M1,2,3	M1,2,3	M1,2,3	M1,2,3			
				60-180	60-160	150-230	100-200	60-160	100-200	100-200	90-140	70-150	120-180	100-170	70-180			
				B22-V2	B32-S2	B41-D1	B42-T2	B42-W2	B51-E1	B52-U2	B62-O2	B62-Y2	B71-G1	B72-R2	B81-F1	F (MM/REV) FEED RATE ↓	AP (MM) DEPTH OF CUT ↓	
MR1 	DCMT 11T304-MR1												●				0,20 - 0,50	0,5 - 9,1
	DCMT 11T308-MR1												●				0,20 - 0,50	0,5 - 9,1
M1 	DCMT 11T304-M1			●				●									0,13 - 0,63	1,0 - 4,0
	DCMT 11T308-M1			●				●									0,13 - 0,63	1,0 - 4,0
E-M1 	DCGT 11T304 EL-M1												●				0,13 - 0,63	1,0 - 4,0
	DCGT 11T304 ER-M1												●				0,13 - 0,63	1,0 - 4,0
	DCGT 11T308 ER-M1												●				0,13 - 0,63	1,0 - 4,0
M11 	DCMT 11T302-M11	●				●				●							0,08 - 0,15	0,40 - 1,5
	DCMT 11T304-M11	●				●				●							0,08 - 0,22	0,40 - 2,5

ORDER EXAMPLE: CCMT 09T304-M A31-A1

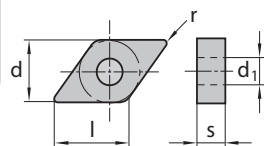
CARBIDE

DC
11T3

55°
 DIAMOND
 7° POSITIVE

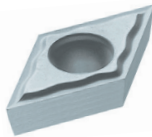
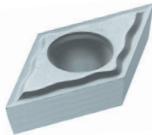
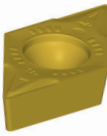
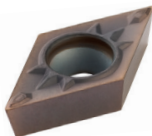
STAINLESS STEEL

9,52	d	INSCRIBED CIRCLE
11,60	l	CUTTING EDGE LENGTH
3,97	s	THICKNESS



TOLERANCE CLASSES	CLASS	m	d	s
	E	± 0,025	± 0,025	± 0,025
	G	± 0,025	± 0,025	± 0,13
	H	± 0,013	± 0,013	± 0,025
	M	± 0,08	± 0,05	± 0,13
	U	± 0,13	± 0,08	± 0,13

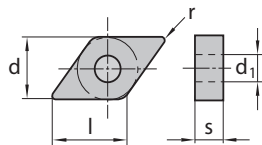
MACHINING MATERIAL	STEEL	P													MACHINING TYPES	SECONDARY USE	PRIMARY USE	
	STAINLESS STEEL	M																
	CAST IRON	K																
	NON-FERROUS METAL	N																
	EXOTIC ALLOY	S																
	STEEL	H																

		MACHINING MATERIAL GROUPE →		Vc (M/MIN) CUTTING SPEED →												Stainless steel Groupe M1 - Ferritic M2 - Martensitic M3 - Austenitic (Hardened - reduce 30%)	
				GRADE →													
		GEOMETRY ↓	DESIGNATION ↓	B22-V2	B32-S2	B41-D1	B42-T2	B42-W2	B51-E1	B52-U2	B62-O2	B62-Y2	B71-G1	B72-R2	B81-F1	F (MM/REV) FEED RATE ↓	AP (MM) DEPTH OF CUT ↓
MF10 	DCGT 11T3008-MF10				●										0,02 - 0,06	0,1 - 0,5	
	DCGT 11T3015-MF10				●										0,02 - 0,06	0,1 - 0,5	
	DCGT 11T301-MF10				●										0,02 - 0,06	0,1 - 0,5	
	DCGT 11T302-MF10				●										0,04 - 0,10	0,1 - 0,6	
	DCGT 11T304-MF10				●										0,08 - 0,20	0,3 - 2,0	
MF15 	DCGT 11T3005-MF15				●										0,02 - 0,06	0,1 - 0,5	
	DCGT 11T3008-MF15				●										0,02 - 0,06	0,1 - 0,5	
	DCGT 11T3015-MF15				●										0,02 - 0,06	0,1 - 0,5	
	DCGT 11T301-MF15				●										0,02 - 0,06	0,1 - 0,5	
	DCGT 11T302-MF15				●										0,04 - 0,10	0,1 - 0,6	
	DCGT 11T304-MF15				●										0,08 - 0,20	0,3 - 2,0	
F 	DCMT 11T302-F			●			●				●				0,05 - 0,20	0,1 - 2,0	
	DCMT 11T304-F						●						●		0,05 - 0,20	0,1 - 2,0	
F10 	DCMT 11T302-F10	●				●			●						0,04 - 0,12	0,10 - 1,0	
	DCMT 11T304-F10	●				●			●						0,05 - 0,16	0,10 - 1,5	

ORDER EXAMPLE: CCMT 09T304-M A31-A1

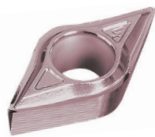
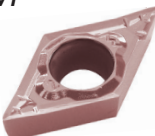
CARBIDE	DC 11T3	55°	STAINLESS STEEL
		DIAMOND	
		7° POSITIVE	

9,52	d	INSCRIBED CIRCLE
11,60	l	CUTTING EDGE LENGTH
3,97	s	THICKNESS



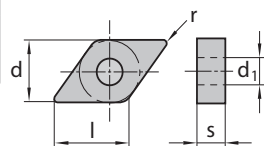
TOLERANCE CLASSES	CLASS	m	d	s
	E	± 0,025	± 0,025	± 0,025
	G	± 0,025	± 0,025	± 0,13
	H	± 0,013	± 0,013	± 0,025
	M	± 0,08	± 0,05	± 0,13
	U	± 0,13	± 0,08	± 0,13

MACHINING MATERIAL	STEEL	P	TOLERANCE CLASSES	CLASS	m	d	s	MACHINING TYPES	SECONDARY USE	PRIMARY USE	CONTINUOUS CUTTING	GENERAL CUTTING	INTERRUPTED CUTTING
	STAINLESS STEEL	M											
	CAST IRON	K											
	NON-FERROUS METAL	N											
	EXOTIC ALLOY	S											
	STEEL	H											

GEOMETRY	DESIGNATION	GRADE →	MACHINING MATERIAL GROUPE →	Vc (M/MIN) CUTTING SPEED →	Stainless steel Groupe									
					M1 - Ferritic M2 - Martensitic M3 - Austenitic (Hardened - reduce 30%)									
					F (MM/REV) FEED RATE	AP (MM) DEPTH OF CUT								
F11		DCGT 11T3008-F11											0,02 - 0,06	0,1 - 1,5
		DCGT 11T3015-F11		●									0,05 - 0,12	0,2 - 2,0
		DCGT 11T301-F11		●									0,02 - 0,06	0,1 - 1,5
		DCGT 11T302-F11		●	●		●						0,05 - 0,12	0,2 - 2,0
		DCGT 11T3035-F11		●									0,06 - 0,17	0,2 - 2,5
		DCGT 11T304-F11		●	●		●						0,08 - 0,25	0,2 - 2,5
		DCGT 11T308-F11		●			●						0,10 - 0,30	0,3 - 3,0
F12		DCGT 11T3008-F12				●							0,02 - 0,06	0,1 - 1,5
		DCGT 11T3015-F12				●							0,05 - 0,12	0,2 - 2,0
		DCGT 11T304-F12	●										0,08 - 0,25	0,2 - 2,5
		DCGT 11T308-F12	●										0,10 - 0,30	0,3 - 3,0
W1		DCGT 11T308-W1		●									0,15 - 0,50	0,5 - 4,0

CARBIDE	DN 1104	55°	STAINLESS STEEL
		DIAMOND	
		0° NEGATIVE	

9,52	d	INSCRIBED CIRCLE
11,60	l	CUTTING EDGE LENGTH
4,76	s	THICKNESS



TOLERANCE CLASSES	CLASS	m	d	s
	E	± 0,025	± 0,025	± 0,025
	G	± 0,025	± 0,025	± 0,13
	H	± 0,013	± 0,013	± 0,025
	M	± 0,08	± 0,05	± 0,13
	U	± 0,13	± 0,08	± 0,13

MACHINING MATERIAL	STEEL	P	TOLERANCE CLASSES	CLASS	m	d	s	MACHINING TYPES	SECONDARY USE	PRIMARY USE	CONTINUOUS CUTTING	GENERAL CUTTING	INTERRUPTED CUTTING
	STAINLESS STEEL	M											
	CAST IRON	K											
	NON-FERROUS METAL	N											
	EXOTIC ALLOY	S											
	STEEL	H											

GEOMETRY ↓	GRADE → DESIGNATION ↓	MACHINING MATERIAL GROUPE → Vc (M/MIN) CUTTING SPEED →												Stainless steel Groupe	
														F (MM/REV) FEED RATE ↓	AP (MM) DEPTH OF CUT ↓
		M1,2,3	M1,2,3	M1,2,3	M1,2,3	M1,2,3	M1,2,3	M1,2,3	M1,2,3	M1,2,3	M1,2,3	M1,2,3	M1,2,3		
M	DNMG 110408-M	B22-V2	B32-S2	B41-D1	B42-T2	B42-W2	B51-E1	B52-U2	B62-O2	B62-Y2	B71-G1	B72-R2	B81-F1	0,16 - 0,40	1,0 - 5,5
M1	DNMG 110404-M1						●							0,16 - 0,40	1,0 - 4,0
	DNMG 110408-M1						●							0,16 - 0,40	1,0 - 4,0
M7	DNMG 110404-M7								●					0,10 - 0,18	0,5 - 2,0
	DNMG 110408-M7								●					0,15 - 0,25	0,8 - 3,0
MF	DNMG 110404-MF		●			●				●				0,10 - 0,30	0,5 - 3,5
	DNMG 110408-MF					●								0,10 - 0,30	0,5 - 3,5

ORDER EXAMPLE: CCMT 09T304-M A31-A1

CARBIDE

DN
1104

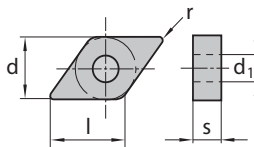
55°

DIAMOND

0° NEGATIVE

STAINLESS STEEL

9,52	d	INSCRIBED CIRCLE
11,60	l	CUTTING EDGE LENGTH
4,76	s	THICKNESS



TOLERANCE CLASSES

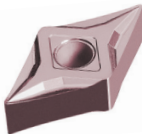
CLASS	m	d	s
E	± 0,025	± 0,025	± 0,025
G	± 0,025	± 0,025	± 0,13
H	± 0,013	± 0,013	± 0,025
M	± 0,08	± 0,05	± 0,13
U	± 0,13	± 0,08	± 0,13

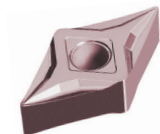
MACHINING MATERIAL

MATERIAL	GRADE
STEEL	P
STAINLESS STEEL	M
CAST IRON	K
NON-FERROUS METAL	N
EXOTIC ALLOY	S
STEEL	H

MACHINING TYPES

SECONDARY USE	PRIMARY USE	DESCRIPTION
		CONTINUOUS CUTTING
		GENERAL CUTTING
		INTERRUPTED CUTTING

		MACHINING MATERIAL GROUPE →												Stainless steel Groupe	
		Vc (M/MIN) CUTTING SPEED →													
GEOMETRY ↓	GRADE → DESIGNATION ↓													F (MM/REV) FEED RATE ↓	AP (MM) DEPTH OF CUT ↓
		B22-V2	B32-S2	B41-D1	B42-T2	B42-W2	B51-E1	B52-U2	B62-O2	B62-Y2	B71-G1	B72-R2	B81-F1		
	DNGP 110402-F14							●						0,05 - 0,25	0,03 - 3,0
	DNGP 110404-F14							●						0,05 - 0,25	0,05 - 3,5



CARBIDE

DN
1504

55°

DIAMOND

0° NEGATIVE

STAINLESS STEEL

12,70	d	INSCRIBED CIRCLE
15,50	l	CUTTING EDGE LENGTH
4,76	s	THICKNESS

TOLERANCE CLASSES	CLASS	m	d	s
	E	± 0,025	± 0,025	± 0,025
	G	± 0,025	± 0,025	± 0,13
	H	± 0,013	± 0,013	± 0,025
	M	± 0,13	± 0,08	± 0,13
	U	± 0,20	± 0,13	± 0,13

SECONDARY USE
○

PRIMARY USE
●

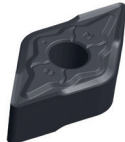
MACHINING MATERIAL	STEEL	P	○	●	○	○	☉	☉	○	☉	☉	☉	☉	☉
	STAINLESS STEEL	M	●	●	●	●	☉	☉	●	☉	☉	☉	☉	☉
	CAST IRON	K	○	○			☉		○	☉				
	NON-FERROUS METAL	N	○	○			☉			☉				
	EXOTIC ALLOY	S	●	●			☉	●	☉					
	STEEL	H	○	○			☉			☉				

MACHINING TYPES
○

SECONDARY USE
●

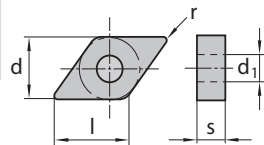
PRIMARY USE
●

○	●	○	●	○	●	○	●	○	●	○	●	○	●	○	●
○	●	○	●	○	●	○	●	○	●	○	●	○	●	○	●
○	●	○	●	○	●	○	●	○	●	○	●	○	●	○	●
○	●	○	●	○	●	○	●	○	●	○	●	○	●	○	●
○	●	○	●	○	●	○	●	○	●	○	●	○	●	○	●
○	●	○	●	○	●	○	●	○	●	○	●	○	●	○	●

		MACHINING MATERIAL GROUPE → Vc (M/MIN) CUTTING SPEED →		M1,2,3	M1,2,3	M1,2,3	M1,2,3	M1,2,3	M1,2,3	M1,2,3	M1,2,3	M1,2,3	M1,2,3	M1,2,3	Stainless steel Groupe	
																M1 - Ferritic M2 - Martensitic M3 - Austenitic (Hardened - reduce 30%)
GEOMETRY ↓	GRADE → DESIGNATION ↓	B22-V2	B32-S2	B41-D1	B42-T2	B42-W2	B51-E1	B52-U2	B62-O2	B62-Y2	B71-G1	B72-R2	B81-F1		F (MM/REV) FEED RATE ↓	AP (MM) DEPTH OF CUT ↓
M 	DNMG 150408-M										●				0,16 - 0,40	1,0 - 5,5
M1 	DNMG 150404-M1			●			●								0,16 - 0,40	1,0 - 4,0
	DNMG 150408-M1			●			●								0,16 - 0,40	1,0 - 4,0
F4 	DNMG 150404-F4	●				●									0,06 - 0,16	0,4 - 1,5
	DNMG 150408-F4	●				●									0,08 - 0,19	0,5 - 2,0

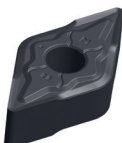
CARBIDE	DN 1506	55°	STAINLESS STEEL
		DIAMOND	
		0° NEGATIVE	

12,70	d INSCRIBED CIRCLE
15,50	l CUTTING EDGE LENGTH
6,35	s THICKNESS



TOLERANCE CLASSES	CLASS	m	d	s
	E	± 0,025	± 0,025	± 0,025
	G	± 0,025	± 0,025	± 0,13
	H	± 0,013	± 0,013	± 0,025
	M	± 0,13	± 0,08	± 0,13
	U	± 0,20	± 0,13	± 0,13

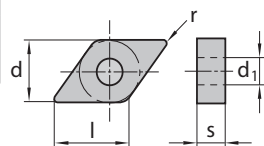
MACHINING MATERIAL	STEEL	P	TOLERANCE CLASSES	CLASS	m	d	s	MACHINING TYPES	SECONDARY USE	PRIMARY USE	CONTINUOUS CUTTING	GENERAL CUTTING	INTERRUPTED CUTTING
	STAINLESS STEEL	M											
	CAST IRON	K											
	NON-FERROUS METAL	N											
	EXOTIC ALLOY	S											
	STEEL	H											

GEOMETRY ↓	GRADE → DESIGNATION	MACHINING MATERIAL GROUPE → Vc (M/MIN) CUTTING SPEED →												Stainless steel Groupe	
														F (MM/REV) FEED RATE ↓	AP (MM) DEPTH OF CUT ↓
		B22-V2	B32-S2	B41-D1	B42-T2	B42-W2	B51-E1	B52-U2	B62-O2	B62-Y2	B71-G1	B72-R2	B81-F1		
MR 	DNMG 150608-MR						●				●		●	0,35 - 0,60	1,2 - 7,2
	DNMG 150612-MR						●				●		●	0,35 - 0,60	1,2 - 7,2
M 	DNMG 150608-M										●			0,16 - 0,40	1,0 - 5,5
	DNMG 150612-M										●			0,16 - 0,40	1,0 - 5,5
M1 	DNMG 150604-M1			●			●							0,16 - 0,40	1,0 - 4,0
	DNMG 150608-M1			●			●						●	0,16 - 0,40	1,0 - 4,0
	DNMG 150612-M1			●			●						●	0,16 - 0,40	1,0 - 4,0
E-M1 	DNMG 150604 EL-M1										●			0,16 - 0,40	1,0 - 4,0
	DNMG 150604 ER-M1										●			0,16 - 0,40	1,0 - 4,0
	DNMG 150608 EL-M1										●			0,16 - 0,40	1,0 - 4,0
	DNMG 150608 ER-M1										●			0,16 - 0,40	1,0 - 4,0

ORDER EXAMPLE: CCMT 09T304-M A31-A1

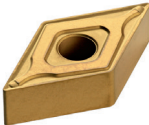
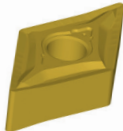
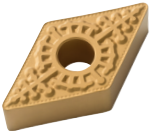
CARBIDE	DN 1506	55°	STAINLESS STEEL
		DIAMOND	
		0° NEGATIVE	

12,70	d INSCRIBED CIRCLE
15,50	l CUTTING EDGE LENGTH
6,35	s THICKNESS



TOLERANCE CLASSES	CLASS	m	d	s
	E	± 0,025	± 0,025	± 0,025
	G	± 0,025	± 0,025	± 0,13
	H	± 0,013	± 0,013	± 0,025
	M	± 0,13	± 0,08	± 0,13
	U	± 0,20	± 0,13	± 0,13

MACHINING MATERIAL	STEEL	P	TOLERANCE CLASSES	CLASS	m	d	s	MACHINING TYPES	SECONDARY USE	PRIMARY USE	CONTINUOUS CUTTING	GENERAL CUTTING	INTERRUPTED CUTTING
	STAINLESS STEEL	M											
	CAST IRON	K											
	NON-FERROUS METAL	N											
	EXOTIC ALLOY	S											
	STEEL	H											

		MACHINING MATERIAL GROUPE →		M1,2,3	M1,2,3	M1,2,3	M1,2,3	M1,2,3	M1,2,3	M1,2,3	M1,2,3	M1,2,3	M1,2,3	M1,2,3	Stainless steel Groupe		
		VC (M/MIN) CUTTING SPEED →		60-180	60-160	150-230	100-200	60-160	100-200	100-200	90-140	70-150	120-180	100-170	70-180	M1 - Ferritic M2 - Martensitic M3 - Austenitic (Hardened - reduce 30%)	
GEOMETRY ↓		GRADE → DESIGNATION ↓		B22-V2	B32-S2	B41-D1	B42-T2	B42-W2	B51-E1	B52-U2	B62-O2	B62-Y2	B71-G1	B72-R2	B81-F1	F (MM/REV) FEED RATE ↓	AP (MM) DEPTH OF CUT ↓
M7 	DNMG 150604-M7										●					0,10 - 0,18	0,5 - 2,5
	DNMG 150608-M7										●					0,15 - 0,25	0,8 - 3,0
	DNMG 150612-M7										●					0,18 - 0,30	0,8 - 3,0
MF 	DNMG 150604-MF			●				●					●			0,10 - 0,30	0,5 - 3,5
	DNMG 150608-MF			●				●					●			0,10 - 0,30	0,5 - 3,5
F4 	DNMG 150604-F4	●						●			●					0,06 - 0,16	0,4 - 1,5
	DNMG 150608-F4							●			●					0,08 - 0,19	0,5 - 2,0

CARBIDE

SC
09T3

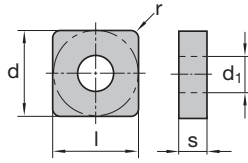
90°

SQUARE

7° POSITIVE

STAINLESS STEEL

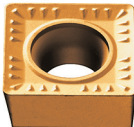
9,52	d	INSCRIBED CIRCLE
9,52	l	CUTTING EDGE LENGTH
3,97	s	THICKNESS



TOLERANCE CLASSES	CLASS	m	d	s
	E	± 0,025	± 0,025	± 0,025
	G	± 0,025	± 0,025	± 0,13
	H	± 0,013	± 0,013	± 0,025
	M	± 0,08	± 0,05	± 0,13
	U	± 0,13	± 0,08	± 0,13

MACHINING TYPES	SECONDARY USE		PRIMARY USE	

MACHINING MATERIAL	STEEL	P													
	STAINLESS STEEL	M													
	CAST IRON	K													
	NON-FERROUS METAL	N													
	EXOTIC ALLOY	S													
	STEEL	H													

		MACHINING MATERIAL GROUPE →		Vc (M/MIN) CUTTING SPEED →		GRADE →		DESIGNATION		Stainless steel Groupe											
										M1 - Ferritic M2 - Martensitic M3 - Austenitic (Hardened - reduce 30%)											
GEOMETRY		F (MM/REV) FEED RATE												AP (MM) DEPTH OF CUT							
↓		↓												↓							
M10 	SCMT 09T304-M10					●			●						0,08 - 0,25	0,4 - 3,0					
	SCMT 09T308-M10								●							0,12 - 0,32	0,5 - 3,0				

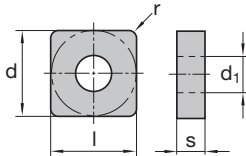
CARBIDE

SC
1204

90°
 SQUARE
 7° POSITIVE

STAINLESS STEEL

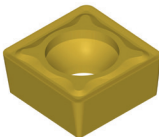
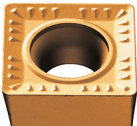
12,70	d	INSCRIBED CIRCLE
12,70	l	CUTTING EDGE LENGTH
4,76	s	THICKNESS



TOLERANCE CLASSES	CLASS	m	d	s
	E	± 0,025	± 0,025	± 0,025
	G	± 0,025	± 0,025	± 0,13
	H	± 0,013	± 0,013	± 0,025
	M	± 0,13	± 0,08	± 0,13
	U	± 0,20	± 0,13	± 0,13

MACHINING TYPES	SECONDARY USE		PRIMARY USE	
			CONTINUOUS CUTTING	
			GENERAL CUTTING	
			INTERRUPTED CUTTING	

MACHINING MATERIAL	STEEL	P						
	STAINLESS STEEL	M						
	CAST IRON	K						
	NON-FERROUS METAL	N						
	EXOTIC ALLOY	S						
	STEEL	H						

GEOMETRY ↓	GRADE → DESIGNATION ↓	MACHINING MATERIAL GROUPE → Vc (M/MIN) CUTTING SPEED →												Stainless steel Groupe	
		M1,2,3	M1,2,3	M1,2,3	M1,2,3	M1,2,3	M1,2,3	M1,2,3	M1,2,3	M1,2,3	M1,2,3	M1,2,3	M1,2,3	M1 - Ferritic M2 - Martensitic M3 - Austenitic (Hardened - reduce 30%)	
		60-180	60-160	150-230	100-200	60-160	100-200	100-200	90-140	70-150	120-180	100-170	70-180	F (MM/REV) FEED RATE ↓	AP (MM) DEPTH OF CUT ↓
MR1 	SCMT 120408-MR1										●			0,20 - 0,50	0,5 - 9,1
M10 	SCMT 120408-M10					●			●					0,12 - 0,32	0,5 - 3,5
	SCMX 120408-M10											●		0,12 - 0,32	0,5 - 3,5

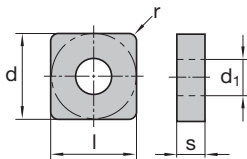
CARBIDE

SN
0903

90°
 SQUARE
 0° NEGATIVE

STAINLESS STEEL

9,52	d	INSCRIBED CIRCLE
9,52	l	CUTTING EDGE LENGTH
3,18	s	THICKNESS



TOLERANCE CLASSES	CLASS	m	d	s
	E	± 0,025	± 0,025	± 0,025
	G	± 0,025	± 0,025	± 0,13
	H	± 0,013	± 0,013	± 0,025
	M	± 0,13	± 0,08	± 0,13
	U	± 0,20	± 0,13	± 0,13

MACHINING MATERIAL	STEEL	P												
	STAINLESS STEEL	M												
	CAST IRON	K												
	NON-FERROUS METAL	N												
	EXOTIC ALLOY	S												
	STEEL	H												

SECONDARY USE

PRIMARY USE

MACHINING TYPES



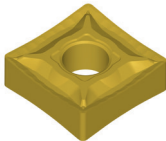
CONTINUOUS CUTTING

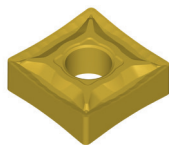


GENERAL CUTTING



INTERRUPTED CUTTING

GEOMETRY ↓	GRADE → DESIGNATION ↓	MACHINING MATERIAL GROUPE → Vc (M/MIN) CUTTING SPEED →												Stainless steel Groupe M1 - Ferritic M2 - Martensitic M3 - Austenitic (Hardened - reduce 30%)		
		B22-V2	B32-S2	B41-D1	B42-T2	B42-W2	B51-E1	B52-U2	B62-O2	B62-Y2	B71-G1	B72-R2	B81-F1		F (MM/REV) FEED RATE	AP (MM) DEPTH OF CUT
															↓	↓
MF	SNMG 090304-MF						●				●				0,10 - 0,30	0,5 - 3,5
																



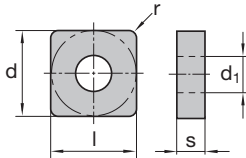
CARBIDE

SN
1204

90°
SQUARE
0° NEGATIVE

STAINLESS STEEL

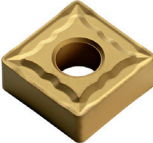
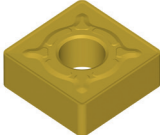
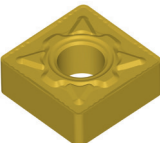
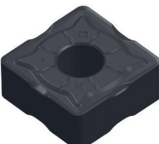
12,70	d	INSCRIBED CIRCLE
12,70	l	CUTTING EDGE LENGTH
4,76	s	THICKNESS



TOLERANCE CLASSES	CLASS	m	d	s
	E	± 0,025	± 0,025	± 0,025
	G	± 0,025	± 0,025	± 0,13
	H	± 0,013	± 0,013	± 0,025
	M	± 0,13	± 0,08	± 0,13
	U	± 0,20	± 0,13	± 0,13

MACHINING TYPES	SECONDARY USE		PRIMARY USE	
				CONTINUOUS CUTTING
				GENERAL CUTTING
				INTERRUPTED CUTTING

MACHINING MATERIAL	STEEL	P													
	STAINLESS STEEL	M													
	CAST IRON	K													
	NON-FERROUS METAL	N													
	EXOTIC ALLOY	S													
	STEEL	H													

GEOMETRY ↓		GRADE → DESIGNATION ↓		MACHINING MATERIAL GROUPE → Vc (M/MIN) CUTTING SPEED →												Stainless steel Groupe	
																M1 - Ferritic M2 - Martensitic M3 - Austenitic (Hardened - reduce 30%)	
				B22-V2	B32-S2	B41-D1	B42-T2	B42-W2	B51-E1	B52-U2	B62-O2	B62-Y2	B71-G1	B72-R2	B81-F1		F (MM/REV) FEED RATE ↓
	SNMG 120408-R7								●						0,20 - 0,50	0,8 - 5,0	
	SNMG 120412-R7								●						0,25 - 0,65	1,0 - 6,0	
	SNMG 120408-MR										●				0,35 - 0,60	1,2 - 7,2	
	SNMG 120412-MR										●		●		0,35 - 0,60	1,2 - 7,2	
	SNMG 120408-M										●				0,16 - 0,40	1,0 - 5,5	
	SNMG 120412-M										●				0,16 - 0,40	1,0 - 5,5	
	SNMG 120408-M1						●						●		0,16 - 0,40	1,0 - 4,0	
	SNMG 120412-M1						●						●		0,16 - 0,40	1,0 - 4,0	

CARBIDE

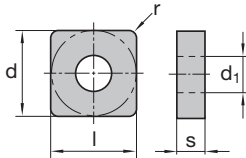
SN

1204

90°
 SQUARE
 0° NEGATIVE

STAINLESS STEEL

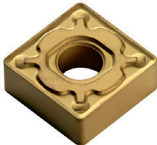
12,70	d	INSCRIBED CIRCLE
12,70	l	CUTTING EDGE LENGTH
4,76	s	THICKNESS



TOLERANCE CLASSES	CLASS	m	d	s
	E	± 0,025	± 0,025	± 0,025
	G	± 0,025	± 0,025	± 0,13
	H	± 0,013	± 0,013	± 0,025
	M	± 0,13	± 0,08	± 0,13
	U	± 0,20	± 0,13	± 0,13

MACHINING MATERIAL	STEEL	P
	STAINLESS STEEL	M
	CAST IRON	K
	NON-FERROUS METAL	N
	EXOTIC ALLOY	S
	STEEL	H

MACHINING TYPES	SECONDARY USE		PRIMARY USE	
			CONTINUOUS CUTTING	
			GENERAL CUTTING	
			INTERRUPTED CUTTING	

GEOMETRY ↓	DESIGNATION ↓	MACHINING MATERIAL GROUPE → Vc (M/MIN) CUTTING SPEED →												Stainless steel Groupe		
		GRADE →												F (MM/REV) FEED RATE ↓	AP (MM) DEPTH OF CUT ↓	
		B22-V2	B32-S2	B41-D1	B42-T2	B42-W2	B51-E1	B52-U2	B62-O2	B62-Y2	B71-G1	B72-R2	B81-F1			
M7	SNMG 120408-M7	●													0,15 - 0,25	0,8 - 3,0
																

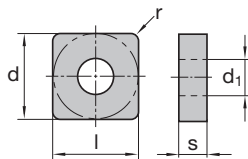
CARBIDE

SN
1506

90°
SQUARE
0° NEGATIVE

STAINLESS STEEL

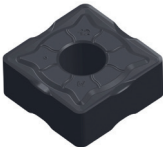
15,88	d	INSCRIBED CIRCLE
15,88	l	CUTTING EDGE LENGTH
6,35	s	THICKNESS



TOLERANCE CLASSES	CLASS	m	d	s
	E	± 0,025	± 0,025	± 0,025
	G	± 0,025	± 0,025	± 0,13
	H	± 0,013	± 0,013	± 0,025
	M	± 0,15	± 0,10	± 0,13
	U	± 0,27	± 0,18	± 0,13

MACHINING TYPES	SECONDARY USE		PRIMARY USE	

MACHINING MATERIAL	STEEL	P						
	STAINLESS STEEL	M						
	CAST IRON	K						
	NON-FERROUS METAL	N						
	EXOTIC ALLOY	S						
	STEEL	H						

GEOMETRY ↓	DESIGNATION ↓	MACHINING MATERIAL GROUPE → Vc (M/MIN) CUTTING SPEED →												Stainless steel Groupe		
		GRADE →												F (MM/REV) FEED RATE ↓	AP (MM) DEPTH OF CUT ↓	
		B22-V2	B32-S2	B41-D1	B42-T2	B42-W2	B51-E1	B52-U2	B62-O2	B62-Y2	B71-G1	B72-R2	B81-F1			
	M1			●			●						●		0,16 - 0,40	1,0 - 4,0
				●			●						●		0,16 - 0,40	1,0 - 4,0

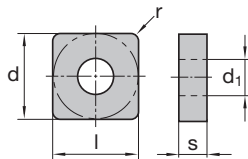
CARBIDE

SN
1906

90°
 SQUARE
 0° NEGATIVE

STAINLESS STEEL

19,05	d	INSCRIBED CIRCLE
19,05	l	CUTTING EDGE LENGTH
6,35	s	THICKNESS



TOLERANCE CLASSES	CLASS	m	d	s
	E	± 0,025	± 0,025	± 0,025
	G	± 0,025	± 0,025	± 0,13
	H	± 0,013	± 0,013	± 0,025
	M	± 0,15	± 0,10	± 0,13
	U	± 0,27	± 0,18	± 0,13

MACHINING MATERIAL	STEEL	P												
	STAINLESS STEEL	M												
	CAST IRON	K												
	NON-FERROUS METAL	N												
	EXOTIC ALLOY	S												
	STEEL	H												

MACHINING TYPES

SECONDARY USE

PRIMARY USE



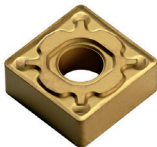
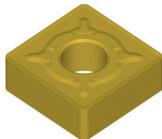
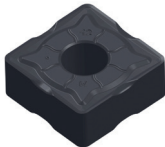
CONTINUOUS CUTTING



GENERAL CUTTING



INTERRUPTED CUTTING

GEOMETRY ↓		GRADE → DESIGNATION ↓		MACHINING MATERIAL GROUPE → Vc (M/MIN) CUTTING SPEED →												Stainless steel Groupe M1 - Ferritic M2 - Martensitic M3 - Austenitic (Hardened - reduce 30%) F (MM/REV) FEED RATE ↓ AP (MM) DEPTH OF CUT ↓		
				B22-V2	B32-S2	B41-D1	B42-T2	B42-W2	B51-E1	B52-U2	B62-O2	B62-Y2	B71-G1	B72-R2	B81-F1			
R8		SNMM 190616-R8										●					0,25 - 1,2	0,8 - 12,0
MR		SNMG 190612-MR						●					●		●		0,35 - 0,60	1,2 - 7,2
		SNMG 190616-MR						●							●		0,35 - 0,60	1,2 - 7,2
M1		SNMG 190612-M1		●			●							●			0,16 - 0,40	1,0 - 4,0
		SNMG 190616-M1		●			●							●			0,16 - 0,40	1,0 - 4,0

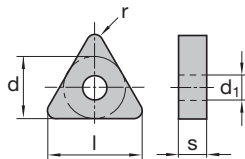
CARBIDE

TC
0902

60°
 TRIANGLE
 7° POSITIVE

STAINLESS STEEL

5,56	d	INSCRIBED CIRCLE
9,60	l	CUTTING EDGE LENGTH
2,38	s	THICKNESS



TOLERANCE CLASSES	CLASS	m	d	s
	E	± 0,025	± 0,025	± 0,025
	G	± 0,025	± 0,025	± 0,13
	H	± 0,013	± 0,013	± 0,025
	M	± 0,08	± 0,05	± 0,13
	U	± 0,13	± 0,08	± 0,13

MACHINING MATERIAL	STEEL	P												
	STAINLESS STEEL	M												
	CAST IRON	K												
	NON-FERROUS METAL	N												
	EXOTIC ALLOY	S												
	STEEL	H												

