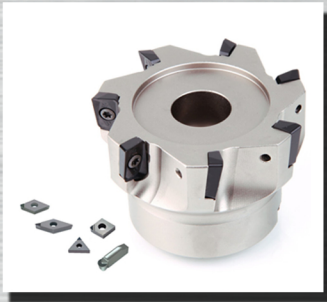


Indexable Carbide Inserts





Indexable Carbide Inserts



Contents

Grade Description	01
Geometries / Chip Breaker	03
Technical Formulas	04
Technical Information	05
Milling Inserts	10
Drilling Inserts	17
Turning Inserts	18



Grade Description

BT9120 

PVD coated grade with Unique Substrate for wide range of MILLING Application

- PVD coating with optimal thermal resistance & added strength.
- Tough carbide substrate designed for demanding application.
- Multipurpose grade for alloy steel, stainless steel, cast iron and exotic materials.

BT6800 

PVD coated grade with Substrate suitable for DRILLING Application

- PVD coating with thermal resistance & added strength specially developed for wide range of drilling applications.
- Tough carbide substrate designed for drilling application.
- Multipurpose grade for alloy steel, stainless steel, cast iron and exotic materials.

BT3320 

CVD coated grade for wear resistant TURNING Application

- Substrate and CVD coating designed for maximum wear resistance.
- Excellent cutting performance under smooth machining condition.
- Grade preferred for alloy steel finish and semi finish applications.

BT2233 

PVD coated grade for general TURNING Application

- Grade designed with PVD coating for wide range of Turning Applications.
- Excellent cutting performance under medium to harsh machining condition.
- Grade preferred for alloy steel and stainless steel applications.

BT3330 

PVD coated grade for rough TURNING Application

- Grade designed with PVD coating for tough Turning Applications.
- Excellent cutting performance under harsh machining condition.
- Grade preferred for alloy steel and stainless steel applications.

Grade Description

BT2255 

CVD coated grade for cast iron TURNING Application

- Thick CVD coating optimized for Cast iron applications.
- Optimal thermal & wear resistance for finish to medium cast iron turning applications.
- Alternate grade for alloy steel finish turning applications.

BT3310 

CVD coated grade for cast iron rough TURNING Application

- Thick CVD coating optimized for wide range of Cast iron applications.
- Optimal thermal & wear resistance for medium to rough cast iron turning applications.

BT2277 

PVD coated grade for GROOVING Application

- PVD coated with tough carbide substrate and improved wear & optimal thermal resistance developed for grooving application.
- Grade suitable for steel and stainless steel applications.

BT2288 

PVD coated grade for THREADING Application

- PVD coated carbide substrate with improved wear & optimal thermal resistance developed for threading application.
- Grade suitable for steel and stainless steel applications.

BT20AL 

Unique Substrate for Milling of Aluminium Alloys

- Uncoated carbide grade suitable for milling aluminium alloys with sharp cutting geometry.

BT10AL 

Unique Substrate for TURNING of Aluminium Alloys

- Uncoated carbide grade suitable for turning aluminium alloys with sharp cutting geometry.



Geometries / Chip Breakers

FF Fine finish geometry with good chip breaker for alloy steel machining with low depth of cut.

MF Medium finish geometry with good chip breaker for alloy steel machining with low to medium depth of cut.

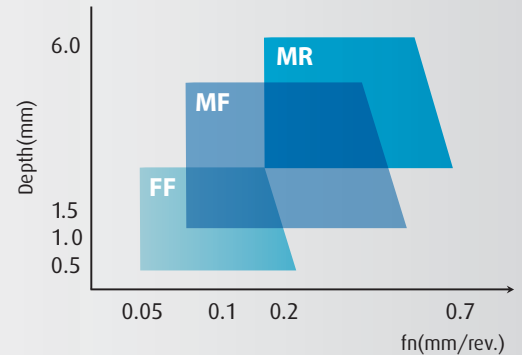
MR Medium rough geometry with chip breaker suitable for alloy steel and stainless steel machining with medium to high depth of cut.

MM Semi finish geometry with chip breaker suitable for stainless steel machining with low to medium depth of cut.

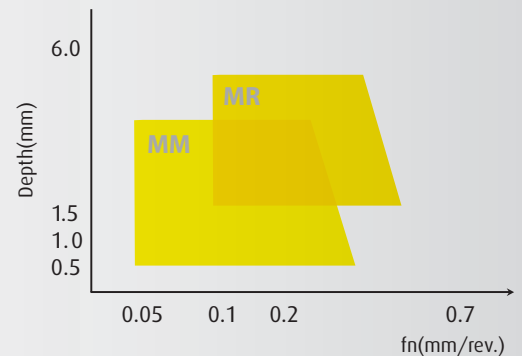
K1 Semi finish geometry with chip breaker suitable for cast iron machining with low to medium depth of cut.

AL Sharp finish geometry with high rake angle suitable for non-ferrous machining with low to medium depth of cut.

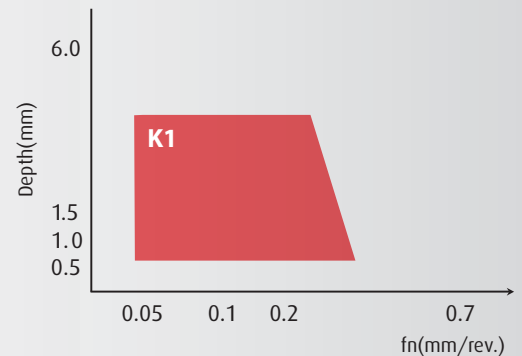
Application area for Alloy steel



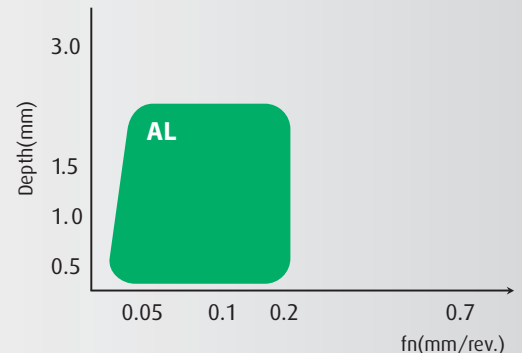
Application area for Stainless steel



Application area for Cast iron



Application area for Aluminium



Technical Formulas

Cutting speed (V_c) [m/min.]

$$V_c = \frac{D \cdot \pi \cdot n}{1000} \text{ [m/min.]}$$

Feed rate (V_f) [rev./min.]

$$V_f = f_n \cdot n \text{ [rev./min.]}$$

Metal Removal Rate [$\text{cm}^3/\text{min.}$]

$$Q = \frac{a_e \cdot a_p \cdot V_f}{1000} \text{ [cm}^3\text{/min.]}$$

Revolutions per minute (n) [rev./min.]

$$n = \frac{V_c \cdot 1000}{D \cdot \pi} \text{ [rev./min.]}$$

Feed per tooth [mm/tooth]

$$f_z = \frac{V_f}{n \cdot z} \text{ [mm/tooth]}$$

Power consumption [kW]

$$P_c = \frac{Q \cdot k_c}{60 \cdot 102 \cdot \eta} \text{ [rev./min.]}$$

Abbriation & Dimension

a_e : Width of cut [mm]

a_p : Depth of cut [mm]

D : Cutter diameter [mm]

D_w : Work piece diameter [mm]

f_z : Feed per tooth [mm/tooth]

π : Circular constant

k_c : Specific cutting resistance [kgf/mm^3]

n : Revolutions of spindle [min.^{-1}]

P_c : Power consumption [kW]

Q : Metal Removal Rate [$\text{cm}^3/\text{min.}$]

V_c : Cutting speed [m/min.]

V_f : Feed rate [mm/min.]

f_n : Feed per revolution [mm/rev.]

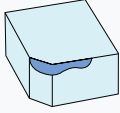
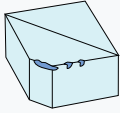
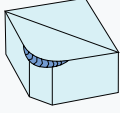
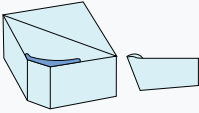
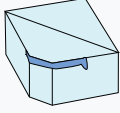
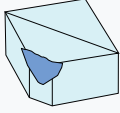
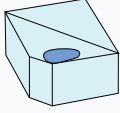
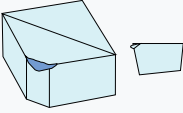
z : Effective number of edges [pcs.]

