
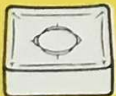








Cutting Data Recommendations

Material				415	425	435
				Feed mm/rev.		
CMC No.	Type	$k_{s0.4}$ N/mm ²	Hardness HB	0.4-0.6-0.8	0.4-0.6-0.8	0.6-0.8-1.2
				Cutting Speed m/min.		
01.1	Non Alloyed Steel C=0.15%	1900	90-200	365-310-320	315-265-205	225-200-160
01.2	C=0.35%	2100	125-225	315-265-230	275-230-175	195-170-140
01.3	C=0.70%	2000	150-250	300-250-220	255-215-165	185-160-130
01.4	High Carbon Steel	2300	180-275	270-230-195	230-195-150	165-145-120
01.5	Hardened & Tempered	2500	250-450	230-190-165	195-165-125	140-125-100
02.1	Low Alloy Steel Non-Hardened	2100	150-260	270-230-200	200-165-130	135-115-95
02.2	Hardened	2750	220-450	155-120-115	110- 95- 75	75- 65-55
03.11	High Alloy Steel Annealed	2500	150-250	235-195-170	175-150-115	110- 95-75
03.21	Hardened	3750	250-350	120-	75- 65- 50	60- 50-40
06.1	Steel Castings Non-Alloyed	1800	-225	230-200-	165-140-115	120-110-90
06-2/3	Low & High Alloyed	2200	150-250	150-130-	105- 90- 75	80- 65-60

Coromant Insert Programme

T-MAX P 	415	425	435
 SNMM 12 04 04-71 SNMM 12 04 08-71 SNMM 12 04 12-71 SNMM 15 06 04-71 SNMM 15 06 08-71 SNMM 15 06 12-71 SNMM 15 06 16-71 SNMM 19 06 16-71  CNMM 12 04 04-71 CNMM 12 04 08-71 CNMM 12 04 12-71 CNMM 16 06 04-71 CNMM 16 06 08-71 CNMM 16 06 12-71 CNMM 16 06 16-71 CNMM 19 06 12-71			
CNMM T-MAX P 	415	425	435
 TNMM 11 03 02-71 TNMM 11 03 04-71 TNMM 16 04 04-71 TNMM 16 04 08-71 TNMM 16 04 12-71 TNMM TNMM 22 04 04-71 TNMM 22 04 08-71 TNMM 22 04 12-71 TNMM 22 04 16-71 TNMM 27 06 12-71			
TNMM T-MAX P 	415	425	435
 SNMM 15 06 24-31 SNMM 19 06 16-31 SNMM 19 06 24-31 SNMM 25 07 24-31 SNMM 25 07 32-31 SNMM 25 09 24-31 SNMM 25 09 32-31  CNMM 19 06 16-62 CNMM 19 06 24-62 CNMM 25 09 24-62 CNMM 25 09 32-62			