MACHINING TYPES

SECONDARY USE

PRIMARY USE



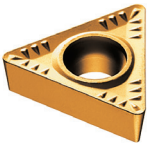
CONTINUOUS CUTTING

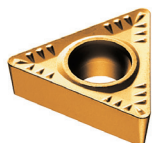


GENERAL CUTTING



INTERRUPTED CUTTING

GEOMETRY ↓	DESIGNATION ↓	MACHINING MATERIAL GROUPE →												Stainless steel Groupe			
		Vc (M/MIN) CUTTING SPEED →												M1 - Ferritic M2 - Martensitic M3 - Austenitic (Hardened - reduce 30%)			
		GRADE →												F (MM/REV) FEED RATE ↓	AP (MM) DEPTH OF CUT ↓		
F11 	TCGT 090202-F11	B22-V2	B32-S2	B41-D1	B42-T2	B42-W2	B51-E1	B52-U2	B62-O2	B62-Y2	B71-G1	B72-R2	B81-F1			0,05 - 0,12	0,2 - 2,0



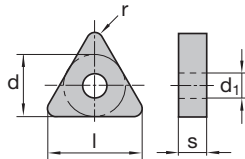
CARBIDE

TC
1102

60°
 TRIANGLE
 7° POSITIVE

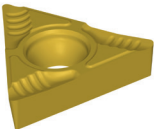
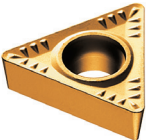
STAINLESS STEEL

6,35	d INSCRIBED CIRCLE
11,00	l CUTTING EDGE LENGTH
2,38	s THICKNESS



TOLERANCE CLASSES	CLASS	m	d	s
	E	± 0,025	± 0,025	± 0,025
	G	± 0,025	± 0,025	± 0,13
	H	± 0,013	± 0,013	± 0,025
	M	± 0,08	± 0,05	± 0,13
	U	± 0,13	± 0,08	± 0,13

MACHINING MATERIAL	STEEL	P													MACHINING TYPES	SECONDARY USE	PRIMARY USE	
	STAINLESS STEEL	M	●	●	●	●	●	●	●	●	●	●	●	●				
	CAST IRON	K	○	○														
	NON-FERROUS METAL	N	○	○														
	EXOTIC ALLOY	S	●	●			●	●	●	●	●	●	●	●				
	STEEL	H	○	○														

GEOMETRY ↓	MACHINING MATERIAL GROUPE → Vc (M/MIN) CUTTING SPEED →	GRADE → DESIGNATION													Stainless steel Groupe	
			M1,2,3	M1,2,3	M1,2,3	M1,2,3	M1,2,3	M1,2,3	M1,2,3	M1,2,3	M1,2,3	M1,2,3	M1,2,3	M1,2,3		
			B22-V2	B32-S2	B41-D1	B42-T2	B42-W2	B51-E1	B52-U2	B62-O2	B62-Y2	B71-G1	B72-R2	B81-F1		
															F (MM/REV) FEED RATE ↓	AP (MM) DEPTH OF CUT ↓
MR1 		TCMT 110204-MR1										●			0,20 - 0,50	0,5 - 9,1
		TCMT 110208-MR1										●			0,20 - 0,50	0,5 - 9,1
E-M1 		TCGT 110204 EL-M1										●			0,13 - 0,63	1,0 - 4,0
M10 		TCMT 110204-M10					●			●					0,08 - 0,20	0,4 - 2,0
MF7 		TCMT 110204-MF7					●			●					0,08 - 0,20	0,4 - 2,0

ORDER EXAMPLE: CCMT 09T304-M A31-A1

CARBIDE

TC

16T3

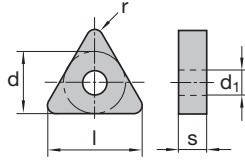
60°

TRIANGLE

7° POSITIVE

STAINLESS STEEL

9,52	d	INSCRIBED CIRCLE
16,50	l	CUTTING EDGE LENGTH
3,97	s	THICKNESS



TOLERANCE CLASSES	CLASS	m	d	s
	E	± 0,025	± 0,025	± 0,025
	G	± 0,025	± 0,025	± 0,13
	H	± 0,013	± 0,013	± 0,025
	M	± 0,08	± 0,05	± 0,13
	U	± 0,13	± 0,08	± 0,13

SECONDARY USE

PRIMARY USE

MACHINING MATERIAL	STEEL	P												
	STAINLESS STEEL	M												
	CAST IRON	K												
	NON-FERROUS METAL	N												
	EXOTIC ALLOY	S												
	STEEL	H												

MACHINING TYPES

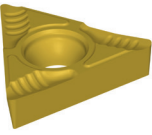
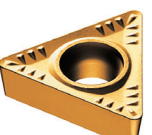
SECONDARY USE

PRIMARY USE

CONTINUOUS CUTTING

GENERAL CUTTING

INTERRUPTED CUTTING

GEOMETRY	MACHINING MATERIAL GROUPE → Vc (M/MIN) CUTTING SPEED →	GRADE → DESIGNATION	Stainless steel Groupe											
			M1,2,3	M1,2,3	M1,2,3	M1,2,3	M1,2,3	M1,2,3	M1,2,3	M1,2,3	M1,2,3	M1,2,3	M1,2,3	
			60-180	60-160	150-230	100-200	60-160	100-200	100-200	90-140	70-150	120-180	100-170	70-180
			B22-V2	B32-S2	B41-D1	B42-T2	B42-W2	B51-E1	B52-U2	B62-O2	B62-Y2	B71-G1	B72-R2	B81-F1
MR1		TCMT 16T304-MR1										●		
		TCMT 16T308-MR1										●		
E-M1		TCGT 16T304 ER-M1										●		
		TCGT 16T308 EL-M1										●		
		TCGT 16T308 ER-M1										●		
M10		TCMT 16T304-M10					●			●				
		TCMT 16T308-M10					●			●				
MF7		TCMT 16T304-MF7					●			●				
		TCMT 16T308-MF7					●			●				

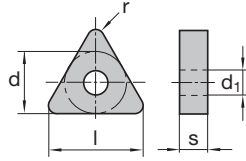
ORDER EXAMPLE: CCMT 09T304-M A31-A1

CARBIDE
TN
1604

 60°
TRIANGLE
0° NEGATIVE

STAINLESS STEEL

9,52	d	INSCRIBED CIRCLE
16,50	l	CUTTING EDGE LENGTH
4,76	s	THICKNESS



TOLERANCE CLASSES	CLASS	m	d	s
	E	± 0,025	± 0,025	± 0,025
	G	± 0,025	± 0,025	± 0,13
	H	± 0,013	± 0,013	± 0,025
	M	± 0,08	± 0,05	± 0,13
	U	± 0,13	± 0,08	± 0,13

SECONDARY USE

PRIMARY USE

MACHINING TYPES



CONTINUOUS CUTTING

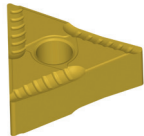
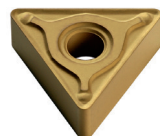


GENERAL CUTTING



INTERRUPTED CUTTING

MACHINING MATERIAL	STEEL	P													
	STAINLESS STEEL	M													
	CAST IRON	K													
	NON-FERROUS METAL	N													
	EXOTIC ALLOY	S													
	STEEL	H													

GEOMETRY ↓	GRADE → DESIGNATION	MACHINING MATERIAL GROUPE → Vc (M/MIN) CUTTING SPEED →													Stainless steel Groupe	
															F (MM/REV) FEED RATE ↓	AP (MM) DEPTH OF CUT ↓
		M1,2,3	M1,2,3	M1,2,3	M1,2,3	M1,2,3	M1,2,3	M1,2,3	M1,2,3	M1,2,3	M1,2,3	M1,2,3	M1,2,3	M1,2,3		
MR6 	TNMG 160408-MR6	●				●			●						0,12 - 0,30	1,0 - 4,0
	TNMG 160412-MR6	●							●						0,15 - 0,30	1,0 - 4,0
M 	TNMG 160408-M							●				●			0,16 - 0,40	1,0 - 5,5
	TNMG 160412-M							●				●			0,16 - 0,40	1,0 - 5,5
M1 	TNMG 160404 EL-M1											●			0,16 - 0,40	1,0 - 4,0
	TNMG 160404 ER-M1											●			0,16 - 0,40	1,0 - 4,0
	TNMG 160408 ER-M1											●			0,16 - 0,40	1,0 - 4,0
M7 	TNMG 160408-M7									●					0,15 - 0,25	0,8 - 3,0

ORDER EXAMPLE: CCMT 09T304-M A31-A1

CARBIDE

TN

1604

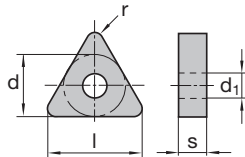
60°

TRIANGLE

0° NEGATIVE

STAINLESS STEEL

9,52	d INSCRIBED CIRCLE
16,50	l CUTTING EDGE LENGTH
4,76	s THICKNESS



TOLERANCE CLASSES	CLASS	m	d	s
	E	± 0,025	± 0,025	± 0,025
	G	± 0,025	± 0,025	± 0,13
	H	± 0,013	± 0,013	± 0,025
	M	± 0,08	± 0,05	± 0,13
	U	± 0,13	± 0,08	± 0,13

SECONDARY USE

PRIMARY USE

MACHINING TYPES



CONTINUOUS CUTTING

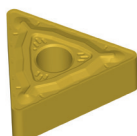


GENERAL CUTTING



INTERRUPTED CUTTING

MACHINING MATERIAL	STEEL	P	○	●	○	○	⊖	⊖	○	⊕	⊕	⊕	⊕	⊕	⊕
	STAINLESS STEEL	M	●	●	●	●	⊖	⊖	●	⊕	⊕	⊕	⊕	⊕	⊕
	CAST IRON	K	○	○			⊖		○	⊕					
	NON-FERROUS METAL	N	○	○			⊖			⊕					
	EXOTIC ALLOY	S	●	●			⊖	●	⊕	⊖					
	STEEL	H	○	○			⊖			⊕					

GEOMETRY ↓	GRADE → DESIGNATION	MACHINING MATERIAL GROUPE → Vc (M/MIN) CUTTING SPEED →														Stainless steel Groupe	
		M1,2,3	M1,2,3	M1,2,3	M1,2,3	M1,2,3	M1,2,3	M1,2,3	M1,2,3	M1,2,3	M1,2,3	M1,2,3	M1,2,3	M1,2,3	M1,2,3	M1 - Ferritic M2 - Martensitic M3 - Austenitic (Hardened - reduce 30%)	
		60-180	60-160	150-230	100-200	60-160	100-200	100-200	90-140	70-150	120-180	100-170	70-180			F (MM/REV) FEED RATE ↓	AP (MM) DEPTH OF CUT ↓
MF 	TNMG 160404-MF						●				●					0,10 - 0,30	0,5 - 3,5
	TNMG 160408-MF						●				●					0,10 - 0,30	0,5 - 3,5
F4 	TNMG 160404-F4	●				●			●							0,08 - 0,17	0,4 - 1,5
	TNMG 160408-F4	●				●			●							0,10 - 0,20	0,5 - 2,0

CARBIDE

TN

2204

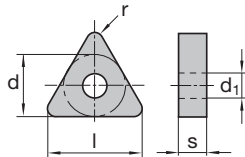
60°

TRIANGLE

0° NEGATIVE

STAINLESS STEEL

12,70	d INSCRIBED CIRCLE
22,00	l CUTTING EDGE LENGTH
4,76	s THICKNESS



TOLERANCE CLASSES	CLASS	m	d	s
	E	± 0,025	± 0,025	± 0,025
	G	± 0,025	± 0,025	± 0,13
	H	± 0,013	± 0,013	± 0,025
	M	± 0,13	± 0,08	± 0,13
	U	± 0,20	± 0,13	± 0,13

MACHINING MATERIAL	STEEL	P																MACHINING TYPES			CONTINUOUS CUTTING
	STAINLESS STEEL	M																			
	CAST IRON	K																			
	NON-FERROUS METAL	N																			
	EXOTIC ALLOY	S																			
	STEEL	H																			

GEOMETRY	DESIGNATION	MACHINING MATERIAL GROUPE →												Stainless steel Groupe	
		Vc (M/MIN) CUTTING SPEED →													
		GRADE →													
M	TNMG 220408-M	M1,2,3	M1,2,3	M1,2,3	M1,2,3	M1,2,3	M1,2,3	M1,2,3	M1,2,3	M1,2,3	M1,2,3	M1,2,3	M1,2,3	F (MM/REV) FEED RATE	AP (MM) DEPTH OF CUT
	TNMG 220412-M	60-180	60-160	150-230	100-200	60-160	100-200	100-200	90-140	70-150	120-180	100-170	70-180	↓	↓
		B22-V2	B32-S2	B41-D1	B42-T2	B42-W2	B51-E1	B52-U2	B62-O2	B62-Y2	B71-G1	B72-R2	B81-F1	0,16 - 0,40	1,0 - 5,5
														0,16 - 0,40	1,0 - 5,5



CARBIDE

VB

1604

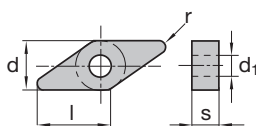
35°

DIAMOND

5° POSITIVE

STAINLESS STEEL

9,52	d INSCRIBED CIRCLE
16,50	l CUTTING EDGE LENGTH
4,76	s THICKNESS



TOLERANCE CLASSES	CLASS	m	d	s
	E	± 0,025	± 0,025	± 0,025
	G	± 0,025	± 0,025	± 0,13
	H	± 0,013	± 0,013	± 0,025
	M	± 0,08	± 0,05	± 0,13
	U	± 0,13	± 0,08	± 0,13

MACHINING MATERIAL	STEEL	P												
	STAINLESS STEEL	M												
	CAST IRON	K												
	NON-FERROUS METAL	N												
	EXOTIC ALLOY	S												
	STEEL	H												

SECONDARY USE

PRIMARY USE

MACHINING TYPES



CONTINUOUS CUTTING

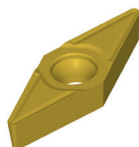


GENERAL CUTTING



INTERRUPTED CUTTING

GEOMETRY ↓		GRADE → DESIGNATION ↓		MACHINING MATERIAL GROUPE → Vc (M/MIN) CUTTING SPEED →		M1,2,3		M1,2,3		M1,2,3		M1,2,3		M1,2,3		M1,2,3		M1,2,3		Stainless steel Groupe M1 - Ferritic M2 - Martensitic M3 - Austenitic (Hardened - reduce 30%)			
F (MM/REV) FEED RATE ↓		AP (MM) DEPTH OF CUT ↓																					
M1 	VBMT 160404-M1																				0,13 - 0,63	1,0 - 4,0	
	VBMT 160408-M1																					0,13 - 0,63	1,0 - 4,0



CARBIDE

VC

0501

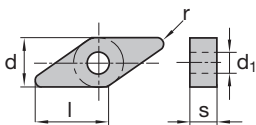
35°

DIAMOND

7° POSITIVE

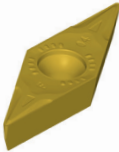
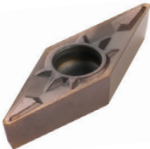
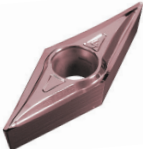
STAINLESS STEEL

3,10	d INSCRIBED CIRCLE
5,40	l CUTTING EDGE LENGTH
1,59	s THICKNESS



TOLERANCE CLASSES	CLASS	m	d	s
	E	± 0,025	± 0,025	± 0,025
	G	± 0,025	± 0,025	± 0,13
	H	± 0,013	± 0,013	± 0,025
	M	± 0,08	± 0,05	± 0,13
	U	± 0,13	± 0,08	± 0,13

MACHINING MATERIAL	STEEL	P													MACHINING TYPES			CONTINUOUS CUTTING	
	STAINLESS STEEL	M																CONTINUOUS CUTTING	
	CAST IRON	K																	CONTINUOUS CUTTING
	NON-FERROUS METAL	N																	CONTINUOUS CUTTING
	EXOTIC ALLOY	S																	CONTINUOUS CUTTING
	STEEL	H																	CONTINUOUS CUTTING

		MACHINING MATERIAL GROUPE →															Stainless steel Groupe M1 - Ferritic M2 - Martensitic M3 - Austenitic (Hardened - reduce 30%)	
		Vc (M/MIN) CUTTING SPEED →																
GEOMETRY ↓		GRADE → DESIGNATION ↓		B22-V2	B32-S2	B41-D1	B42-T2	B42-W2	B51-E1	B52-U2	B62-O2	B62-Y2	B71-G1	B72-R2	B81-F1	F (MM/REV) FEED RATE ↓	AP (MM) DEPTH OF CUT ↓	
F 		VCGT 050102-F							●						●	0,05 - 0,20	0,1 - 2,0	
F10 		VCGT 050101-F10						●								0,04 - 0,15	0,05 - 1,0	
		VCGT 050102-F10						●									0,04 - 0,20	0,1 - 2,5
		VCGT 050104-F10						●									0,05 - 0,16	0,1 - 2,5
F11 		VCGT 050102-F11					●									0,02 - 0,05	0,10 - 0,8	

CARBIDE

VC

0702

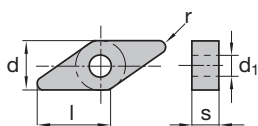
35°

DIAMOND

7° POSITIVE

STAINLESS STEEL

3,97	d INSCRIBED CIRCLE
6,85	l CUTTING EDGE LENGTH
2,38	s THICKNESS



TOLERANCE CLASSES	CLASS	m	d	s
	E	± 0,025	± 0,025	± 0,025
	G	± 0,025	± 0,025	± 0,13
	H	± 0,013	± 0,013	± 0,025
	M	± 0,08	± 0,05	± 0,13
	U	± 0,13	± 0,08	± 0,13

MACHINING TYPES	SECONDARY USE		PRIMARY USE	

MACHINING MATERIAL	STEEL	P													
	STAINLESS STEEL	M													
	CAST IRON	K													
	NON-FERROUS METAL	N													
	EXOTIC ALLOY	S													
	STEEL	H													

GEOMETRY ↓	DESIGNATION ↓	MACHINING MATERIAL GROUPE → VC (M/MIN) CUTTING SPEED →													Stainless steel Groupe	
		GRADE →													F (MM/REV) FEED RATE ↓	AP (MM) DEPTH OF CUT ↓
		B22-V2	B32-S2	B41-D1	B42-T2	B42-W2	B51-E1	B52-U2	B62-O2	B62-Y2	B71-G1	B72-R2	B81-F1			
MF7 	VCMT 070204-MF7														0,05 - 0,15	0,4 - 1,0
F 	VCMT 070202-M														0,05 - 0,20	0,1 - 2,0
	VCMT 070204-M														0,05 - 0,20	0,1 - 2,0
F11 	VCGT 0702015-F11														0,02 - 0,06	0,1 - 1,0
	VCGT 070202-F11														0,05 - 0,08	0,2 - 1,0
	VCGT 070204-F11														0,08 - 1,20	0,2 - 1,0

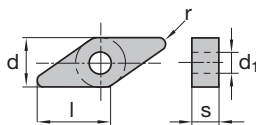
CARBIDE

VC
1103

35°
DIAMOND
7° POSITIVE

STAINLESS STEEL

6,35	d INSCRIBED CIRCLE
11,10	l CUTTING EDGE LENGTH
3,18	s THICKNESS



TOLERANCE CLASSES	CLASS	m	d	s
	E	± 0,025	± 0,025	± 0,025
	G	± 0,025	± 0,025	± 0,13
	H	± 0,013	± 0,013	± 0,025
	M	± 0,08	± 0,05	± 0,13
	U	± 0,13	± 0,08	± 0,13

MACHINING MATERIAL	STEEL	P												
	STAINLESS STEEL	M												
	CAST IRON	K												
	NON-FERROUS METAL	N												
	EXOTIC ALLOY	S												
	STEEL	H												

MACHINING TYPES

SECONDARY USE

PRIMARY USE



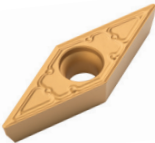
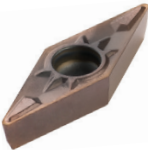
CONTINUOUS CUTTING



GENERAL CUTTING



INTERRUPTED CUTTING

GEOMETRY ↓		GRADE → DESIGNATION ↓		MACHINING MATERIAL GROUPE → VC (M/MIN) CUTTING SPEED →												Stainless steel Groupe M1 - Ferritic M2 - Martensitic M3 - Austenitic (Hardened - reduce 30%)		
				B22-V2	B32-S2	B41-D1	B42-T2	B42-W2	B51-E1	B52-U2	B62-O2	B62-Y2	B71-G1	B72-R2	B81-F1			
		VCMT 110302-M11		●				●			●						0,08 - 0,20	0,4 - 2,0
		VCMT 110304-M11		●				●			●						0,08 - 0,20	0,4 - 2,0
		VCMT 110302-MF7		●				●			●						0,05 - 0,15	0,4 - 1,5
		VCMT 110304-MF7		●				●			●						0,08 - 0,20	0,4 - 1,5
		VCMT 110302-F							●						●		0,05 - 0,20	0,1 - 2,0
		VCMT 110304-F							●						●		0,05 - 0,20	0,1 - 2,0
		VCMT 110302-F10		●				●									0,04 - 0,12	0,1 - 1,0
		VCMT 110304-F10		●				●			●						0,05 - 0,16	0,1 - 1,5

ORDER EXAMPLE: CCMT 09T304-M A31-A1

CARBIDE

VC
1103

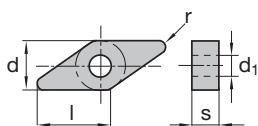
35°

DIAMOND

7° POSITIVE

STAINLESS STEEL

6,35	d INSCRIBED CIRCLE
11,10	l CUTTING EDGE LENGTH
3,18	s THICKNESS



TOLERANCE CLASSES	CLASS	m	d	s
	E	± 0,025	± 0,025	± 0,025
	G	± 0,025	± 0,025	± 0,13
	H	± 0,013	± 0,013	± 0,025
	M	± 0,08	± 0,05	± 0,13
	U	± 0,13	± 0,08	± 0,13

MACHINING TYPES	SECONDARY USE		PRIMARY USE	

MACHINING MATERIAL	STEEL	P													
	STAINLESS STEEL	M													
	CAST IRON	K													
	NON-FERROUS METAL	N													
	EXOTIC ALLOY	S													
	STEEL	H													

GEOMETRY ↓	GRADE → DESIGNATION ↓	MACHINING MATERIAL GROUPE → VC (M/MIN) CUTTING SPEED →														Stainless steel Groupe	
																F (MM/REV) FEED RATE ↓	AP (MM) DEPTH OF CUT ↓
		B22-V2	B32-S2	B41-D1	B42-T2	B42-W2	B51-E1	B52-U2	B62-O2	B62-Y2	B71-G1	B72-R2	B81-F1				
F11 	VCGT 1103008-F11				●											0,02 - 0,06	0,1 - 1,5
	VCGT 1103015-F11		●		●											0,05 - 0,12	0,2 - 2,0
	VCGT 110301-F11		●													0,02 - 0,06	0,1 - 1,5
	VCGT 110302-F11		●		●			●								0,05 - 0,12	0,2 - 2,0
	VCGT 1103035-F11		●													0,08 - 0,25	0,2 - 2,5
	VCGT 110304-F11		●		●			●								0,08 - 0,25	0,2 - 2,5
F12 	VCGT 1103005-F12					●										0,02 - 0,06	0,1 - 1,5
	VCGT 1103008-F12				●											0,02 - 0,06	0,1 - 1,5
	VCGT 1103015-F12				●											0,05 - 0,12	0,2 - 2,0
	VCGT 110301-F12					●										0,02 - 0,06	0,1 - 1,5
	VCGT 110302-F12	●				●										0,05 - 0,12	0,2 - 2,0
	VCGT 110304-F12	●				●										0,08 - 0,25	0,2 - 2,5

CARBIDE

VC

1303

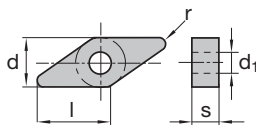
35°

DIAMOND

7° POSITIVE

STAINLESS STEEL

7,94	d INSCRIBED CIRCLE
13,10	l CUTTING EDGE LENGTH
3,18	s THICKNESS



TOLERANCE CLASSES	CLASS	m	d	s
	E	± 0,025	± 0,025	± 0,025
	G	± 0,025	± 0,025	± 0,13
	H	± 0,013	± 0,013	± 0,025
	M	± 0,08	± 0,05	± 0,13
	U	± 0,13	± 0,08	± 0,13

MACHINING MATERIAL	STEEL	P												
	STAINLESS STEEL	M												
	CAST IRON	K												
	NON-FERROUS METAL	N												
	EXOTIC ALLOY	S												
	STEEL	H												

MACHINING TYPES

SECONDARY USE

PRIMARY USE



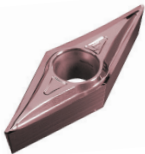
CONTINUOUS CUTTING

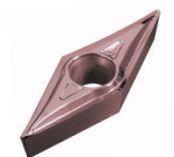


GENERAL CUTTING



INTERRUPTED CUTTING

GEOMETRY ↓	MACHINING MATERIAL GROUPE →	Vc (M/MIN) CUTTING SPEED →												Stainless steel Groupe M1 - Ferritic M2 - Martensitic M3 - Austenitic (Hardened - reduce 30%)		
		GRADE →														
		DESIGNATION														
		B22-V2	B32-S2	B41-D1	B42-T2	B42-W2	B51-E1	B52-U2	B62-O2	B62-Y2	B71-G1	B72-R2	B81-F1		F (MM/REV) FEED RATE ↓	AP (MM) DEPTH OF CUT ↓
F11 	VC GT 130302-F11		●												0,05 - 0,12	0,2 - 2,0
	VC GT 130304-F11		●												0,08 - 0,25	0,2 - 2,5



CARBIDE

VC
1604

35°
DIAMOND
7° POSITIVE

STAINLESS STEEL

9,52	d	INSCRIBED CIRCLE
16,60	l	CUTTING EDGE LENGTH
4,76	s	THICKNESS

TOLERANCE CLASSES	CLASS	m	d	s
	E	± 0,025	± 0,025	± 0,025
	G	± 0,025	± 0,025	± 0,13
	H	± 0,013	± 0,013	± 0,025
	M	± 0,08	± 0,05	± 0,13
	U	± 0,13	± 0,08	± 0,13

MACHINING MATERIAL

STEEL	P
STAINLESS STEEL	M
CAST IRON	K
NON-FERROUS METAL	N
EXOTIC ALLOY	S
STEEL	H

○	●	○	○	☉	☉	○	☉	☉	☉	☉	☉	☉
●	●	●	●	☉	☉	●	☉	☉	☉	☉	☉	☉
○	○			☉		○	☉					
○	○			☉			☉					
●	●			☉		●	☉					
○	○			☉			☉					

MACHINING TYPES

SECONDARY USE
○

PRIMARY USE
●

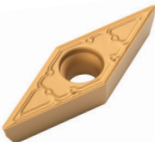
○
☉
☉

●
☉
☉

CONTINUOUS CUTTING

GENERAL CUTTING

INTERRUPTED CUTTING

		MACHINING MATERIAL GROUPE →												Stainless steel Groupe		
		Vc (M/MIN) CUTTING SPEED →														
		GRADE →														
GEOMETRY ↓		DESIGNATION ↓												F (MM/REV) FEED RATE ↓	AP (MM) DEPTH OF CUT ↓	
		B22-V2	B32-S2	B41-D1	B42-T2	B42-W2	B51-E1	B52-U2	B62-O2	B62-Y2	B71-G1	B72-R2	B81-F1			
MR1 	VCMT 160404-MR1										●				0,20 - 0,50	0,5 - 5,0
	VCMT 160408-MR1										●				0,20 - 0,50	0,5 - 5,0
	VCMT 160412-MR1										●				0,20 - 0,50	0,5 - 5,0
M1 	VCMT 160404-M1			●			●								0,13 - 0,63	1,0 - 4,0
	VCMT 160408-M1			●			●								0,13 - 0,63	1,0 - 4,0
	VCMT 160412-M1						●								0,13 - 0,63	1,0 - 4,0
M11 	VCMT 160404-M11	●				●			●						0,12 - 0,25	0,8 - 3,0
	VCMT 160408-M11	●				●			●						0,15 - 0,25	0,8 - 3,0
MF7 	VCMT 160404-MF7	●				●			●						0,08 - 0,20	0,4 - 2,0
	VCMT 160408-MF7	●				●			●						0,12 - 0,30	0,5 - 2,0

ORDER EXAMPLE: CCMT 09T304-M A31-A1

CARBIDE

VC

1604

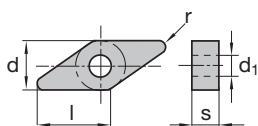
35°

DIAMOND

7° POSITIVE

STAINLESS STEEL

9,52	d INSCRIBED CIRCLE
16,60	l CUTTING EDGE LENGTH
4,76	s THICKNESS



TOLERANCE CLASSES	CLASS	m	d	s
	E	± 0,025	± 0,025	± 0,025
	G	± 0,025	± 0,025	± 0,13
	H	± 0,013	± 0,013	± 0,025
	M	± 0,08	± 0,05	± 0,13
	U	± 0,13	± 0,08	± 0,13

MACHINING MATERIAL	STEEL	P												
	STAINLESS STEEL	M												
	CAST IRON	K												
	NON-FERROUS METAL	N												
	EXOTIC ALLOY	S												
	STEEL	H												

MACHINING TYPES

SECONDARY USE

PRIMARY USE



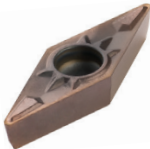
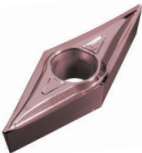
CONTINUOUS CUTTING



GENERAL CUTTING



INTERRUPTED CUTTING

GEOMETRY ↓		GRADE → DESIGNATION ↓		MACHINING MATERIAL GROUPE → Vc (M/MIN) CUTTING SPEED →												Stainless steel Groupe M1 - Ferritic M2 - Martensitic M3 - Austenitic (Hardened - reduce 30%)	
		B22-V2	B32-S2	B41-D1	B42-T2	B42-W2	B51-E1	B52-U2	B62-O2	B62-Y2	B71-G1	B72-R2	B81-F1	F (MM/REV) FEED RATE ↓	AP (MM) DEPTH OF CUT ↓		
		VCMT 160404-F10	●				●			●					0,05 - 0,16	0,1 - 1,5	
		VCMT 160402-F11		●					●						0,05 - 0,12	0,2 - 2,0	
		VCMT 160404-F11		●					●						0,08 - 0,25	0,2 - 2,5	
		VCMT 160408-F11		●											0,10 - 0,30	0,3 - 3,0	

CARBIDE

VN

1604

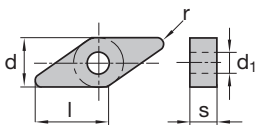
35°

DIAMOND

0° NEGATIVE

STAINLESS STEEL

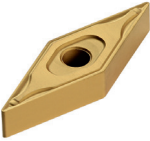
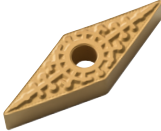
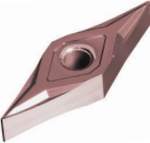
9,52	d	INSCRIBED CIRCLE
16,60	l	CUTTING EDGE LENGTH
4,76	s	THICKNESS



TOLERANCE CLASSES	CLASS	m	d	s
	E	± 0,025	± 0,025	± 0,025
	G	± 0,025	± 0,025	± 0,13
	H	± 0,013	± 0,013	± 0,025
	M	± 0,08	± 0,05	± 0,13
	U	± 0,13	± 0,08	± 0,13

MACHINING TYPES	SECONDARY USE		PRIMARY USE	

MACHINING MATERIAL	STEEL	P													
	STAINLESS STEEL	M													
	CAST IRON	K													
	NON-FERROUS METAL	N													
	EXOTIC ALLOY	S													
	STEEL	H													

		MACHINING MATERIAL GROUPE →		Vc (M/MIN) CUTTING SPEED →												Stainless steel Groupe	
				GRADE →													
		GEOMETRY ↓	DESIGNATION ↓	B22-V2	B32-S2	B41-D1	B42-T2	B42-W2	B51-E1	B52-U2	B62-O2	B62-Y2	B71-G1	B72-R2	B81-F1		
M7	VNMG 160404-M7									●						0,10 - 0,18	0,5 - 2,0
																	
M8	VNMG 160408-M8									●						0,15 - 0,25	0,8 - 3,0
																	
F4	VNMG 160404-F4	●				●										0,05 - 0,15	0,2 - 1,5
	VNMG 160408-F4	●				●			●							0,07 - 0,18	0,3 - 2,0
F14	VNGP 160402-F14								●							0,05 - 0,25	0,03 - 3,0
	VNGP 160404-F14								●							0,05 - 0,25	0,05 - 3,5

ORDER EXAMPLE: CCMT 09T304-M A31-A1

CARBIDE

WC

0201

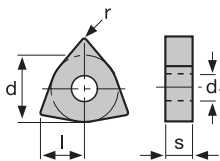
80°

TRIGON

7° POSITIVE

STAINLESS STEEL

3,97	d INSCRIBED CIRCLE
2,70	l CUTTING EDGE LENGTH
1,59	s THICKNESS



TOLERANCE CLASSES	CLASS	m	d	s
	E	± 0,025	± 0,025	± 0,025
	G	± 0,025	± 0,025	± 0,13
	H	± 0,013	± 0,013	± 0,025
	M	± 0,08	± 0,05	± 0,13
	U	± 0,13	± 0,08	± 0,13

SECONDARY USE

PRIMARY USE

MACHINING TYPES


CONTINUOUS CUTTING



GENERAL CUTTING



INTERRUPTED CUTTING

MACHINING MATERIAL	STEEL	P	○	●	○	○	☉	☉	○	☉	☉	☉	☉	☉	☉
	STAINLESS STEEL	M	●	●	●	●	☉	☉	●	☉	☉	☉	☉	☉	☉
	CAST IRON	K	○	○			☉		○	☉					
	NON-FERROUS METAL	N	○	○			☉			☉					
	EXOTIC ALLOY	S	●	●			☉	●	☉						
	STEEL	H	○	○			☉			☉					

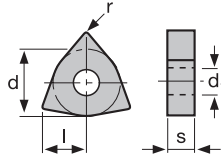
		MACHINING MATERIAL GROUPE →		Vc (M/MIN) CUTTING SPEED →														Stainless steel Groupe	
GEOMETRY ↓		GRADE →																	
DESIGNATION ↓		B22-V2	B32-S2	B41-D1	B42-T2	B42-W2	B51-E1	B52-U2	B62-O2	B62-Y2	B71-G1	B72-R2	B81-F1		F (MM/REV) FEED RATE ↓	AP (MM) DEPTH OF CUT ↓			
NCB1 	WCMT 020104-NCB1							●							0,08 - 0,25	0,3 - 1,5			
MF7 	WCMT 020102-MF7									●					0,05 - 0,12	0,2 - 1,0			
	WCMT 020104-MF7									●					0,08 - 0,25	0,3 - 1,5			
F10 	WCMT 020102-F10									●					0,04 - 0,12	0,1 - 1,0			
	WCMT 020104-F10									●					0,05 - 0,16	0,1 - 1,5			

CARBIDE
WC
0402

80°
TRIGON
7° POSITIVE

STAINLESS STEEL

6,35	d INSCRIBED CIRCLE
4,30	l CUTTING EDGE LENGTH
2,38	s THICKNESS



TOLERANCE CLASSES	CLASS	m	d	s
	E	± 0,025	± 0,025	± 0,025
	G	± 0,025	± 0,025	± 0,13
	H	± 0,013	± 0,013	± 0,025
	M	± 0,08	± 0,05	± 0,13
	U	± 0,13	± 0,08	± 0,13