η : Mechanical efficiency [%]



Technical Information

Wear of Insert & Counter Measure

	Description	Solution
 Rapid Flank wear	<ol style="list-style-type: none"> 1. Inappropriate feed(f) rate 2. Cutting speed(s) too high 	<ol style="list-style-type: none"> 1. Adjust feed(f) rate according to depth(a_p), width(a_e) 2. Reduce cutting speed(s)
 Chipping	<ol style="list-style-type: none"> 1. Feed(f) rate too high 2. Cutting speed(s) too low 3. Vibration of holder & machine 	<ol style="list-style-type: none"> 1. Reduce feed(f) rate 2. Increase cutting speed(s) 3. Reduce the tool overhang & improve the rigidity of machine and workpiece
 Thermal crack	<ol style="list-style-type: none"> 1. Insufficient coolant 2. Cutting speed(s) too high 	<ol style="list-style-type: none"> 1. Check cooling system, supply enough coolant or use dry milling 2. Reduce cutting speed(s)
 Built-up edge	<ol style="list-style-type: none"> 1. Cutting speed(s) too low 2. Insufficient coolant 3. Not enough rake angle 	<ol style="list-style-type: none"> 1. Increase cutting speed(s) 2. Supply enough coolant 3. Increase rake angle of change inserts
 Notching	<ol style="list-style-type: none"> 1. Scaling or work hardening in workpiece surface area 2. Burrs in workpiece 	<ol style="list-style-type: none"> 1. Change/Vary cutting condition (feed & depth) 2. Change path or direction
 Fracture	<ol style="list-style-type: none"> 1. Wrong insert shape or corner radius 2. Corner radius too small 3. Cutting force fluctuation too high 	<ol style="list-style-type: none"> 1. Choose the insert with bigger corner or radius
 Cratering	<ol style="list-style-type: none"> 1. Insufficient coolant supply 2. Cutting speed(s) and feed(f) rate too high 	<ol style="list-style-type: none"> 1. Increase coolant supply or concentration 2. Reduce cutting speed(s) and feed(f) rate
 Plastic deformation	<ol style="list-style-type: none"> 1. Cutting speed(s) too high 2. Too much stress applied on the cutting edge 	<ol style="list-style-type: none"> 1. Reduce cutting speed(s) 2. Supply enough coolant 3. Choose insert with bigger corner radius

Technical Information

Trouble Shooting

Trouble	Cause	Counter Measure			
		Cutting Conditions			
		Cutting Speed	Feed Rate	Depth of Cut	Coolant
Heat	Inappropriate cutting condition	↓	↓	↓	
Poor surface quality of machined surface	Premature insert wear	↓			●
	Chipping of cutting edge		↓	↓	
	Built up edge	↑	↑		●
	Inappropriate cutting condition	↑	↓	↓	●
	Chatter	↓	↓	↓	●
Change of cutting edge line	Inappropriate cutting condition	↓	↑		
Burr, Chipping (Steel, Aluminum)	Inappropriate cutting condition	↓	↑		●
Chipping of workpiece (Cast Iron)	Inappropriate cutting condition		↓	↓	
Burr (Mild steel)	Inappropriate cutting condition	↑	↕		●

- ↓: decrease ↑: increase ↕: depends on status ●: use coolant



Recommended Cutting Conditions

For MILLING and DRILLING Application

ISO	Material Group	VDI Group	Relative materials (DIN)	Hardness HB	Cutting speed (m/min.)
P	Non-alloy steel	1 - 5	9 SMn 28, C35, C50, C40E, C45E, 49 CrMo 4	125 - 250	150 - 250
	Low alloy steel	6 - 9	13 CrMo 44, 40NiCrMo22, 58 CrV 4	200 - 350	140 - 200
	High alloy steel	10 - 11	X 40 CrMoV 51, X100 CrMoV 51, 56-5-5	200 - 325	80 - 140
M	Ferritic/martensitic Stainless steel	12 - 13	X6Cr13, X10CrA118, X20CrNi175	200 - 240	130 - 190
	Austenitic Stainless steel	14	X5 CrNi 18 9, X5 CrNiMo 17 13 3, X6 CrNiTi 18 9	180	100 - 200
K	Grey cast iron	15 - 16	GG15, GG20, GGG40, GG-35	180 - 260	160 - 200
	Malleable castiron	19 - 20	GTS-35-10, GTS-35, GTS70-02, 20mN5	130 - 230	130 - 180
S	Fe, Ni or Co based	31 - 35	X12 NiCrAlTi 31 20, TiAl5Sn2	200 - 350	30 - 50
	Titanium and Ti-alloy based	36 - 37	TiCu2, TiAl6V4, TiAl6V4ELI	-	35 - 75
H	Hardended steel	38 - 39	C 105 W1,75 CrMoNiW 6 7	55 - 60 HRc	55 - 65
	Chilled cast iron	40	G-X 260 NiCr 4 2, X15 CrNiSi 25 20	400	45 - 55
	Cast iron	41	G-X 300 CrMo 15 3	55 HRc	55 - 65

- Above recommend cutting condition can be changed according to the customer's machining condition.

Grade Comparison Chart

MILLING and DRILLING

ISO	Symbol	Brisloy	Sandvik	Kennametal	Seco	Iscar	Mitsubishi	Sumitomo	Tungaloy	Taegutec
P	P10	BT6800 BT9120	GC1010 GC1025	KC715M		IC250 IC808 IC908		ACP200		TT2510 TT7080
	P20	BT6800 BT9120	GC1010 GC1025 GC2030	KC522M KC525M	F25M MP3000	IC250 IC808 IC908 IC928	MP6120 VP15TF	ACP200	AH725 AH120 AH330 GH330	TT2510 TT7080 TT9080
	P30	BT6800* BT9120	GC1010 GC1030 GC2030	KC725M KC530M	F25M MP3000 F30M	IC250 IC808 IC908 IC928	MP6120 VP15TF MP6130 VP30RT	ACP200 ACP300	AH725 AH120 AH130 GH130	TT8080 TT9080
	P40	BT6800* BT9120	GC1030	KC735M	F40M T60M		VP30RT	ACP300	AH140	TT8080 TT9080
M	M10	BT6800* BT9120	GC1025 GC1030	KC715M		IC903				
	M20	BT6800* BT9120	GC1025 GC1030 GC1040 GC2030	KC730 KC522M KC525M	F25M MP3000	IC250 IC300 IC808 IC928	VP15TF MP7130 MP7030 VP20RT	ACP200	AH725 AH120 AH330 GH330	TT9080
	M30	BT6800 BT9120	GC1040 GC2030	KC725M KC735M	F30M F40M MP3000	IC250 IC300 IC808 IC928	VP15TF MP7130 MP7030 VP20RT	ACP200 ACP300	AH120 AH725 GH130 GH340	TT8080 TT9080
	M40	BT6800 BT9120			F40M		MP7140 VP30RT	ACP300	AH140	TT8080 TT9080
K	K10	BT6800 BT9120	GC1010	KC510M		IC350 IC810 IC900 IC910 IC950	MP8010		AH110 GH110 AH330	TT6080 TT7080
	K20	BT6800* BT9120	GC1010 GC1020	KC520M KC525M	MK2000	IC350 IC830 IC928	VP15TF VP20RT	ACK300	GH130	TT6080 TT7080
	K30	BT6800* BT9120	GC1020	KC725M KC735M		IC350 IC830 IC928	VP15TF VP20RT	ACK300		
S	S10	BT6800* BT9120	GC1025	KC510M		IC903	MP9120 VP15TF			
	S20	BT6800* BT9120	GC1025 GC2030	KC522M KC525M		IC300 IC808 IC908 IC328	MP9120 VP15TF MP9130 MP9030			TT9080
	S30	BT6800 BT9120	GC2030	KC725M	F40M	IC830 IC928				TT8080 TT9080
H	H10	BT6800 BT9120	GC1010 GC1030	KC635M	MH1000 F15M	IC900	VP15TF VP10H			TT2510 TT6080
	H20	BT6800 BT9120	GC1010 GC1030	KC635M	F15M	IC900 IC808 IC908	VP15TF			TT2510 TT6080
	H30	BT6800 BT9120		KC530M	MP3000 F30M	IC808 IC908 IC1008				

- * Represents first choice application range.
 - Above data is just for reference.

