



Milling - Metric

Date compiled Nov. 10 2016

APKT 100305 PDTR											
Material			Cutting conditions								
Group	Sub Group	Hardness (HB)	Feed Fz (mm/Tooth)			Speed Vc (m/min)			Depth Of Cut (mm)		
			Min	Max	Recommend	Min	Max	Recommend	Min	Max	Recommend
P	Non Alloy	120	0.13	0.26	0.20	190	330	250	0.5	9.0	2.0
	Low Alloy	200	0.11	0.21	0.16	150	240	200	0.5	9.0	2.0
	High Alloy	220	0.08	0.18	0.13	90	150	120	0.5	6.4	1.5
M	Austenitic	190	0.11	0.21	0.16	190	250	220	0.5	9.0	2.0
K	Grey Cast Iron	140	0.13	0.26	0.20	150	240	200	0.5	9.0	2.0
S	Heat resistant and super alloys	240	0.08	0.15	0.12	25	45	35	0.5	6.4	1.5
H	Hardened material	45HRc	0.07	0.15	0.11	40	80	60	0.5	3.2	1.0

APKT 100308 PDTR											
Material			Cutting conditions								
Group	Sub Group	Hardness (HB)	Feed Fz (mm/Tooth)			Speed Vc (m/min)			Depth Of Cut (mm)		
			Min	Max	Recommend	Min	Max	Recommend	Min	Max	Recommend
P	Non Alloy	120	0.13	0.26	0.20	190	330	250	0.5	9.0	2.0
	Low Alloy	200	0.11	0.21	0.16	150	240	200	0.5	9.0	2.0
	High Alloy	220	0.08	0.18	0.13	90	150	120	0.5	6.4	1.5
M	Austenitic	190	0.11	0.21	0.16	190	250	220	0.5	9.0	2.0
K	Grey Cast Iron	140	0.13	0.26	0.20	150	240	200	0.5	9.0	2.0
S	Heat resistant and super alloys	240	0.08	0.15	0.12	25	45	35	0.5	6.4	1.5
H	Hardened material	45HRc	0.07	0.15	0.11	40	80	60	0.5	3.2	1.0

APKT 160408 PDTR											
Material			Cutting conditions								
Group	Sub Group	Hardness (HB)	Feed Fz (mm/Tooth)			Speed Vc (m/min)			Depth Of Cut (mm)		
			Min	Max	Recommend	Min	Max	Recommend	Min	Max	Recommend
P	Non Alloy	120	0.18	0.32	0.25	190	330	250	0.5	15.0	4.0
	Low Alloy	200	0.15	0.25	0.20	150	240	195	0.5	15.0	4.0
	High Alloy	220	0.12	0.22	0.17	90	150	120	0.5	10.7	4.0
M	Austenitic	190	0.15	0.25	0.20	190	250	220	0.5	15.0	3.0
K	Grey Cast Iron	140	0.18	0.32	0.25	150	240	195	0.5	15.0	4.0
S	Heat resistant and super alloys	240	0.12	0.18	0.15	25	45	35	0.5	10.7	3.0
H	Hardened material	45HRc	0.10	0.18	0.14	40	80	60	0.5	5.4	2.0

APMT 113504 PDTR											
Material			Cutting conditions								
Group	Sub Group	Hardness (HB)	Feed Fz (mm/Tooth)			Speed Vc (m/min)			Depth Of Cut (mm)		
			Min	Max	Recommend	Min	Max	Recommend	Min	Max	Recommend
P	Non Alloy	120	0.13	0.22	0.18	190	330	250	0.5	10.0	2.0
	Low Alloy	200	0.11	0.18	0.15	150	240	200	0.5	10.0	2.0
	High Alloy	220	0.08	0.15	0.12	90	150	120	0.5	7.2	1.5
M	Austenitic	190	0.11	0.18	0.15	190	250	220	0.5	10.0	2.0
K	Grey Cast Iron	140	0.13	0.22	0.18	150	240	200	0.5	10.0	2.0
S	Heat resistant and super alloys	240	0.08	0.13	0.11	25	45	35	0.5	7.2	1.5
H	Hardened material	45HRc	0.07	0.13	0.07	40	80	60	0.5	3.6	1.0