SECONDARY USE

PRIMARY USE

MACHINING MATERIAL	STEEL	P	○	●	○	○	☉	☉	○	☉	☉	☉	☉	☉	☉
	STAINLESS STEEL	M	●	●	●	●	☉	☉	●	☉	☉	☉	☉	☉	☉
	CAST IRON	K	○	○			☉		○	☉					
	NON-FERROUS METAL	N	○	○			☉			☉					
	EXOTIC ALLOY	S	●	●			☉	●	☉	☉					
	STEEL	H	○	○			☉			☉					
			MACHINING TYPES												
			○	●											
			☉	☉											
			☉	☉											

CONTINUOUS CUTTING

GENERAL CUTTING

INTERRUPTED CUTTING

GEOMETRY ↓	DESIGNATION ↓	MACHINING MATERIAL GROUPE → Vc (M/MIN) CUTTING SPEED →												Stainless steel Groupe M1 - Ferritic M2 - Martensitic M3 - Austenitic (Hardened - reduce 30%)		
		GRADE →														
		B22-V2	B32-S2	B41-D1	B42-T2	B42-W2	B51-E1	B52-U2	B62-O2	B62-Y2	B71-G1	B72-R2	B81-F1			
M10	WCMT 040204-M10					●									0,08 - 0,25	0,4 - 2,0
																

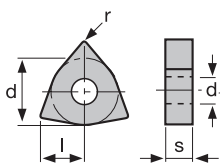
CARBIDE

WC
06T3

80°
 TRIGON
 7° POSITIVE

STAINLESS STEEL

9,52	d INSCRIBED CIRCLE
6,50	l CUTTING EDGE LENGTH
3,97	s THICKNESS



TOLERANCE CLASSES	CLASS	m	d	s
	E	± 0,025	± 0,025	± 0,025
	G	± 0,025	± 0,025	± 0,13
	H	± 0,013	± 0,013	± 0,025
	M	± 0,08	± 0,05	± 0,13
	U	± 0,13	± 0,08	± 0,13

MACHINING MATERIAL	STEEL	P												
	STAINLESS STEEL	M												
	CAST IRON	K												
	NON-FERROUS METAL	N												
	EXOTIC ALLOY	S												
	STEEL	H												

MACHINING TYPES

SECONDARY USE

PRIMARY USE



CONTINUOUS CUTTING



GENERAL CUTTING



INTERRUPTED CUTTING

GEOMETRY ↓	GRADE → DESIGNATION ↓	MACHINING MATERIAL GROUPE → Vc (M/MIN) CUTTING SPEED →												Stainless steel Groupe M1 - Ferritic M2 - Martensitic M3 - Austenitic (Hardened - reduce 30%)		
		B22-V2	B32-S2	B41-D1	B42-T2	B42-W2	B51-E1	B52-U2	B62-O2	B62-Y2	B71-G1	B72-R2	B81-F1		F (MM/REV) FEED RATE ↓	AP (MM) DEPTH OF CUT ↓
M10 	WCMT 06T304-M10					●			●						0,08 - 0,25	0,4 - 2,5
	WCMT 06T308-M10					●									0,12 - 0,32	0,5 - 2,5

CARBIDE

WN

0604

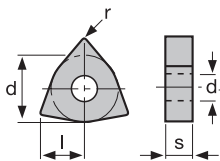
80°

TRIGON

0° NEGATIVE

STAINLESS STEEL

9,52	d INSCRIBED CIRCLE
6,50	l CUTTING EDGE LENGTH
3,97	s THICKNESS



TOLERANCE CLASSES	CLASS	m	d	s
	E	± 0,025	± 0,025	± 0,025
	G	± 0,025	± 0,025	± 0,13
	H	± 0,013	± 0,013	± 0,025
	M	± 0,08	± 0,05	± 0,13
	U	± 0,13	± 0,08	± 0,13

MACHINING MATERIAL	STEEL	P												
	STAINLESS STEEL	M												
	CAST IRON	K												
	NON-FERROUS METAL	N												
	EXOTIC ALLOY	S												
	STEEL	H												

MACHINING TYPES

SECONDARY USE

PRIMARY USE



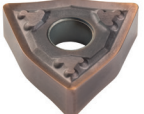
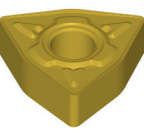
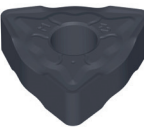
CONTINUOUS CUTTING



GENERAL CUTTING



INTERRUPTED CUTTING

GEOMETRY ↓		GRADE → DESIGNATION ↓		MACHINING MATERIAL GROUPE → Vc (M/MIN) CUTTING SPEED →		Stainless steel Groupe											
						M1 - Ferritic M2 - Martensitic M3 - Austenitic (Hardened - reduce 30%)											
						M1,2,3	M1,2,3	M1,2,3	M1,2,3	M1,2,3	M1,2,3	M1,2,3	M1,2,3	M1,2,3	M1,2,3	M1,2,3	
														F (MM/REV) FEED RATE ↓	AP (MM) DEPTH OF CUT ↓		
MR5 	WNMG 060404-MR5					●									0,05 - 0,12	0,2 - 1,0	
	WNMG 060408-MR5					●									0,07 - 0,16	0,4 - 1,5	
MR6 	WNMG 060404-MR6					●									0,10 - 0,25	0,7 - 3,5	
	WNMG 060408-MR6					●									0,12 - 0,30	0,8 - 4,0	
M 	WNMG 060408-M										●				0,16 - 0,40	1,0 - 5,5	
M1 	WNMG 060404-M1						●								0,16 - 0,40	1,0 - 4,0	

ORDER EXAMPLE: CCMT 09T304-M A31-A1

CARBIDE

WN

0604

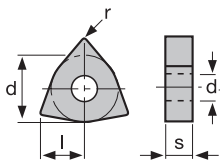
80°

TRIGON

0° NEGATIVE

STAINLESS STEEL

9,52	d INSCRIBED CIRCLE
6,50	l CUTTING EDGE LENGTH
3,97	s THICKNESS



TOLERANCE CLASSES	CLASS	m	d	s
	E	± 0,025	± 0,025	± 0,025
	G	± 0,025	± 0,025	± 0,13
	H	± 0,013	± 0,013	± 0,025
	M	± 0,08	± 0,05	± 0,13
	U	± 0,13	± 0,08	± 0,13

SECONDARY USE

PRIMARY USE

MACHINING MATERIAL	STEEL	P													
	STAINLESS STEEL	M													
	CAST IRON	K													
	NON-FERROUS METAL	N													
	EXOTIC ALLOY	S													
	STEEL	H													

MACHINING TYPES

SECONDARY USE

PRIMARY USE

CONTINUOUS CUTTING

GENERAL CUTTING

INTERRUPTED CUTTING

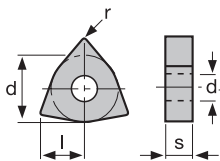
GEOMETRY	GRADE → DESIGNATION	MACHINING MATERIAL GROUPE → Vc (M/MIN) CUTTING SPEED →												Stainless steel Groupe	
M7	WNMG 060404-M7 WNMG 060408-M7	B22-V2	B32-S2	B41-D1	B42-T2	B42-W2	B51-E1	B52-U2	B62-O2	B62-Y2	B71-G1	B72-R2	B81-F1	F (MM/REV) FEED RATE	AP (MM) DEPTH OF CUT
MF	WNMG 060404-MF														

CARBIDE
WN
0804

 80°
TRIGON
0° NEGATIVE

STAINLESS STEEL

12,70	d INSCRIBED CIRCLE
8,72	l CUTTING EDGE LENGTH
4,76	s THICKNESS



TOLERANCE CLASSES	CLASS	m	d	s
	E	± 0,025	± 0,025	± 0,025
	G	± 0,025	± 0,025	± 0,13
	H	± 0,013	± 0,013	± 0,025
	M	± 0,13	± 0,08	± 0,13
	U	± 0,20	± 0,13	± 0,13

MACHINING TYPES	SECONDARY USE		PRIMARY USE	

MACHINING MATERIAL	STEEL	P													
	STAINLESS STEEL	M													
	CAST IRON	K													
	NON-FERROUS METAL	N													
	EXOTIC ALLOY	S													
	STEEL	H													

GEOMETRY	GRADE → DESIGNATION	MACHINING MATERIAL GROUPE → Vc (M/MIN) CUTTING SPEED →												Stainless steel Groupe	
														F (MM/REV) FEED RATE ↓	AP (MM) DEPTH OF CUT ↓
		M1,2,3	M1,2,3	M1,2,3	M1,2,3	M1,2,3	M1,2,3	M1,2,3	M1,2,3	M1,2,3	M1,2,3	M1,2,3	M1,2,3		
R7 	WNMG 080408-R7													0,20 - 0,40	0,8 - 6,0
	WNMG 080412-R7													0,25 - 0,60	1,0 - 6,0
MR 	WNMG 080408-MR													0,35 - 0,60	1,2 - 7,2
	WNMG 080412-MR													0,35 - 0,60	1,2 - 7,2
M 	WNMG 080408-M													0,16 - 0,40	1,0 - 5,5
	WNMG 080412-M													0,16 - 0,40	1,0 - 5,5
	WNMG 080416-M													0,16 - 0,40	1,0 - 5,5
M1 	WNMG 080408-M1													0,16 - 0,40	1,0 - 4,0
	WNMG 080412-M1													0,16 - 0,40	1,0 - 4,0
	WNMG 080416-M1													0,16 - 0,40	1,0 - 4,0

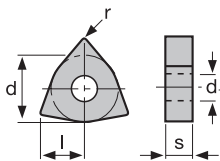
ORDER EXAMPLE: CCMT 09T304-M A31-A1

CARBIDE
WN
0804

 80°
TRIGON
0° NEGATIVE

STAINLESS STEEL

12,70	d	INSCRIBED CIRCLE
8,72	l	CUTTING EDGE LENGTH
4,76	s	THICKNESS



TOLERANCE CLASSES	CLASS	m	d	s
	E	± 0,025	± 0,025	± 0,025
	G	± 0,025	± 0,025	± 0,13
	H	± 0,013	± 0,013	± 0,025
	M	± 0,13	± 0,08	± 0,13
	U	± 0,20	± 0,13	± 0,13

MACHINING MATERIAL	STEEL	P												
	STAINLESS STEEL	M												
	CAST IRON	K												
	NON-FERROUS METAL	N												
	EXOTIC ALLOY	S												
	STEEL	H												

MACHINING TYPES

SECONDARY USE

PRIMARY USE



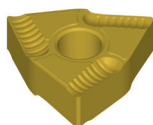
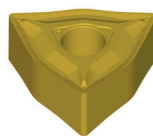
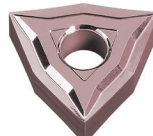
CONTINUOUS CUTTING



GENERAL CUTTING



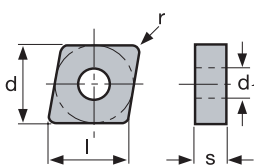
INTERRUPTED CUTTING

GEOMETRY ↓		GRADE → DESIGNATION ↓		MACHINING MATERIAL GROUPE → Vc (M/MIN) CUTTING SPEED →												Stainless steel Groupe	
																M1 - Ferritic M2 - Martensitic M3 - Austenitic (Hardened - reduce 30%)	
				M1,2,3	M1,2,3	M1,2,3	M1,2,3	M1,2,3	M1,2,3	M1,2,3	M1,2,3	M1,2,3	M1,2,3	M1,2,3	M1,2,3		
		B22-V2	B32-S2	B41-D1	B42-T2	B42-W2	B51-E1	B52-U2	B62-O2	B62-Y2	B71-G1	B72-R2	B81-F1		F (MM/REV) FEED RATE ↓	AP (MM) DEPTH OF CUT ↓	
E-M1 	WNMG 080404 ER-M1										●				0,20 - 0,40	1,0 - 3,2	
	WNMG 080408 EL-M1										●				0,20 - 0,40	1,0 - 3,2	
	WNMG 080408 ER-M1										●				0,20 - 0,40	1,0 - 3,2	
	WNMG 080412 EL-M1										●				0,20 - 0,40	1,0 - 3,2	
	WNMG 080412 ER-M1										●				0,20 - 0,40	1,0 - 3,2	
M7 	WNMG 080404-M7								●						0,10 - 0,20	0,5 - 3,0	
	WNMG 080408-M7								●						0,15 - 0,32	0,8 - 3,0	
	WNMG 080412-M7								●						0,15 - 0,35	0,8 - 3,5	
MF 	WNMG 080404-MF						●				●				0,10 - 0,30	0,5 - 3,5	
	WNMG 080408-MF						●				●				0,10 - 0,30	0,5 - 3,5	
F14 	WNGP 080404-F14							●							0,05 - 0,25	0,05 - 3,5	
	WNGP 080408-F14							●							0,05 - 0,25	0,05 - 4,0	

ORDER EXAMPLE: CCMT 09T304-M A31-A1

CARBIDE	CC 0602	80°	CAST IRON
		DIAMOND	
		7° POSITIVE	

6,35	d INSCRIBED CIRCLE
6,40	l CUTTING EDGE LENGTH
2,38	s THICKNESS



TOLERANCE CLASSES	CLASS	m	d	s
	E	± 0,025	± 0,025	± 0,025
	G	± 0,025	± 0,025	± 0,13
	H	± 0,013	± 0,013	± 0,025
	M	± 0,08	± 0,05	± 0,13
	U	± 0,13	± 0,08	± 0,13

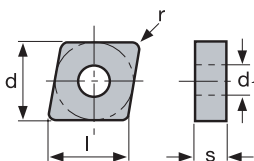
MACHINING MATERIAL	STEEL	P	TOLERANCE CLASSES	CLASS	m	d	s	MACHINING TYPES	SECONDARY USE	PRIMARY USE	CONTINUOUS CUTTING	GENERAL CUTTING	INTERRUPTED CUTTING
	STAINLESS STEEL	M											
	CAST IRON	K											
	NON-FERROUS METAL	N											
	EXOTIC ALLOY	S											
	STEEL	H											

GEOMETRY	GRADE → DESIGNATION	MACHINING MATERIAL GROUPE → Vc (M/MIN) CUTTING SPEED →	Cast iron Groupe										F (MM/REV) FEED RATE ↓	AP (MM) DEPTH OF CUT ↓
			K1,2,3	K1,2,3	K1,2,3	K1,2,3	K1,2,3	K1,2,3	K1,2,3	K1,2,3	K1,2,3	K1,2,3		
MF7	CCMT 060204-MF7		C22-AB2	C21-I1	A22-A2	C31-J1	C22-AA2	A32-B2	C52-AD2	C42-AC2	A52-C2		0,08 - 0,20	0,4 - 2,0
	CCGT 0602005-MF17			●			●						0,02 - 0,06	0,05 - 1,5
	CCGT 060201-MF17			●			●						0,02 - 0,06	0,5 - 1,5
	CCGT 060202-MF17			●			●						0,05 - 0,12	0,5 - 2,0
	CCGT 060204-MF17			●			●						0,08 - 0,25	0,6 - 3,0
	CCGT 0602005-F12			●			●						0,02 - 0,06	0,1 - 1,5
	CCGT 060201-F12			●			●						0,02 - 0,06	0,1 - 1,5
	CCGT 060202-F12			●			●						0,05 - 0,12	0,2 - 2,0
	CCGT 060204-F12			●			●						0,08 - 0,25	0,2 - 2,5
	CCGT 060202-W1			●									0,10 - 0,30	0,3 - 3,0
	CCGT 060204-W1			●									0,12 - 0,40	0,5 - 4,0
	CCGT 060208-W1			●									0,15 - 0,50	0,7 - 4,0

ORDER EXAMPLE: CCMT 09T304-M A31-A1

CARBIDE	CC 09T3	80°	CAST IRON
		DIAMOND	
		7° POSITIVE	

9,52	d INSCRIBED CIRCLE
9,70	l CUTTING EDGE LENGTH
3,97	s THICKNESS



TOLERANCE CLASSES	CLASS	m	d	s
	E	± 0,025	± 0,025	± 0,025
	G	± 0,025	± 0,025	± 0,13
	H	± 0,013	± 0,013	± 0,025
	M	± 0,08	± 0,05	± 0,13
	U	± 0,13	± 0,08	± 0,13

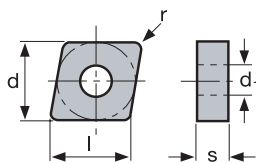
MACHINING MATERIAL	STEEL	P	TOLERANCE CLASSES	CLASS	m	d	s	MACHINING TYPES	SECONDARY USE	PRIMARY USE	CONTINUOUS CUTTING	GENERAL CUTTING	INTERRUPTED CUTTING
	STAINLESS STEEL	M											
	CAST IRON	K											
	NON-FERROUS METAL	N											
	EXOTIC ALLOY	S											
	STEEL	H											

GEOMETRY	GRADE → DESIGNATION	MACHINING MATERIAL GROUPE → Vc (M/MIN) CUTTING SPEED →	Cast iron Groupe										F (MM/REV) FEED RATE ↓	AP (MM) DEPTH OF CUT ↓
			K1,2,3	K1,2,3	K1,2,3	K1,2,3	K1,2,3	K1,2,3	K1,2,3	K1,2,3	K1,2,3	K1,2,3		
M2	CCMT 09T304-M2	CCMT 09T308-M2	C22-AB2	C21-I1	A22-A2	C31-J1	C22-AA2	A32-B2	C52-AD2	C42-AC2	A52-C2			
													0,15 - 0,50	0,8 - 8,0
													0,15 - 0,50	0,8 - 8,0
MF7	CCMT 09T308-MF7												0,12 - 0,32	0,5 - 3,0
MF17	CCGT 09T301-MF17												0,02 - 0,06	0,5 - 1,5
	CCGT 09T302-MF17												0,05 - 0,12	0,5 - 2,0
	CCGT 09T304-MF17												0,08 - 0,25	0,6 - 4,0
	CCGT 09T308-MF17												0,10 - 0,35	0,8 - 4,0
F12	CCGT 09T3005-F12												0,02 - 0,06	0,1 - 1,5
	CCGT 09T301-F12												0,02 - 0,06	0,1 - 1,5
	CCGT 09T302-F12												0,05 - 0,12	0,2 - 2,0
	CCGT 09T304-F12												0,08 - 0,25	0,2 - 2,5
	CCGT 09T308-F12												0,10 - 0,30	0,3 - 3,0

ORDER EXAMPLE: CCMT 09T304-M A31-A1

CARBIDE	CC 09T3	80°	CAST IRON
		DIAMOND	
		7° POSITIVE	

9,52	d	INSCRIBED CIRCLE
9,70	l	CUTTING EDGE LENGTH
3,97	s	THICKNESS



TOLERANCE CLASSES	CLASS	m	d	s
	E	± 0,025	± 0,025	± 0,025
	G	± 0,025	± 0,025	± 0,13
	H	± 0,013	± 0,013	± 0,025
	M	± 0,08	± 0,05	± 0,13
	U	± 0,13	± 0,08	± 0,13

MACHINING MATERIAL	STEEL	P	TOLERANCE CLASSES	CLASS	m	d	s	MACHINING TYPES	SECONDARY USE	PRIMARY USE	CONTINUOUS CUTTING	GENERAL CUTTING	INTERRUPTED CUTTING
	STAINLESS STEEL	M											
	CAST IRON	K											
	NON-FERROUS METAL	N											
	EXOTIC ALLOY	S											
	STEEL	H											

GEOMETRY ↓	DESIGNATION ↓	MACHINING MATERIAL GROUPE → Vc (M/MIN) CUTTING SPEED →	GRADE →	Cast iron Groupe	F (MM/REV) FEED RATE ↓	AP (MM) DEPTH OF CUT ↓
W1 	CCGT 09T302-W1	K1,2,3	C22-AB2	K1 - Grey cast iron	0,10 - 0,30	0,3 - 3,0
	CCGT 09T304-W1	K1,2,3	C21-I1	K2 - Ductile cast iron (Vc -20%)	0,12 - 0,40	0,5 - 4,0
	CCGT 09T308-W1	K1,2,3	A22-A2	K3 - Malleable cast iron	0,15 - 0,50	0,7 - 4,0
		K1,2,3	C31-J1	Pearlitic structure Vc -25%		
		K1,2,3	C22-AA2			
		K1,2,3	A32-B2			
		K1,2,3	C52-AD2			
		K1,2,3	C42-AC2			
		K1,2,3	A52-C2			

CARBIDE

CC

1204

80°

DIAMOND

7° POSITIVE

CAST IRON

12,70

d

INSCRIBED CIRCLE

12,90

l

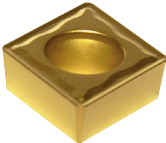
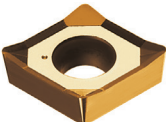
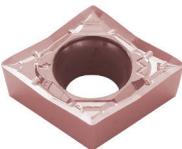
CUTTING EDGE LENGTH

4,76

s

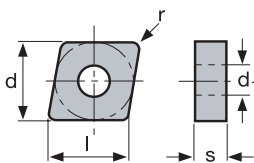
THICKNESS

</

GEOMETRY ↓		GRADE → DESIGNATION ↓		MACHINING MATERIAL GROUPE →		Vc (M/MIN) CUTTING SPEED →		Cast iron Groupe										
				K1.2.3	K1.2.3	K1.2.3	K1.2.3	K1.2.3	K1.2.3	K1.2.3	K1.2.3	K1.2.3					K1 - Grey cast iron K2 - Ductile cast iron (Vc -20%) K3 - Malleable cast iron Pearlitic structure Vc -25%	F (MM/REV) FEED RATE ↓
		C22-AB2	C21-I1	A22-A2	C31-J1	C22-AA2	A32-B2	C52-AD2	C42-AC2	A52-C2								
M		CCMT 120408-M	●	●													0,15 - 0,50	0,8 -8,0
MF17		CCGT 120401-MF17		●													0,05 - 0,12	0,5 - 2,0
		CCGT 120402-MF17		●			●										0,05 - 0,12	0,5 - 2,0
		CCGT 120404-MF17		●			●										0,08 - 0,25	0,6 - 5,0
		CCGT 120408-MF17		●			●										0,10 - 0,35	0,8 - 5,0
W1		CCGT 120404-W1		●													0,12 - 0,40	0,5 - 4,0
		CCGT 120408-W1		●													0,15 - 0,50	0,7 - 4,0

CARBIDE	CN 0903	80°	CAST IRON
		DIAMOND	
		0° NEGATIVE	

9,52	d	INSCRIBED CIRCLE
9,70	l	CUTTING EDGE LENGTH
3,18	s	THICKNESS



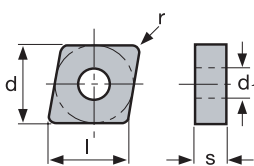
TOLERANCE CLASSES	CLASS	m	d	s
	E	± 0,025	± 0,025	± 0,025
	G	± 0,025	± 0,025	± 0,13
	H	± 0,013	± 0,013	± 0,025
	M	± 0,08	± 0,05	± 0,13
	U	± 0,13	± 0,08	± 0,13

MACHINING MATERIAL	STEEL	P	TOLERANCE CLASSES	CLASS	m	d	s	MACHINING TYPES	SECONDARY USE	PRIMARY USE	CONTINUOUS CUTTING	GENERAL CUTTING	INTERRUPTED CUTTING
	STAINLESS STEEL	M											
	CAST IRON	K											
	NON-FERROUS METAL	N											
	EXOTIC ALLOY	S											
	STEEL	H											

GEOMETRY	DESIGNATION	MACHINING MATERIAL GROUPE →	Vc (M/MIN) CUTTING SPEED →	GRADE →	Cast iron Groupe	F (MM/REV) FEED RATE	AP (MM) DEPTH OF CUT
M6	CNMG 090304-M6				K1, 2, 3	0,10 - 0,20	0,5 - 2,0
					K1, 2, 3		
					K1, 2, 3		
					K1, 2, 3		
					K1, 2, 3		
					K1, 2, 3		
					K1, 2, 3		
					K1, 2, 3		
					K1, 2, 3		
					K1, 2, 3		
					K1, 2, 3		

CARBIDE	CN 1204	80°	CAST IRON
		DIAMOND	
		0° NEGATIVE	

12,70	d INSCRIBED CIRCLE
12,90	l CUTTING EDGE LENGTH
4,76	s THICKNESS



TOLERANCE CLASSES	CLASS	m	d	s
	E	± 0,025	± 0,025	± 0,025
	G	± 0,025	± 0,025	± 0,13
	H	± 0,013	± 0,013	± 0,025
	M	± 0,13	± 0,08	± 0,13
	U	± 0,20	± 0,13	± 0,13

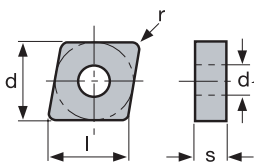
MACHINING MATERIAL	STEEL	P	TOLERANCE CLASSES	CLASS	m	d	s	MACHINING TYPES	SECONDARY USE	PRIMARY USE	CONTINUOUS CUTTING	GENERAL CUTTING	INTERRUPTED CUTTING
	STAINLESS STEEL	M											
	CAST IRON	K											
	NON-FERROUS METAL	N											
	EXOTIC ALLOY	S											
	STEEL	H											

GEOMETRY	GRADE → DESIGNATION	MACHINING MATERIAL GROUPE → Vc (M/MIN) CUTTING SPEED →	Cast iron Groupe										F (MM/REV) FEED RATE ↓	AP (MM) DEPTH OF CUT ↓
			K1,2,3	K1,2,3	K1,2,3	K1,2,3	K1,2,3	K1,2,3	K1,2,3	K1,2,3	K1,2,3	K1,2,3		
R7	CNMG 120408-R7	CNMG 120412-R7	C22-AB2	C21-I1	A22-A2	C31-J1	C22-AA2	A32-B2	C52-AD2	C42-AC2	A52-C2		0,20 - 0,40	0,8 - 6,0
													0,25 - 0,60	1,0 - 6,0
MR	CNMG 120408-MR	CNMG 120412-MR	CNMG 120416-MR										0,25 - 1,00	1,2 - 10,0
													0,25 - 1,00	1,2 - 10,0
													0,25 - 1,00	1,2 - 10,0
M	CNMG 120408-M	CNMG 120412-M	CNMG 120416-M										0,15 - 0,50	0,8 - 8,0
													0,15 - 0,50	0,8 - 8,0
													0,15 - 0,50	0,8 - 8,0
M	CNMG 120404-M												0,11 - 0,40	0,6 - 5,0

ORDER EXAMPLE: CCMT 09T304-M A31-A1

CARBIDE	CN 1204	80°	CAST IRON
		DIAMOND	
		0° NEGATIVE	

12,70	d	INSCRIBED CIRCLE
12,90	l	CUTTING EDGE LENGTH
4,76	s	THICKNESS



TOLERANCE CLASSES	CLASS	m	d	s
	E	± 0,025	± 0,025	± 0,025
	G	± 0,025	± 0,025	± 0,13
	H	± 0,013	± 0,013	± 0,025
	M	± 0,13	± 0,08	± 0,13
	U	± 0,20	± 0,13	± 0,13

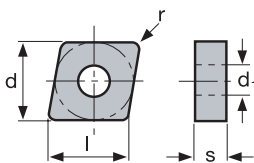
MACHINING MATERIAL	STEEL	P	○		●		○	●	○	⌚	⌚					MACHINING TYPES	○	●	CONTINUOUS CUTTING	
	STAINLESS STEEL	M			○			○	○		⌚						⌚	⌚	GENERAL CUTTING	
	CAST IRON	K	●	●	●	●	●	●	●	⌚	⌚						⌚	⌚	GENERAL CUTTING	
	NON-FERROUS METAL	N																		
	EXOTIC ALLOY	S										⌚								
	STEEL	H																		
																		⌚	⌚	INTERRUPTED CUTTING

○	●	CONTINUOUS CUTTING
⊖	⊕	GENERAL CUTTING
⊗	⊙	INTERRUPTED CUTTING

GEOMETRY ↓	DESIGNATION ↓	MACHINING MATERIAL GROUPE →										Cast iron Groupe	
		Vc (M/MIN) CUTTING SPEED →											
		GRADE →										F (MM/REV) FEED RATE ↓	AP (MM) DEPTH OF CUT ↓
	CNMA 120408	K1,2,3	K1,2,3	K1,2,3	K1,2,3	K1,2,3	K1,2,3	K1,2,3	K1,2,3	K1,2,3		0,30 - 0,70	0,8 - 5,0
	CNMA 120412	K1,2,3	K1,2,3	K1,2,3	K1,2,3	K1,2,3	K1,2,3	K1,2,3	K1,2,3	K1,2,3		0,30 - 0,70	1,2 - 5,0

CARBIDE	CN 1606	80°	CAST IRON
		DIAMOND	
		0° NEGATIVE	

15,88	d	INSCRIBED CIRCLE
16,10	l	CUTTING EDGE LENGTH
6,35	s	THICKNESS



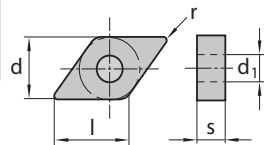
TOLERANCE CLASSES	CLASS	m	d	s
	E	± 0,025	± 0,025	± 0,025
	G	± 0,025	± 0,025	± 0,13
	H	± 0,013	± 0,013	± 0,025
	M	± 0,15	± 0,10	± 0,13
	U	± 0,27	± 0,18	± 0,13

MACHINING MATERIAL	STEEL	P	MACHINING TYPES	SECONDARY USE	PRIMARY USE	CONTINUOUS CUTTING	GENERAL CUTTING	INTERRUPTED CUTTING
	STAINLESS STEEL	M						
	CAST IRON	K						
	NON-FERROUS METAL	N						
	EXOTIC ALLOY	S						
	STEEL	H						

GEOMETRY ↓	GRADE → DESIGNATION	MACHINING MATERIAL GROUPE → Vc (M/MIN) CUTTING SPEED →	Cast iron Groupe										F (MM/REV) FEED RATE ↓	AP (MM) DEPTH OF CUT ↓
			K1,2,3	K1,2,3	K1,2,3	K1,2,3	K1,2,3	K1,2,3	K1,2,3	K1,2,3	K1,2,3	K1,2,3		
R7	CNMG 160612-R7												0,25 - 0,60	1,2 - 8,0
MR	CNMG 160612-MR		●		●								0,25 - 1,00	1,2 - 10,0
	CNMG 160616-MR		●		●								0,25 - 1,00	1,2 - 10,0

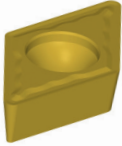
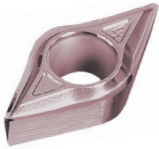
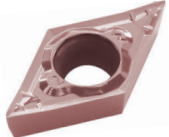
CARBIDE	DC 0702	55°	CAST IRON
		DIAMOND	
		7° POSITIVE	

6,35	d INSCRIBED CIRCLE
7,70	l CUTTING EDGE LENGTH
2,38	s THICKNESS



TOLERANCE CLASSES	CLASS	m	d	s
	E	± 0,025	± 0,025	± 0,025
	G	± 0,025	± 0,025	± 0,13
	H	± 0,013	± 0,013	± 0,025
	M	± 0,08	± 0,05	± 0,13
	U	± 0,13	± 0,08	± 0,13

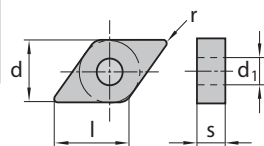
MACHINING MATERIAL	STEEL	P	TOLERANCE CLASSES	CLASS	m	d	s	SECONDARY USE	PRIMARY USE	MACHINING TYPES	CONTINUOUS CUTTING	GENERAL CUTTING	INTERRUPTED CUTTING
	STAINLESS STEEL	M											
	CAST IRON	K											
	NON-FERROUS METAL	N											
	EXOTIC ALLOY	S											
	STEEL	H											

GEOMETRY	GRADE → DESIGNATION	MACHINING MATERIAL GROUPE → Vc (M/MIN) CUTTING SPEED →	Cast iron Groupe									
			K1 2,3	K1 2,3	K1 2,3	K1 2,3	K1 2,3	K1 2,3	K1 2,3	K1 2,3	F (MM/REV) FEED RATE	AP (MM) DEPTH OF CUT
M 	DCMT 070204-M		●	●							0,15 - 0,50	0,8 - 5,0
	DCMT 070208-M		●	●							0,15 - 0,50	0,8 - 5,0
MF17 	DCGT 0702005-MF17			●		●					0,02 - 0,06	0,5 - 1,5
	DCGT 070201-MF17			●		●					0,02 - 0,06	0,5 - 1,5
	DCGT 070202-MF17			●		●					0,05 - 0,12	0,5 - 2,0
	DCGT 070204-MF17			●		●					0,08 - 0,25	0,6 - 2,5
F12 	DCGT 0702005-F12			●		●					0,02 - 0,06	0,1 - 1,5
	DCGT 070201-F12			●		●					0,02 - 0,06	0,1 - 1,5
	DCGT 070202-F12			●		●					0,05 - 0,12	0,2 - 2,0
	DCGT 070204-F12			●		●					0,08 - 0,25	0,2 - 2,5
W1 	DCGT 070202-W1			●							0,10 - 0,30	0,3 - 3,0
	DCGT 070204-W1			●							0,12 - 0,40	0,5 - 4,0
	DCGT 070208-W1			●							0,15 - 0,50	0,5 - 4,0

ORDER EXAMPLE: CCMT 09T304-M A31-A1

CARBIDE	DC 11T3	55°	CAST IRON
		DIAMOND	
		7° POSITIVE	

9,52	d	INSCRIBED CIRCLE
11,60	l	CUTTING EDGE LENGTH
3,97	s	THICKNESS



TOLERANCE CLASSES	CLASS	m	d	s
	E	± 0,025	± 0,025	± 0,025
	G	± 0,025	± 0,025	± 0,13
	H	± 0,013	± 0,013	± 0,025
	M	± 0,08	± 0,05	± 0,13
	U	± 0,13	± 0,08	± 0,13

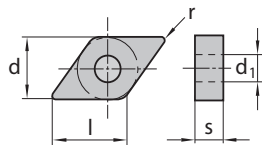
MACHINING MATERIAL	STEEL	P	TOLERANCE CLASSES	CLASS	m	d	s	SECONDARY USE	PRIMARY USE	MACHINING TYPES	CONTINUOUS CUTTING	GENERAL CUTTING	INTERRUPTED CUTTING
	STAINLESS STEEL	M											
	CAST IRON	K											
	NON-FERROUS METAL	N											
	EXOTIC ALLOY	S											
	STEEL	H											