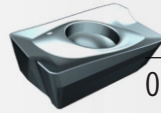


Cutting Tool Performance

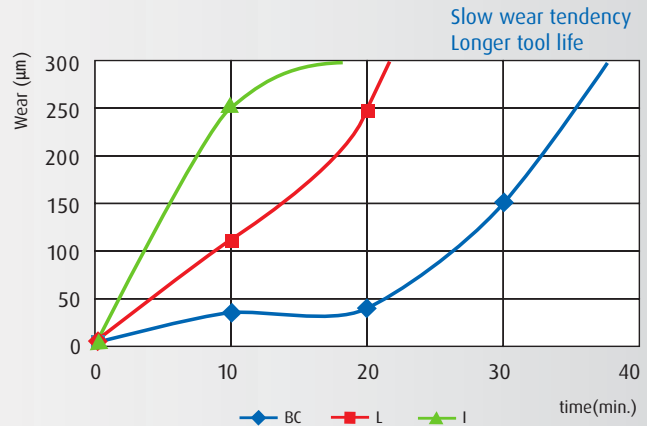
▶ Test Condition

Material (Alloy tool steel)	DIN : X100CrMoV5 1 AISI : D2 JIS : SKD11
Workpiece HB	210~220
Workpiece size	150 x 200 x 120
Vc(m/min.)	140
fz(mm/tooth)	0.1
ap/ae(mm)	8 / 3
Coolant	Dry

Test finishing wear value : 300 μ m(flank wear)

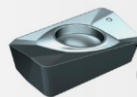


01. Test result for APKT 1003PDTR

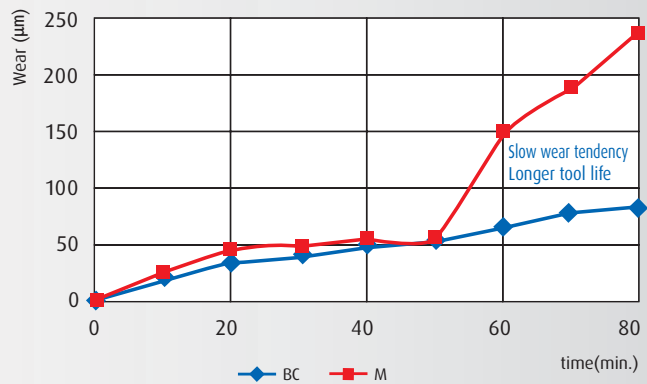


▶ Test Condition

Material (Alloy steel)	DIN : 42CrMo4 AISI : 4140 JIS : SCM440
Workpiece HB	190~200
Workpiece size	300 x 60 x 150
Vc(m/min.)	180
fz(mm/tooth)	0.15
ap/ae(mm)	2 / 20
Coolant	Dry

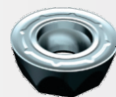


02. Test result for APMT 1135PDTR

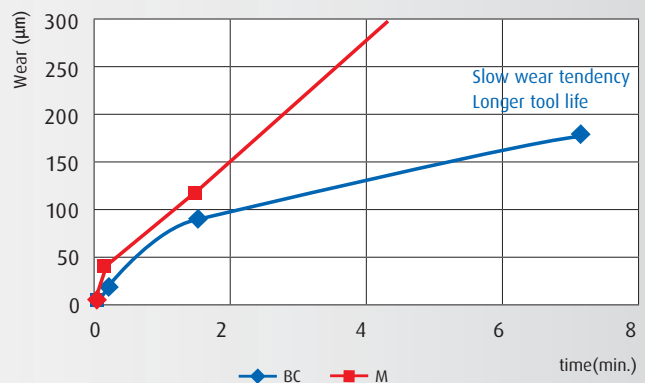


▶ Test Condition

Material (Alloy tool steel)	DIN : X100CrMoV5 1 AISI : D2 JIS : SKD11
Workpiece HB	210~230
Workpiece size	120 x 100 x 150
Vc(m/min.)	120
fz(mm/tooth)	0.23
ap/ae(mm)	1.5 / 20
Coolant	Dry



03. Test result for RPMT 1204M0



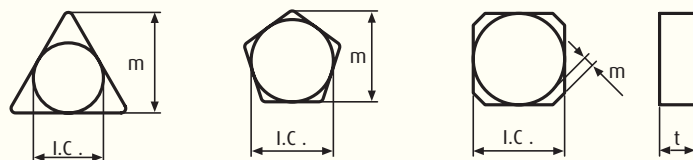
Milling Inserts Designation System-ISO

1. Insert Shape				2. Clearance Angle				4. Cross Section Shape				
A	B	C	D					5°	7°	15°	20°	
				25°	30°	0°	11°			special		
E	H	K	L	F	G	N	P	C'Sink40°~60° C'Sink40°~60°				
											special	
O	P	R	S								T	W
		special										
T	W	X										



3. Tolerance

	Tolerance (mm)			I.C. Size (mm)					
	m	t	I.C.	6.35	9.525	12.7	15.875	19.05	25.4
A	± 0.005	± 0.025	± 0.025	•	•	•	•	•	•
C	± 0.013	± 0.025	± 0.025	•	•	•	•	•	•
E	± 0.025	± 0.025	± 0.025	•	•	•	•	•	•
F	± 0.005	± 0.025	± 0.013	•	•	•	•	•	•
G	± 0.025	± 0.13	± 0.025	•	•	•	•	•	•
H	± 0.013	± 0.025	± 0.013	•	•	•	•	•	•
K	± 0.013	± 0.025	± 0.05	•	•				
			± 0.08			•			
			± 0.10				•	•	
			± 0.13						•
M	± 0.08	± 0.13	± 0.05	•	•				
			± 0.08			•			
			± 0.10				•	•	
			± 0.13						•





Milling Inserts Designation System-ISO

6. Thickness (mm)		8. Edge Preparation	9. Cutting Direction	10. Chip Breaker
				For Application
t	mm			
02	2.38			
03	3.18			
T3	3.97			
04	4.76			
06	6.35			
07	7.94			
09	9.52			

12	03	ED	T	R	CHIP BREAKER
5	6	7	8	9	10

5. Cutting Edge Length (mm)							7. Lead Angle & Relief Angle of Minor Cutting Edge	
I.C.	C	S	R	T	H	O		
L							Lead Angle	
5.56				09			A	45°
6.35	06	06	06	11			D	60°
7.94	08			13			E	75°
9.525	09	09	09	16			F	85°
12.7	12	12	12	22	05	05	P	90°
15.875	16	15	15	27	09		Z	Special
17.94						07	Relief Angle of minor cutting edge	
19.05	19	19	19	33	10		B	5°
25.4	25	25	25				C	7°
							D	15°
							E	20°
							F	25°
							G	30°
							N	0°
							P	11°
							Z	Special