APMT 113508 PDTR											
Material			Cutting conditions								
Group	Sub Group	Hardness (HB)	Feed Fz (mm/Tooth)			Speed Vc (m/min)			Depth Of Cut (mm)		
			Min	Max	Recommend	Min	Max	Recommend	Min	Max	Recommend
P	Non Alloy	120	0.13	0.22	0.18	190	330	250	0.5	10.0	2.0
	Low Alloy	200	0.11	0.18	0.15	150	240	200	0.5	10.0	2.0
	High Alloy	220	0.08	0.15	0.12	90	150	120	0.5	7.2	1.5
M	Austenitic	190	0.11	0.18	0.15	190	250	220	0.5	10.0	2.0
K	Grey Cast Iron	140	0.13	0.22	0.18	150	240	200	0.5	10.0	2.0
S	Heat resistant and super alloys	240	0.08	0.13	0.11	25	45	35	0.5	7.2	1.5
H	Hardened material	45HRc	0.07	0.13	0.07	40	80	60	0.5	3.6	1.0



APMT 160408 PDTR											
Material			Cutting conditions								
Group	Sub Group	Hardness (HB)	Feed Fz (mm/Tooth)			Speed Vc (m/min)			Depth Of Cut (mm)		
			Min	Max	Recommend	Min	Max	Recommend	Min	Max	Recommend
P	Non Alloy	120	0.16	0.30	0.23	190	330	250	0.5	15.0	4.0
	Low Alloy	200	0.14	0.23	0.19	150	240	200	0.5	15.0	4.0
	High Alloy	220	0.11	0.2	0.16	90	150	120	0.5	10.7	4.0
M	Austenitic	190	0.14	0.23	0.19	190	250	220	0.5	15.0	4.0
K	Grey Cast Iron	140	0.16	0.30	0.23	150	240	200	0.5	15.0	4.0
S	Heat resistant and super alloys	240	0.11	0.17	0.14	25	45	35	0.5	10.7	3.0
H	Hardened material	45HRc	0.09	0.17	0.13	40	80	60	0.5	5.4	2.0

ODMT 060508											
Material			Cutting conditions								
Group	Sub Group	Hardness (HB)	Feed Fz (mm/Tooth)			Speed Vc (m/min)			Depth Of Cut (mm)		
			Min	Max	Recommend	Min	Max	Recommend	Min	Max	Recommend
P	Non Alloy	120	0.22	0.54	0.38	190	330	250	0.5	4.0	2.5
	Low Alloy	200	0.18	0.43	0.31	150	240	195	0.5	4.0	2.5
	High Alloy	220	0.14	0.37	0.26	90	150	120	0.5	2.9	1.9
M	Austenitic	190	0.18	0.37	0.28	190	250	220	0.5	4.0	2.5
K	Grey Cast Iron	140	0.22	0.54	0.38	150	240	195	0.5	4.0	2.5
S	Heat resistant and super alloys	240	0.14	0.31	0.23	25	45	35	0.5	2.9	1.9
H	Hardened material	45HRc	0.12	0.31	0.22	40	80	60	0.4	1.4	1.3

ODMW 060508											
Material			Cutting conditions								
Group	Sub Group	Hardness (HB)	Feed Fz (mm/Tooth)			Speed Vc (m/min)			Depth Of Cut (mm)		
			Min	Max	Recommend	Min	Max	Recommend	Min	Max	Recommend
P	Non Alloy	120	0.22	0.58	0.40	190	330	250	0.5	4.0	3.0
	Low Alloy	200	0.18	0.45	0.32	150	240	195	0.5	4.0	3.0
	High Alloy	220	0.14	0.40	0.27	90	150	120	0.5	2.9	2.3
K	Grey Cast Iron	140	0.22	0.58	0.40	150	240	195	0.5	4.0	3.0
H	Hardened material	45HRc	0.12	0.32	0.22	40	80	60	0.4	1.4	1.3

OFMT 05T308											
Material			Cutting conditions								
Group	Sub Group	Hardness (HB)	Feed Fz (mm/Tooth)			Speed Vc (m/min)			Depth Of Cut (mm)		
			Min	Max	Recommend	Min	Max	Recommend	Min	Max	Recommend
P	Non Alloy	120	0.22	0.51	0.37	190	330	250	0.5	3.5	2.5
	Low Alloy	200	0.18	0.40	0.29	150	240	195	0.5	3.5	2.5
	High Alloy	220	0.14	0.35	0.25	90	150	120	0.5	2.5	1.9
	Austenitic	190	0.18	0.35	0.27	190	250	220	0.5	3.5	2.5
K	Grey Cast Iron	140	0.22	0.51	0.37	150	240	195	0.5	3.5	2.5
S	Heat resistant and super alloys	240	0.14	0.29	0.22	25	45	35	0.5	2.5	1.9
H	Hardened material	45HRc	0.12	0.29	0.21	40	80	60	0.4	1.3	1.3