GEOMETRY	GRADE → DESIGNATION	MACHINING MATERIAL GROUPE → Vc (M/MIN) CUTTING SPEED →	Cast iron Groupe										F (MM/REV) FEED RATE ↓	AP (MM) DEPTH OF CUT ↓
			K1,2,3	K1,2,3	K1,2,3	K1,2,3	K1,2,3	K1,2,3	K1,2,3	K1,2,3	K1,2,3	K1,2,3		
M	DCMT 11T304-M	DCMT 11T308-M	C22-AB2	C21-I1	A22-A2	C31-J1	C22-AA2	A32-B2	C52-AD2	C42-AC2	A52-C2			
													0,15 - 0,50	0,8 - 6,0
													0,15 - 0,50	0,8 - 6,0
MF7	DCMT 11T304-MF7	DCMT 11T308-MF7											0,08 - 0,25	0,4 - 3,0
													0,12 - 0,32	0,5 - 3,0
MF17	DCGT 11T301-MF17	DCGT 11T302-MF17											0,02 - 0,06	0,5 - 1,5
	DCGT 11T304-MF17	DCGT 11T308-MF17											0,05 - 0,12	0,5 - 2,0
													0,08 - 0,25	0,6 - 3,0
													0,10 - 0,30	0,8 - 3,5
F12	DCGT 11T3005-F12	DCGT 11T301-F12											0,02 - 0,06	0,1 - 1,5
	DCGT 11T302-F12	DCGT 11T304-F12											0,02 - 0,06	0,1 - 1,5
													0,05 - 0,12	0,2 - 2,0
													0,08 - 0,25	0,2 - 2,5
													0,10 - 0,30	0,3 - 3,0

ORDER EXAMPLE: CCMT 09T304-M A31-A1

CARBIDE	DC 11T3	55°	CAST IRON
		DIAMOND	
		7° POSITIVE	

9,52	d	INSCRIBED CIRCLE
11,60	l	CUTTING EDGE LENGTH
3,97	s	THICKNESS



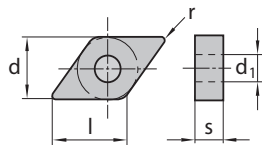
TOLERANCE CLASSES	CLASS	m	d	s
	E	± 0,025	± 0,025	± 0,025
	G	± 0,025	± 0,025	± 0,13
	H	± 0,013	± 0,013	± 0,025
	M	± 0,08	± 0,05	± 0,13
	U	± 0,13	± 0,08	± 0,13

MACHINING MATERIAL	STEEL	P	MACHINING TYPES	SECONDARY USE	PRIMARY USE	CONTINUOUS CUTTING	GENERAL CUTTING	INTERRUPTED CUTTING
	STAINLESS STEEL	M						
	CAST IRON	K						
	NON-FERROUS METAL	N						
	EXOTIC ALLOY	S						
	STEEL	H						

GEOMETRY ↓	GRADE → DESIGNATION ↓	MACHINING MATERIAL GROUPE → Vc (M/MIN) CUTTING SPEED →										Cast iron Groupe	
												F (MM/REV) FEED RATE ↓	AP (MM) DEPTH OF CUT ↓
		K1,2,3	K1,2,3	K1,2,3	K1,2,3	K1,2,3	K1,2,3	K1,2,3	K1,2,3	K1,2,3	K1,2,3		
W1 	DCGT 11T302-W1			●								0,10 - 0,30	0,3 - 3,0
	DCGT 11T304-W1			●								0,12 - 0,40	0,5 - 4,0
	DCGT 11T308-W1			●								0,15 - 0,50	0,5 - 4,0

CARBIDE	DN 1104	55°	CAST IRON
		DIAMOND	
		0° NEGATIVE	

9,52	d	INSCRIBED CIRCLE
11,60	l	CUTTING EDGE LENGTH
4,76	s	THICKNESS



TOLERANCE CLASSES	CLASS	m	d	s
	E	± 0,025	± 0,025	± 0,025
	G	± 0,025	± 0,025	± 0,13
	H	± 0,013	± 0,013	± 0,025
	M	± 0,08	± 0,05	± 0,13
	U	± 0,13	± 0,08	± 0,13

MACHINING MATERIAL	STEEL	P	MACHINING TYPES	SECONDARY USE	PRIMARY USE	CONTINUOUS CUTTING	GENERAL CUTTING	INTERRUPTED CUTTING
	STAINLESS STEEL	M						
	CAST IRON	K						
	NON-FERROUS METAL	N						
	EXOTIC ALLOY	S						
	STEEL	H						

GEOMETRY ↓	DESIGNATION ↓	GRADE → ↓	MACHINING MATERIAL GROUPE → ↓	Vc (M/MIN) CUTTING SPEED →	Cast iron Groupe	F (MM/REV) FEED RATE ↓	AP (MM) DEPTH OF CUT ↓
M	DNMG 110404-M	●	●			0,11 - 0,40	0,6 - 4,0
	DNMG 110408-M	●	●			0,11 - 0,40	0,6 - 4,0

CARBIDE

DN 1506

55°

DIAMOND

0° NEGATIVE

CAST IRON

12,70

d

INSCRIBED CIRCLE

15,50

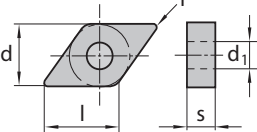
I

CUTTING EDGE LENGTH

6,35

s

THICKNESS



TOLERANCE CLASSES

CLASS	m	d	s
E	± 0,025	± 0,025	± 0,025
G	± 0,025	± 0,025	± 0,13
H	± 0,013	± 0,013	± 0,025
M	± 0,13	± 0,08	± 0,13
U	± 0,20	± 0,13	± 0,13

SECONDARY USE

PRIMARY USE

MACHINING MATERIAL

STEEL	P
STAINLESS STEEL	M
CAST IRON	K
NON-FERROUS METAL	N
EXOTIC ALLOY	S
STEEL	H

MACHINING TYPES

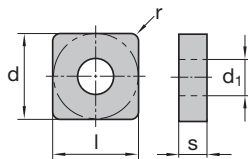
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[illegible]

ORDER EXAMPLE: CCMT 09T304-M A31-A1

CARBIDE	SC 09T3	90°	CAST IRON
		SQUARE	
		7° POSITIVE	

9,52	d	INSCRIBED CIRCLE
9,52	l	CUTTING EDGE LENGTH
3,97	s	THICKNESS



TOLERANCE CLASSES	CLASS	m	d	s
	E	± 0,025	± 0,025	± 0,025
	G	± 0,025	± 0,025	± 0,13
	H	± 0,013	± 0,013	± 0,025
	M	± 0,08	± 0,05	± 0,13
	U	± 0,13	± 0,08	± 0,13

MACHINING MATERIAL	STEEL	P	○	●	○	●	○	⊕	⊖				
	STAINLESS STEEL	M		○		○	○	⊕					
	CAST IRON	K	●	●	●	●	●	⊖	⊖				
	NON-FERROUS METAL	N											
	EXOTIC ALLOY	S						⊕					
	STEEL	H											

MACHINING TYPES

SECONDARY USE

PRIMARY USE



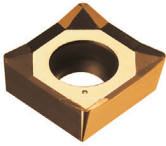
CONTINUOUS CUTTING



GENERAL CUTTING

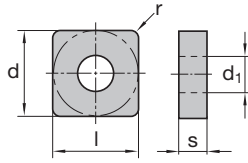


INTERRUPTED CUTTING

GEOMETRY ↓	DESIGNATION ↓	MACHINING MATERIAL GROUPE →										Cast iron Groupe	
		Vc (M/MIN) CUTTING SPEED →										F (MM/REV) FEED RATE ↓	AP (MM) DEPTH OF CUT ↓
		C22-AB2	C21-I1	A22-A2	C31-J1	C22-AA2	A32-B2	C52-AD2	C42-AC2	A52-C2			
MF17 	SCGT 09T304-MF17			●			●					0,08 - 0,25	0,6 - 4,0
	SCGT 09T308-MF17			●			●					0,10 - 0,35	0,7 - 4,0

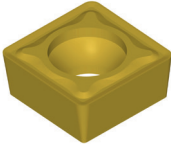
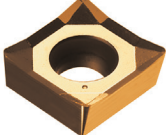
CARBIDE	SC 1204	90°	CAST IRON
		SQUARE	
		7° POSITIVE	

12,70	d	INSCRIBED CIRCLE
12,70	l	CUTTING EDGE LENGTH
4,76	s	THICKNESS



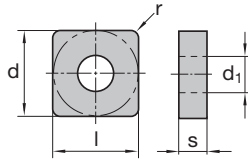
TOLERANCE CLASSES	CLASS	m	d	s
	E	± 0,025	± 0,025	± 0,025
	G	± 0,025	± 0,025	± 0,13
	H	± 0,013	± 0,013	± 0,025
	M	± 0,13	± 0,08	± 0,13
	U	± 0,20	± 0,13	± 0,13

MACHINING MATERIAL	STEEL	P	MACHINING TYPES	SECONDARY USE	PRIMARY USE	CONTINUOUS CUTTING
	STAINLESS STEEL	M				
	CAST IRON	K				
	NON-FERROUS METAL	N				
	EXOTIC ALLOY	S				
	STEEL	H				

GEOMETRY	GRADE → DESIGNATION	MACHINING MATERIAL GROUPE → Vc (M/MIN) CUTTING SPEED →	C22-AB2	C21-I1	A22-A2	C31-J1	C22-AA2	A32-B2	C52-AD2	C42-AC2	A52-C2						Cast iron Groupe	
																	F (MM/REV) FEED RATE	AP (MM) DEPTH OF CUT
M	SCMT 120408-M		●		●												0,15 - 0,50	0,8 - 8,0
																		
MF17	SCGT 120404-MF17			●			●										0,10 - 0,40	0,4 - 6,0
	SCGT 120408-MF17			●			●										0,10 - 0,40	0,4 - 6,0
	SCGT 120412-MF17			●													0,10 - 0,40	1,0 - 6,0
																		

CARBIDE	SN 1204	90°	CAST IRON
		SQUARE	
		0° NEGATIVE	

12,70	d	INSCRIBED CIRCLE
12,70	l	CUTTING EDGE LENGTH
4,76	s	THICKNESS



TOLERANCE CLASSES	CLASS	m	d	s
	E	± 0,025	± 0,025	± 0,025
	G	± 0,025	± 0,025	± 0,13
	H	± 0,013	± 0,013	± 0,025
	M	± 0,13	± 0,08	± 0,13
	U	± 0,20	± 0,13	± 0,13

MACHINING MATERIAL	STEEL	P	○	●	○	●	○	⊕	⊖								
	STAINLESS STEEL	M		○		○	○	⊕									
	CAST IRON	K	●	●	●	●	●	●	⊖	⊕							
	NON-FERROUS METAL	N															
	EXOTIC ALLOY	S							⊕								
	STEEL	H															

MACHINING TYPES

SECONDARY USE

PRIMARY USE



CONTINUOUS CUTTING



GENERAL CUTTING



INTERRUPTED CUTTING

GEOMETRY	GRADE → DESIGNATION	MACHINING MATERIAL GROUPE → Vc (M/MIN) CUTTING SPEED →										Cast iron Groupe	
		K1,2,3	K1,2,3	K1,2,3	K1,2,3	K1,2,3	K1,2,3	K1,2,3	K1,2,3	K1,2,3		F (MM/REV) FEED RATE ↓	AP (MM) DEPTH OF CUT ↓
R7	SNMG 120412-R7					●						0,25 - 0,65	1,0 - 6,0
MR	SNMG 120408-MR		●		●							0,25 - 1,00	1,2 - 10,0
	SNMG 120412-MR		●		●							0,25 - 1,00	1,2 - 10,0
M	SNMG 120408-M		●		●							0,32 - 0,60	0,80 - 7,00
	SNMG 120412-M		●		●							0,32 - 0,80	1,20 - 7,00
-	SNMA 120408		●									0,20 - 0,40	0,80 - 7,00
	SNMA 120412		●		●							0,20 - 0,50	1,20 - 7,00
	SNMA 120416		●		●							0,20 - 0,50	1,60 - 7,00

ORDER EXAMPLE: CCMT 09T304-M A31-A1

CARBIDE

SN
1506

90°

SQUARE

0° NEGATIVE

CAST IRON

12,70

d INSCRIBED CIRCLE

12,70

I CUTTING EDGE LENGTH

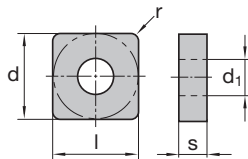
4,76

s THICKNESS

[illegible]

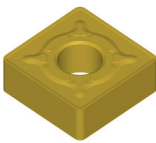
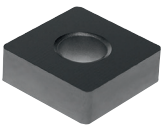
CARBIDE	SN 1906	90°	CAST IRON
		SQUARE	
		0° NEGATIVE	

19,05	d	INSCRIBED CIRCLE
19,05	l	CUTTING EDGE LENGTH
6,35	s	THICKNESS



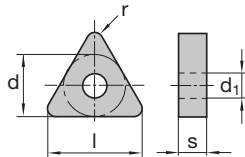
TOLERANCE CLASSES	CLASS	m	d	s
	E	± 0,025	± 0,025	± 0,025
	G	± 0,025	± 0,025	± 0,13
	H	± 0,013	± 0,013	± 0,025
	M	± 0,15	± 0,10	± 0,13
	U	± 0,27	± 0,18	± 0,13

MACHINING MATERIAL	STEEL	P	○	●	○	●	○	⊖	⊕				
	STAINLESS STEEL	M		○		○	○	⊖					
	CAST IRON	K	●	●	●	●	●	●	●				
	NON-FERROUS METAL	N											
	EXOTIC ALLOY	S							⊖				
	STEEL	H											
MACHINING TYPES													
	SECONDARY USE	PRIMARY USE											
	○	●	CONTINUOUS CUTTING										
	⊖	⊕	GENERAL CUTTING										
	⊕	⊖	INTERRUPTED CUTTING										

GEOMETRY ↓	GRADE → DESIGNATION ↓	MACHINING MATERIAL GROUPE → Vc (M/MIN) CUTTING SPEED →											Cast iron Groupe	
													F (MM/REV) FEED RATE ↓	AP (MM) DEPTH OF CUT ↓
MR 	SNMG 190612-MR		●										0,25 - 1,00	1,2 - 10,0
	SNMG 190616-MR		●	●									0,25 - 1,00	1,2 - 10,0
- 	SNMA 190616			●									0,40 - 0,90	1,60 - 10,0

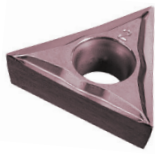
CARBIDE	TC 06T1	60°	CAST IRON
		TRIANGLE	
		7° POSITIVE	

3,97	d INSCRIBED CIRCLE
6,35	l CUTTING EDGE LENGTH
1,98	s THICKNESS



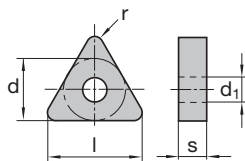
TOLERANCE CLASSES	CLASS	m	d	s
	E	± 0,025	± 0,025	± 0,025
	G	± 0,025	± 0,025	± 0,13
	H	± 0,013	± 0,013	± 0,025
	M	± 0,08	± 0,05	± 0,13
	U	± 0,13	± 0,08	± 0,13

MACHINING MATERIAL	STEEL	P	MACHINING TYPES	SECONDARY USE	PRIMARY USE	CONTINUOUS CUTTING
	STAINLESS STEEL	M				
	CAST IRON	K				
	NON-FERROUS METAL	N				
	EXOTIC ALLOY	S				
	STEEL	H				

GEOMETRY ↓	MACHINING MATERIAL GROUPE → Vc (M/MIN) CUTTING SPEED →	GRADE → DESIGNATION	Cast iron Groupe									
			K1 - Grey cast iron K2 - Ductile cast iron (Vc -20%) K3 - Malleable cast iron Pearlitic structure Vc -25%									
			F (MM/REV) FEED RATE ↓	AP (MM) DEPTH OF CUT ↓								
MF17 	TCGT 06T101-MF17										0,02 - 0,06	0,5 - 1,0
	TCGT 06T102-MF17										0,05 - 0,12	0,6 - 1,2
F12 	TCGT 06T102-F12										0,05 - 0,12	0,2 - 2,0

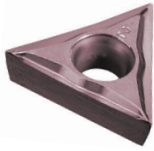
CARBIDE	TC 0902	60°	CAST IRON
		TRIANGLE	
		7° POSITIVE	

5,56	d	INSCRIBED CIRCLE
9,60	l	CUTTING EDGE LENGTH
2,38	s	THICKNESS



TOLERANCE CLASSES	CLASS	m	d	s
	E	± 0,025	± 0,025	± 0,025
	G	± 0,025	± 0,025	± 0,13
	H	± 0,013	± 0,013	± 0,025
	M	± 0,08	± 0,05	± 0,13
	U	± 0,13	± 0,08	± 0,13

MACHINING MATERIAL	STEEL	P	TOLERANCE CLASSES	CLASS	m	d	s	SECONDARY USE	PRIMARY USE	MACHINING TYPES	CONTINUOUS CUTTING	GENERAL CUTTING	INTERRUPTED CUTTING
	STAINLESS STEEL	M											
	CAST IRON	K											
	NON-FERROUS METAL	N											
	EXOTIC ALLOY	S											
	STEEL	H											

		MACHINING MATERIAL GROUPE →		Cast iron Groupe														
		K1 - Grey cast iron K2 - Ductile cast iron (Vc -20%) K3 - Malleable cast iron Pearlitic structure Vc -25%																
		Vc (M/MIN) CUTTING SPEED →																
GEOMETRY ↓		GRADE → DESIGNATION ↓		C22-AB2	C21-I1	A22-A2	C31-J1	C22-AA2	A32-B2	C52-AD2	C42-AC2	A52-C2					F (MM/REV) FEED RATE ↓	AP (MM) DEPTH OF CUT ↓
	TCGT 090202-MF17			●				●									0,05 - 0,12	0,6 - 1,6
	TCGT 090204-MF17			●				●									0,08 - 0,16	0,6 - 1,6
	TCGT 090202-F12			●				●									0,05 - 0,12	0,2 - 2,0

[illegible][illegible]

[illegible][illegible]

[illegible][illegible]

CARBIDE

TN
2204

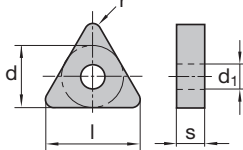
60°

TRIANGLE

0° NEGATIVE

CAST IRON

12,70	d INSCRIBED CIRCLE
22,00	I CUTTING EDGE LENGTH
4,76	S THICKNESS



TOLERANCE CLASSES	CLASS	m	d	s
	E	± 0,025	± 0,025	± 0,025
	G	± 0,025	± 0,025	± 0,13
	H	± 0,013	± 0,013	± 0,025
	M	± 0,13	± 0,08	± 0,13
	U	± 0,20	± 0,13	± 0,13

MACHINING MATERIAL	STEEL	P	○		●		○	●	○	⌚	⬤				
	STAINLESS STEEL	M			○			○	○		⌚				
	CAST IRON	K	●	●	●	●	●	●	●	⬤	⬤				
	NON-FERROUS METAL	N													
	EXOTIC ALLOY	S									⌚				
	STEEL	H													

	SECONDARY USE		PRIMARY USE	
	○	⬤	⌚	⬤
				CONTINUOUS CUTTING
				GENERAL CUTTING
				INTERRUPTED CUTTING

[illegible]

CARBIDE

VC

0702

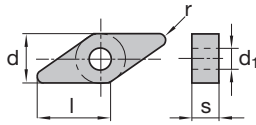
35°

DIAMOND

7° POSITIVE

CAST IRON

3,97	d INSCRIBED CIRCLE
6,85	l CUTTING EDGE LENGTH
2,38	s THICKNESS



TOLERANCE CLASSES	CLASS	m	d	s
	E	± 0,025	± 0,025	± 0,025
	G	± 0,025	± 0,025	± 0,13
	H	± 0,013	± 0,013	± 0,025
	M	± 0,08	± 0,05	± 0,13
	U	± 0,13	± 0,08	± 0,13

SECONDARY USE

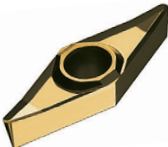
PRIMARY USE

MACHINING MATERIAL	STEEL	P	○	●	○	●	○	⊕	⊖						
	STAINLESS STEEL	M		○		○	○	⊕							
	CAST IRON	K	●	●	●	●	●	⊖	⊖						
	NON-FERROUS METAL	N													
	EXOTIC ALLOY	S						⊕							
	STEEL	H													
MACHINING TYPES			○	●											
			⊕	⊖											
			⊕	⊖											

CONTINUOUS CUTTING

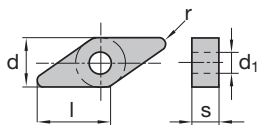
GENERAL CUTTING

INTERRUPTED CUTTING

GEOMETRY ↓	DESIGNATION ↓	MACHINING MATERIAL GROUPE →										Cast iron Groupe	
		Vc (M/MIN) CUTTING SPEED →										F (MM/REV) FEED RATE ↓	AP (MM) DEPTH OF CUT ↓
		C22-AB2	C21-I1	A22-A2	C31-J1	C22-AA2	A32-B2	C52-AD2	C42-AC2	A52-C2			
MF17 	VCGT 0702005-MF17			●			●					0,02 - 0,06	0,2 - 1,0
	VCGT 070201-MF17			●			●					0,02 - 0,06	0,2 - 1,0
	VCGT 070202-MF17			●			●					0,05 - 0,08	0,2 - 1,0
	VCGT 070204-MF17			●			●					0,08 - 0,12	0,2 - 1,0
F12 	VCGT 0702005-F12			●								0,02 - 0,06	0,1 - 1,0
	VCGT 070201-F12			●			●					0,02 - 0,06	0,1 - 1,0
	VCGT 070202-F12			●			●					0,05 - 0,08	0,2 - 1,0
	VCGT 070204-F12			●			●					0,08 - 0,12	0,2 - 1,0

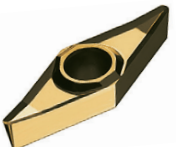
CARBIDE	VC 1103	35°	CAST IRON
		DIAMOND	
		7° POSITIVE	

6,35	d INSCRIBED CIRCLE
11,10	l CUTTING EDGE LENGTH
3,18	s THICKNESS



TOLERANCE CLASSES	CLASS	m	d	s
	E	± 0,025	± 0,025	± 0,025
	G	± 0,025	± 0,025	± 0,13
	H	± 0,013	± 0,013	± 0,025
	M	± 0,08	± 0,05	± 0,13
	U	± 0,13	± 0,08	± 0,13

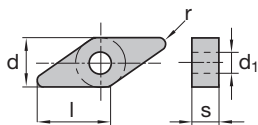
MACHINING MATERIAL	STEEL	P	MACHINING TYPES	SECONDARY USE	PRIMARY USE	CONTINUOUS CUTTING
	STAINLESS STEEL	M				
	CAST IRON	K				
	NON-FERROUS METAL	N				
	EXOTIC ALLOY	S				
	STEEL	H				

GEOMETRY ↓	GRADE → DESIGNATION ↓	MACHINING MATERIAL GROUPE → VC (M/MIN) CUTTING SPEED →										Cast iron Groupe	
												F (MM/REV) FEED RATE ↓	AP (MM) DEPTH OF CUT ↓
		K1,2,3	K1,2,3	K1,2,3	K1,2,3	K1,2,3	K1,2,3	K1,2,3	K1,2,3	K1,2,3	K1,2,3		
M10	VCMT 110308-M10											0,12 - 0,25	0,5 - 1,5
													
MF7	VCMT 110304-MF7											0,08 - 0,20	0,4 - 1,5
													
MF17	VCGT 1103005-MF17											0,02 - 0,06	0,5 - 1,5
	VCGT 110301-MF17											0,02 - 0,06	0,5 - 1,5
	VCGT 110302-MF17											0,05 - 0,12	0,5 - 2,0
	VCGT 110304-MF17											0,08 - 0,25	0,6 - 2,5
	VCGT 110308-MF17											0,10 - 0,35	0,8 - 3,0
F12	VCGT 1103005-F12											0,02 - 0,06	0,1 - 1,5
	VCGT 110301-F12											0,02 - 0,06	0,1 - 1,5
	VCGT 110302-F12											0,05 - 0,12	0,2 - 2,0
	VCGT 110304-F12											0,08 - 0,25	0,2 - 2,5

ORDER EXAMPLE: CCMT 09T304-M A31-A1

CARBIDE	VC 1103	35°	CAST IRON
		DIAMOND	
		7° POSITIVE	

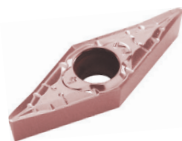
6,35	d INSCRIBED CIRCLE
11,10	l CUTTING EDGE LENGTH
3,18	s THICKNESS



TOLERANCE CLASSES	CLASS	m	d	s
	E	± 0,025	± 0,025	± 0,025
	G	± 0,025	± 0,025	± 0,13
	H	± 0,013	± 0,013	± 0,025
	M	± 0,08	± 0,05	± 0,13
	U	± 0,13	± 0,08	± 0,13

MACHINING MATERIAL	STEEL	P	MACHINING TYPES	SECONDARY USE	PRIMARY USE	CONTINUOUS CUTTING
	STAINLESS STEEL	M				
	CAST IRON	K				
	NON-FERROUS METAL	N				
	EXOTIC ALLOY	S				
	STEEL	H				

GEOMETRY ↓	DESIGNATION ↓	MACHINING MATERIAL GROUPE →										Cast iron Groupe	
		VC (M/MIN) CUTTING SPEED →										F (MM/REV) FEED RATE ↓	AP (MM) DEPTH OF CUT ↓
		C22-AB2	C21-I1	A22-A2	C31-J1	C22-AA2	A32-B2	C52-AD2	C42-AC2	A52-C2			
W1	VCGT 110302-W1			●								0,10 - 0,30	0,3 - 3,0
	VCGT 110304-W1			●								0,12 - 0,40	0,5 - 4,0



[illegible][illegible]

CARBIDE

VC

1604

35°

DIAMOND

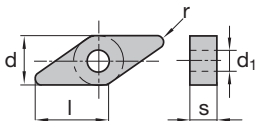
7° POSITIVE

CAST IRON

9,52d INSCRIBED CIRCLE

16,60l CUTTING EDGE LENGTH

4,76s THICKNESS



TOLERANCE CLASSES

CLASS	m	d	s
E	± 0,025	± 0,025	± 0,025
G	± 0,025	± 0,025	± 0,13
H	± 0,013	± 0,013	± 0,025
M	± 0,08	± 0,05	± 0,13
U	± 0,13	± 0,08	± 0,13

MACHINING MATERIAL

STEEL	P
STAINLESS STEEL	M
CAST IRON	K
NON-FERROUS METAL	N
EXOTIC ALLOY	S
STEEL	H

○	●	○	●	○	⌚	⌚				
		○		○	○	⌚				
●	●	●	●	●	●	⌚	⌚			
						⌚				

MACHINING TYPES

SECONDARY USE

PRIMARY USE

○

⌚

⌚

●

⌚

⌚

CONTINUOUS CUTTING

GENERAL CUTTING

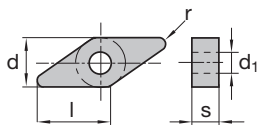
INTERRUPTED CUTTING

[illegible]

ORDER EXAMPLE: CCMT 09T304-M A31-A1

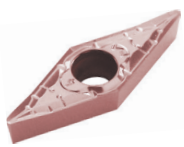
CARBIDE	VC 1604	35°	CAST IRON
		DIAMOND	
		7° POSITIVE	

9,52	d	INSCRIBED CIRCLE
16,60	l	CUTTING EDGE LENGTH
4,76	s	THICKNESS



TOLERANCE CLASSES	CLASS	m	d	s
	E	± 0,025	± 0,025	± 0,025
	G	± 0,025	± 0,025	± 0,13
	H	± 0,013	± 0,013	± 0,025
	M	± 0,08	± 0,05	± 0,13
	U	± 0,13	± 0,08	± 0,13

MACHINING MATERIAL	STEEL	P	MACHINING TYPES	SECONDARY USE	PRIMARY USE	CONTINUOUS CUTTING
	STAINLESS STEEL	M				
	CAST IRON	K				
	NON-FERROUS METAL	N				
	EXOTIC ALLOY	S				
	STEEL	H				

GEOMETRY ↓	DESIGNATION ↓	GRADE → ↓	MACHINING MATERIAL GROUPE → ↓	VC (M/MIN) CUTTING SPEED → ↓	Cast iron Groupe	F (MM/REV) FEED RATE ↓	AP (MM) DEPTH OF CUT ↓
W1 	VCGT 160404-W1				K1, 2, 3	0,12 - 0,40	0,5 - 4,0
	VCGT 160408-W1				K1, 2, 3	0,15 - 0,50	0,7 - 4,0
					K1, 2, 3		

CARBIDE

VC
2205

35°

DIAMOND

7° POSITIVE

CAST IRON

12,70

d

INSCRIBED CIRCLE

22,10

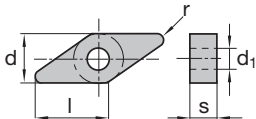
I

CUTTING EDGE LENGTH

5,56

s

THICKNESS



TOLERANCE CLASSES

CLASS	m	d	s
E	± 0,025	± 0,025	± 0,025
G	± 0,025	± 0,025	± 0,13
H	± 0,013	± 0,013	± 0,025
M	± 0,13	± 0,08	± 0,13
U	± 0,20	± 0,13	± 0,13

STEEL

P

STAINLESS STEEL

M

CAST IRON

K

NON-FERROUS METAL

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EXOTIC ALLOY

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[illegible]

CARBIDE

WC
0201

80°

TRIGON

7° POSITIVE

CAST IRON

3,97

d INSCRIBED CIRCLE

2,70

l CUTTING EDGE LENGTH

1,59

s THICKNESS

d

r

l

s

d₁

TOLERANCE CLASSES

CLASS	m	d	s
E	± 0,025	± 0,025	± 0,025
G	± 0,025	± 0,025	± 0,13
H	± 0,013	± 0,013	± 0,025
M	± 0,08	± 0,05	± 0,13
U	± 0,13	± 0,08	± 0,13

SECONDARY USE

PRIMARY USE

CONTINUOUS CUTTING

GENERAL CUTTING

INTERRUPTED CUTTING

MACHINING MATERIAL

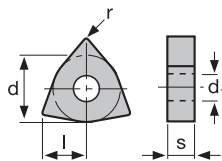
STEEL	P	
STAINLESS STEEL	M	
CAST IRON	K	
NON-FERROUS METAL	N	
EXOTIC ALLOY	S	
STEEL	H	

MACHINING TYPES

[illegible]

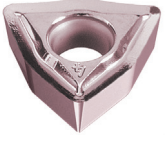
CARBIDE	WC 0402	80°	CAST IRON
		TRIGON	
		7° POSITIVE	

6,35	d INSCRIBED CIRCLE
4,30	l CUTTING EDGE LENGTH
2,38	s THICKNESS



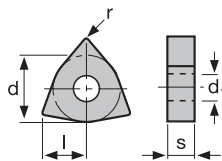
TOLERANCE CLASSES	CLASS	m	d	s
	E	± 0,025	± 0,025	± 0,025
	G	± 0,025	± 0,025	± 0,13
	H	± 0,013	± 0,013	± 0,025
	M	± 0,08	± 0,05	± 0,13
	U	± 0,13	± 0,08	± 0,13

MACHINING MATERIAL	STEEL	P	MACHINING TYPES	SECONDARY USE	PRIMARY USE	CONTINUOUS CUTTING
	STAINLESS STEEL	M				
	CAST IRON	K				
	NON-FERROUS METAL	N				
	EXOTIC ALLOY	S				
	STEEL	H				

GEOMETRY ↓	DESIGNATION ↓	MACHINING MATERIAL GROUPE → Vc (M/MIN) CUTTING SPEED →										Cast iron Groupe	
		GRADE →										F (MM/REV) FEED RATE ↓	AP (MM) DEPTH OF CUT ↓
		C22-AB2	C21-I1	A22-A2	C31-J1	C22-AA2	A32-B2	C52-AD2	C42-AC2	A52-C2			
MF17 	WCGT 040202-MF17						●					0,05 - 0,12	0,5 - 2,0
	WCGT 040204-MF17			●								0,08 - 0,25	0,6 - 2,5
F12 	WCGT 040202-F12			●			●					0,05 - 0,12	0,2 - 2,0
	WCGT 040204-F12			●								0,08 - 0,25	0,2 - 2,5

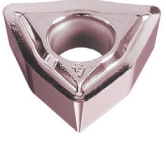
CARBIDE	WC 06T3	80°	CAST IRON
		TRIGON	
		7° POSITIVE	

9,52	d	INSCRIBED CIRCLE
6,50	l	CUTTING EDGE LENGTH
3,97	s	THICKNESS



TOLERANCE CLASSES	CLASS	m	d	s
	E	± 0,025	± 0,025	± 0,025
	G	± 0,025	± 0,025	± 0,13
	H	± 0,013	± 0,013	± 0,025
	M	± 0,08	± 0,05	± 0,13
	U	± 0,13	± 0,08	± 0,13

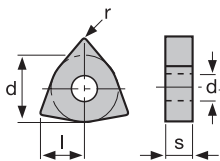
MACHINING MATERIAL	STEEL	P	○	●	○	●	○	⊕	⊖				
	STAINLESS STEEL	M		○		○	○	⊕					
	CAST IRON	K	●	●	●	●	●	⊖	⊖				
	NON-FERROUS METAL	N											
	EXOTIC ALLOY	S						⊕					
	STEEL	H											
MACHINING TYPES													
	SECONDARY USE	PRIMARY USE											
	○	●	CONTINUOUS CUTTING										
	⊕	⊖	GENERAL CUTTING										
	⊕⊖	⊖⊕	INTERRUPTED CUTTING										

GEOMETRY ↓	DESIGNATION ↓	MACHINING MATERIAL GROUPE → Vc (M/MIN) CUTTING SPEED →										Cast iron Groupe	
												F (MM/REV) FEED RATE ↓	AP (MM) DEPTH OF CUT ↓
		C22-AB2	C21-I1	A22-A2	C31-J1	C22-AA2	A32-B2	C52-AD2	C42-AC2	A52-C2			
MF17 	WCGT 06T302-MF17			●			●					0,05 - 0,12	0,6 - 2,0
	WCGT 06T304-MF17			●			●					0,08 - 0,25	0,6 - 3,0
F12 	WCGT 06T304-F12			●			●					0,08 - 0,25	0,2 - 2,5

[illegible][illegible]

CARBIDE	WN 0804	80°	CAST IRON
		TRIGON	
		0° NEGATIVE	

12,70	d INSCRIBED CIRCLE
8,60	l CUTTING EDGE LENGTH
4,76	s THICKNESS



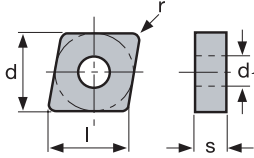
TOLERANCE CLASSES	CLASS	m	d	s
	E	± 0,025	± 0,025	± 0,025
	G	± 0,025	± 0,025	± 0,13
	H	± 0,013	± 0,013	± 0,025
	M	± 0,13	± 0,08	± 0,13
	U	± 0,20	± 0,13	± 0,13

MACHINING MATERIAL	STEEL	P	TOLERANCE CLASSES	CLASS	m	d	s	MACHINING TYPES	SECONDARY USE	PRIMARY USE	CONTINUOUS CUTTING	GENERAL CUTTING	INTERRUPTED CUTTING
	STAINLESS STEEL	M											
	CAST IRON	K											
	NON-FERROUS METAL	N											
	EXOTIC ALLOY	S											
	STEEL	H											