Milling Inserts

Unit : mm

Insert Shape	Designation	Dimensions					Feed (mm/tooth)		Depth of Cut		Geometry
		l	D	S	Θ	r	min.	max.	min.	max.	
	ADKT 1505PDTR [●]	14.42	9.67	5.80	15	0.8	0.10	0.32	0.50	14.00	
	AOMT 123604PDTR [●]	11.30	6.60	3.60	11	0.4	0.07	0.22	0.50	11.00	
	AOMT 123608PDTR [●]	11.30	6.60	3.60	11	0.8	0.07	0.22	0.50	11.00	
	APKT 1003PDTR [●]	10.58	6.70	3.60	11	0.5	0.07	0.26	0.50	9.00	
	APKT 100308PDTR [●]	10.50	6.70	3.50	11	0.8	0.07	0.26	0.50	9.00	
	APKT 11T3PDSR [●]	11.30	6.60	3.60	11	0.8	0.10	0.32	0.50	11.00	
	APKT 120408PDTR [●]	13.10	8.30	4.76	11	0.8	0.05	0.20	0.50	12.00	
	APKT 160404PDTR [●]	16.30	9.40	5.27	11	0.4	0.10	0.32	0.50	15.00	
	APKT 160416PDTR [●]	16.30	9.40	5.27	11	1.6	0.10	0.32	0.50	15.00	
	APKT 1705PDTR [●]	17.50	10.70	5.56	11	0.8	0.10	0.30	0.50	16.00	
	APMT 1135PDTR [●]	10.69	6.20	3.50	11	0.4	0.07	0.24	0.50	10.00	
	APMT 113508PDTR [●]	11.18	6.20	3.50	11	0.8	0.07	0.24	0.50	10.00	
	APMT 1604PDTR [●]	16.25	9.22	4.76	11	0.8	0.09	0.30	0.50	15.00	
	APMT 1604PDER [●]	16.25	9.22	4.76	11	0.8	0.09	0.30	0.50	15.00	
	APGT 1003-AL PDTR [*]	10.5	6.7	3.5	11	0.8	0.07	0.26	0.50	9.00	
	APGT 1604-AL PDTR [*]	16.3	9.5	5.3	11	1.6	0.10	0.32	0.50	15.00	
	APKT 1003-AL PDTR [*]	10.5	6.7	3.5	11	0.8	0.07	0.26	0.50	9.00	
	APKT 1604-AL PDTR [*]	16.3	9.5	5.3	11	1.6	0.10	0.32	0.50	15.00	
	APMT 1604-AL PDTR [●]	16.51	9.5	4.76	11	0.8	0.09	0.30	0.50	15.00	

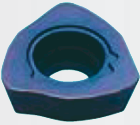
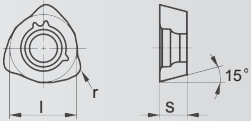
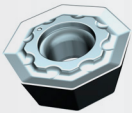
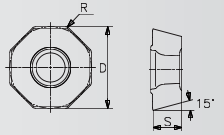
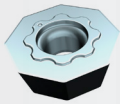
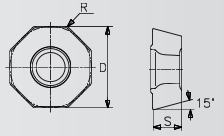
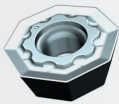
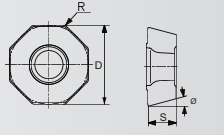
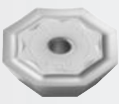
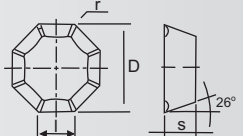
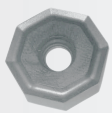
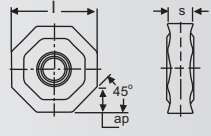
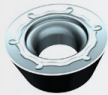
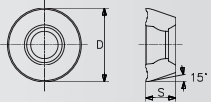
- Grades:● = BT9120, * = BT20AL

- Feed and Depth of cut need to be adapted according to the Material Group and machining condition.

- Product image shown on this catalogue may differ from actual products.



Unit : mm

Insert Shape	Designation	Dimensions					Feed (mm/tooth)		Depth of Cut		Geometry
		l	D	S	Ø	r	min.	max.	min.	max.	
	JDMW 09T320 [•]	9.525	-	3.97	15	2.0	0.20	0.80	0.20	0.80	
	JDMT 09T320 [•]	9.525	-	3.97	15	2.0	0.20	1.00	0.20	0.80	
	JDMW 120420 [•]	12	-	4.76	15	2.0	0.20	1.20	0.20	1.20	
	JDMT 120420 [•]	12	-	4.76	15	2.0	0.20	1.50	0.20	1.20	
	ODMT 060508 [•]	6.60	15.88	5.50	15	0.8	0.12	0.54	0.40	4.00	
	ODMW 060508 [•]	6.60	15.88	5.50	15	0.8	0.12	0.58	0.40	4.00	
	OFMT 05T308TN [•]	5.27	12.70	4.02	25	0.8	0.12	0.51	0.40	4.00	
	OFMT 070405 [•]	-	17.9	4.87	26	-	0.10	0.48	0.30	4.00	
	OFER 0704 [•]	-	17.9	4.76	26	-	0.10	0.48	0.30	4.00	
	OFER 070405 [•]	7.48	18.5	4.78	25	0.5	0.12	0.50	0.40	4.50	
	ONMU 080608 [•]	-	20.2	6.0	26	0.8	0.20	0.30	0.50	5.50	
	RDMT 0602M0 [•]	-	6.00	2.38	15	-	0.10	0.50	0.30	3.00	
	RDMT 0802M0 [•]	-	8.00	2.38	15	-	0.10	0.58	0.30	4.00	
	RDMT 0803M0 [•]	-	8.00	3.18	15	-	0.10	0.58	0.30	4.00	
	RDMT 10T3M0 [•]	-	10.00	3.97	15	-	0.10	0.64	0.30	5.00	
	RDMT 1204M0 [•]	-	12.00	4.76	15	-	0.14	0.74	0.30	6.00	

- Grades:● = BT9120.

- Feed and Depth of cut need to be adapted according to the Material Group and machining condition.

- Product image shown on this catalogue may differ from actual products.

Unit : mm

Insert Shape	Designation	Dimensions					Feed (mm/tooth)		Depth of Cut		Geometry
		l	D	S	Θ	r	min.	max.	min.	max.	
	RDMW 0602M0 [●]	-	6.00	2.38	15	-	0.10	0.48	0.30	3.00	
	RDMW 0802M0 [●]	-	8.00	2.38	15	-	0.10	0.58	0.30	4.00	
	RDMW 10T3M0 [●]	-	10.00	3.97	15	-	0.10	0.70	0.30	5.00	
	RDMW 1204M0 [●]	-	12.00	4.76	15	-	0.10	0.74	0.30	6.00	
	RPMT 08T2M0 [●]	-	8.00	2.78	11	-	0.10	0.58	0.30	4.00	
	RPMT 10T3M0 [●]	-	10.00	3.97	11	-	0.10	0.64	0.30	5.00	
	RPMT 1204M0 [●]	-	12.00	4.76	11	-	0.14	0.74	0.30	6.00	
	RPMW 1003M0 [●]	-	10.00	3.18	11	-	0.10	0.64	0.30	5.00	
	RPMW 1204M0 [●]	-	12.00	4.76	11	-	0.14	0.74	0.30	6.00	
	RPMX 1204M0 [●]	-	12.00	4.76	11	-	0.05	0.64	0.50	6.00	
	SEGT 1204-AL PDTR [*]	-	12.70	3.18	20	-	0.10	0.46	0.50	6.00	
	SEGT 12T3-AL PDTR [*]	-	12.70	3.18	20	-	0.10	0.46	0.50	6.00	
	SEKT 1204-AL PDTR [*]	-	12.70	3.18	20	-	0.10	0.46	0.50	6.00	
	SEKT 12T3-AL PDTR [*]	-	12.70	3.18	20	-	0.10	0.46	0.50	6.00	
	SEKN 1203AFTN [●]	-	12.70	3.18	20	-	0.10	0.46	0.50	7.00	
	SEKN 1504AFTN [●]	-	15.88	4.76	20	-	0.10	5.00	0.50	8.00	
	SEKR 1203AFTN [●]	-	12.70	3.18	20	-	0.10	0.46	0.50	7.00	


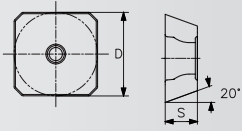

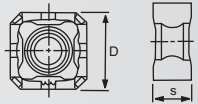
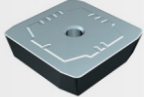
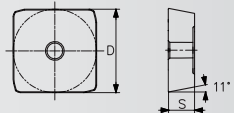
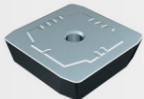
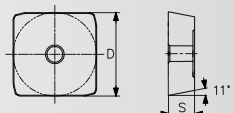

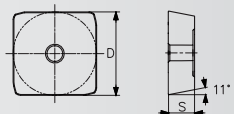
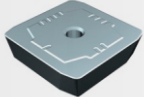
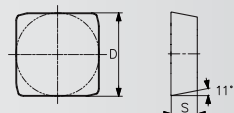
- Grades: ● = BT9120, * = BT20AL

- Feed and Depth of cut need to be adapted according to the Material Group and machining condition.

- Product image shown on this catalogue may differ from actual products.



Unit : mm

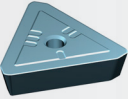
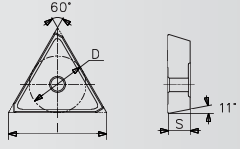

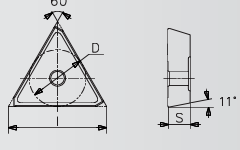
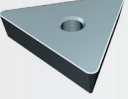
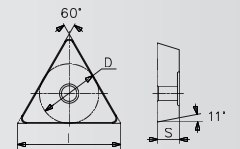
Insert Shape	Designation	Dimensions					Feed (mm/tooth)		Depth of Cut		Geometry
		l	D	S	Ø	r	min.	max.	min.	max.	
	SEKT 12T3AGTN [●]	-	13.40	3.97	20	-	0.10	0.46	0.50	7.00	
	SEKT 1204AFTN [●]	-	12.70	4.94	20	-	0.10	0.46	0.50	7.00	
	SEMT 1204AFTN [●]	-	12.70	5.06	20	-	0.10	0.46	0.50	7.00	
	SEKT 13T3AGTN [●]	-	13.40	5.06	20	-	0.10	0.46	0.50	7.00	
	SEMT 13T3AGSN [●]	-	13.40	5.06	20	-	0.10	0.46	0.50	7.00	
	SNMX 1206 [●]	-	12.70	4.50	20	-	0.10	0.46	0.50	7.00	
	SPKN 1203EDTR [●]	-	12.70	3.18	11	-	0.10	0.43	0.50	7.00	
	SPKN 1504EDTR [●]	-	15.88	4.76	11	-	0.10	0.43	0.50	9.00	
	SPKR 1203EDTR [●]	-	12.70	3.18	11	-	0.10	0.43	0.50	7.00	
	SPMT 09T308 [●]	-	9.53	3.71	11	0.8	0.04	0.22	0.50	9.00	
	SPMT 12T308 [●]	-	13.29	3.97	11	0.8	0.07	0.29	0.50	9.00	
	SPMT 120408 [●]	-	12.70	4.80	11	0.8	0.07	0.29	0.50	9.00	
	SPUN 120308 [●]	-	12.70	3.18	11	0.8	0.10	0.37	0.50	6.00	

- Grades: ● = BT9120.

- Feed and Depth of cut need to be adapted according to the Material Group and machining condition.

- Product image shown on this catalogue may differ from actual products.

Unit : mm

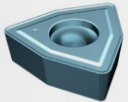
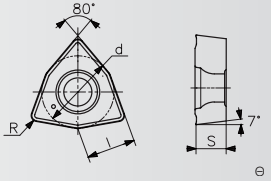
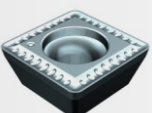
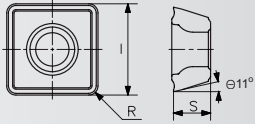
Insert Shape	Designation	Dimensions					Feed (mm/tooth)		Depth of Cut		Geometry
		l	D	S	Θ	r	min.	max.	min.	max.	
	TPKN 1603PDTR [●]	16.50	9.53	3.18	11	-	0.08	0.27	0.50	12.00	
	TPKN 2204PDTR [●]	22.00	12.70	4.76	11	-	0.09	0.27	0.50	18.00	
	TPKR 1603PDTR [●]	16.50	9.53	3.18	11	-	0.09	0.22	0.50	12.00	
	TPKR 2204PDTR [●]	22.00	9.53	3.18	11	-	0.09	0.22	0.50	18.00	
	TPUN 160308 [●]	16.50	9.53	3.18	11	0.8	0.08	0.27	0.50	12.00	

- Grades: ● = BT9120.
- Feed and Depth of cut need to be adapted according to the Material Group and machining condition.
- Product image shown on this catalogue may differ from actual products.



Drilling Inserts

Unit : mm

Insert Shape	Designation	Dimensions					Feed (mm/tooth)		Geometry
		l	D	S	Θ	r	min.	max.	
	WCMX 040208●	3.99	6.35	2.38	7	0.8	0.05	0.11	
	WCMX 050308●	5.07	7.94	3.18	7	0.8	0.06	0.11	
	WCMX 06T308●	6.14	9.52	3.97	7	0.8	0.06	0.13	
	WCMX 080412●	8.14	12.7	4.76	7	1.2	0.06	0.18	
	SPMG 050204●	5.00	-	2.38	11	0.4	0.04	0.10	
	SPMG 060204●	6.00	-	2.38	11	0.4	0.04	0.10	
	SPMG 07T308●	7.94	-	3.97	11	0.8	0.05	0.11	
	SPMG 090408●	9.80	-	4.30	11	0.8	0.06	0.12	
	SPMG 110408●	11.50	-	4.80	11	0.8	0.06	0.15	
	SPMG 140512●	14.20	-	5.20	11	0.8	0.08	0.20	

- Grades:● = BT6800.
- Feed and Depth of cut need to be adapted according to the Material Group and machining condition.
- Product image shown on this catalogue may differ from actual products.

Recommend cutting conditions

For TURNING Application

ISO	Material Group	VDI Group	Relative materials (DIN)	Hardness HB	Cutting speed (m/min.)
P	Non-alloy steel	1 - 5	9 SMn 28, C35, C50, C40E, C45E, 49 CrMo 4	125 - 250	180 - 320
	Low alloy steel	6 - 9	13 CrMo 44, 40NiCrM022, 58 CrV 4	200 - 350	120 - 280
	High alloy steel	10 - 11	X 40 CrMoV 5 1, X100 CrMoV 5 1, S6-5-5	200 - 325	70 - 190
M	Ferritic/martensitic Stainless steel	12 - 13	X6Cr13, X10CrA118, X20CrNi175	200 - 240	170 - 250
	Austenitic	14	X5 CrNi 18 9, X5 CrNiMo 17 13 3, X6 CrNiTi 18 9	180	160 - 220
K	Grey cast iron	15 - 16	GG15, GG20, GGG40, GG-35	180 - 260	30 - 140
	Malleable cast iron	19 - 20	GTS-35-10, GTS-35, GTS70-02, 20mN5	130 - 230	30 - 140
S	Fe, Ni or Co based	31 - 35	X12 NiCrAlTi 31 20, TiAl5Sn2	200 - 350	30 - 80
	Titanium and Ti-alloy based	36 - 37	TiCu2, TiAl6V4, TiAl6V4ELI	-	50 - 180
H	Hardened steel	38 - 39	C 105 W1, 75 CrMoNiW 6 7	55 - 60 HRC	20 - 90
	Chilled Cast iron	40	G-X 260 NiCr 4 2, X15 CrNiSi 25 20	400	40 - 60
	White Cast iron	41	G-X 300 CrMo 15 3	55 HRC	30 - 50

- Above recommend cutting condition can be changed according to the customer's machining condition.