GEOMETRY	GRADE → DESIGNATION	MACHINING MATERIAL GROUPE → Vc (M/MIN) CUTTING SPEED →	Cast iron Groupe										F (MM/REV) FEED RATE ↓	AP (MM) DEPTH OF CUT ↓
			K1,2,3	K1,2,3	K1,2,3	K1,2,3	K1,2,3	K1,2,3	K1,2,3	K1,2,3	K1,2,3	K1,2,3		
R7	WNMG 080408-R7	WNMG 080412-R7	C22-AB2	C21-I1	A22-A2	C31-J1	C22-AA2	A32-B2	C52-AD2	C42-AC2	A52-C2			
			●										0,20 - 0,40	0,8 - 6,0
MR	WNMG 080408-MR	WNMG 080412-MR		●	●								0,25 - 1,00	0,8 - 5,5
				●	●								0,25 - 1,00	1,2 - 6,0
M	WNMG 080404-M	WNMG 080408-M		●	●								0,10 - 0,25	0,4 - 5,5
				●	●								0,15 - 0,40	0,8 - 5,5
-	WNMA 080408	WNMA 080412		●	●								0,30 - 0,60	0,8 - 5,0
				●	●								0,30 - 0,60	1,2 - 5,0

CARBIDE	CC 0602	80°	NON-FERROUS METALS
		DIAMOND	
		7° POSITIVE	

6,35	d INSCRIBED CIRCLE
6,40	l CUTTING EDGE LENGTH
2,38	s THICKNESS



TOLERANCE CLASSES	CLASS	m	d	s
	E	± 0,025	± 0,025	± 0,025
	G	± 0,025	± 0,025	± 0,13
	H	± 0,013	± 0,013	± 0,025
	M	± 0,08	± 0,05	± 0,13
	U	± 0,13	± 0,08	± 0,13

MACHINING TYPES	SECONDARY USE		PRIMARY USE	CONTINUOUS CUTTING

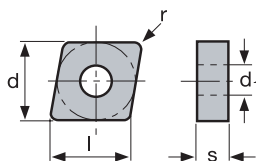
MACHINING MATERIAL	STEEL	P																
	STAINLESS STEEL	M																
	CAST IRON	K																
	NON-FERROUS METAL	N																
	EXOTIC ALLOY	S																
	STEEL	H																

GEOMETRY ↓	GRADE → DESIGNATION ↓	MACHINING MATERIAL GROUPE → Vc (M/MIN) CUTTING SPEED →												Non-ferrous materials Groupe	
														F (MM/REV) FEED RATE ↓	AP (MM) DEPTH OF CUT ↓
		D1,2	D1,2,3	D1,2	D1	D1,2,3	D1,2	D1	D1	D1,2,3	D1,2,3	D1			
MR 	CCGT 060202-MR			●			●							0,15 - 0,65	1,0 - 8,0
	CCGT 060204-MR			●			●							0,15 - 0,65	1,0 - 8,0
MF10 	CCGT 060201-MF10									●				0,02 - 0,06	0,1 - 0,5
	CCGT 060202-MF10									●				0,04 - 0,10	0,1 - 0,6
	CCGT 060204-MF10									●				0,06 - 0,12	0,2 - 0,6
MF15 	CCGT 0602005-MF15	●								●				0,02 - 0,06	0,1 - 0,5
	CCGT 060201-MF15	●								●				0,02 - 0,06	0,1 - 0,5
	CCGT 060202-MF15	●								●				0,04 - 0,10	0,1 - 0,6
	CCGT 060204-MF15	●								●				0,06 - 0,12	0,2 - 0,6
MF17 	CCGT 0602005-MF17			●	●		●	●		●	●			0,02 - 0,06	0,5 - 1,5
	CCGT 060201-MF17			●	●		●	●		●	●			0,02 - 0,06	0,5 - 1,5
	CCGT 060202-MF17			●	●		●	●		●	●			0,05 - 0,12	0,5 - 2,0
	CCGT 060204-MF17			●	●		●	●		●	●			0,08 - 0,25	0,6 - 3,0

ORDER EXAMPLE: CCMT 09T304-M A31-A1

CARBIDE	CC 0602	80°	NON-FERROUS METALS
		DIAMOND	
		7° POSITIVE	

6,35	d INSCRIBED CIRCLE
6,40	l CUTTING EDGE LENGTH
2,38	s THICKNESS



TOLERANCE CLASSES	CLASS	m	d	s
	E	± 0,025	± 0,025	± 0,025
	G	± 0,025	± 0,025	± 0,13
	H	± 0,013	± 0,013	± 0,025
	M	± 0,08	± 0,05	± 0,13
	U	± 0,13	± 0,08	± 0,13

MACHINING MATERIAL	STEEL	P																		
	STAINLESS STEEL	M																		
	CAST IRON	K																		
	NON-FERROUS METAL	N	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●
	EXOTIC ALLOY	S																		
	STEEL	H																		

MACHINING TYPES

SECONDARY USE

PRIMARY USE



CONTINUOUS CUTTING



GENERAL CUTTING



INTERRUPTED CUTTING

GEOMETRY	GRADE → DESIGNATION	MACHINING MATERIAL GROUPE → Vc (M/MIN) CUTTING SPEED →												Non-ferrous materials Groupe	
		D1,2	D1,2,3	D1,2	D1	D1,2,3	D1,2	D1	D1	D1,2,3	D1,2,3	D1		F (MM/REV) FEED RATE	AP (MM) DEPTH OF CUT
F11	CCGT 060201-F11										●	●		0,02 - 0,06	0,1 - 1,5
	CCGT 060202-F11										●	●		0,05 - 0,12	0,2 - 2,0
	CCGT 060204-F11											●		0,08 - 0,25	0,2 - 2,5
F12	CCGT 0602005-F12				●	●		●			●			0,02 - 0,06	0,1 - 1,5
	CCGT 060201-F12				●	●		●			●			0,02 - 0,06	0,1 - 1,5
	CCGT 060202-F12				●	●		●			●	●		0,05 - 0,12	0,2 - 2,0
	CCGT 060204-F12				●	●		●			●			0,08 - 0,25	0,2 - 2,5
W1	CCGT 060202-W1				●	●								0,10 - 0,30	0,3 - 3,0
	CCGT 060204-W1				●	●								0,12 - 0,40	0,5 - 4,0
	CCGT 060208-W1				●	●								0,15 - 0,50	0,7 - 4,0

[illegible][illegible]

ORDER EXAMPLE: CCMT 09T304-M A31-A1

CARBIDE

CC
09T3

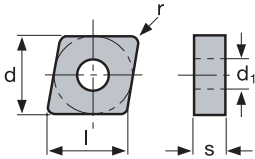
80°

DIAMOND

7° POSITIVE

NON-FERROUS METALS

9,52	d	INSCRIBED CIRCLE
9,70	l	CUTTING EDGE LENGTH
3,97	s	THICKNESS

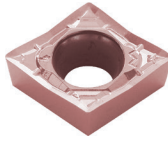


TOLERANCE CLASSES	CLASS	m	d	s
	E	± 0,025	± 0,025	± 0,025
	G	± 0,025	± 0,025	± 0,13
	H	± 0,013	± 0,013	± 0,025
	M	± 0,08	± 0,05	± 0,13
	U	± 0,13	± 0,08	± 0,13

SECONDARY USE

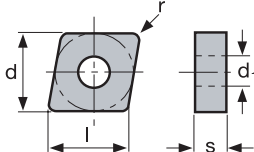
PRIMARY USE

MACHINING MATERIAL	MACHINING TYPES															
	STEEL		P													
	STAINLESS STEEL		M													
	CAST IRON		K													
	NON-FERROUS METAL		N													
	EXOTIC ALLOY		S													
STEEL		H														

		MACHINING MATERIAL GROUPE →														Non-ferrous materials Groupe		
		Vc (M/MIN) CUTTING SPEED →														D1 - Aluminium alloys (heat treated Vc -40%) D2 - Copper alloys (Vc -70%) D3 - Non-metallic materials (Vc -90%)		
GEOMETRY ↓		GRADE → DESIGNATION ↓		D1,2	D1,2,3	D1,2	D1	D1,2,3	D1,2	D1	D1	D1,2,3	D1,2,3	D1			F (MM/REV) FEED RATE ↓	AP (MM) DEPTH OF CUT ↓
F11 	CCGT 09T302-F11												●	●			0,05 - 0,12	0,2 - 2,0
	CCGT 09T304-F11												●	●			0,08 - 0,25	0,2 - 2,5
F12 	CCGT 09T3005-F12				●	●		●	●			●					0,02 - 0,06	0,1 - 1,5
	CCGT 09T301-F12				●	●		●				●					0,02 - 0,06	0,1 - 1,5
	CCGT 09T302-F12				●	●		●				●					0,05 - 0,12	0,2 - 2,0
	CCGT 09T304-F12				●	●		●				●					0,08 - 0,25	0,2 - 2,5
	CCGT 09T308-F12				●	●		●				●					0,10 - 0,30	0,3 - 3,0
W1 	CCGT 09T302-W1				●	●											0,10 - 0,30	0,3 - 3,0
	CCGT 09T304-W1				●	●											0,12 - 0,40	0,5 - 4,0
	CCGT 09T308-W1				●	●											0,15 - 0,50	0,7 - 4,0

CARBIDE	CC 1204	80°	NON-FERROUS METALS
		DIAMOND	
		7° POSITIVE	

12,70	d INSCRIBED CIRCLE
12,90	l CUTTING EDGE LENGTH
4,76	s THICKNESS



TOLERANCE CLASSES	CLASS	m	d	s
	E	± 0,025	± 0,025	± 0,025
	G	± 0,025	± 0,025	± 0,13
	H	± 0,013	± 0,013	± 0,025
	M	± 0,13	± 0,08	± 0,13
	U	± 0,20	± 0,13	± 0,13

MACHINING MATERIAL	STEEL	P												
	STAINLESS STEEL	M												
	CAST IRON	K												
	NON-FERROUS METAL	N												
	EXOTIC ALLOY	S												
	STEEL	H												

MACHINING TYPES

SECONDARY USE

PRIMARY USE



CONTINUOUS CUTTING



GENERAL CUTTING



INTERRUPTED CUTTING

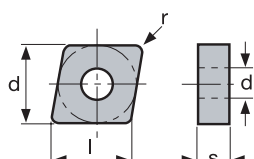
GEOMETRY	GRADE → DESIGNATION	MACHINING MATERIAL GROUPE → Vc (M/MIN) CUTTING SPEED →												Non-ferrous materials Groupe	
		D1,2	D1,2,3	D1,2	D1	D1,2,3	D1,2	D1	D1	D1,2,3	D1,2,3	D1		F (MM/REV) FEED RATE	AP (MM) DEPTH OF CUT
MR	CCGT 120404-MR			●			●							0,15 - 0,65	1,0 - 8,0
	CCGT 120408-MR			●			●							0,15 - 0,65	1,0 - 8,0
MF17	CCGT 120401-MF17				●	●		●	●		●	●		0,05 - 0,12	0,5 - 2,0
	CCGT 120402-MF17				●	●		●	●		●	●		0,05 - 0,12	0,5 - 2,0
	CCGT 120404-MF17				●	●		●	●		●	●		0,08 - 0,25	0,6 - 5,0
	CCGT 120408-MF17				●	●		●	●		●	●		0,10 - 0,35	0,8 - 5,0
W1	CCGT 120404-W1				●	●								0,12 - 0,40	0,5 - 4,0
	CCGT 120408-W1				●	●								0,15 - 0,50	0,7 - 4,0

CARBIDE
CN
1204

80°
DIAMOND
0° NEGATIVE

NON-FERROUS METALS

12,70	d	INSCRIBED CIRCLE
12,90	l	CUTTING EDGE LENGTH
4,76	s	THICKNESS



TOLERANCE CLASSES

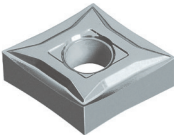
CLASS	m	d	s
E	± 0,025	± 0,025	± 0,025
G	± 0,025	± 0,025	± 0,13
H	± 0,013	± 0,013	± 0,025
M	± 0,13	± 0,08	± 0,13
U	± 0,20	± 0,13	± 0,13

MACHINING MATERIAL

STEEL	P
STAINLESS STEEL	M
CAST IRON	K
NON-FERROUS METAL	N
EXOTIC ALLOY	S
STEEL	H

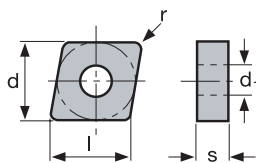
MACHINING TYPES

SECONDARY USE	PRIMARY USE

GEOMETRY ↓	DESIGNATION ↓	MACHINING MATERIAL GROUPE →											Non-ferrous materials Groupe					
		Vc (M/MIN) CUTTING SPEED →											D1 - Aluminium alloys (heat treated Vc -40%) D2 - Copper alloys (Vc -70%) D3 - Non-metallic materials (Vc -90%)					
		GRADE →												F (MM/REV) FEED RATE ↓		AP (MM) DEPTH OF CUT ↓		
		D22-AE2	D22-AL2	D21-K1	D22-AF2	D22-AK2	D21-P1	D42-AG2	D42-AH2	D42-AM2	D42-AN2	D42-AI2						
	CNGP 120402-F14									●						0,05 - 0,25	0,03 - 0,3	
	CNGP 120404-F14									●						0,05 - 0,25	0,05 - 3,5	
	CNGP 120408-F14									●						0,05 - 0,25	0,05 - 4,0	

CARBIDE	CN 1606	80°	NON-FERROUS METALS
		DIAMOND	
		0° NEGATIVE	

15,88	d	INSCRIBED CIRCLE
16,10	l	CUTTING EDGE LENGTH
6,35	s	THICKNESS



TOLERANCE CLASSES	CLASS	m	d	s
	E	± 0,025	± 0,025	± 0,025
	G	± 0,025	± 0,025	± 0,13
	H	± 0,013	± 0,013	± 0,025
	M	± 0,15	± 0,10	± 0,13
	U	± 0,27	± 0,18	± 0,13

MACHINING MATERIAL	STEEL	P																
	STAINLESS STEEL	M																
	CAST IRON	K																
	NON-FERROUS METAL	N	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●
	EXOTIC ALLOY	S																
	STEEL	H																

MACHINING TYPES

SECONDARY USE

PRIMARY USE



CONTINUOUS CUTTING



GENERAL CUTTING



INTERRUPTED CUTTING

GEOMETRY ↓	DESIGNATION ↓	MACHINING MATERIAL GROUPE → Vc (M/MIN) CUTTING SPEED →											Non-ferrous materials Groupe D1 - Aluminium alloys (heat treated Vc -40%) D2 - Copper alloys (Vc -70%) D3 - Non-metallic materials (Vc -90%)			
		D22-AE2	D22-AL2	D21-K1	D22-AF2	D22-AK2	D21-P1	D42-AG2	D42-AH2	D42-AM2	D42-AN2	D42-AI2			F (MM/REV) FEED RATE ↓	AP (MM) DEPTH OF CUT ↓
MF17	CNGM 160612-MF17							●			●	●			0,10 - 0,35	0,8 - 6,0
																



[illegible][illegible]

CARBIDE
DC
0702

55°
DIAMOND
7° POSITIVE

NON-FERROUS METALS

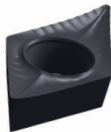
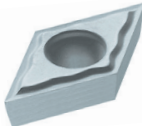
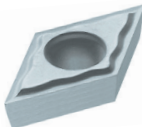
6,35	d	INSCRIBED CIRCLE
7,70	l	CUTTING EDGE LENGTH
2,38	s	THICKNESS

TOLERANCE CLASSES	CLASS	m	d	s
	E	± 0,025	± 0,025	± 0,025
	G	± 0,025	± 0,025	± 0,13
	H	± 0,013	± 0,013	± 0,025
	M	± 0,08	± 0,05	± 0,13
	U	± 0,13	± 0,08	± 0,13

SECONDARY USE
○

PRIMARY USE
●

MACHINING MATERIAL	MACHINING MATERIAL		MACHINING TYPES												
	STEEL	P													
STAINLESS STEEL	M														
CAST IRON	K														
NON-FERROUS METAL	N														
EXOTIC ALLOY	S														
STEEL	H														

		MACHINING MATERIAL GROUPE →												Non-ferrous materials Groupe			
		Vc (M/MIN) CUTTING SPEED →															
GRADE →		DESIGNATION →												F (MM/REV) FEED RATE		AP (MM) DEPTH OF CUT	
GEOMETRY ↓		D22-AE2	D22-AL2	D21-K1	D22-AF2	D22-AK2	D21-P1	D42-AG2	D42-AH2	D42-AM2	D42-AN2	D42-AI2			↓	↓	
MR	DCGT 070202-MR			●			●								0,15 - 0,65	1,0 - 8,0	
	DCGT 070204-MR			●			●								0,15 - 0,65	1,0 - 8,0	
																	
MF10	DCGT 0702005-MF10									●					0,02 - 0,06	0,1 - 0,5	
	DCGT 0702008-MF10									●					0,02 - 0,06	0,1 - 0,5	
	DCGT 0702015-MF10									●					0,02 - 0,06	0,1 - 0,5	
	DCGT 070201-MF10									●					0,02 - 0,06	0,1 - 0,5	
	DCGT 070202-MF10									●					0,04 - 0,10	0,1 - 0,6	
	DCGT 070204-MF10									●					0,06 - 0,18	0,3 - 2,0	
																	
MF15	DCGT 0702005-MF15		●							●					0,02 - 0,06	0,1 - 0,5	
	DCGT 0702008-MF15		●							●					0,02 - 0,06	0,1 - 0,5	
	DCGT 0702015-MF15		●							●					0,02 - 0,06	0,1 - 0,5	
	DCGT 070201-MF15		●							●					0,02 - 0,06	0,1 - 0,5	
	DCGT 070202-MF15		●							●					0,04 - 0,10	0,1 - 0,6	
	DCGT 070204-MF15		●							●					0,06 - 0,18	0,3 - 2,0	
																	
MF17	DCGT 0702005-MF17				●	●		●	●		●				0,02 - 0,06	0,5 - 1,5	
	DCGT 070201-MF17				●	●		●	●		●	●			0,02 - 0,06	0,5 - 1,5	
	DCGT 070202-MF17				●	●		●	●		●	●			0,05 - 0,12	0,5 - 2,0	
	DCGT 070204-MF17				●	●		●	●		●	●			0,08 - 0,25	0,6 - 2,5	
																	

ORDER EXAMPLE: CCMT 09T304-M A31-A1

CARBIDE

DC
0702

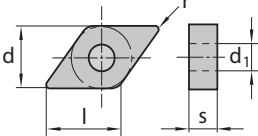
55°

DIAMOND

7° POSITIVE

NON-FERROUS METALS

6,35	d	INSCRIBED CIRCLE
7,70	l	CUTTING EDGE LENGTH
2,38	s	THICKNESS



TOLERANCE CLASSES	CLASS	m	d	s
	E	± 0,025	± 0,025	± 0,025
	G	± 0,025	± 0,025	± 0,13
	H	± 0,013	± 0,013	± 0,025
	M	± 0,08	± 0,05	± 0,13
	U	± 0,13	± 0,08	± 0,13

SECONDARY USE

PRIMARY USE

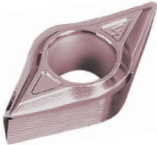
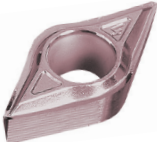
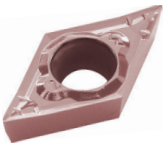
MACHINING MATERIAL	STEEL	P															
	STAINLESS STEEL	M															
	CAST IRON	K															
	NON-FERROUS METAL	N															
	EXOTIC ALLOY	S															
	STEEL	H															

MACHINING TYPES

CONTINUOUS CUTTING

GENERAL CUTTING

INTERRUPTED CUTTING

		MACHINING MATERIAL GROUPE →												Non-ferrous materials Groupe D1 - Aluminium alloys (heat treated Vc - 40%) D2 - Copper alloys (Vc - 70%) D3 - Non-metallic materials (Vc - 90%)				
		Vc (M/MIN) CUTTING SPEED →																
GEOMETRY ↓		GRADE → DESIGNATION ↓		D22-AE2	D22-AL2	D21-K1	D22-AF2	D22-AK2	D21-P1	D42-AG2	D42-AH2	D42-AM2	D42-AN2	D42-AI2			F (MM/REV) FEED RATE ↓	AP (MM) DEPTH OF CUT ↓
F11 	DCGT 0702008-F11											●					0,05 - 0,12	0,2 - 2,0
	DCGT 0702015-F11											●					0,05 - 0,12	0,2 - 2,0
	DCGT 070201-F11												●				0,02 - 0,06	0,1 - 1,5
	DCGT 070202-F11											●	●				0,05 - 0,12	0,2 - 2,0
	DCGT 070204-F11											●	●				0,08 - 0,25	0,2 - 2,5
F12 	DCGT 0702005-F12												●				0,02 - 0,06	0,1 - 1,5
	DCGT 0702008-F12											●					0,02 - 0,06	0,1 - 1,5
	DCGT 0702015-F12											●					0,05 - 0,12	0,2 - 2,0
	DCGT 070201-F12												●				0,02 - 0,06	0,1 - 1,5
	DCGT 070202-F12												●	●			0,05 - 0,12	0,2 - 2,0
	DCGT 070204-F12												●	●			0,08 - 0,25	0,2 - 2,5
W1 	DCGT 070202-W1				●	●											0,10 - 0,30	0,3 - 3,0
	DCGT 070204-W1				●	●											0,12 - 0,40	0,5 - 4,0
	DCGT 070208-W1				●	●											0,15 - 0,50	0,5 - 4,0

CARBIDE

DC 11T3

55°

DIAMOND

7° POSITIVE

NON-FERROUS METALS

9,52	d INSCRIBED CIRCLE
11,60	l CUTTING EDGE LENGTH
3,97	s THICKNESS

The diagram shows a diamond tool with a 55-degree cutting angle. The tool's cutting edge length is labeled 'l', its thickness is 's', and the chip thickness being removed is 'd1'. The workpiece has an inscribed circle diameter 'd'.

TOLERANCE CLASSES	CLASS	m	d	s
	E	± 0,025	± 0,025	± 0,025
	G	± 0,025	± 0,025	± 0,13
	H	± 0,013	± 0,013	± 0,025
	M	± 0,08	± 0,05	± 0,13
	U	± 0,13	± 0,08	± 0,13

SECONDARY USE

PRIMARY USE

CONTINUOUS CUTTING

GENERAL CUTTING

INTERRUPTED CUTTING

MACHINING MATERIAL	STEEL	P											
	STAINLESS STEEL	M											
	CAST IRON	K											
	NON-FERROUS METAL	N											
	EXOTIC ALLOY	S											
	STEEL	H											

MACHINING TYPES

[illegible]

ORDER EXAMPLE: CCMT 09T304-M A31-A1

CARBIDE
DC
11T3

55°
DIAMOND
7° POSITIVE

NON-FERROUS METALS

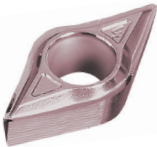
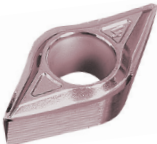
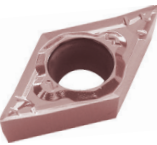
9,52	d	INSCRIBED CIRCLE
11,60	I	CUTTING EDGE LENGTH
3,97	s	THICKNESS

TOLERANCE CLASSES	CLASS	m	d	s
	E	± 0,025	± 0,025	± 0,025
	G	± 0,025	± 0,025	± 0,13
	H	± 0,013	± 0,013	± 0,025
	M	± 0,08	± 0,05	± 0,13
	U	± 0,13	± 0,08	± 0,13

SECONDARY USE
○

PRIMARY USE
●

MACHINING MATERIAL			MACHINING TYPES															
	STEEL	P	○				●				○				●			
STAINLESS STEEL		M																
CAST IRON		K																
NON-FERROUS METAL		N	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●
EXOTIC ALLOY		S																
STEEL		H																

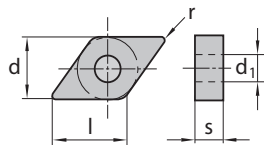
		MACHINING MATERIAL GROUPE →												Non-ferrous materials Groupe D1 - Aluminium alloys (heat treated Vc -40%) D2 - Copper alloys (Vc -70%) D3 - Non-metallic materials (Vc -90%)			
		D1,2	D1,2,3	D1,2	D1	D1,2,3	D1,2	D1	D1	D1,2,3	D1,2,3	D1					
		Vc (M/MIN) CUTTING SPEED →															
GEOMETRY ↓		GRADE → DESIGNATION ↓												F (MM/REV) FEED RATE ↓		AP (MM) DEPTH OF CUT ↓	
F11 	DCGT 11T3008-F11											●				0,05 - 0,12	0,2 - 2,0
	DCGT 11T3015-F11											●				0,05 - 0,12	0,2 - 2,0
	DCGT 11T301-F11												●			0,02 - 0,06	0,1 - 1,5
	DCGT 11T302-F11											●	●			0,05 - 0,12	0,2 - 2,0
	DCGT 11T304-F11											●	●			0,08 - 0,25	0,2 - 2,5
	DCGT 11T308-F11												●			0,10 - 0,30	0,3 - 3,0
F12 	DCGT 11T3005-F12				●	●		●				●				0,02 - 0,06	0,1 - 1,5
	DCGT 11T3015-F12					●						●				0,05 - 0,12	0,2 - 2,0
	DCGT 11T301-F12				●	●		●				●				0,02 - 0,06	0,1 - 1,5
	DCGT 11T302-F12				●	●		●	●			●				0,05 - 0,12	0,2 - 2,0
	DCGT 11T304-F12				●	●		●	●			●				0,08 - 0,25	0,2 - 2,5
	DCGT 11T308-F12				●	●		●				●				0,10 - 0,30	0,3 - 3,0
W1 	DCGT 11T302-W1				●	●										0,10 - 0,30	0,3 - 3,0
	DCGT 11T304-W1				●	●										0,12 - 0,40	0,5 - 4,0
	DCGT 11T308-W1				●	●										0,15 - 0,50	0,5 - 4,0

CARBIDE
DN 1104

55°
DIAMOND
0° NEGATIVE

NON-FERROUS METALS

9,52	d	INSCRIBED CIRCLE
11,60	l	CUTTING EDGE LENGTH
4,76	s	THICKNESS



TOLERANCE CLASSES	CLASS	m	d	s
	E	± 0,025	± 0,025	± 0,025
	G	± 0,025	± 0,025	± 0,13
	H	± 0,013	± 0,013	± 0,025
	M	± 0,08	± 0,05	± 0,13
	U	± 0,13	± 0,08	± 0,13

MACHINING MATERIAL	STEEL	P																		
	STAINLESS STEEL	M																		
	CAST IRON	K																		
	NON-FERROUS METAL	N	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●
	EXOTIC ALLOY	S																		
	STEEL	H																		

MACHINING TYPES

SECONDARY USE

PRIMARY USE



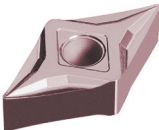
CONTINUOUS CUTTING

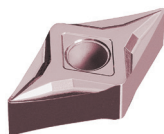


GENERAL CUTTING



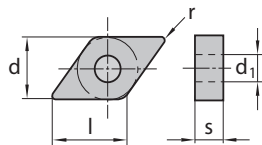
INTERRUPTED CUTTING

GEOMETRY ↓	DESIGNATION ↓	MACHINING MATERIAL GROUPE →												Non-ferrous materials Groupe D1 - Aluminium alloys (heat treated Vc -40%) D2 - Copper alloys (Vc -70%) D3 - Non-metallic materials (Vc -90%)	
		Vc (M/MIN) CUTTING SPEED →													
		D22-AE2	D22-AL2	D21-K1	D22-AF2	D22-AK2	D21-P1	D42-AG2	D42-AH2	D42-AM2	D42-AN2	D42-AI2			F (MM/REV) FEED RATE ↓
F14	DNGP 110404-F14									●				0,05 - 0,25	0,05 - 3,5
															



CARBIDE	DN 1506	55°	NON-FERROUS METALS
		DIAMOND	
		0° NEGATIVE	

12,70	d INSCRIBED CIRCLE
15,50	l CUTTING EDGE LENGTH
6,35	s THICKNESS



TOLERANCE CLASSES	CLASS	m	d	s
	E	± 0,025	± 0,025	± 0,025
	G	± 0,025	± 0,025	± 0,13
	H	± 0,013	± 0,013	± 0,025
	M	± 0,13	± 0,08	± 0,13
	U	± 0,20	± 0,13	± 0,13

MACHINING MATERIAL	STEEL	P																		
	STAINLESS STEEL	M																		
	CAST IRON	K																		
	NON-FERROUS METAL	N																		
	EXOTIC ALLOY	S																		
	STEEL	H																		

MACHINING TYPES

SECONDARY USE

PRIMARY USE



CONTINUOUS CUTTING



GENERAL CUTTING

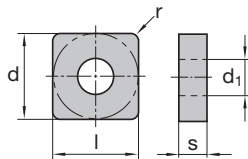


INTERRUPTED CUTTING

GEOMETRY ↓	GRADE → DESIGNATION	MACHINING MATERIAL GROUPE → Vc (M/MIN) CUTTING SPEED →											Non-ferrous materials Groupe	
		D1,2	D1,2,3	D1,2	D1	D1,2,3	D1,2	D1	D1	D1,2,3	D1,2,3	D1		
F14	DNGP 150604-F14	D22-AE2	D22-AL2	D21-K1	D22-AF2	D22-AK2	D21-P1	D42-AG2	D42-AH2	D42-AM2	D42-AN2	D42-AI2	F (MM/REV) FEED RATE ↓	AP (MM) DEPTH OF CUT ↓
		650-2000	300-2500	400-2400	850-1300	300-2500	700-3000	850-1300	750-1200	300-2500	300-2500	750-1200		
	DNGP 150608-F14									●			0,06 - 0,28	0,05 - 3,5
										●			0,06 - 0,28	0,06 - 3,5

CARBIDE	SC 09T3	90°	NON-FERROUS METALS
		SQUARE	
		7° POSITIVE	

9,52	d	INSCRIBED CIRCLE
9,52	l	CUTTING EDGE LENGTH
3,97	s	THICKNESS



TOLERANCE CLASSES	CLASS	m	d	s
	E	± 0,025	± 0,025	± 0,025
	G	± 0,025	± 0,025	± 0,13
	H	± 0,013	± 0,013	± 0,025
	M	± 0,08	± 0,05	± 0,13
	U	± 0,13	± 0,08	± 0,13

MACHINING MATERIAL	STEEL	P																		
	STAINLESS STEEL	M																		
	CAST IRON	K																		
	NON-FERROUS METAL	N	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●
	EXOTIC ALLOY	S																		
	STEEL	H																		

MACHINING TYPES

SECONDARY USE

PRIMARY USE



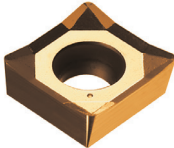
CONTINUOUS CUTTING



GENERAL CUTTING

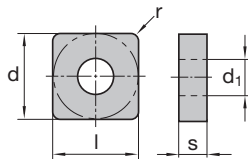


INTERRUPTED CUTTING

GEOMETRY ↓	DESIGNATION ↓	MACHINING MATERIAL GROUPE → Vc (M/MIN) CUTTING SPEED →											Non-ferrous materials Groupe			
		D22-AE2	D22-AL2	D21-K1	D22-AF2	D22-AK2	D21-P1	D42-AG2	D42-AH2	D42-AM2	D42-AN2	D42-AI2	F (MM/REV) FEED RATE ↓	AP (MM) DEPTH OF CUT ↓		
	SCGT 09T304-MF17				●	●		●	●		●	●			0,08 - 0,25	0,6 - 4,0
	SCGT 09T308-MF17				●	●		●	●		●	●			0,10 - 0,35	0,7 - 4,0

CARBIDE	SC 1204	90°	NON-FERROUS METALS
		SQUARE	
		7° POSITIVE	

12,70	d	INSCRIBED CIRCLE
12,70	l	CUTTING EDGE LENGTH
4,76	s	THICKNESS



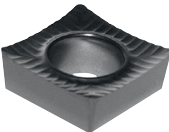
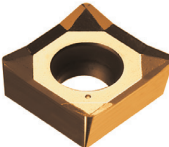
TOLERANCE CLASSES	CLASS	m	d	s
	E	± 0,025	± 0,025	± 0,025
	G	± 0,025	± 0,025	± 0,13
	H	± 0,013	± 0,013	± 0,025
	M	± 0,13	± 0,08	± 0,13
	U	± 0,20	± 0,13	± 0,13

SECONDARY USE	PRIMARY USE

MACHINING MATERIAL	STEEL	P													
	STAINLESS STEEL	M													
	CAST IRON	K													
	NON-FERROUS METAL	N													
	EXOTIC ALLOY	S													
	STEEL	H													

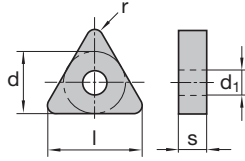
MACHINING TYPES

		CONTINUOUS CUTTING
		GENERAL CUTTING
		INTERRUPTED CUTTING

GEOMETRY ↓		GRADE → DESIGNATION ↓		MACHINING MATERIAL GROUPE → Vc (M/MIN) CUTTING SPEED →												Non-ferrous materials Groupe	
				D1,2	D1,2,3	D1,2	D1	D1,2,3	D1,2	D1	D1	D1,2,3	D1,2,3	D1			D1 - Aluminium alloys (heat treated Vc -40%) D2 - Copper alloys (Vc -70%) D3 - Non-metallic materials (Vc -90%)
		D22-AE2	D22-AL2	D21-K1	D22-AF2	D22-AK2	D21-P1	D42-AG2	D42-AH2	D42-AM2	D42-AN2	D42-AI2			F (MM/REV) FEED RATE ↓	AP (MM) DEPTH OF CUT ↓	
MR		SCGT 120408-MR			●		●								0,15 - 0,65	1,0 - 8,0	
MF17		SCGT 120404-MF17				●	●		●	●		●	●		0,10 - 0,40	0,4 - 6,0	
		SCGT 120408-MF17				●	●		●	●		●	●		0,10 - 0,40	0,8 - 6,0	
		SCGT 120412-MF17					●		●	●		●	●		0,10 - 0,40	1,0 - 6,0	
		SCGT 120416-MF17				●	●					●	●		0,10 - 0,40	1,2 - 6,0	

CARBIDE	TC 06T1	60°	NON-FERROUS METALS
		TRIANGLE	
		7° POSITIVE	

3,97	d INSCRIBED CIRCLE
6,40	l CUTTING EDGE LENGTH
1,98	s THICKNESS



TOLERANCE CLASSES	CLASS	m	d	s
	E	± 0,025	± 0,025	± 0,025
	G	± 0,025	± 0,025	± 0,13
	H	± 0,013	± 0,013	± 0,025
	M	± 0,08	± 0,05	± 0,13
	U	± 0,13	± 0,08	± 0,13

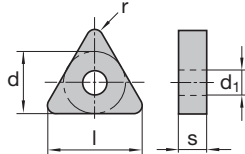
MACHINING TYPES	SECONDARY USE		PRIMARY USE	CONTINUOUS CUTTING

MACHINING MATERIAL	STEEL	P																
	STAINLESS STEEL	M																
	CAST IRON	K																
	NON-FERROUS METAL	N																
	EXOTIC ALLOY	S																
	STEEL	H																

GEOMETRY ↓	DESIGNATION ↓	MACHINING MATERIAL GROUPE → Vc (M/MIN) CUTTING SPEED →													Non-ferrous materials Groupe	
		GRADE →													F (MM/REV) FEED RATE ↓	AP (MM) DEPTH OF CUT ↓
		D22-AE2	D22-AL2	D21-K1	D22-AF2	D22-AK2	D21-P1	D42-AG2	D42-AH2	D42-AM2	D42-AN2	D42-AI2				
MF17 	TCGT 06T101-MF17					●		●			●				0,02 - 0,06	0,5 - 1,0
	TCGT 06T102-MF17				●	●		●	●		●	●			0,05 - 0,12	0,6 - 1,2
F12 	TCGT 06T102-F12					●					●				0,05 - 0,12	0,2 - 2,0

CARBIDE	TC 0902	60°	NON-FERROUS METALS
		TRIANGLE	
		7° POSITIVE	

5,56	d INSCRIBED CIRCLE
9,60	l CUTTING EDGE LENGTH
2,38	s THICKNESS



TOLERANCE CLASSES	CLASS	m	d	s
	E	± 0,025	± 0,025	± 0,025
	G	± 0,025	± 0,025	± 0,13
	H	± 0,013	± 0,013	± 0,025
	M	± 0,08	± 0,05	± 0,13
	U	± 0,13	± 0,08	± 0,13

SECONDARY USE

PRIMARY USE

MACHINING TYPES



CONTINUOUS CUTTING

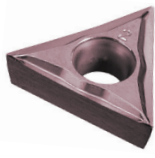


GENERAL CUTTING



INTERRUPTED CUTTING

MACHINING MATERIAL	STEEL	P																
	STAINLESS STEEL	M																
	CAST IRON	K																
	NON-FERROUS METAL	N																
	EXOTIC ALLOY	S																
	STEEL	H																

GEOMETRY ↓	GRADE → DESIGNATION ↓	MACHINING MATERIAL GROUPE → Vc (M/MIN) CUTTING SPEED →												Non-ferrous materials Groupe	
														F (MM/REV) FEED RATE ↓	AP (MM) DEPTH OF CUT ↓
		D1,2	D1,2,3	D1,2	D1	D1,2,3	D1,2	D1	D1	D1,2,3	D1,2,3	D1			
MF17 	TCGT 090202-MF17				●	●		●		●	●			0,05 - 0,12	0,6 - 1,6
	TCGT 090204-MF17				●	●		●	●		●	●		0,08 - 0,16	0,6 - 1,6
	TCGT 090208-MF17					●					●			0,08 - 0,16	0,6 - 1,6
F11 	TCGT 090202-F11										●			0,05 - 0,12	0,2 - 2,0
F12 	TCGT 090202-F12				●						●			0,05 - 0,12	0,6 - 1,6

[illegible][illegible]

CARBIDE

TC
16T3

60°
 TRIANGLE
 7° POSITIVE

NON-FERROUS METALS

9,52	d	INSCRIBED CIRCLE
16,50	l	CUTTING EDGE LENGTH
3,97	s	THICKNESS

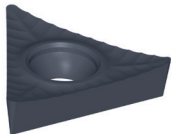
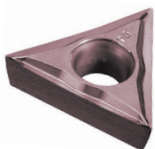
TOLERANCE CLASSES	CLASS	m	d	s
	E	± 0,025	± 0,025	± 0,025
	G	± 0,025	± 0,025	± 0,13
	H	± 0,013	± 0,013	± 0,025
	M	± 0,08	± 0,05	± 0,13
	U	± 0,13	± 0,08	± 0,13

MACHINING MATERIAL

STEEL	P
STAINLESS STEEL	M
CAST IRON	K
NON-FERROUS METAL	N
EXOTIC ALLOY	S
STEEL	H

MACHINING TYPES

SECONDARY USE	PRIMARY USE	
		CONTINUOUS CUTTING
		GENERAL CUTTING
		INTERRUPTED CUTTING

		MACHINING MATERIAL GROUPE →												Non-ferrous materials Groupe				
		Vc (M/MIN) CUTTING SPEED →												D1 - Aluminium alloys (heat treated Vc - 40%) D2 - Copper alloys (Vc - 70%) D3 - Non-metallic materials (Vc - 90%)				
GEOMETRY ↓		GRADE → DESIGNATION ↓		D22-AE2	D22-AL2	D21-K1	D22-AF2	D22-AK2	D21-P1	D42-AG2	D42-AH2	D42-AM2	D42-AN2	D42-AI2			F (MM/REV) FEED RATE ↓	AP (MM) DEPTH OF CUT ↓
MR		TCGT 16T304-MR				●			●								0,15 - 0,65	1,0 - 8,0
																		
MF17		TCGT 16T302-MF17					●	●		●	●		●	●			0,05 - 0,12	0,5 - 2,0
		TCGT 16T304-MF17					●	●		●	●		●	●			0,08 - 0,25	0,6 - 4,0
		TCGT 16T308-MF17					●	●		●	●		●	●			0,10 - 0,35	0,8 - 4,0
F12		TCGT 16T301-F12						●									0,02 - 0,06	0,1 - 1,5
		TCGT 16T302-F12								●			●				0,05 - 0,12	0,2 - 2,0
		TCGT 16T304-F12						●		●			●				0,08 - 0,25	0,2 - 2,5

CARBIDE

VC
0501

35°
 DIAMOND
 7° POSITIVE

NON-FERROUS METALS

3,10

d

INSCRIBED CIRCLE

5,40

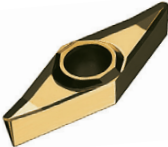
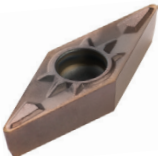
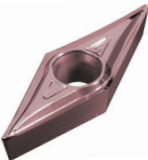
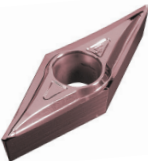
l

CUTTING EDGE LENGTH

1,59

s

THICKNESS

		MACHINING MATERIAL GROUPE →														Non-ferrous materials Groupe D1 - Aluminium alloys (heat treated Vc -40%) D2 - Copper alloys (Vc -70%) D3 - Non-metallic materials (Vc -90%)		
		Vc (M/MIN) CUTTING SPEED →																
GEOMETRY ↓		GRADE → DESIGNATION ↓		D1,2	D1,2,3	D1,2	D1	D1,2,3	D1,2	D1	D1	D1,2,3	D1,2,3	D1			F (MM/REV) FEED RATE ↓	AP (MM) DEPTH OF CUT ↓
MF17 	VCGT 050101-MF17												●				0,020 - 0,06	0,10 - 1,0
	VCGT 050102-MF17												●				0,020 - 0,06	0,10 - 1,0
	VCGT 050104-MF17												●				0,050 - 0,08	0,20 - 1,0
F10 	VCGT 050101-F10		●														0,04 - 0,15	0,05 - 1,0
	VCGT 050102-F10		●														0,04 - 0,20	0,1 - 2,5
	VCGT 050104-F10		●														0,05 - 0,16	0,1 - 1,5
F11 	VCGT 050102-F11											●					0,020 - 0,06	0,10 - 1,0
F12 	VCGT 050102-F12												●				0,020 - 0,06	0,10 - 1,0

ORDER EXAMPLE: CCMT 09T304-M A31-A1

CARBIDE

VC
0702

35°
 DIAMOND
 7° POSITIVE

NON-FERROUS METALS

3,97	d	INSCRIBED CIRCLE
6,85	l	CUTTING EDGE LENGTH
2,38	s	THICKNESS

Technical drawing of a triangular cutting insert. The main view shows a triangle with an inscribed circle of diameter 'd', a cutting edge length 'l', and a thickness 's'. A fillet radius 'r' is indicated at the corner. A side view shows the thickness 's' and a diameter 'd1' at the base.

TOLERANCE CLASSES	CLASS	m	d	s
	E	± 0,025	± 0,025	± 0,025
	G	± 0,025	± 0,025	± 0,13
	H	± 0,013	± 0,013	± 0,025
	M	± 0,08	± 0,05	± 0,13
	U	± 0,13	± 0,08	± 0,13

SECONDARY USE

PRIMARY USE

MACHINING MATERIAL	STEEL		P				⌚			⌚					
	STAINLESS STEEL		M				⌚		⌚	⌚			⌚		
	CAST IRON		K		⌚	⌚	⌚	⌚	⌚	⌚	⌚	⌚	⌚		
	NON-FERROUS METAL		N	●	●	●	●	●	●	●	●	●	●	●	
	EXOTIC ALLOY		S		⌚		⌚	⌚		⌚	⌚	⌚	⌚		
	STEEL		H				⌚			⌚			⌚		
	MACHINING TYPES														

○

●

CONTINUOUS CUTTING

⌚

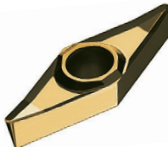
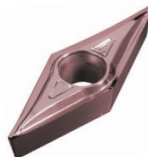
⌚

GENERAL CUTTING

⌚

⌚

INTERRUPTED CUTTING

		MACHINING MATERIAL GROUPE →														Non-ferrous materials Groupe		
		Vc (M/MIN) CUTTING SPEED →												D1 - Aluminium alloys (heat treated Vc -40%) D2 - Copper alloys (Vc -70%) D3 - Non-metallic materials (Vc -90%)				
GEOMETRY ↓		GRADE → DESIGNATION ↓		D1,2	D1,2,3	D1,2	D1	D1,2,3	D1,2	D1	D1	D1,2,3	D1,2,3	D1			F (MM/REV) FEED RATE ↓	AP (MM) DEPTH OF CUT ↓
	MF17	VCGT 0702005-MF17				●	●		●	●		●	●				0,02 - 0,06	0,2 - 1,0
		VCGT 070201-MF17				●	●		●	●		●	●				0,02 - 0,06	0,2 - 1,0
		VCGT 070202-MF17				●	●		●	●		●	●				0,05 - 0,08	0,2 - 1,0
		VCGT 070204-MF17				●	●		●	●		●	●				0,08 - 0,12	0,2 - 1,0
	F11	VCGT 070202-F11											●				0,05 - 0,08	0,2 - 1,0
		VCGT 070204-F11											●				0,08 - 1,20	0,2 - 1,0
	F12	VCGT 0702005-F12				●											0,02 - 0,06	0,1 - 1,0
		VCGT 070201-F12				●	●		●			●					0,02 - 0,06	0,1 - 1,0
		VCGT 070202-F12				●	●		●			●					0,05 - 0,08	0,2 - 1,0
		VCGT 070204-F12				●	●		●			●					0,08 - 1,20	0,2 - 1,0

CARBIDE
VC 1103

35°
DIAMOND
7° POSITIVE

NON-FERROUS METALS

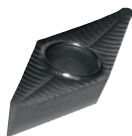
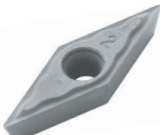
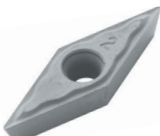
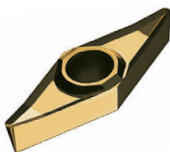
6,35	d	INScribed CIRCLE
11,10	l	CUTTING EDGE LENGTH
3,18	s	THICKNESS

TOLERANCE CLASSES	CLASS	m	d	s
	E	± 0,025	± 0,025	± 0,025
	G	± 0,025	± 0,025	± 0,13
	H	± 0,013	± 0,013	± 0,025
	M	± 0,08	± 0,05	± 0,13
	U	± 0,13	± 0,08	± 0,13

SECONDARY USE

PRIMARY USE

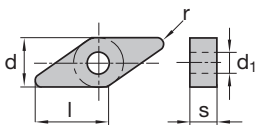
MACHINING MATERIAL	MACHINING MATERIAL		MACHINING TYPES												
	STEEL	P													
	STAINLESS STEEL	M													
	CAST IRON	K													
	NON-FERROUS METAL	N													
	EXOTIC ALLOY	S													
STEEL	H														

		MACHINING MATERIAL GROUPE →											Non-ferrous materials Groupe D1 - Aluminium alloys (heat treated Vc -40%) D2 - Copper alloys (Vc -70%) D3 - Non-metallic materials (Vc -90%)					
		Vc (M/MIN) CUTTING SPEED →																
GEOMETRY ↓		GRADE →											F (MM/REV) FEED RATE ↓		AP (MM) DEPTH OF CUT ↓			
		DESIGNATION ↓																
		D22-AE2	D22-AL2	D21-K1	D22-AF2	D22-AK2	D21-P1	D42-AG2	D42-AH2	D42-AM2	D42-AN2	D42-AI2						
				●			●											
					●			●										
		VCGT 1103008-MF10								●							0,040 - 0,10	0,10 - 1,0
		VCGT 1103015-MF10								●							0,040 - 0,10	0,10 - 1,0
		VCGT 110301-MF10								●							0,040 - 0,10	0,10 - 1,0
		VCGT 110302-MF10								●							0,040 - 0,10	0,20 - 1,5
		VCGT 110304-MF10								●							0,060 - 0,18	0,30 - 2,0
		VCGT 1103005-MF15		●						●						0,04 - 0,10	0,1 - 1,0	
		VCGT 1103008-MF15		●						●						0,04 - 0,10	0,1 - 1,0	
		VCGT 1103015-MF15		●						●						0,04 - 0,10	0,1 - 1,0	
		VCGT 110301-MF15		●		●				●						0,04 - 0,10	0,1 - 1,0	
		VCGT 110302-MF15		●		●				●						0,04 - 0,10	0,2 - 1,5	
		VCGT 110304-MF15		●						●						0,06 - 0,18	0,3 - 2,0	
		VCGT 1103005-MF17				●	●		●			●				0,02 - 0,06	0,5 - 1,5	
		VCGT 110301-MF17				●	●		●	●		●	●			0,02 - 0,06	0,5 - 1,5	
		VCGT 110302-MF17				●	●		●	●		●	●			0,05 - 0,12	0,5 - 2,0	
		VCGT 110304-MF17				●	●		●	●		●	●			0,08 - 0,25	0,6 - 2,5	
		VCGT 110308-MF17				●	●		●	●		●	●			0,10 - 0,35	0,8 - 3,0	

ORDER EXAMPLE: CCMT 09T304-M A31-A1

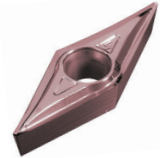
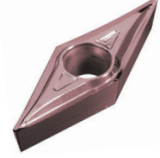
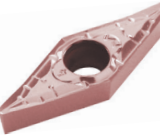
CARBIDE	VC 1103	35°	NON-FERROUS METALS
		DIAMOND	
		7° POSITIVE	

6,35	d INSCRIBED CIRCLE
11,10	l CUTTING EDGE LENGTH
3,18	s THICKNESS



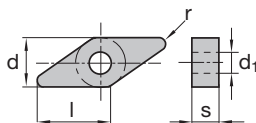
TOLERANCE CLASSES	CLASS	m	d	s
	E	± 0,025	± 0,025	± 0,025
	G	± 0,025	± 0,025	± 0,13
	H	± 0,013	± 0,013	± 0,025
	M	± 0,08	± 0,05	± 0,13
	U	± 0,13	± 0,08	± 0,13

MACHINING MATERIAL	STEEL	P	MACHINING TYPES	SECONDARY USE	PRIMARY USE	CONTINUOUS CUTTING
	STAINLESS STEEL	M				
	CAST IRON	K				
	NON-FERROUS METAL	N				
	EXOTIC ALLOY	S				
	STEEL	H				

GEOMETRY ↓	GRADE → DESIGNATION ↓	MACHINING MATERIAL GROUPE → VC (M/MIN) CUTTING SPEED →												Non-ferrous materials Groupe	
														F (MM/REV) FEED RATE ↓	AP (MM) DEPTH OF CUT ↓
		D1,2	D1,2,3	D1,2	D1	D1,2,3	D1,2	D1	D1	D1,2,3	D1,2,3	D1			
F11 	VCGT 1103008-F11													0,020 - 0,06	0,10 - 1,5
	VCGT 1103015-F11													0,05 - 0,12	0,2 - 2,0
	VCGT 110301-F11													0,02 - 0,06	0,1 - 1,5
	VCGT 110302-F11													0,05 - 0,12	0,2 - 2,0
	VCGT 110304-F11													0,08 - 0,25	0,2 - 2,5
F12 	VCGT 1103005-F12				●	●		●			●			0,02 - 0,06	0,1 - 1,5
	VCGT 1103008-F12					●				●				0,02 - 0,06	0,1 - 1,5
	VCGT 1103015-F12					●				●				0,05 - 0,12	0,2 - 2,0
	VCGT 110301-F12				●	●		●			●			0,02 - 0,06	0,1 - 1,5
	VCGT 110302-F12				●	●		●		●	●			0,05 - 0,12	0,2 - 2,0
	VCGT 110304-F12				●	●		●			●	●		0,08 - 0,25	0,2 - 2,5
W1 	VCGT 110302-W1				●	●								0,10 - 0,30	0,3 - 3,0
	VCGT 110304-W1				●	●								0,12 - 0,40	0,5 - 4,0

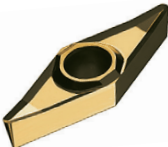
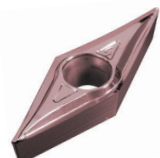
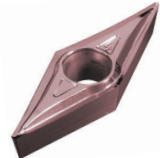
CARBIDE	VC 1303	35°	NON-FERROUS METALS
		DIAMOND	
		7° POSITIVE	

7,94	d INSCRIBED CIRCLE
13,10	l CUTTING EDGE LENGTH
3,18	s THICKNESS



TOLERANCE CLASSES	CLASS	m	d	s
	E	± 0,025	± 0,025	± 0,025
	G	± 0,025	± 0,025	± 0,13
	H	± 0,013	± 0,013	± 0,025
	M	± 0,08	± 0,05	± 0,13
	U	± 0,13	± 0,08	± 0,13

MACHINING MATERIAL	STEEL	P	MACHINING TYPES	SECONDARY USE	PRIMARY USE	CONTINUOUS CUTTING
	STAINLESS STEEL	M				
	CAST IRON	K				
	NON-FERROUS METAL	N				
	EXOTIC ALLOY	S				
	STEEL	H				

GEOMETRY ↓	GRADE → DESIGNATION ↓	MACHINING MATERIAL GROUPE → VC (M/MIN) CUTTING SPEED →											Non-ferrous materials Groupe	
		D1,2	D1,2,3	D1,2	D1	D1,2,3	D1,2	D1	D1	D1,2,3	D1,2,3	D1	F (MM/REV) FEED RATE ↓	AP (MM) DEPTH OF CUT ↓
		D22-AE2	D22-AL2	D21-K1	D22-AF2	D22-AK2	D21-P1	D42-AG2	D42-AH2	D42-AM2	D42-AN2	D42-AI2		
MF17 	VCGT 1303005-MF17				●	●		●					0,02 - 0,06	0,5 - 1,5
	VCGT 130301-MF17				●	●		●					0,02 - 0,06	0,5 - 1,5
	VCGT 130302-MF17				●	●		●	●		●	●	0,05 - 0,12	0,5 - 2,0
	VCGT 130304-MF17				●	●		●	●		●	●	0,08 - 0,25	0,6 - 3,0
	VCGT 130308-MF17				●	●		●	●		●	●	0,08 - 0,25	0,6 - 3,0
F11 	VCGT 130302-F11										●		0,05 - 0,12	0,2 - 2,0
	VCGT 130304-F11										●		0,08 - 0,25	0,2 - 2,5
F12 	VCGT 1303005-F12				●					●			0,05 - 0,12	0,2 - 2,0
	VCGT 130301-F12				●	●		●		●			0,05 - 0,12	0,2 - 2,0
	VCGT 130302-F12				●	●		●		●			0,05 - 0,12	0,2 - 2,0
	VCGT 130304-F12				●	●		●		●			0,08 - 0,25	0,2 - 2,5

CARBIDE

VC
1604

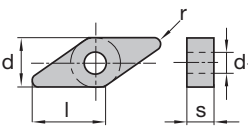
35°

DIAMOND

7° POSITIVE

NON-FERROUS METALS

9,52	d	INSCRIBED CIRCLE
16,60	l	CUTTING EDGE LENGTH
4,76	s	THICKNESS



TOLERANCE CLASSES	CLASS	m	d	s
	E	± 0,025	± 0,025	± 0,025
	G	± 0,025	± 0,025	± 0,13
	H	± 0,013	± 0,013	± 0,025
	M	± 0,08	± 0,05	± 0,13
	U	± 0,13	± 0,08	± 0,13

SECONDARY USE

PRIMARY USE

MACHINING MATERIAL	STEEL	P				☺			☺	☺				☹		
	STAINLESS STEEL	M				☺		☺	☺	☺				☹		
	CAST IRON	K		☺	☺	☺	☺	☺	☺	☺	☺	☺	☹			
	NON-FERROUS METAL	N	●	●	●	●	●	●	●	●	●	●	●	●	●	●
	EXOTIC ALLOY	S		☺		☺	☺		☺	☺	☺	☺	☹			
	STEEL	H				☺			☺	☺			☹			

MACHINING TYPES

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●

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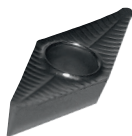
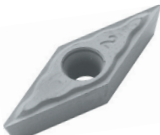
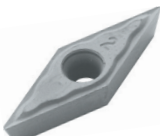
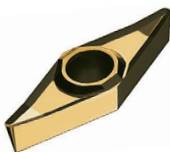
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CONTINUOUS CUTTING

GENERAL CUTTING

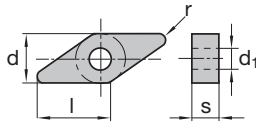
INTERRUPTED CUTTING

		MACHINING MATERIAL GROUPE →												Non-ferrous materials Groupe D1 - Aluminium alloys (heat treated Vc -40%) D2 - Copper alloys (Vc -70%) D3 - Non-metallic materials (Vc -90%)				
		Vc (M/MIN) CUTTING SPEED →																
		D1,2	D1,2,3	D1,2	D1	D1,2,3	D1,2	D1	D1	D1,2,3	D1,2,3	D1						
GEOMETRY ↓		GRADE → DESIGNATION ↓		D22-AE2	D22-AL2	D21-K1	D22-AF2	D22-AK2	D21-P1	D42-AG2	D42-AH2	D42-AM2	D42-AN2	D42-AI2			F (MM/REV) FEED RATE ↓	AP (MM) DEPTH OF CUT ↓
MR 	VCGT 160402-MR					●				●							0,15 - 0,65	1,0 - 8,0
	VCGT 160404-MR					●				●							0,15 - 0,65	1,0 - 8,0
	VCGT 160408-MR					●				●							0,15 - 0,65	1,0 - 8,0
	VCGT 160412-MR					●				●							0,15 - 0,65	1,0 - 8,0
MF10 	VCGT 160401-MF10											●					0,040 - 0,10	0,10 - 1,0
	VCGT 160402-MF10											●					0,040 - 0,10	0,20 - 1,5
	VCGT 160404-MF10											●					0,080 - 0,20	0,30 - 2,0
MF15 	VCGT 1604005-MF15			●								●					0,04 - 0,10	0,1 - 1,0
	VCGT 160401-MF15			●								●					0,04 - 0,10	0,1 - 1,0
	VCGT 160402-MF15			●								●					0,04 - 0,10	0,2 - 1,5
	VCGT 160404-MF15			●								●					0,08 - 0,20	0,3 - 2,0
MF17 	VCGT 160401-MF17					●	●			●	●		●	●			0,02 - 0,06	0,5 - 1,5
	VCGT 160402-MF17					●	●			●	●		●	●			0,05 - 0,12	0,5 - 2,0
	VCGT 160404-MF17					●	●			●	●		●	●			0,08 - 0,25	0,6 - 3,5
	VCGT 160408-MF17					●	●			●	●		●	●			0,10 - 0,35	0,8 - 3,5
	VCGT 160412-MF17					●	●			●	●		●	●			0,10 - 0,45	1,0 - 3,5

ORDER EXAMPLE: CCMT 09T304-M A31-A1

CARBIDE	VC 1604	35°	NON-FERROUS METALS
		DIAMOND	
		7° POSITIVE	

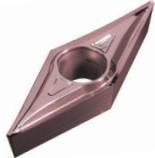
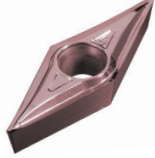
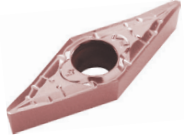
9,52	d INSCRIBED CIRCLE
16,60	l CUTTING EDGE LENGTH
4,76	s THICKNESS



TOLERANCE CLASSES	CLASS	m	d	s
	E	± 0,025	± 0,025	± 0,025
	G	± 0,025	± 0,025	± 0,13
	H	± 0,013	± 0,013	± 0,025
	M	± 0,08	± 0,05	± 0,13
	U	± 0,13	± 0,08	± 0,13

MACHINING TYPES	SECONDARY USE		PRIMARY USE	
	○	●	○	●
	⊖	⊖	⊖	⊖
	⊕	⊕	⊕	⊕
			CONTINUOUS CUTTING	
			GENERAL CUTTING	
			INTERRUPTED CUTTING	

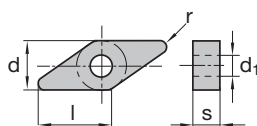
MACHINING MATERIAL	STEEL	P																		
	STAINLESS STEEL	M																		
	CAST IRON	K																		
	NON-FERROUS METAL	N	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●
	EXOTIC ALLOY	S																		
	STEEL	H																		

GEOMETRY ↓	GRADE → DESIGNATION ↓	MACHINING MATERIAL GROUPE → Vc (M/MIN) CUTTING SPEED →												Non-ferrous materials Groupe	
														F (MM/REV) FEED RATE ↓	AP (MM) DEPTH OF CUT ↓
		D1,2	D1,2,3	D1,2	D1	D1,2,3	D1,2	D1	D1	D1,2,3	D1,2,3	D1			
F11 	VCGT 160402-F11												●	0,05 - 0,12	0,2 - 2,0
	VCGT 160404-F11												●	0,08 - 0,25	0,2 - 2,5
	VCGT 160408-F11												●	0,10 - 0,30	0,3 - 3,0
F12 	VCGT 160401-F12				●	●		●					●	0,05 - 0,12	0,2 - 2,0
	VCGT 160402-F12				●	●		●					●	0,05 - 0,12	0,2 - 2,0
	VCGT 160404-F12				●	●		●					● ●	0,08 - 0,25	0,2 - 2,5
	VCGT 160408-F12				●	●		●					●	0,10 - 0,30	0,3 - 3,0
W1 	VCGT 160404-W1				●	●								0,12 - 0,40	0,5 - 4,0
	VCGT 160408-W1				●	●								0,15 - 0,50	0,7 - 4,0

[illegible][illegible]

CARBIDE	VN 1604	35°	NON-FERROUS METALS
		DIAMOND	
		0° NEGATIVE	

9,52	d	INSCRIBED CIRCLE
16,60	l	CUTTING EDGE LENGTH
4,76	s	THICKNESS



TOLERANCE CLASSES	CLASS	m	d	s
	E	± 0,025	± 0,025	± 0,025
	G	± 0,025	± 0,025	± 0,13
	H	± 0,013	± 0,013	± 0,025
	M	± 0,08	± 0,05	± 0,13
	U	± 0,13	± 0,08	± 0,13

MACHINING MATERIAL	STEEL	P																
	STAINLESS STEEL	M																
	CAST IRON	K																
	NON-FERROUS METAL	N	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●
	EXOTIC ALLOY	S																
	STEEL	H																

MACHINING TYPES

SECONDARY USE

PRIMARY USE



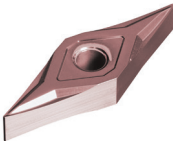
CONTINUOUS CUTTING

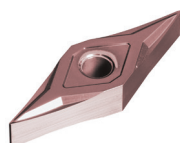


GENERAL CUTTING



INTERRUPTED CUTTING

GEOMETRY ↓	DESIGNATION ↓	MACHINING MATERIAL GROUPE → Vc (M/MIN) CUTTING SPEED →											Non-ferrous materials Groupe		
		D22-AE2	D22-AL2	D21-K1	D22-AF2	D22-AK2	D21-P1	D42-AG2	D42-AH2	D42-AM2	D42-AN2	D42-AI2	F (MM/REV) FEED RATE ↓	AP (MM) DEPTH OF CUT ↓	
F14	VNGP 160404-F14									●				0,05 - 0,25	0,05 - 3,5
															



CARBIDE

WC
0201

80°

TRIGON

7° POSITIVE

NON-FERROUS METALS

3,97	d	INSCRIBED CIRCLE
2,70	l	CUTTING EDGE LENGTH
1,59	s	THICKNESS

TOLERANCE CLASSES	CLASS	m	d	s
	E	± 0,025	± 0,025	± 0,025
	G	± 0,025	± 0,025	± 0,13
	H	± 0,013	± 0,013	± 0,025
	M	± 0,08	± 0,05	± 0,13
	U	± 0,13	± 0,08	± 0,13

SECONDARY USE

PRIMARY USE

MACHINING MATERIAL	STEEL	P				☺			☺	☺				☹		
	STAINLESS STEEL	M				☺		☺	☺	☺				☹		
	CAST IRON	K		☺	☺	☺	☺	☺	☺	☺	☺	☺	☹			
	NON-FERROUS METAL	N	●	●	●	●	●	●	●	●	●	●	●	●	●	●
	EXOTIC ALLOY	S		☺		☺	☺		☺	☺	☺	☺	☹			
	STEEL	H				☺			☺	☺				☹		

MACHINING TYPES

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CONTINUOUS CUTTING

GENERAL CUTTING

INTERRUPTED CUTTING

GEOMETRY ↓	DESIGNATION ↓	MACHINING MATERIAL GROUPE → Vc (M/MIN) CUTTING SPEED → GRADE →	Non-ferrous materials Groupe												F (MM/REV) FEED RATE ↓	AP (MM) DEPTH OF CUT ↓
			D1 - Aluminium alloys (heat treated Vc -40%) D2 - Copper alloys (Vc -70%) D3 - Non-metallic materials (Vc -90%)													
			D1,2	D1,2,3	D1,2	D1	D1,2,3	D1,2	D1	D1	D1,2,3	D1,2,3	D1			
			D22-AE2	D22-AL2	D21-K1	D22-AF2	D22-AK2	D21-P1	D42-AG2	D42-AH2	D42-AM2	D42-AN2	D42-AI2			
	WCGT 0201005-MF17											●			0,05 - 0,12	0,5 - 1,5
	WCGT 020101-MF17											●			0,05 - 0,12	0,5 - 1,5
	WCGT 020102-MF17							●				●			0,05 - 0,12	0,5 - 1,5

CARBIDE

WC
0402

80°

TRIGON

7° POSITIVE

NON-FERROUS METALS

6,35	d INSCRIBED CIRCLE
4,30	l CUTTING EDGE LENGTH
2,38	s THICKNESS

TOLERANCE CLASSES	CLASS	m	d	s
	E	± 0,025	± 0,025	± 0,025
	G	± 0,025	± 0,025	± 0,13
	H	± 0,013	± 0,013	± 0,025
	M	± 0,08	± 0,05	± 0,13
	U	± 0,13	± 0,08	± 0,13

MACHINING MATERIAL	STEEL	P
	STAINLESS STEEL	M
	CAST IRON	K
	NON-FERROUS METAL	N
	EXOTIC ALLOY	S
	STEEL	H

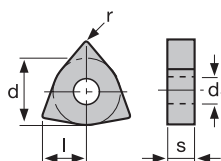
MACHINING TYPES	SECONDARY USE		PRIMARY USE	
	○	●	○	●
	⊕	⊖	⊕	⊖
	⊕	⊖	⊕	⊖
	⊕	⊖	⊕	⊖
	⊕	⊖	⊕	⊖

○	●	CONTINUOUS CUTTING
⊕	⊖	GENERAL CUTTING
⊕	⊖	INTERRUPTED CUTTING

[illegible]

CARBIDE	WC 06T3	80°	Non-FERROUS METALS
		TRIGON	
		7° POSITIVE	

9,52	d INSCRIBED CIRCLE
6,50	l CUTTING EDGE LENGTH
3,97	s THICKNESS



TOLERANCE CLASSES	CLASS	m	d	s
	E	± 0,025	± 0,025	± 0,025
	G	± 0,025	± 0,025	± 0,13
	H	± 0,013	± 0,013	± 0,025
	M	± 0,08	± 0,05	± 0,13
	U	± 0,13	± 0,08	± 0,13

MACHINING MATERIAL	STEEL	P												
	STAINLESS STEEL	M												
	CAST IRON	K												
	NON-FERROUS METAL	N												
	EXOTIC ALLOY	S												
	STEEL	H												

MACHINING TYPES

SECONDARY USE

PRIMARY USE



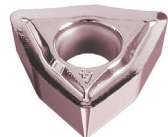
CONTINUOUS CUTTING



GENERAL CUTTING



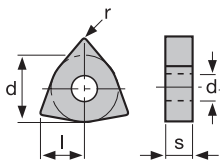
INTERRUPTED CUTTING

		MACHINING MATERIAL GROUPE →														Non-ferrous materials Groupe		
		Vc (M/MIN) CUTTING SPEED →														D1 - Aluminium alloys (heat treated Vc -40%) D2 - Copper alloys (Vc -70%) D3 - Non-metallic materials (Vc -90%)		
GEOMETRY ↓		GRADE → DESIGNATION ↓		D22-AE2	D22-AL2	D21-K1	D22-AF2	D22-AK2	D21-P1	D42-AG2	D42-AH2	D42-AM2	D42-AN2	D42-AI2			F (MM/REV) FEED RATE ↓	AP (MM) DEPTH OF CUT ↓
MR 	WCGT 06T302-MR								●								0,15 - 0,65	1,0 - 8,0
	WCGT 06T304-MR				●				●								0,15 - 0,65	1,0 - 8,0
	WCGT 06T308-MR				●				●								0,15 - 0,65	1,0 - 8,0
MF17 	WCGT 06T301-MF17							●			●		●				0,05 - 0,12	0,6 - 2,0
	WCGT 06T302-MF17					●	●			●	●		●	●			0,05 - 0,12	0,6 - 2,0
	WCGT 06T304-MF17					●	●			●	●		●	●			0,08 - 0,25	0,6 - 3,0
F12 	WCGT 06T301-F12							●									0,02 - 0,06	0,1 - 1,5
	WCGT 06T302-F12					●	●										0,05 - 0,12	0,2 - 2,0
	WCGT 06T304-F12					●	●			●			●				0,08 - 0,25	0,2 - 2,5

[illegible]

CARBIDE	WN 0804	80°	NON-FERROUS METALS
		TRIGON	
		0° NEGATIVE	

12,70	d INSCRIBED CIRCLE
8,60	l CUTTING EDGE LENGTH
4,76	s THICKNESS



TOLERANCE CLASSES	CLASS	m	d	s
	<i>E</i>	$\pm 0,025$	$\pm 0,025$	$\pm 0,025$
	<i>G</i>	$\pm 0,025$	$\pm 0,025$	$\pm 0,13$
	<i>H</i>	$\pm 0,013$	$\pm 0,013$	$\pm 0,025$
	<i>M</i>	$\pm 0,13$	$\pm 0,08$	$\pm 0,13$
	<i>U</i>	$\pm 0,20$	$\pm 0,13$	$\pm 0,13$

SECONDARY USE	PRIMARY USE	
		CONTINUOUS CUTTING
		GENERAL CUTTING
		INTERRUPTED CUTTING

[illegible][illegible]

CARBIDE

CC0602

80°

DIAMOND

7° POSITIVE

EXOTIC ALLOY

6,35

d

INSCRIBED CIRCLE

6,40

I

CUTTING EDGE LENGTH

2,38

s

THICKNESS

TOLERANCE CLASSES

CLASS	m	d	s
E	± 0,025	± 0,025	± 0,025
G	± 0,025	± 0,025	± 0,13
H	± 0,013	± 0,013	± 0,025
M	± 0,08	± 0,05	± 0,13
U	± 0,13	± 0,08	± 0,13