Grades Comparison Chart

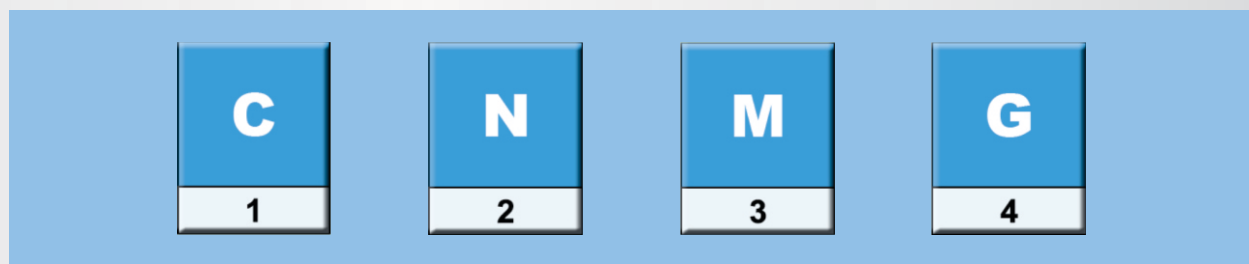
TURNING

ISO	Symbol	Brisloy	Sandvik	Kennametal	Seco	Iscar	Mitsubishi	Sumitomo	Tungaloy	Taegutec
P	P10	BT3310 BT3320*	GC1525 GC1025	KC5010 KC5510 KU10T	CP200 TS2000	IC507 IC807 IC907	VP10MF		AH710	
	P20	BT3320* BT2233	GC1525 GC1025 GC1125	KC5025 KC5525 KC7215 KC7315 KU25T	CP250 TS2500	IC507 IC807 IC907 IC908 IC928	VP10RT VP20RT VP15TF VP20MF	AC520U	AH710 AH725	TT9020
	P30	BT2233* BT3330	GC1025 GC1125	KC7015 KC7020 KU25T KC7235	CP500	IC328 IC1008 IC3028	VP10RT VP20RT VP15TF VP20MF	AC530U	AH725 AH120 GH130	TT8020 TT9020
	P40	BT3330*		KC7040 KC7140 KC7030	CP500	IC328 IC1008 IC3028		AC530U	AH740	TT8020 TT9020
M	M10	BT2233	GC1005 GC1025 GC1125 GC1105	KC5010 KC5510 KC6005 KC6015	CP200 TS2000	IC330 IC507 IC570 IC907	VP10MF		AH710	TT5080
	M20	BT2233*	GC1005 GC1025 GC1125 GC1105	KC5025 KC5525 KC7020 KC7025	CP250 TS2500 CP500	IC250 IC354 IC908 IC3028	VP10RT VP20RT VP15TF VP20MF	AC520U	AH710 AH120 GH730	TT5080 TT9020 TT9080
	M30	BT3330	GC1125 GC2035	KC7030 KC7225	CP500	IC328 IC928 IC3028	VP10RT VP20RT VP15TF VP20MF MP7035	AC520U AC530U	GH330 AH120 GH730	TT8020 TT9020 TT9080
	M40	BT3330*	GC2035			IC328 IC928 IC3028	MP7035	AC530U	J740	TT8020 TT9080
K	K10	BT2255*		KC5010 KC7210	CP200 TS2000	IC350 IC1008		AC510U	GH110 AH110	
	K20	BT2255		KC7015 KC7215 KC7315	CP200 CP250 TS2000 TS250	IC228 IC808 IC908	VP10RT VP20RT VP15TF		GH110 AH110 AH725	
	K30	BT3310*		KC7225	CP500	IC228 IC808 IC908	VP10RT VP20RT VP15TF		AH725 AH120 GH730	
S	S10	BT3320 BT2233	GC1105 GC1005 GC1025	KC5010 KC5410 KC5510	CP200 CP250 TS2000 TS250	IC507 IC903	MP9005 MP9015 VP10RT	AU510U	AH905 AH110 AH120	TT5080
	S20	BT3320 BT2233	GC1025 GC1125	KC5025 KC5525	CP250 TS2500 CP500	IC300 IC808 IC908	MP9015 MT9015 VP20RT	AC510U AC520U	AH120 AH725	TT5080 TT9080
	S30	BT3320 BT2233	GC1125				VP15TF	AC520U	AH725	TT8020 TT9080
H	H10	BT3320 BT2233	GC15 GC1125				VP15TF			
	H20	BT3320 BT2233	GC1025 GC1515	KCU25 KC5525	CP500	IC808 IC908	VP15TF VP20RT	AC520U EH20Z	AH120	TT9080
	H30	BT3320 BT2233	GC1525	KC5025						

- * Represents first choice application range.
 - Above data is just for reference.

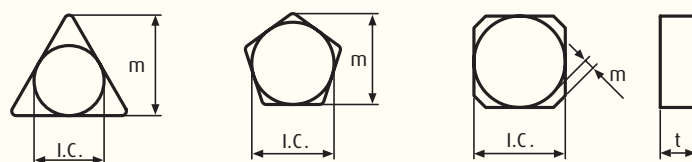
Turning Inserts Designation System-ISO

1. Insert Shape				2. Clearance Angle				4. Cross Section Shape		
A	B	C	D					A	F	G
				5°	7°	15°	20°			
E	H	K	L	B	C	D	E	M	N	R
				25°	30°	0°	11°			special
O	P	R	S	F	G	N	P	T	W	X
		special								
T	W	X								



3. Tolerance

	Tolerance (mm)			I.C. Size (mm)					
	m	t	I.C.	6.35	9.525	12.7	15.875	19.05	25.4
A	± 0.005	± 0.025	± 0.025	•	•	•	•	•	•
C	± 0.013	± 0.025	± 0.025	•	•	•	•	•	•
E	± 0.025	± 0.025	± 0.025	•	•	•	•	•	•
F	± 0.005	± 0.025	± 0.013	•	•	•	•	•	•
G	± 0.025	± 0.13	± 0.025	•	•	•	•	•	•
H	± 0.013	± 0.025	± 0.013	•	•	•	•	•	•
K	± 0.013	± 0.025	± 0.05	•	•				
			± 0.08			•			
			± 0.10				•	•	
			± 0.13						•
M	± 0.13	± 0.13	± 0.05	•	•				
			± 0.08			•			
			± 0.10				•	•	
			± 0.13						•





Turning Inserts Designation System-ISO

5. Cutting Edge Length (mm)									
I.C.	C	D	R	S	T	V	W	K	H
L									
	3.97	03	04		03	06		02	
	4.76	04	05		04	08	08		
	5.56	05	06		05	09	09	03	
	6.35	06	07		06	11	11	04	
	7.94	08	09		07	13	13	05	
	9.525	09	11	09	09	16	16	06	16
	12.7	12	15		12	22	22	08	05
	15.875	16	19	15	15	27	27	10	
	19.05	19	23	19	19	33	33	13	10
25.4	25	31	25	25	44	44	17		

8. Chip Breaker
For Application

12	04	08	CHIP BREAKER
5	6	7	8

6. Thickness (mm)	
t	mm
02	2.38
03	3.18
T3	3.97
04	4.76
06	6.35
07	7.94
09	9.52

7. Nose Radius (mm)	
r	mm
02	0.2
04	0.4
08	0.8
10	1.0
12	1.2
16	1.6
20	2.0

Turning Inserts (Negative)

Unit : mm

Insert Shape	Designation	BT2255	BT3310	BT3320	BT2233/40	BT3330	BT10L	Dimensions				Feed (mm/rev.)		Depth of Cut		Geometry
								l	D	S	r	min.	max.	min.	max.	
	CNMA 120404	○						12.90	12.70	4.76	0.4	0.10	0.30	0.30	2.0	
	CNMA 120408	■	□					12.90	12.70	4.76	0.8	0.20	0.80	0.80	6.0	
	CNMA 120412	■	□					12.90	12.70	4.76	1.2	0.20	0.70	1.20	6.0	
	CNMA 160612	○	○					12.90	15.88	6.35	1.2	0.20	0.70	1.20	6.0	
	CNMG 120404			○	□	○		12.90	12.70	4.76	0.4	0.05	0.23	0.50	3.0	
	CNMG 120408	■	○	○	■	□		12.90	12.70	4.76	0.8	0.05	0.80	0.80	3.0	
	CNMG 120412	■	○	○	■	□		12.90	12.70	4.76	1.2	0.11	0.50	1.20	5.0	
	DNMG 110404			○	■	○		11.60	9.53	4.76	0.4	0.05	0.23	0.50	3.0	
	DNMG 110408			○	○	○		11.60	9.53	4.76	0.8	0.11	0.60	0.80	4.0	
	DNMG 150404			○	■	○		15.50	12.70	4.76	0.4	0.05	0.23	0.50	3.0	
	DNMG 150408			○	○	○		15.50	12.70	4.76	0.8	0.11	0.50	0.80	5.0	
	DNMG 150604			○	■	○		15.50	12.70	6.35	0.4	0.05	0.23	0.50	3.0	
	DNMG 150608			○	■	○		15.50	12.70	6.35	0.4	0.05	0.23	0.80	3.0	
	DNMG 150612			○	○			15.50	12.70	6.35	1.2	0.14	0.68	1.20	6.0	
	SNMA 120408	■	○					12.70	12.70	4.76	0.8	0.15	0.70	1.00	6.0	
	SNMA 120412	■	○					12.70	12.70	4.76	1.2	0.20	0.80	1.50	6.0	
	SNMG 120404				●			12.70	12.70	4.76	0.4	0.16	0.70	0.50	5.0	
	SNMG 120408			□	■			12.70	12.70	4.76	0.8	0.16	0.70	0.80	5.0	
	SNMG 120412			○	●			12.70	12.70	4.76	1.2	0.19	0.95	1.20	6.0	

Symbols:

- Stocked in Gurugram.
- Ordered as per demand.
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- To be ordered in demand- New grades / Geometries.

Available Geometries:

FF BT 2233, 2240, 3320 grades with CR-0.4 & 0.8	MF BT 2233, 2240, 3320 grades with CR-0.4, 0.8 & 1.2	MM BT 2233, 2240, 3320 grades with CR-0.4, 0.8 & 1.2
MF BT 2233, 2240, 3320 grades with CR-0.4, 0.8 & 1.2	MR BT 2233, 2240, 3320 grades with CR-0.8 & 1.2	K1 BT 2255, 3310, grades with CR-0.4, 0.8 & 1.2



Unit : mm

Insert Shape	Designation	BT2255	BT3310	BT3320	BT2233/40	BT3330	BT10L	Dimensions				Feed (mm/rev.)		Depth of Cut		Geometry
								l	D	S	r	min.	max.	min.	max.	
	TNMA 160408	■						16.50	9.53	4.76	0.8	0.10	0.40	1.00	4.00	
	TNMA 160412	■						16.50	9.53	4.76	1.2	0.10	0.50	1.50	4.50	
	TNMG 160404			○	■			16.50	9.53	4.76	0.4	0.05	0.23	0.50	3.00	
	TNMG 160408			□	■	□		16.50	9.53	4.76	0.8	0.11	0.50	0.80	5.00	
	TNMG 160412				□			16.50	9.53	4.76	1.2	0.14	0.68	1.20	5.00	
	TNMG 220404				○			22.00	12.70	4.76	0.4	0.05	0.23	0.50	3.00	
	TNMG 220408					■		22.00	12.70	4.76	0.8	0.11	0.50	0.80	5.00	
	TNMG 220412					■		22.00	12.70	4.76	1.2	0.14	0.68	1.20	7.00	
	TNUX 160404 L				●			16.50	9.53	4.76	0.4	0.05	0.23	0.50	3.00	
	TNUX 160408 L					●		16.50	9.53	4.76	0.8	0.11	0.50	0.80	5.00	
	TNUX 160404 R					●		16.50	9.53	4.76	0.4	0.05	0.23	0.50	3.00	
	TNUX 160408 R					●		16.50	9.53	4.76	0.8	0.11	0.50	0.80	5.00	
	VNMG 160404				■			16.00	9.53	4.76	0.4	0.05	0.23	0.50	3.00	
	VNMG 160408				■			16.00	9.53	4.76	0.8	0.10	0.40	0.80	4.00	
	VNMG 160412				○			16.00	9.53	4.76	1.2	0.10	0.40	0.80	4.00	
	VNMG 220408				○	○		22.00	12.70	4.76	0.8	0.10	0.50	1.50	5.00	
	WNMA 080404	■						8.70	12.70	4.76	0.4	0.15	0.60	1.00	5.00	
	WNMA 080408	■						8.70	12.70	4.76	0.8	0.15	0.60	1.00	6.00	
	WNMA 080412	■						8.70	12.70	4.76	1.2	0.15	0.70	1.50	6.00	
	WNMG 060404				■			6.60	9.53	4.76	0.4	0.05	0.23	0.50	3.00	
	WNMG 060408				■			6.60	9.53	4.76	0.8	0.11	0.50	0.80	3.00	
	WNMG 080404	●			■			8.70	12.70	4.76	0.4	0.05	0.23	0.50	3.00	
	WNMG 080408	■			■			8.70	12.70	4.76	0.8	0.11	0.50	0.80	3.50	
	WNMG 080412	●			●			8.70	12.70	4.76	0.4	0.11	0.50	1.50	3.50	

Symbols:

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- To be ordered in demand- New grades / Geometries.

Available Geometries:

FF BT 2233, 2240, 3320 grades with CR-0.4 & 0.8	MF BT 2233, 2240, 3320 grades with CR-0.4, 0.8 & 1.2	MM BT 2233, 2240, 3320 grades with CR-0.4, 0.8 & 1.2
MF BT 2233, 2240, 3320 grades with CR-0.4, 0.8 & 1.2	MR BT 2233, 2240, 3320 grades with CR-0.8 & 1.2	K1 BT 2255, 3310, grades with CR-0.4 0.8 & 1.2

Turning Inserts (Positive)

Unit : mm

Insert Shape	Designation	BT2255	BT3310	BT3320	BT2233/40	BT3330	BT10L	Dimensions				Feed (mm/rev.)		Depth of Cut		Geometry
								l	D	S	r	min.	max.	min.	max.	
	CCMT 060204	○			■	○		6.50	6.35	2.38	0.4	0.04	0.20	0.50	2.10	
	CCMT 060208	○			■	○		6.50	6.35	2.38	0.8	0.04	0.20	0.80	2.10	
	CCMT 09T304				■	○		9.70	9.53	3.97	0.4	0.05	0.23	0.50	3.00	
	CCMT 09T308	○			■	○		9.70	9.53	3.97	0.8	0.11	0.50	0.80	4.00	
	CCMT 120408	○			●	○		12.90	12.70	4.76	0.8	0.11	0.50	0.80	5.00	
	DCMT 070204				■	○		7.80	6.35	2.38	0.4	0.04	0.20	0.50	2.10	
	DCMT 11T304				●	○		11.60	9.53	3.97	0.4	0.05	0.23	0.50	3.00	
	DCMT 11T308	○			●	○		11.60	9.53	3.97	0.8	0.11	0.50	0.80	4.00	
	RCMT 0602M0	○			■	○		-	6.00	2.38	-	0.05	0.40	0.30	3.00	
	RCMT 0803M0	○			■	○		-	8.00	3.18	-	0.05	0.40	0.30	4.00	
	RCMT 10T3M0	○			■	○		-	10.00	3.97	-	0.05	0.40	0.30	5.00	
	RCMT 1204M0	○			■	○		-	12.00	4.76	-	0.05	0.40	0.50	6.00	
	SCMT 09T304	○			■	○		9.53	9.53	3.97	0.4	0.05	0.26	0.50	3.00	
	SCMT 09T308	○			■	○		9.53	9.53	3.97	0.8	0.11	0.50	0.80	3.00	
	SCMT 120408	○			○	○		12.70	12.70	4.76	0.8	0.12	0.50	0.80	4.00	
	TCMT 110204	○			■	○		11.00	6.35	2.38	0.4	0.04	0.20	0.50	2.10	
	TCMT 16T304	○			■	○		16.50	9.53	3.97	0.4	0.05	0.23	0.50	3.00	
	TCMT 16T308	○			■	□		16.50	9.53	3.97	0.8	0.11	0.43	0.80	5.00	
	VBMT 110304	○			○	○		11.00	6.35	3.18	0.4	0.04	0.20	0.50	2.10	
	VBMT 160404	○			■	○		16.00	9.53	4.76	0.4	0.05	0.23	0.50	3.00	
	VBMT 160408	○			■	○		16.00	9.53	4.76	0.8	0.10	0.40	0.80	3.50	
	VCMT 110304	○			○	○		11.00	6.35	3.18	0.4	0.04	0.20	0.50	2.10	
	VCMT 160404	○			●	○		16.00	9.53	4.76	0.4	0.05	0.23	0.50	3.00	
	VCMT 160408	○			■	○		16.00	9.53	4.76	0.8	0.10	0.40	0.80	3.50	



Turning Pos Aluminium

Unit : mm

Insert Shape	Designation	BT2255	BT3310	BT3320	BT2233/40	BT3330	BT10L	Dimensions				Feed (mm/rev.)		Depth of Cut		Geometry
								l	D	S	r	min.	max.	min.	max.	
	CCGT 09T304-AL						○	9.00	9.525	3.96	0.4	0.05	0.25	0.50	2.00	
	CCGT 09T308-AL						○	9.00	9.525	3.96	0.8	0.10	0.35	0.50	3.00	
	DCGT 070204-AL						○	7.00	7.00	2.38	0.4	0.08	0.25	0.50	2.50	
	DCGT 11T304-AL						○	11.00	11.00	3.96	0.4	0.08	0.25	0.50	2.50	
	DCGT 11T308-AL						○	11.00	11.00	3.96	0.4	0.10	0.35	0.50	3.00	
	TCGT 16T304-AL						○	16.00	9.525	3.96	0.4	0.05	0.25	0.50	3.00	
	TCGT 16T308-AL						○	16.00	9.525	3.96	0.8	0.10	0.35	0.50	3.50	
	VCGT 160404-AL						○	16.2	9.525	4.76	0.4	0.05	0.25	0.50	2.50	

Symbols:


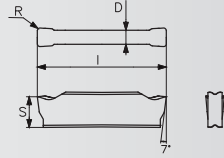

- Stocked in Gurugram.
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- To be stocked at Gurugram very soon- New grades / Geometries.
- To be ordered in demand- New grades / Geometries.