SECONDARY USE

PRIMARY USE

MACHINING MATERIAL

STEEL	P	○	●				●	●	☺				☺	☺		
STAINLESS STEEL	M	●	○		○	●	●	●	☺		●	☺	☺	☺		
CAST IRON	K	○	●					○	☺				☺			
NON-FERROUS METAL	N	○				●	○	☺					☺			
EXOTIC ALLOY	S	●	●	●	●	●	●	●	☺	☺	☺	☺	☺	☺	☺	☺
STEEL	H	○			●			○	☺				☺			

MACHINING TYPES

○

☺

●

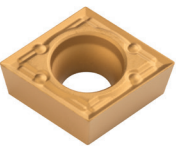
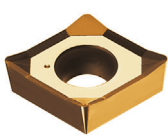
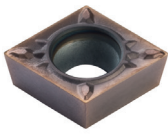
☺

☺

CONTINUOUS CUTTING

GENERAL CUTTING

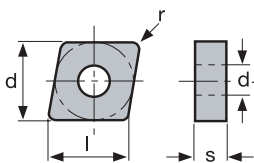
INTERRUPTED CUTTING

GEOMETRY ↓	GRADE → DESIGNATION ↓	MACHINING MATERIAL GROUPE → VC (M/MIN) CUTTING SPEED →												Exotic alloy Groupe	
														F (MM/REV) FEED RATE ↓	AP (MM) DEPTH OF CUT ↓
		S1,2,3	S1	S2,3	S3	S1	S2,3	S1,2,3	S1,2,3	S3	S1	S1,2,3	S1,2,3		
M11 	CCMT 060202-M11	●									●			0,05 - 0,20	0,2 - 1,5
	CCMT 060204-M11	●									●			0,06 - 0,20	0,2 - 1,5
MF17 	CCGT 060204-MF17		●											0,08 - 0,25	0,6 - 3,0
F10 	CCMT 060202-F10	●									●			0,04 - 0,12	0,1 - 1,0
	CCMT 060204-F10	●									●			0,05 - 0,16	0,1 - 1,5
F11 	CCGT 060201-F11								●					0,02 - 0,06	0,1 - 1,5
	CCGT 060202-F11								●					0,05 - 0,12	0,2 - 2,0
	CCGT 060204-F11								●					0,08 - 0,25	0,2 - 2,5

ORDER EXAMPLE: CCMT 09T304-M A31-A1

CARBIDE	CC 0602	80°	EXOTIC ALLOY
		DIAMOND	
		7° POSITIVE	

6,35	d	INSCRIBED CIRCLE
6,40	l	CUTTING EDGE LENGTH
2,38	s	THICKNESS



TOLERANCE CLASSES	CLASS	m	d	s
	E	± 0,025	± 0,025	± 0,025
	G	± 0,025	± 0,025	± 0,13
	H	± 0,013	± 0,013	± 0,025
	M	± 0,08	± 0,05	± 0,13
	U	± 0,13	± 0,08	± 0,13

MACHINING MATERIAL	STEEL	P	TOLERANCE CLASSES	CLASS	m	d	s	MACHINING TYPES	SECONDARY USE	PRIMARY USE	CONTINUOUS CUTTING	GENERAL CUTTING	INTERRUPTED CUTTING
	STAINLESS STEEL	M											
	CAST IRON	K											
	NON-FERROUS METAL	N											
	EXOTIC ALLOY	S											
	STEEL	H											

GEOMETRY	DESIGNATION	GRADE	MACHINING MATERIAL GROUPE →	Vc (M/MIN) CUTTING SPEED →	Exotic alloy Groupe	F (MM/REV) FEED RATE	AP (MM) DEPTH OF CUT
F12	CCGT 060202-F12	●	S1,2,3	15-90	B22-V2	0,05 - 0,12	0,2 - 2,0
	CCGT 060204-F12	●	S1	15-70	A22-J2	0,08 - 0,25	0,2 - 2,5
			S2,3	30-70	E21-L1		
			S3	30-80	E22-AO2		
			S1	20-100	E31-N1		
			S2,3	30-70	E31-M1		
			S1,2,3	15-80	B32-S2		
			S1,2,3	15-80	B42-W2		
			S3	30-70	E42-AP2		
			S1	20-100	E41-O1		
			S1,2,3	15-70	B62-Y2		
			S1,2,3	5-35	B72-M2		



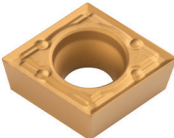
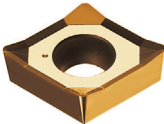
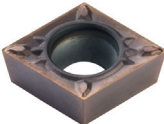
CARBIDE	CC		80°	EXOTIC ALLOY									
	09T3		DIAMOND										
			7° POSITIVE										

9,52	d	INSCRIBED CIRCLE
9,70	l	CUTTING EDGE LENGTH
3,97	s	THICKNESS

TOLERANCE CLASSES	CLASS	m	d	s
	E	± 0,025	± 0,025	± 0,025
	G	± 0,025	± 0,025	± 0,13
	H	± 0,013	± 0,013	± 0,025
	M	± 0,08	± 0,05	± 0,13
	U	± 0,13	± 0,08	± 0,13

MACHINING MATERIAL	STEEL	P	○ ●				● ●	☉			☉ ☉	☉	
	STAINLESS STEEL	M	● ○	○	● ●	● ●	☉	☉	☉	☉ ☉	☉		
	CAST IRON	K	○ ●				○	☉		☉			
	NON-FERROUS METAL	N	○			● ○	☉		☉				
	EXOTIC ALLOY	S	● ●	● ●	● ●	● ●	☉ ☉	☉	☉ ☉	☉			
	STEEL	H	○		●		○	☉		☉			

MACHINING TYPES	SECONDARY USE	PRIMARY USE	CONTINUOUS CUTTING	GENERAL CUTTING	INTERRUPTED CUTTING
	○	●			
	☉	☐			
	☉☉	☐☐			
	☉☉☉	☐☐☐			
	☉☉☉☉	☐☐☐☐			

		MACHINING MATERIAL GROUPE →														Exotic alloy Groupe		
		Vc (M/MIN) CUTTING SPEED →														S1 - High temperature resistant alloys S2 - Pure titanium (Vc +100%) S3 - Titanium alloys		
GEOMETRY ↓		GRADE → DESIGNATION ↓		B22-V2	A22-J2	E21-L1	E22-AO2	E31-N1	E31-M1	B32-S2	B42-W2	E42-AP2	E41-O1	B62-Y2	B72-M2		F (MM/REV) FEED RATE ↓	AP (MM) DEPTH OF CUT ↓
M2 		CCMT 09T304-M2				●							●				0,20 - 0,45	1,0 - 5,0
M11 		CCMT 09T302-M11		●								●					0,05 -0,20	0,3 - 2,0
		CCMT 09T304-M11		●								●						0,06 -0,20
MF17 		CCGT 09T304-MF17			●												0,08 - 0,25	0,6 - 4,0
F10 		CCMT 09T302-F10		●								●					0,04 - 0,12	0,1 - 1,0
		CCMT 09T304-F10		●								●						0,05 - 0,16

ORDER EXAMPLE: CCMT 09T304-M A31-A1

CARBIDE

CC09T3

80°

DIAMOND

7° POSITIVE

EXOTIC ALLOY

9,52	d	INSCRIBED CIRCLE
9,70	l	CUTTING EDGE LENGTH
3,97	s	THICKNESS

TOLERANCE CLASSES	CLASS	m	d	s
	E	± 0,025	± 0,025	± 0,025
	G	± 0,025	± 0,025	± 0,13
	H	± 0,013	± 0,013	± 0,025
	M	± 0,08	± 0,05	± 0,13
	U	± 0,13	± 0,08	± 0,13

SECONDARY USE

PRIMARY USE

MACHINING MATERIAL	STEEL	P	○●			●●	⊖			⊕⊕	
	STAINLESS STEEL	M	●○	○	●	●●	⊖		●	⊕⊕	
	CAST IRON	K	○●				○⊖			⊕	
	NON-FERROUS METAL	N	○			●	○⊖			⊕	
	EXOTIC ALLOY	S	●●	●●	●	●●	●●	⊖⊖	⊖	⊕⊕	
	STEEL	H	○		●			○⊖		⊕	

MACHINING TYPES

○●

●○

○

●

⊖

⊕

⊕⊕

⊖⊖

⊕⊖

⊖⊕

CONTINUOUS CUTTING

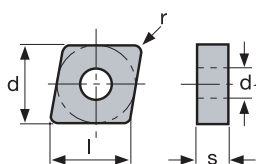
GENERAL CUTTING

INTERRUPTED CUTTING

GEOMETRY ↓	DESIGNATION ↓	MACHINING MATERIAL GROUPE → Vc (M/MIN) CUTTING SPEED →												Exotic alloy Groupe	
		GRADE →												F (MM/REV) FEED RATE ↓	AP (MM) DEPTH OF CUT ↓
		B22-V2	A22-J2	E21-L1	E22-AO2	E31-N1	E31-M1	B32-S2	B42-W2	E42-AP2	E41-O1	B62-Y2	B72-M2		
F11 	CCGT 09T302-F11							●						0,05 - 0,12	0,2 - 2,0
	CCGT 09T304-F11							●						0,08 - 0,25	0,2 - 2,5
F12 	CCGT 09T304-F12	●												0,08 - 0,25	0,2 - 2,5
	CCGT 09T308-F12	●												0,10 - 0,30	0,3 - 3,0

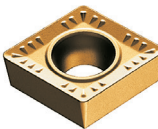
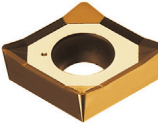
CARBIDE	CC 1204	80°	EXOTIC ALLOY
		DIAMOND	
		7° POSITIVE	

12,70	d	INSCRIBED CIRCLE
12,90	l	CUTTING EDGE LENGTH
4,76	s	THICKNESS



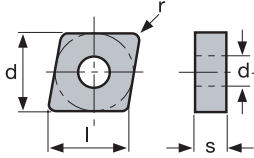
TOLERANCE CLASSES	CLASS	m	d	s
	E	± 0,025	± 0,025	± 0,025
	G	± 0,025	± 0,025	± 0,13
	H	± 0,013	± 0,013	± 0,025
	M	± 0,13	± 0,08	± 0,13
	U	± 0,20	± 0,13	± 0,13

MACHINING MATERIAL	STEEL	P	TOLERANCE CLASSES	CLASS	m	d	s	MACHINING TYPES	SECONDARY USE	PRIMARY USE	CONTINUOUS CUTTING	GENERAL CUTTING	INTERRUPTED CUTTING
	STAINLESS STEEL	M											
	CAST IRON	K											
	NON-FERROUS METAL	N											
	EXOTIC ALLOY	S											
	STEEL	H											

GEOMETRY ↓		MACHINING MATERIAL GROUPE →		Exotic alloy Groupe											
		Vc (M/MIN) CUTTING SPEED →		S1 - High temperature resistant alloys S2 - Pure titanium (Vc +100%) S3 - Titanium alloys											
GRADE → DESIGNATION ↓		B22-V2	A22-J2	E21-L1	E22-AO2	E31-N1	E31-M1	B32-S2	B42-W2	E42-AP2	E41-O1	B62-Y2	B72-M2	F (MM/REV) FEED RATE ↓	AP (MM) DEPTH OF CUT ↓
M10 	CCMT 120404-M10								●					0,12 - 0,25	0,4 - 3,5
	CCMT 120408-M10								●					0,12 - 0,32	0,5 - 3,5
MF17 	CCGT 120404-MF17		●											0,08 - 0,25	0,6 - 5,0

CARBIDE	CN 1204	80°	EXOTIC ALLOY
		DIAMOND	
		0° NEGATIVE	

12,70	d	INSCRIBED CIRCLE
12,90	l	CUTTING EDGE LENGTH
4,76	s	THICKNESS



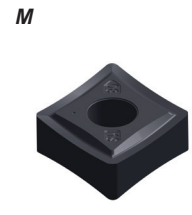
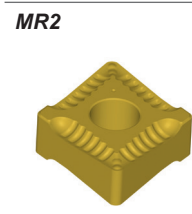
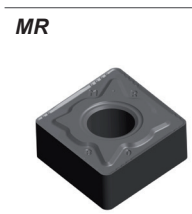
TOLERANCE CLASSES	CLASS	m	d	s
	E	± 0,025	± 0,025	± 0,025
	G	± 0,025	± 0,025	± 0,13
	H	± 0,013	± 0,013	± 0,025
	M	± 0,13	± 0,08	± 0,13
	U	± 0,20	± 0,13	± 0,13

MACHINING TYPES	SECONDARY USE		PRIMARY USE	

MACHINING MATERIAL	STEEL	P
	STAINLESS STEEL	M
	CAST IRON	K
	NON-FERROUS METAL	N
	EXOTIC ALLOY	S
	STEEL	H

GEOMETRY	GRADE → DESIGNATION	MACHINING MATERIAL GROUPE → Vc (M/MIN) CUTTING SPEED →											
		S1,2,3	S1	S2,3	S3	S1	S2,3	S1,2,3	S1,2,3	S3	S1	S1,2,3	S1,2,3
		B22-V2	A22-J2	E21-L1	E22-AO2	E31-N1	E31-M1	B32-S2	B42-W2	E42-AP2	E41-O1	B62-Y2	B72-M2

Exotic alloy Groupe	
S1 - High temperature resistant alloys	
S2 - Pure titanium (Vc +100%)	
S3 - Titanium alloys	
F (MM/REV) FEED RATE	AP (MM) DEPTH OF CUT
0,20 - 0,40	0,8 - 6,0
0,25 - 0,60	1,0 - 6,0
0,20 - 0,50	1,2 - 6,0
0,20 - 0,50	1,2 - 6,0
0,20 - 0,45	1,0 - 3,2
0,20 - 0,40	1,0 - 3,5
0,20 - 0,40	1,0 - 3,5
0,20 - 0,40	1,0 - 3,5
0,20 - 0,40	1,0 - 3,5
0,20 - 0,40	1,0 - 3,5
0,20 - 0,40	1,0 - 3,5



ORDER EXAMPLE: CCMT 09T304-M A31-A1

CARBIDE

CN1204

80°

DIAMOND

0° NEGATIVE

EXOTIC ALLOY

12,70	d INSCRIBED CIRCLE
12,90	l CUTTING EDGE LENGTH
4,76	s THICKNESS

TOLERANCE CLASSES	CLASS	m	d	s
	E	± 0,025	± 0,025	± 0,025
	G	± 0,025	± 0,025	± 0,13
	H	± 0,013	± 0,013	± 0,025
	M	± 0,13	± 0,08	± 0,13
	U	± 0,20	± 0,13	± 0,13

SECONDARY USE

PRIMARY USE

MACHINING MATERIAL	STEEL	P	○	●				●	●	⌚			⌚	⌚	
	STAINLESS STEEL	M	●	○		○	●	●	●	⌚		●	⌚	⌚	
	CAST IRON	K	○	●					○	⌚			⌚		
	NON-FERROUS METAL	N	○				●	○	⌚				⌚		
	EXOTIC ALLOY	S	●	●	●	●	●	●	●	⌚	●	●	⌚	⌚	
	STEEL	H	○			●			○	⌚			⌚		

MACHINING TYPES

○

⌚

⌚

●

⌚

⌚

CONTINUOUS CUTTING

GENERAL CUTTING

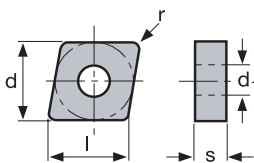
INTERRUPTED CUTTING

[illegible]

ORDER EXAMPLE: CCMT 09T304-M A31-A1

CARBIDE	CN 1906	80°	EXOTIC ALLOY
		DIAMOND	
		0° NEGATIVE	

19,05	d	INSCRIBED CIRCLE
19,30	l	CUTTING EDGE LENGTH
6,35	s	THICKNESS



TOLERANCE CLASSES	CLASS	m	d	s
	E	± 0,025	± 0,025	± 0,025
	G	± 0,025	± 0,025	± 0,13
	H	± 0,013	± 0,013	± 0,025
	M	± 0,15	± 0,10	± 0,13
	U	± 0,27	± 0,18	± 0,13

MACHINING MATERIAL	STEEL	P	○	●				●	●	☉			☉	☉	
	STAINLESS STEEL	M	●	○		○	●	●	●	☉		●	☉	☉	
	CAST IRON	K	○	●					○	☉			☉		
	NON-FERROUS METAL	N	○				●	○	☉				☉		
	EXOTIC ALLOY	S	●	●	●	●	●	●	●	☉	☉	☉	☉	☉	
	STEEL	H	○			●			○	☉			☉		

MACHINING TYPES

SECONDARY USE

PRIMARY USE



CONTINUOUS CUTTING

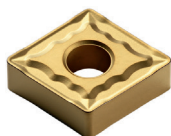


GENERAL CUTTING



INTERRUPTED CUTTING

GEOMETRY ↓	GRADE → DESIGNATION	MACHINING MATERIAL GROUPE → Vc (M/MIN) CUTTING SPEED →												Exotic alloy Groupe	
		S1,2,3	S1	S2,3	S3	S1	S2,3	S1,2,3	S1,2,3	S3	S1	S1,2,3	S1,2,3		
R7	CNMG 190612-R7	B22-V2	A22-J2	E21-L1	E22-AO2	E31-N1	E31-M1	B32-S2	B42-W2	E42-AP2	E41-O1	B62-Y2	B72-M2	F (MM/REV) FEED RATE ↓	AP (MM) DEPTH OF CUT ↓
									●					0,25 - 0,65	1,2 - 10,0
	CNMG 190616-R7											●		0,35 - 0,80	1,6 - 10,0



CARBIDE

DC
0702

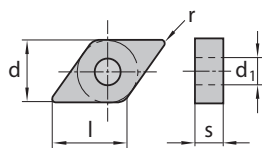
55°

DIAMOND

7° POSITIVE

EXOTIC ALLOY

6,35	d	INSCRIBED CIRCLE
7,70	l	CUTTING EDGE LENGTH
2,38	s	THICKNESS



TOLERANCE CLASSES	CLASS	m	d	s
	E	± 0,025	± 0,025	± 0,025
	G	± 0,025	± 0,025	± 0,13
	H	± 0,013	± 0,013	± 0,025
	M	± 0,08	± 0,05	± 0,13
	U	± 0,13	± 0,08	± 0,13

SECONDARY USE

PRIMARY USE

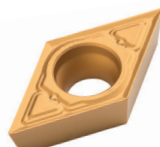
MACHINING MATERIAL	STEEL	P														
	STAINLESS STEEL	M														
	CAST IRON	K														
	NON-FERROUS METAL	N														
	EXOTIC ALLOY	S														
	STEEL	H														

MACHINING TYPES

CONTINUOUS CUTTING

GENERAL CUTTING

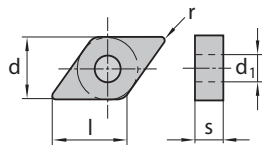
INTERRUPTED CUTTING

		MACHINING MATERIAL GROUPE →												Vc (M/MIN) CUTTING SPEED →		Exotic alloy Groupe	
																S1 - High temperature resistant alloys S2 - Pure titanium (Vc +100%) S3 - Titanium alloys	
		GRADE →															
GEOMETRY ↓	DESIGNATION ↓	B22-V2	A22-J2	E21-L1	E22-AO2	E31-N1	E31-M1	B32-S2	B42-W2	E42-AP2	E41-O1	B62-Y2	B72-M2			F (MM/REV) FEED RATE ↓	AP (MM) DEPTH OF CUT ↓
E-M1 	DCGT 0702008 FL-M1						●									0,10 - 0,30	0,5 - 4,0
	DCGT 0702008 FR-M1						●									0,10 - 0,30	0,5 - 4,0
	DCGT 0702015 FL-M1						●									0,10 - 0,30	0,5 - 4,0
	DCGT 0702015 FR-M1						●									0,10 - 0,30	0,5 - 4,0
M11 	DCMT 070202-M11	●							●							0,08 - 0,15	0,4 - 1,5
	DCMT 070204-M11	●							●							0,08 - 0,22	0,4 - 2,5
- 	DCGT 0702008						●									0,05 - 0,20	0,1 - 1,0
	DCGT 0702015						●									0,05 - 0,20	0,1 - 1,0
MF17 	DCGT 070204-MF17		●													0,08 - 0,25	0,6 - 2,5

ORDER EXAMPLE: CCMT 09T304-M A31-A1

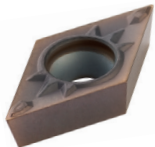
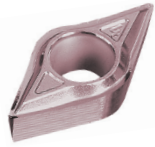
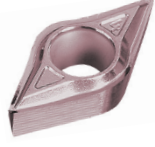
CARBIDE	DC 0702	55°	EXOTIC ALLOY
		DIAMOND	
		7° POSITIVE	

6,35	d INSCRIBED CIRCLE
7,70	l CUTTING EDGE LENGTH
2,38	s THICKNESS



TOLERANCE CLASSES	CLASS	m	d	s
	E	± 0,025	± 0,025	± 0,025
	G	± 0,025	± 0,025	± 0,13
	H	± 0,013	± 0,013	± 0,025
	M	± 0,08	± 0,05	± 0,13
	U	± 0,13	± 0,08	± 0,13

MACHINING MATERIAL	STEEL	P	TOLERANCE CLASSES	CLASS	m	d	s	MACHINING TYPES	SECONDARY USE	PRIMARY USE	CUTTING TYPE
	STAINLESS STEEL	M									
	CAST IRON	K									
	NON-FERROUS METAL	N									
	EXOTIC ALLOY	S									
	STEEL	H									

GEOMETRY ↓	DESIGNATION ↓	GRADE →	MACHINING MATERIAL GROUPE →	Vc (M/MIN) CUTTING SPEED →	Exotic alloy Groupe	
					F (MM/REV) FEED RATE ↓	AP (MM) DEPTH OF CUT ↓
F10 	DCMT 070202-F10	●			0,04 - 0,12	0,1 - 1,0
	DCMT 070204-F10	●			0,05 - 0,16	0,1 - 1,5
F11 	DCGT 0702015-F11				0,05 - 0,12	0,2 - 2,0
	DCGT 070201-F11				0,02 - 0,06	0,1 - 1,5
	DCGT 070202-F11				0,05 - 0,12	0,2 - 2,0
	DCGT 070204-F11				0,08 - 0,25	0,2 - 2,5
F12 	DCGT 070202-F12	●			0,05 - 0,12	0,2 - 2,0
	DCGT 070204-F12	●			0,08 - 0,25	0,2 - 2,5

CARBIDE

DC

11T3

55°

DIAMOND

7° POSITIVE

EXOTIC ALLOY

9,52

d

INSCRIBED CIRCLE

11,60

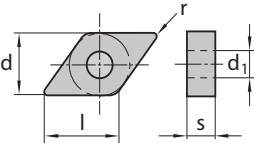
l

CUTTING EDGE LENGTH

3,97

s

THICKNESS



TOLERANCE CLASSES

CLASS	m	d	s
E	± 0,025	± 0,025	± 0,025
G	± 0,025	± 0,025	± 0,13
H	± 0,013	± 0,013	± 0,025
M	± 0,08	± 0,05	± 0,13
U	± 0,13	± 0,08	± 0,13

MACHINING MATERIAL

STEEL	P	○ ●				● ●	☉		☉ ☉	☉	
STAINLESS STEEL	M	● ○	○	● ●	● ●	☉		☉ ☉	☉		
CAST IRON	K	○ ●				○	☉		☉		
NON-FERROUS METAL	N	○			● ○	☉		☉			
EXOTIC ALLOY	S	● ●	● ●	● ●	● ●	☉ ☉	☉	☉ ☉	☉		
STEEL	H	○		●		○	☉		☉		

MACHINING TYPES

SECONDARY USE

PRIMARY USE

○ ●

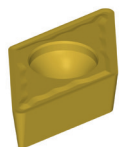
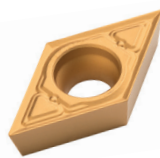
☉ ●

☉ ☉

CONTINUOUS CUTTING

GENERAL CUTTING

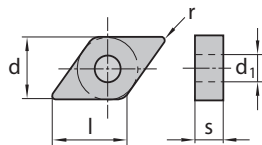
INTERRUPTED CUTTING

		MACHINING MATERIAL GROUPE →										Vc (M/MIN) CUTTING SPEED →		Exotic alloy Groupe	
														S1 - High temperature resistant alloys S2 - Pure titanium (Vc +100%) S3 - Titanium alloys	
		GRADE →													
GEOMETRY ↓		DESIGNATION ↓												F (MM/REV) FEED RATE ↓	
														AP (MM) DEPTH OF CUT ↓	
MR1		DCMT 11T304-MR1					●							0,20 - 0,50	0,5 - 9,1
E-M1		DCGT 11T3015 FL-M1					●							0,10 - 0,30	0,5 - 4,0
		DCGT 11T3015 FR-M1					●							0,10 - 0,30	0,5 - 4,0
		DCGT 11T3035 FL-M1					●							0,10 - 0,30	0,5 - 4,0
		DCGT 11T3035 FR-M1					●							0,10 - 0,30	0,5 - 4,0
M2		DCMT 11T304-M2			●						●			0,20 - 0,45	1,0 - 5,0
		DCMT 11T308-M2			●						●			0,20 - 0,45	1,0 - 5,0
M11		DCMT 11T302-M11	●							●				0,08 - 0,15	0,4 - 1,5
		DCMT 11T304-M11	●							●				0,08 - 0,22	0,4 - 2,5

ORDER EXAMPLE: CCMT 09T304-M A31-A1

CARBIDE	DC 11T3	55°	EXOTIC ALLOY
		DIAMOND	
		7° POSITIVE	

9,52	d	INSCRIBED CIRCLE
11,60	l	CUTTING EDGE LENGTH
3,97	s	THICKNESS



TOLERANCE CLASSES	CLASS	m	d	s
	E	± 0,025	± 0,025	± 0,025
	G	± 0,025	± 0,025	± 0,13
	H	± 0,013	± 0,013	± 0,025
	M	± 0,08	± 0,05	± 0,13
	U	± 0,13	± 0,08	± 0,13

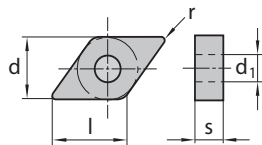
MACHINING MATERIAL	STEEL	P	TOLERANCE CLASSES	CLASS	m	d	s	MACHINING TYPES	SECONDARY USE	PRIMARY USE	CONTINUOUS CUTTING	GENERAL CUTTING	INTERRUPTED CUTTING
	STAINLESS STEEL	M											
	CAST IRON	K											
	NON-FERROUS METAL	N											
	EXOTIC ALLOY	S											
	STEEL	H											

GEOMETRY	DESIGNATION	GRADE	MACHINING MATERIAL GROUPE →	Vc (M/MIN) CUTTING SPEED →	Exotic alloy Groupe									
					S1 - High temperature resistant alloys S2 - Pure titanium (Vc +100%) S3 - Titanium alloys									
					F (MM/REV) FEED RATE ↓ AP (MM) DEPTH OF CUT ↓									
	DCGT 11T3015												0,05 - 0,20	0,1 - 1,0
	DCGT 11T3035												0,05 - 0,20	0,1 - 1,0
MF17 	DCGT 11T304-MF17												0,08 - 0,25	0,6 - 3,0
F10 	DCMT 11T302-F10												0,04 - 0,12	0,1 - 1,0
	DCMT 11T304-F10												0,05 - 0,16	0,1 - 1,5
F11 	DCGT 11T3015-F11												0,05 - 0,12	0,2 - 2,0
	DCGT 11T301-F11												0,02 - 0,06	0,1 - 1,5
	DCGT 11T302-F11												0,05 - 0,12	0,2 - 2,0
	DCGT 11T3035-F11												0,08 - 0,25	0,2 - 2,5
	DCGT 11T304-F11												0,08 - 0,25	0,2 - 2,5
	DCGT 11T308-F11												0,10 - 0,30	0,3 - 3,0

ORDER EXAMPLE: CCMT 09T304-M A31-A1

CARBIDE	DC 11T3	55°	EXOTIC ALLOY
		DIAMOND	
		7° POSITIVE	

9,52	d	INSCRIBED CIRCLE
11,60	l	CUTTING EDGE LENGTH
3,97	s	THICKNESS



TOLERANCE CLASSES	CLASS	m	d	s
	E	± 0,025	± 0,025	± 0,025
	G	± 0,025	± 0,025	± 0,13
	H	± 0,013	± 0,013	± 0,025
	M	± 0,08	± 0,05	± 0,13
	U	± 0,13	± 0,08	± 0,13

MACHINING MATERIAL	STEEL	P	○	●				●	●	☉			☉	☉	
	STAINLESS STEEL	M	●	○		○	●	●	●	☉		☉	☉	☉	
	CAST IRON	K	○	●					○	☉			☉		
	NON-FERROUS METAL	N	○				●	○	☉				☉		
	EXOTIC ALLOY	S	●	●	●	●	●	●	●	☉	☉	☉	☉	☉	
	STEEL	H	○			●			○	☉			☉		

MACHINING TYPES

SECONDARY USE

PRIMARY USE



CONTINUOUS CUTTING

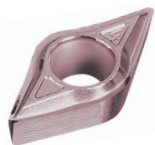


GENERAL CUTTING



INTERRUPTED CUTTING

GEOMETRY ↓	DESIGNATION ↓	MACHINING MATERIAL GROUPE → VC (M/MIN) CUTTING SPEED →												Exotic alloy Groupe	
		GRADE →												F (MM/REV) FEED RATE ↓	AP (MM) DEPTH OF CUT ↓
		B22-V2	A22-J2	E21-L1	E22-AO2	E31-N1	E31-M1	B32-S2	B42-W2	E42-AP2	E41-O1	B62-Y2	B72-M2		
F12	DCGT 11T304-F12	●												0,08 - 0,25	0,2 - 2,5
	DCGT 11T308-F12	●												0,10 - 0,30	0,3 - 3,0



CARBIDE

DN

1504

55°

DIAMOND

0° NEGATIVE

EXOTIC ALLOY

12,70	d INSCRIBED CIRCLE
15,50	l CUTTING EDGE LENGTH
4,76	s THICKNESS

TOLERANCE CLASSES	CLASS	m	d	s
	E	± 0,025	± 0,025	± 0,025
	G	± 0,025	± 0,025	± 0,13
	H	± 0,013	± 0,013	± 0,025
	M	± 0,13	± 0,08	± 0,13
	U	± 0,20	± 0,13	± 0,13

MACHINING MATERIAL	STEEL	P	○	●				●	●	⌚			⌚	⌚	
	STAINLESS STEEL	M	●	○		○	●	●	●	⌚		●	⌚	⌚	
	CAST IRON	K	○	●					○	⌚			⌚		
	NON-FERROUS METAL	N	○				●	○	⌚				⌚		
	EXOTIC ALLOY	S	●	●	●	●	●	●	●	⌚	●	●	⌚	⌚	
	STEEL	H	○			●			○	⌚			⌚		

SECONDARY USE

PRIMARY USE

○

●

CONTINUOUS CUTTING

GENERAL CUTTING

INTERRUPTED CUTTING

MACHINING TYPES

○

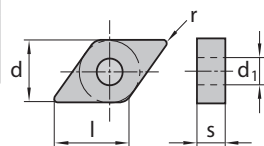
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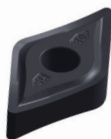
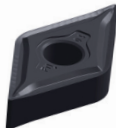
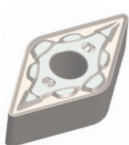
CARBIDE	DN 1506	55°	EXOTIC ALLOY
		DIAMOND	
		0° NEGATIVE	

12,70	d INSCRIBED CIRCLE
15,50	l CUTTING EDGE LENGTH
6,35	s THICKNESS



TOLERANCE CLASSES	CLASS	m	d	s
	E	± 0,025	± 0,025	± 0,025
	G	± 0,025	± 0,025	± 0,13
	H	± 0,013	± 0,013	± 0,025
	M	± 0,13	± 0,08	± 0,13
	U	± 0,20	± 0,13	± 0,13

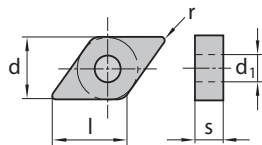
MACHINING MATERIAL	STEEL	P	TOLERANCE CLASSES	CLASS	m	d	s	MACHINING TYPES	SECONDARY USE	PRIMARY USE	CONTINUOUS CUTTING
	STAINLESS STEEL	M									
	CAST IRON	K									
	NON-FERROUS METAL	N									
	EXOTIC ALLOY	S									
	STEEL	H									

		MACHINING MATERIAL GROUPE →		Exotic alloy Groupe															
																VC (M/MIN) CUTTING SPEED →			
GEOMETRY ↓		GRADE → DESIGNATION ↓		B22-V2	A22-J2	E21-L1	E22-AO2	E31-N1	E31-M1	B32-S2	B42-W2	E42-AP2	E41-O1	B62-Y2	B72-M2			F (MM/REV) FEED RATE ↓	AP (MM) DEPTH OF CUT ↓
M 	DNMG 150604-M					●												0,20 - 0,40	1,0 - 3,5
	DNMG 150608-M					●												0,20 - 0,40	1,0 - 3,5
	DNMG 150612-M					●												0,20 - 0,40	1,0 - 3,5
M1 	DNMG 150604-M1					●								●				0,10 - 0,30	0,5 - 4,0
	DNMG 150608-M1					●								●				0,10 - 0,30	0,5 - 4,0
	DNMG 150612-M1					●								●				0,10 - 0,30	0,5 - 4,0
M2 	DNMG 150608-M2			●										●				0,20 - 0,45	1,0 - 5,0
M8 	DNMG 150604-M8										●							0,08 - 0,22	0,4 - 2,5
	DNMG 150608-M8										●							0,12 - 0,28	0,6 - 4,0

ORDER EXAMPLE: CCMT 09T304-M A31-A1

CARBIDE	DN 1506	55°	EXOTIC ALLOY
		DIAMOND	
		0° NEGATIVE	

12,70	d	INSCRIBED CIRCLE
15,50	l	CUTTING EDGE LENGTH
6,35	s	THICKNESS



TOLERANCE CLASSES	CLASS	m	d	s
	E	± 0,025	± 0,025	± 0,025
	G	± 0,025	± 0,025	± 0,13
	H	± 0,013	± 0,013	± 0,025
	M	± 0,13	± 0,08	± 0,13
	U	± 0,20	± 0,13	± 0,13

MACHINING MATERIAL	STEEL	P	○	●					●	●	☺			☺	☺	
	STAINLESS STEEL	M	●	○		○	●	●	●	●	☹		●	☹	☹	
	CAST IRON	K	○	●						○	☺			☺		
	NON-FERROUS METAL	N	○					●	○	☺				☺		
	EXOTIC ALLOY	S	●	●	●	●	●	●	●	●	☹	☹	☹	☹	☹	
	STEEL	H	○			●			○	☺				☺		

MACHINING TYPES

SECONDARY USE

PRIMARY USE


 CONTINUOUS
CUTTING

 GENERAL
CUTTING

 INTERRUPTED
CUTTING

GEOMETRY ↓	GRADE → DESIGNATION	MACHINING MATERIAL GROUPE → VC (M/MIN) CUTTING SPEED →												Exotic alloy Groupe	
		S1,2,3	S1	S2,3	S3	S1	S2,3	S1,2,3	S1,2,3	S3	S1	S1,2,3	S1,2,3	S1 - High temperature resistant alloys S2 - Pure titanium (Vc +100%) S3 - Titanium alloys	
		15-90	15-70	30-70	30-80	20-100	30-70	15-80	15-80	30-70	20-100	15-70	5-35		
F4		B22-V2	A22-J2	E21-L1	E22-AO2	E31-N1	E31-M1	B32-S2	B42-W2	E42-AP2	E41-O1	B62-Y2	B72-M2	F (MM/REV) FEED RATE ↓	AP (MM) DEPTH OF CUT ↓
	DNMG 150604-F4	●			●				●	●				0,06 - 0,16	0,4 - 1,5
	DNMG 150608-F4				●				●	●				0,08 - 0,19	0,5 - 2,0



CARBIDE

SC09T3

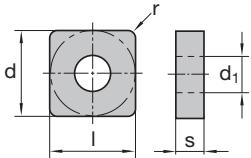
90°

SQUARE

7° POSITIVE

EXOTIC ALLOY

9,52	d INSCRIBED CIRCLE
9,70	l CUTTING EDGE LENGTH
3,97	s THICKNESS



TOLERANCE CLASSES	CLASS	m	d	s
	E	± 0,025	± 0,025	± 0,025
	G	± 0,025	± 0,025	± 0,13
	H	± 0,013	± 0,013	± 0,025
	M	± 0,08	± 0,05	± 0,13
	U	± 0,13	± 0,08	± 0,13

MACHINING MATERIAL	STEEL	P	○	●				●	●	⌚			⌚	⌚	
	STAINLESS STEEL	M	●	○		○	●	●	●	⌚		●	⌚	⌚	
	CAST IRON	K	○	●					○	⌚			⌚		
	NON-FERROUS METAL	N	○				●	○	⌚				⌚		
	EXOTIC ALLOY	S	●	●	●	●	●	●	●	⌚	●	●	⌚	⌚	
	STEEL	H	○			●			○	⌚			⌚		

SECONDARY USE

PRIMARY USE

○

●

⌚

⌚

CONTINUOUS CUTTING

GENERAL CUTTING

INTERRUPTED CUTTING

MACHINING TYPES

[illegible]

CARBIDE

SC
1204

90°

SQUARE

7° POSITIVE

EXOTIC ALLOY

12,70	d INSCRIBED CIRCLE
12,70	I CUTTING EDGE LENGTH
4,76	S THICKNESS

TOLERANCE CLASSES	CLASS	m	d	s
	E	± 0,025	± 0,025	± 0,025
	G	± 0,025	± 0,025	± 0,13
	H	± 0,013	± 0,013	± 0,025
	M	± 0,13	± 0,08	± 0,13
	U	± 0,20	± 0,13	± 0,13

SECONDARY USE

PRIMARY USE

MACHINING MATERIAL

STEEL	P	○	●				●	●	☺			☺	☺	
STAINLESS STEEL	M	●	○		○	●	●	●	☹		☹	☹	☹	
CAST IRON	K	○	●					○	☺			☺		
NON-FERROUS METAL	N	○				●	○	☺				☺		
EXOTIC ALLOY	S	●	●	●	●	●	●	●	☹	☹	☹	☹	☹	
STEEL	H	○			●			○	☺			☺		

MACHINING TYPES

○

☺

☹

☺

●

☹

☹

☹

CONTINUOUS CUTTING

GENERAL CUTTING

INTERRUPTED CUTTING

[illegible]

[illegible][illegible]

CARBIDE

TC

1102

60°

TRIANGLE

7° POSITIVE

EXOTIC ALLOY

6,35	d INSCRIBED CIRCLE
11,00	l CUTTING EDGE LENGTH
2,38	s THICKNESS

TOLERANCE CLASSES	CLASS	m	d	s
	E	± 0,025	± 0,025	± 0,025
	G	± 0,025	± 0,025	± 0,13
	H	± 0,013	± 0,013	± 0,025
	M	± 0,08	± 0,05	± 0,13
	U	± 0,13	± 0,08	± 0,13

MACHINING MATERIAL

STEEL	P	○	●				●	●	☉			☿	☿		
STAINLESS STEEL	M	●	○		○	●	●	●	☉		☉	☿	☿		
CAST IRON	K	○	●					○	☉			☿			
NON-FERROUS METAL	N	○					●	○	☉			☿			
EXOTIC ALLOY	S	●	●	●	●	●	●	●	☉	☉	☉	☿	☿		
STEEL	H	○			●			○	☉			☿			

MACHINING TYPES

○	●	CONTINUOUS CUTTING
☉	☿	GENERAL CUTTING
☿	☿	INTERRUPTED CUTTING

SECONDARY USE

PRIMARY USE

[illegible]

CARBIDE

TC
16T3

60°
TRIANGLE
7° POSITIVE

EXOTIC ALLOY

9,52	d INSCRIBED CIRCLE
16,50	l CUTTING EDGE LENGTH
3,97	s THICKNESS

TOLERANCE CLASSES	CLASS	m	d	s
	E	± 0,025	± 0,025	± 0,025
G	± 0,025	± 0,025	± 0,13	
H	± 0,013	± 0,013	± 0,025	
M	± 0,08	± 0,05	± 0,13	
U	± 0,13	± 0,08	± 0,13	

SECONDARY USE

PRIMARY USE

CONTINUOUS CUTTING

GENERAL CUTTING

INTERRUPTED CUTTING

MACHINING MATERIAL

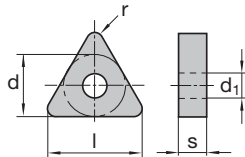
STEEL	P	○	●				●	●	☉			☿	☿		
STAINLESS STEEL	M	●	○		○	●	●	●	☉		☉	☿	☿		
CAST IRON	K	○	●					○	☉			☿			
NON-FERROUS METAL	N	○					●	○	☉			☿			
EXOTIC ALLOY	S	●	●	●	●	●	●	●	☉	☉	☉	☿	☿		
STEEL	H	○			●			○	☉			☿			

MACHINING TYPES

[illegible]

CARBIDE	TN 1604	60°	EXOTIC ALLOY
		TRIANGLE	
		0° NEGATIVE	

9,52	d	INSCRIBED CIRCLE
16,50	l	CUTTING EDGE LENGTH
4,76	s	THICKNESS



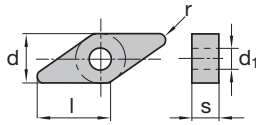
TOLERANCE CLASSES	CLASS	m	d	s
	E	± 0,025	± 0,025	± 0,025
	G	± 0,025	± 0,025	± 0,13
	H	± 0,013	± 0,013	± 0,025
	M	± 0,08	± 0,05	± 0,13
	U	± 0,13	± 0,08	± 0,13

MACHINING MATERIAL	STEEL	P	TOLERANCE CLASSES	CLASS	m	d	s	MACHINING TYPES	SECONDARY USE	PRIMARY USE	CUTTING TYPE
	STAINLESS STEEL	M									
	CAST IRON	K									
	NON-FERROUS METAL	N									
	EXOTIC ALLOY	S									
	STEEL	H									

GEOMETRY ↓	GRADE → DESIGNATION	MACHINING MATERIAL GROUPE → Vc (M/MIN) CUTTING SPEED →												Exotic alloy Groupe	
														F (MM/REV) FEED RATE ↓	AP (MM) DEPTH OF CUT ↓
		S1,2,3	S1	S2,3	S3	S1	S2,3	S1,2,3	S1,2,3	S3	S1	S1,2,3	S1,2,3		
M8 	TNMG 160404-M8													0,08 - 0,20	0,6 - 3,0
	TNMG 160408-M8													0,12 - 0,30	1,0 - 4,0
F4 	TNMG 160404-F4	●			●			●	●					0,08 - 0,17	0,4 - 1,5
	TNMG 160408-F4	●			●			●	●					0,10 - 0,20	0,5 - 2,0

CARBIDE	VC 0501	35°	EXOTIC ALLOY
		DIAMOND	
		7° POSITIVE	

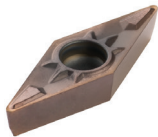
3,10	d	INSCRIBED CIRCLE
5,40	l	CUTTING EDGE LENGTH
1,59	s	THICKNESS



TOLERANCE CLASSES	CLASS	m	d	s
	E	± 0,025	± 0,025	± 0,025
	G	± 0,025	± 0,025	± 0,13
	H	± 0,013	± 0,013	± 0,025
	M	± 0,08	± 0,05	± 0,13
	U	± 0,13	± 0,08	± 0,13

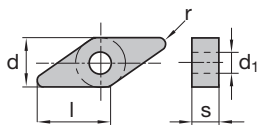
MACHINING MATERIAL	STEEL	P	TOLERANCE CLASSES	CLASS	m	d	s	MACHINING TYPES	SECONDARY USE	PRIMARY USE	CUTTING TYPE
	STAINLESS STEEL	M									
	CAST IRON	K									
	NON-FERROUS METAL	N									
	EXOTIC ALLOY	S									
	STEEL	H									

GEOMETRY ↓	DESIGNATION ↓	GRADE →	MACHINING MATERIAL GROUPE →	VC (M/MIN) CUTTING SPEED →	Exotic alloy Groupe	
					S1 - High temperature resistant alloys	S2 - Pure titanium (Vc +100%)
					S3 - Titanium alloys	
F10	VC050101-F10	VC050102-F10	VC050104-F10		F (MM/REV) FEED RATE	AP (MM) DEPTH OF CUT
					0,04 - 0,15	0,05 - 1,0
					0,04 - 0,20	0,1 - 2,5
					0,05 - 0,16	0,1 - 1,5



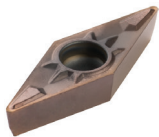
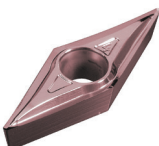
CARBIDE	VC 0702	35°	EXOTIC ALLOY
		DIAMOND	
		7° POSITIVE	

3,97	d	INSCRIBED CIRCLE
6,85	l	CUTTING EDGE LENGTH
2,38	s	THICKNESS



TOLERANCE CLASSES	CLASS	m	d	s
	E	± 0,025	± 0,025	± 0,025
	G	± 0,025	± 0,025	± 0,13
	H	± 0,013	± 0,013	± 0,025
	M	± 0,08	± 0,05	± 0,13
	U	± 0,13	± 0,08	± 0,13

MACHINING MATERIAL	STEEL	P	TOLERANCE CLASSES	CLASS	m	d	s	MACHINING TYPES	SECONDARY USE	PRIMARY USE	CONTINUOUS CUTTING	GENERAL CUTTING	INTERRUPTED CUTTING
	STAINLESS STEEL	M											
	CAST IRON	K											
	NON-FERROUS METAL	N											
	EXOTIC ALLOY	S											
	STEEL	H											

GEOMETRY ↓	DESIGNATION ↓	GRADE →	MACHINING MATERIAL GROUPE →	VC (M/MIN) CUTTING SPEED →	Exotic alloy Groupe	
					F (MM/REV) FEED RATE ↓	AP (MM) DEPTH OF CUT ↓
F10 	VCMT 070202-F10				0,04 - 0,20	0,1 - 2,5
	VCMT 070204-F10				0,05 - 0,16	0,1 - 1,5
F11 	VCMT 070202-F11				0,02 - 0,06	0,1 - 1,0

CARBIDE

VC
1103

35°

DIAMOND

7° POSITIVE

EXOTIC ALLOY

6,35

d

INSCRIBED CIRCLE

11,10

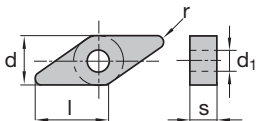
l

CUTTING EDGE LENGTH

3,18

s

THICKNESS



TOLERANCE CLASSES

CLASS	m	d	s
E	± 0,025	± 0,025	± 0,025
G	± 0,025	± 0,025	± 0,13
H	± 0,013	± 0,013	± 0,025
M	± 0,08	± 0,05	± 0,13
U	± 0,13	± 0,08	± 0,13

MACHINING MATERIAL

STEEL	P	○	●				●	●	⌚			⌚	⌚	
STAINLESS STEEL	M	●	○		○	●	●	●	⌚		●	⌚	⌚	
CAST IRON	K	○	●					○	⌚			⌚		
NON-FERROUS METAL	N	○					●	○	⌚			⌚		
EXOTIC ALLOY	S	●	●	●	●	●	●	●	⌚	⌚	⌚	⌚	⌚	
STEEL	H	○			●			○	⌚			⌚		

MACHINING TYPES

SECONDARY USE

○

⌚

⌚

PRIMARY USE

●

⌚

⌚

CONTINUOUS CUTTING

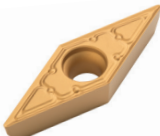
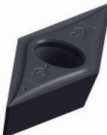
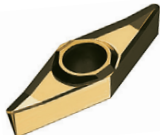
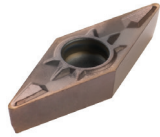
○

GENERAL CUTTING

⌚

INTERRUPTED CUTTING

⌚

		MACHINING MATERIAL GROUPE →														Exotic alloy Groupe		
		Vc (M/MIN) CUTTING SPEED →												S1 - High temperature resistant alloys S2 - Pure titanium (Vc +100%) S3 - Titanium alloys				
GEOMETRY ↓		GRADE → DESIGNATION ↓		B22-V2	A22-J2	E21-L1	E22-AO2	E31-N1	E31-M1	B32-S2	B42-W2	E42-AP2	E41-O1	B62-Y2	B72-M2		F (MM/REV) FEED RATE ↓	AP (MM) DEPTH OF CUT ↓
M11 	VCMT 110302-M11	●									●						0,08 - 0,20	0,4 - 2,0
	VCMT 110304-M11	●									●							
- 	VCGT 1103008								●								0,05 - 0,20	0,1 - 1,0
	VCGT 1103015								●								0,05 - 0,20	0,1 - 1,0
MF17 	VCGT 110301-MF17		●														0,02 - 0,06	0,5 - 1,5
	VCGT 110302-MF17		●														0,05 - 0,12	0,5 - 2,0
	VCGT 110304-MF17		●														0,08 - 0,25	0,6 - 2,5
F10 	VCMT 110302-F10	●									●						0,04 - 0,12	0,1 - 1,0
	VCMT 110304-F10	●									●						0,05 - 0,16	0,1 - 1,5

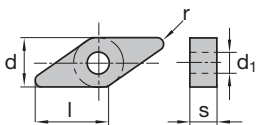
ORDER EXAMPLE: CCMT 09T304-M A31-A1

CARBIDE
VC
1103

35°
DIAMOND
7° POSITIVE

EXOTIC ALLOY

6,35	d INSCRIBED CIRCLE
11,10	l CUTTING EDGE LENGTH
3,18	s THICKNESS



TOLERANCE CLASSES	CLASS	m	d	s
	E	± 0,025	± 0,025	± 0,025
	G	± 0,025	± 0,025	± 0,13
	H	± 0,013	± 0,013	± 0,025
	M	± 0,08	± 0,05	± 0,13
	U	± 0,13	± 0,08	± 0,13

SECONDARY USE

PRIMARY USE

MACHINING MATERIAL	STEEL	P	○	●				●	●	☉			☉	☉	
	STAINLESS STEEL	M	●	○		○	●	●	●	☉		☉	☉	☉	
	CAST IRON	K	○	●					○	☉			☉		
	NON-FERROUS METAL	N	○				●	○	☉				☉		
	EXOTIC ALLOY	S	●	●	●	●	●	●	●	☉	☉	☉	☉	☉	
	STEEL	H	○			●		○	☉				☉		

MACHINING TYPES



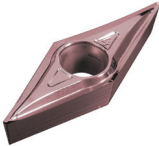
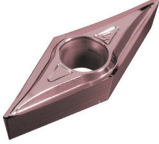
CONTINUOUS CUTTING



GENERAL CUTTING

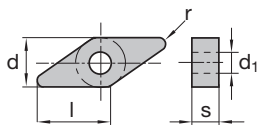


INTERRUPTED CUTTING

GEOMETRY ↓	GRADE → DESIGNATION ↓	MACHINING MATERIAL GROUPE → VC (M/MIN) CUTTING SPEED →												Exotic alloy Groupe	
		S1,2,3	S1	S2,3	S3	S1	S2,3	S1,2,3	S1,2,3	S3	S1	S1,2,3	S1,2,3	F (MM/REV) FEED RATE ↓	
		15-90	15-70	30-70	30-80	20-100	30-70	15-80	15-80	30-70	20-100	15-70	5-35		
F11 	VC GT 1103015-F11							●						0,05 - 0,12	0,2 - 2,0
	VC GT 110301-F11							●						0,02 - 0,06	0,1 - 1,5
	VC GT 110302-F11							●						0,05 - 0,12	0,2 - 2,0
	VC GT 1103035-F11							●						0,08 - 0,25	0,2 - 2,5
	VC GT 110304-F11							●						0,08 - 0,25	0,2 - 2,5
F12 	VC GT 1103005-F12							●						0,02 - 0,06	0,1 - 1,5
	VC GT 110301-F12							●						0,02 - 0,06	0,1 - 1,5
	VC GT 110302-F12	●						●						0,05 - 0,12	0,2 - 2,0
	VC GT 110304-F12	●						●						0,08 - 0,25	0,2 - 2,5

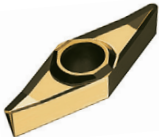
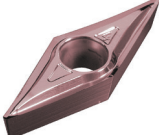
CARBIDE	VC 1303	35°	EXOTIC ALLOY
		DIAMOND	
		7° POSITIVE	

7,94	d	INSCRIBED CIRCLE
13,10	l	CUTTING EDGE LENGTH
3,18	s	THICKNESS



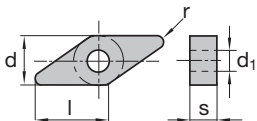
TOLERANCE CLASSES	CLASS	m	d	s
	E	± 0,025	± 0,025	± 0,025
	G	± 0,025	± 0,025	± 0,13
	H	± 0,013	± 0,013	± 0,025
	M	± 0,08	± 0,05	± 0,13
	U	± 0,13	± 0,08	± 0,13

MACHINING MATERIAL	STEEL	P	TOLERANCE CLASSES	CLASS	m	d	s	MACHINING TYPES	SECONDARY USE	PRIMARY USE	CONTINUOUS CUTTING	GENERAL CUTTING	INTERRUPTED CUTTING
	STAINLESS STEEL	M											
	CAST IRON	K											
	NON-FERROUS METAL	N											
	EXOTIC ALLOY	S											
	STEEL	H											

GEOMETRY ↓	MACHINING MATERIAL GROUPE → VC (M/MIN) CUTTING SPEED → GRADE → DESIGNATION ↓	Exotic alloy Groupe												F (MM/REV) FEED RATE ↓	AP (MM) DEPTH OF CUT ↓
		S1,2,3	S1	S2,3	S3	S1	S2,3	S1,2,3	S1,2,3	S3	S1	S1,2,3	S1,2,3		
		B22-V2	A22-J2	E21-L1	E22-AO2	E31-N1	E31-M1	B32-S2	B42-W2	E42-AP2	E41-O1	B62-Y2	B72-M2		
MF17 	VCGT 130302-MF17		●											0,05 - 0,12	0,5 - 2,0
	VCGT 130304-MF17		●											0,08 - 0,25	0,6 - 3,0
F11 	VCGT 130302-F11							●						0,05 - 0,12	0,2 - 2,0
	VCGT 130304-F11							●						0,08 - 0,25	0,2 - 2,5

CARBIDE	VC		35°	EXOTIC ALLOY									
	1604		DIAMOND										
			7° POSITIVE										

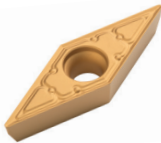
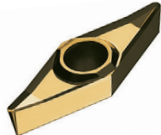
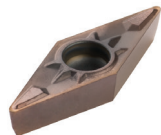
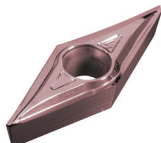
9,52	d	INSCRIBED CIRCLE
16,60	l	CUTTING EDGE LENGTH
4,76	s	THICKNESS



TOLERANCE CLASSES	CLASS	m	d	s
	E	± 0,025	± 0,025	± 0,025
	G	± 0,025	± 0,025	± 0,13
	H	± 0,013	± 0,013	± 0,025
	M	± 0,08	± 0,05	± 0,13
	U	± 0,13	± 0,08	± 0,13

MACHINING MATERIAL	STEEL	P	○	●				●	●	⊕			⊕	⊕		
	STAINLESS STEEL	M	●	○		○	●	●	●	⊕		⊕	⊕	⊕	⊕	
	CAST IRON	K	○	●					○	⊕			⊕			
	NON-FERROUS METAL	N	○				●	○	⊕			⊕				
	EXOTIC ALLOY	S	●	●	●	●	●	●	●	⊕	⊕	⊕	⊕	⊕	⊕	
	STEEL	H	○			●			○	⊕			⊕			

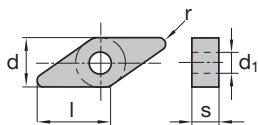
MACHINING TYPES	○	●	CONTINUOUS CUTTING
	⊕	⊕	GENERAL CUTTING
	⊕	⊕	INTERRUPTED CUTTING

GEOMETRY ↓		MACHINING MATERIAL GROUPE → Vc (M/MIN) CUTTING SPEED →		Exotic alloy Groupe												
				S1 - High temperature resistant alloys S2 - Pure titanium (Vc +100%) S3 - Titanium alloys												
GRADE → DESIGNATION ↓		B22-V2	A22-J2	E21-L1	E22-AO2	E31-N1	E31-M1	B32-S2	B42-W2	E42-AP2	E41-O1	B62-Y2	B72-M2		F (MM/REV) FEED RATE ↓	AP (MM) DEPTH OF CUT ↓
M11 	VCMT 160404-M11	●							●						0,12 - 0,25	0,8 - 3,0
	VCMT 160408-M11	●							●						0,15 - 0,25	0,8 - 3,0
MF17 	VCGT 160402-MF17		●												0,05 - 0,12	0,5 - 2,0
	VCGT 160404-MF17		●												0,08 - 0,25	0,6 - 3,5
	VCGT 160408-MF17		●												0,10 - 0,35	0,8 - 3,5
F10 	VCMT 160404-F10	●							●						0,05 - 0,16	0,1 - 1,5
F11 	VCGT 160402-F11							●							0,05 - 0,12	0,2 - 2,0
	VCGT 160404-F11							●							0,08 - 0,25	0,2 - 2,5
	VCGT 160408-F11							●							0,10 - 0,30	0,3 - 3,0

ORDER EXAMPLE: CCMT 09T304-M A31-A1

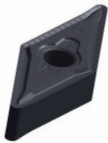
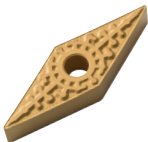
CARBIDE	VN 1604	35°	EXOTIC ALLOY
		DIAMOND	
		0° NEGATIVE	

9,52	d	INSCRIBED CIRCLE
16,60	l	CUTTING EDGE LENGTH
4,76	s	THICKNESS



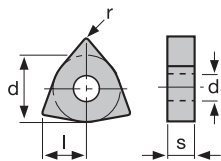
TOLERANCE CLASSES	CLASS	m	d	s
	E	± 0,025	± 0,025	± 0,025
	G	± 0,025	± 0,025	± 0,13
	H	± 0,013	± 0,013	± 0,025
	M	± 0,08	± 0,05	± 0,13
	U	± 0,13	± 0,08	± 0,13

MACHINING MATERIAL	STEEL	P	TOLERANCE CLASSES	CLASS	m	d	s	MACHINING TYPES	SECONDARY USE	PRIMARY USE	CONTINUOUS CUTTING	GENERAL CUTTING	INTERRUPTED CUTTING
	STAINLESS STEEL	M											
	CAST IRON	K											
	NON-FERROUS METAL	N											
	EXOTIC ALLOY	S											
	STEEL	H											

GEOMETRY ↓	GRADE → DESIGNATION ↓	MACHINING MATERIAL GROUPE → Vc (M/MIN) CUTTING SPEED →												Exotic alloy Groupe	
														F (MM/REV) FEED RATE ↓	AP (MM) DEPTH OF CUT ↓
		B22-V2	A22-J2	E21-L1	E22-AO2	E31-N1	E31-M1	B32-S2	B42-W2	E42-AP2	E41-O1	B62-Y2	B72-M2		
M1 	VNMG 160404-M1					●								0,10 - 0,30	0,5 - 4,0
	VNMG 160408-M1					●								0,10 - 0,30	0,5 - 4,0
F4 	VNMG 160404-F4	●			●				●	●				0,05 - 0,15	0,2 - 1,5
	VNMG 160408-F4	●			●				●	●				0,07 - 0,18	0,3 - 2,0

CARBIDE	WC 0201	80°	EXOTIC ALLOY
		TRIGON	
		7° POSITIVE	

3,97	d INSCRIBED CIRCLE
2,70	l CUTTING EDGE LENGTH
1,59	s THICKNESS



TOLERANCE CLASSES	CLASS	m	d	s
	E	± 0,025	± 0,025	± 0,025
	G	± 0,025	± 0,025	± 0,13
	H	± 0,013	± 0,013	± 0,025
	M	± 0,08	± 0,05	± 0,13
	U	± 0,13	± 0,08	± 0,13

MACHINING MATERIAL	STEEL	P	○	●				●	●	☉			☉	☉	
	STAINLESS STEEL	M	●	○		○	●	●	●	☉		●	☉	☉	
	CAST IRON	K	○	●					○	☉			☉		
	NON-FERROUS METAL	N	○				●	○	☉				☉		
	EXOTIC ALLOY	S	●	●	●	●	●	●	●	☉	☉	☉	☉	☉	
	STEEL	H	○			●			○	☉			☉		

MACHINING TYPES

SECONDARY USE

PRIMARY USE



CONTINUOUS CUTTING



GENERAL CUTTING



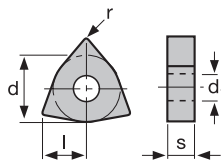
INTERRUPTED CUTTING

GEOMETRY ↓		MACHINING MATERIAL GROUPE →		Vc (M/MIN) CUTTING SPEED →		GRADE →		DESIGNATION ↓		Exotic alloy Groupe											
										S1 - High temperature resistant alloys S2 - Pure titanium (Vc +100%) S3 - Titanium alloys											
		B22-V2	A22-J2	E21-L1	E22-AO2	E31-N1	E31-M1	B32-S2	B42-W2	E42-AP2	E41-O1	B62-Y2	B72-M2		F (MM/REV) FEED RATE ↓	AP (MM) DEPTH OF CUT ↓					
F10 	WCMT 020102-F10											●			0,04 - 0,12	0,1 - 1,0					
	WCMT 020104-F10											●			0,05 - 0,16	0,1 - 1,5					



CARBIDE	WC 0402	80°	EXOTIC ALLOY
		TRIGON	
		7° POSITIVE	

6,35	d	INSCRIBED CIRCLE
4,30	l	CUTTING EDGE LENGTH
2,38	s	THICKNESS



TOLERANCE CLASSES	CLASS	m	d	s
	E	± 0,025	± 0,025	± 0,025
	G	± 0,025	± 0,025	± 0,13
	H	± 0,013	± 0,013	± 0,025
	M	± 0,08	± 0,05	± 0,13
	U	± 0,13	± 0,08	± 0,13

MACHINING MATERIAL	STEEL	P	○	●				●	●	☉			☉	☉	
	STAINLESS STEEL	M	●	○		○	●	●	●	☉		☉	☉	☉	
	CAST IRON	K	○	●					○	☉			☉		
	NON-FERROUS METAL	N	○				●	○	☉				☉		
	EXOTIC ALLOY	S	●	●	●	●	●	●	●	☉	☉	☉	☉	☉	
	STEEL	H	○			●			○	☉			☉		

MACHINING TYPES

SECONDARY USE

PRIMARY USE



CONTINUOUS CUTTING



GENERAL CUTTING

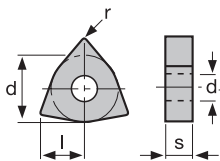


INTERRUPTED CUTTING

GEOMETRY ↓	DESIGNATION ↓	MACHINING MATERIAL GROUPE →		Vc (M/MIN) CUTTING SPEED →												Exotic alloy Groupe	
		GRADE →		S1,2,3	S1	S2,3	S3	S1	S2,3	S1,2,3	S1,2,3	S3	S1	S1,2,3	S1,2,3		S1 - High temperature resistant alloys S2 - Pure titanium (Vc +100%) S3 - Titanium alloys
		B22-V2	A22-J2	E21-L1	E22-AO2	E31-N1	E31-M1	B32-S2	B42-W2	E42-AP2	E41-O1	B62-Y2	B72-M2			F (MM/REV) FEED RATE ↓	AP (MM) DEPTH OF CUT ↓
M10	WCMT 040204-M10								●							0,08 - 0,25	0,4 - 2,0
																	

CARBIDE	WC 06T3	80°	EXOTIC ALLOY
		TRIGON	
		7° POSITIVE	

9,52	d	INSCRIBED CIRCLE
6,50	l	CUTTING EDGE LENGTH
3,97	s	THICKNESS



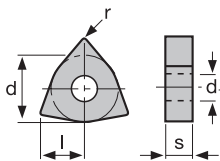
TOLERANCE CLASSES	CLASS	m	d	s
	E	± 0,025	± 0,025	± 0,025
	G	± 0,025	± 0,025	± 0,13
	H	± 0,013	± 0,013	± 0,025
	M	± 0,08	± 0,05	± 0,13
	U	± 0,13	± 0,08	± 0,13

MACHINING MATERIAL	STEEL	P	TOLERANCE CLASSES	CLASS	m	d	s	MACHINING TYPES	SECONDARY USE	PRIMARY USE	CUTTING TYPE
	STAINLESS STEEL	M									
	CAST IRON	K									
	NON-FERROUS METAL	N									
	EXOTIC ALLOY	S									
	STEEL	H									

GEOMETRY ↓	DESIGNATION ↓	GRADE →	MACHINING MATERIAL GROUPE →	Vc (M/MIN) CUTTING SPEED →	Exotic alloy Groupe	
					S1 - High temperature resistant alloys	S2 - Pure titanium (Vc +100%)
					S3 - Titanium alloys	
M10	WCMT 06T304-M10	WCMT 06T308-M10			F (MM/REV) FEED RATE ↓	AP (MM) DEPTH OF CUT ↓
					0,08 - 0,25	0,4 - 2,5
					0,12 - 0,32	0,5 - 2,5

CARBIDE	WN 0604	80°	EXOTIC ALLOY
		TRIGON	
		0° NEGATIVE	

9,52	d	INSCRIBED CIRCLE
6,50	l	CUTTING EDGE LENGTH
4,76	s	THICKNESS



TOLERANCE CLASSES	CLASS	m	d	s
	E	± 0,025	± 0,025	± 0,025
	G	± 0,025	± 0,025	± 0,13
	H	± 0,013	± 0,013	± 0,025
	M	± 0,08	± 0,05	± 0,13
	U	± 0,13	± 0,08	± 0,13

MACHINING MATERIAL	STEEL	P	○	●				●	●	☉			☉	☉	
	STAINLESS STEEL	M	●	○		○	●	●	●	☉		☉	☉	☉	
	CAST IRON	K	○	●					○	☉			☉		
	NON-FERROUS METAL	N	○				●	○	☉				☉		
	EXOTIC ALLOY	S	●	●	●	●	●	●	●	☉	☉	☉	☉	☉	
	STEEL	H	○			●			○	☉			☉		

MACHINING TYPES

SECONDARY USE

PRIMARY USE



CONTINUOUS CUTTING



GENERAL CUTTING

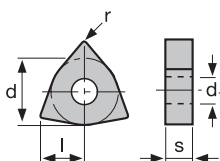


INTERRUPTED CUTTING

GEOMETRY	DESIGNATION	MACHINING MATERIAL GROUPE →											Exotic alloy Groupe	
		Vc (M/MIN) CUTTING SPEED →											F (MM/REV) FEED RATE	AP (MM) DEPTH OF CUT
M1	WNGG 060408-M1	B22-V2	A22-J2	E21-L1	E22-AO2	E31-N1	E31-M1	B32-S2	B42-W2	E42-AP2	E41-O1	B62-Y2	B72-M2	
		15-90	15-70	30-70	30-80	20-100	30-70	15-80	15-80	30-70	20-100	15-70	5-35	
						●								0,10 - 0,30
														0,5 - 4,0

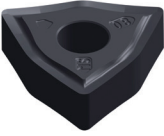
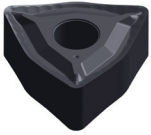
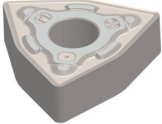
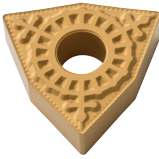
CARBIDE	WN 0804	80°	EXOTIC ALLOY
		TRIGON	
		0° NEGATIVE	

12,70	d INSCRIBED CIRCLE
8,60	l CUTTING EDGE LENGTH
4,76	s THICKNESS



TOLERANCE CLASSES	CLASS	m	d	s
	E	± 0,025	± 0,025	± 0,025
	G	± 0,025	± 0,025	± 0,13
	H	± 0,013	± 0,013	± 0,025
	M	± 0,13	± 0,08	± 0,13
	U	± 0,20	± 0,13	± 0,13

MACHINING MATERIAL	STEEL	P	TOLERANCE CLASSES	CLASS	m	d	s	MACHINING TYPES	SECONDARY USE	PRIMARY USE	CONTINUOUS CUTTING	GENERAL CUTTING	INTERRUPTED CUTTING
	STAINLESS STEEL	M											
	CAST IRON	K											
	NON-FERROUS METAL	N											
	EXOTIC ALLOY	S											
	STEEL	H											

GEOMETRY ↓	GRADE → DESIGNATION	MACHINING MATERIAL GROUPE → Vc (M/MIN) CUTTING SPEED →												Exotic alloy Groupe	
														F (MM/REV) FEED RATE ↓	AP (MM) DEPTH OF CUT ↓
		B22-V2	A22-J2	E21-L1	E22-AO2	E31-N1	E31-M1	B32-S2	B42-W2	E42-AP2	E41-O1	B62-Y2	B72-M2		
M 	WNGG 080404-M					●								0,20 - 0,40	1,0 - 3,5
	WNGG 080408-M					●								0,20 - 0,40	1,0 - 3,5
	WNGG 080412-M					●								0,20 - 0,40	1,0 - 3,5
	WNMG 080404-M					●								0,20 - 0,40	1,0 - 3,5
	WNMG 080408-M					●								0,20 - 0,40	1,0 - 3,5
	WNMG 080412-M					●								0,20 - 0,40	1,0 - 3,5
M1 	WNGG 080404-M1					●								0,10 - 0,30	0,5 - 4,0
	WNGG 080408-M1					●								0,10 - 0,30	0,5 - 4,0
	WNGG 080412-M1					●								0,10 - 0,30	0,5 - 4,0
M2 	WNMG 080408-M2			●							●			0,20 - 0,45	1,0 - 5,0
F4 	WNMG 080404-F4	●			●				●	●				0,08 - 0,17	0,4 - 1,5
	WNMG 080408-F4	●			●				●	●				0,10 - 0,20	0,5 - 2,0

ORDER EXAMPLE: CCMT 09T304-M A31-A1