Available Geometries:

FF BT 2233, 2240, 3320 grades with CR-0.4 & 0.8	MF BT 2233, 2240, 3320 grades with CR-0.4, 0.8 & 1.2	MM BT 2233, 2240, 3320 grades with CR-0.4, 0.8 & 1.2
MF BT 2233, 2240, 3320 grades with CR-0.4, 0.8 & 1.2	MR BT 2233, 2240, 3320 grades with CR-0.8 & 1.2	K1 BT 2255, 3310, grades with CR-0.4 0.8 & 1.2

Parting & Grooving

Unit : mm

Insert Shape	Designation	Dimensions				Feed (mm/rev.)		Depth of Cut		Geometry
		l	D	S	r	min.	max.	min.	max.	
	MGMN 1402-N [•]	16.00	1.60	3.50	0.2	0.05	0.15		14.00	
	MGMN 2002-N [•]	16.00	1.60	3.50	0.2	0.05	0.15		14.00	
	MGMN 2002-P [•]	16.00	1.60	3.50	0.2	0.05	0.15		14.00	
	MGMN 3004-N [•]	21.00	2.35	4.80	0.4	0.05	0.15		19.00	
	MGMN 3004-P [•]	21.00	2.35	4.80	0.4	0.05	0.15		19.00	
	MGMN 4004-N [•]	21.00	3.30	4.80	0.4	0.05	0.15		19.00	
	MGMN 4004-P [•]	21.00	3.30	4.80	0.4	0.05	0.15		19.00	
	MGMN 5008-N [•]	26.00	4.10	5.80	0.8	0.05	0.15		24.00	
	MGMN 5008-P [•]	26.00	4.10	5.80	0.8	0.05	0.15		24.00	
		MRMN 200 [•]	16.00	1.60	3.50	0.2	0.05	0.15		
MRMN 300 [•]		21.00	2.35	4.80	0.4	0.05	0.15		19.00	
MRMN 400 [•]		21.00	3.30	4.80	0.4	0.05	0.15		19.00	
MRMN 500 [•]		26.00	4.10	5.80	0.8	0.05	0.15		24.00	

- Grades: • = BT2277.

- Feed and Depth of cut need to be adapted according to the Material Group and machining condition.

- Product image shown on this catalogue may differ from actual products.



Threading Full Profile

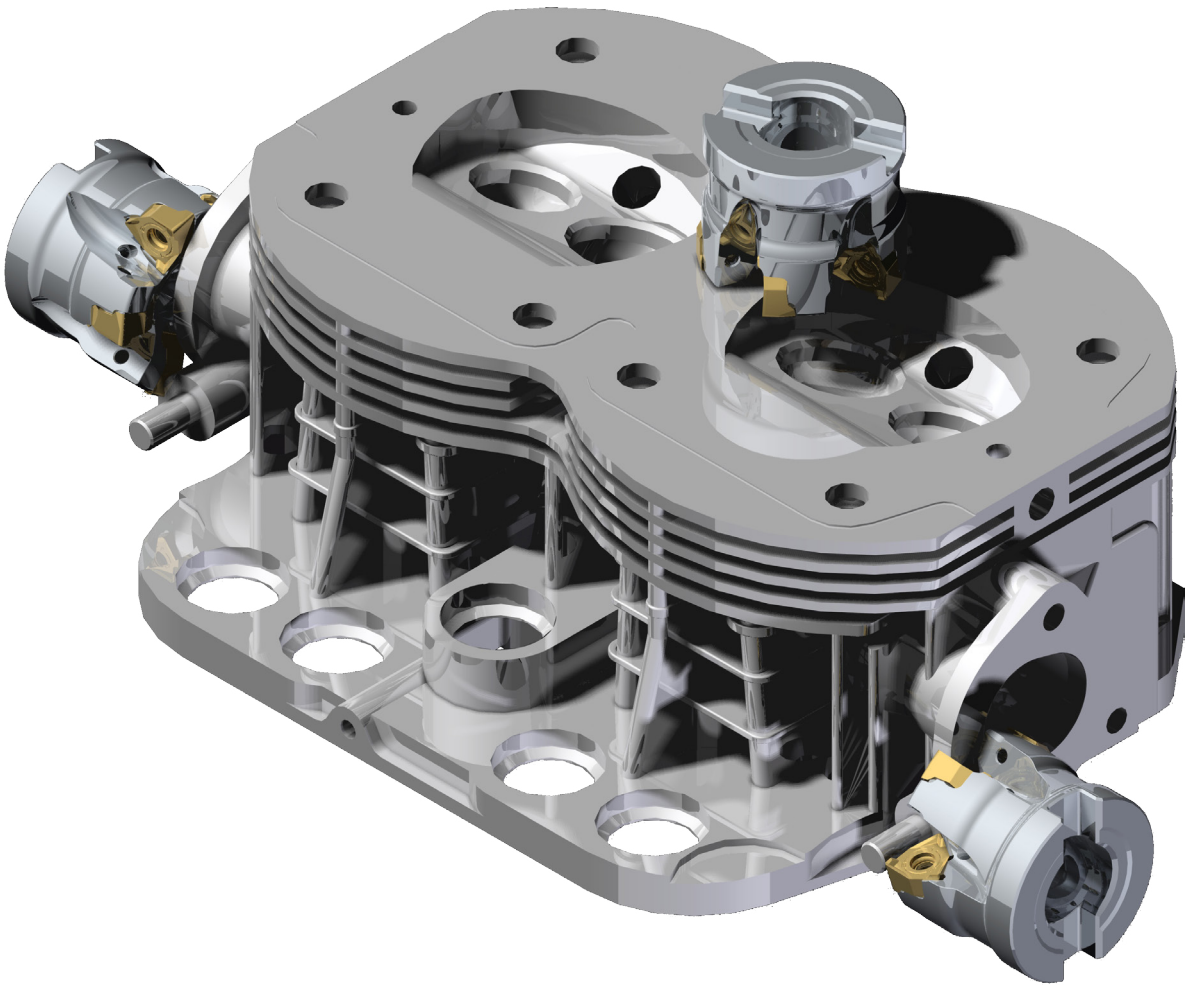
Unit : mm

Insert Shape	Designation	Dimensions				Feed (mm/rev.)		Depth of Cut		Geometry
		l	D	S	r	min.	max.	min.	max.	
	16ERM 1.0-ISO *									
	16ERM 1.25-ISO *									
	16ERM 1.5-ISO *									
	16ERM 1.75-ISO *									
	16ERM 2.0-ISO *									
	16IRM 1.0-ISO *									
	16IRM 1.25-ISO *									
	16IRM 1.5-ISO *									
	16IRM 1.75-ISO *									
	16IRM 2.0-ISO *									
	16ELM 1.25-ISO *									
	16ELM 1.5-ISO *									
	16ELM 1.75-ISO *									
	16ELM 2.0-ISO *									
	16ERM 16-UN *									
	16ERM 14-UN *									
	16ERM 12UN *									
	16ER AG55 *									
	16IR AG55 *									
	16EL AG55 *									
	16IL AG55 *									
	16ER AG60 *									
	16IR AG60 *									
	16EL AG60 *									
	16IL AG60 *									

- Grades: * = BT2288.

- Feed and Depth of cut need to be adapted according to the Material Group. Please see on page 18.

- Product image shown on this catalogue may differ from actual products.





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