RDKT 0802 M0											
Material			Cutting conditions								
Group	Sub Group	Hardness (HB)	Feed Fz (mm/Tooth)			Speed Vc (m/min)			Depth Of Cut (mm)		
			Min	Max	Recommend	Min	Max	Recommend	Min	Max	Recommend
P	Non Alloy	120	0.18	0.64	0.35	190	330	250	0.5	2.5	0.8
	Low Alloy	200	0.15	0.50	0.30	150	240	195	0.5	2.5	0.8
	High Alloy	220	0.12	0.44	0.25	90	150	120	0.5	1.8	0.6
M	Austenitic	190	0.15	0.50	0.30	190	250	220	0.5	2.5	0.8
K	Grey Cast Iron	140	0.18	0.64	0.35	150	240	195	0.5	2.5	0.8
S	Heat resistant and super alloys	240	0.12	0.32	0.24	25	45	35	0.5	1.5	0.6
H	Hardened material	45HRc	0.10	0.32	0.23	40	80	60	0.3	0.7	0.4

RDKT 10T3 M0											
Material			Cutting conditions								
Group	Sub Group	Hardness (HB)	Feed Fz (mm/Tooth)			Speed Vc (m/min)			Depth Of Cut (mm)		
			Min	Max	Recommend	Min	Max	Recommend	Min	Max	Recommend
P	Non Alloy	120	0.18	0.64	0.35	190	330	250	0.5	2.5	1.0
	Low Alloy	200	0.15	0.50	0.30	150	240	200	0.5	2.5	1.0
	High Alloy	220	0.12	0.44	0.25	90	150	120	0.5	1.8	0.8
M	Austenitic	190	0.15	0.50	0.30	190	250	220	0.5	2.5	1.0
K	Grey Cast Iron	140	0.18	0.64	0.35	150	240	200	0.5	2.5	1.0
S	Heat resistant and super alloys	240	0.12	0.36	0.24	25	45	35	0.5	2.0	0.5
H	Hardened material	45HRc	0.10	0.36	0.23	40	80	60	0.3	0.9	0.5

RDKT 1204 M0											
Material			Cutting conditions								
Group	Sub Group	Hardness (HB)	Feed Fz (mm/Tooth)			Speed Vc (m/min)			Depth Of Cut (mm)		
			Min	Max	Recommend	Min	Max	Recommend	Min	Max	Recommend
P	Non Alloy	120	0.18	0.64	0.35	190	330	250	0.5	2.5	1.3
	Low Alloy	200	0.15	0.50	0.30	150	240	200	0.5	2.5	1.3
	High Alloy	220	0.12	0.44	0.25	90	150	120	0.5	1.8	1.0
M	Austenitic	190	0.15	0.50	0.30	190	250	220	0.5	2.5	1.3
K	Grey Cast Iron	140	0.18	0.64	0.35	150	240	200	0.5	2.5	1.3
S	Heat resistant and super alloys	240	0.17	0.41	0.29	25	45	35	0.5	2.4	1.0
H	Hardened material	45HRc	0.14	0.41	0.28	40	80	60	0.3	1.1	0.7

RDKW 0802 M0											
Material			Cutting conditions								
Group	Sub Group	Hardness (HB)	Feed Fz (mm/Tooth)			Speed Vc (m/min)			Depth Of Cut (mm)		
			Min	Max	Recommend	Min	Max	Recommend	Min	Max	Recommend
P	Non Alloy	120	0.18	0.64	0.41	190	330	260	0.5	2.5	0.8
	Low Alloy	200	0.15	0.50	0.33	150	240	195	0.5	2.5	0.8
	High Alloy	220	0.12	0.44	0.28	90	150	120	0.5	1.8	0.6
K	Grey Cast Iron	140	0.18	0.64	0.41	150	240	195	0.5	2.5	0.8
H	Hardened material	45HRc	0.10	0.32	0.23	40	80	60	0.3	0.7	0.4

RDKW 10T3 M0											
Material			Cutting conditions								
Group	Sub Group	Hardness (HB)	Feed Fz (mm/Tooth)			Speed Vc (m/min)			Depth Of Cut (mm)		
			Min	Max	Recommend	Min	Max	Recommend	Min	Max	Recommend
P	Non Alloy	120	0.18	0.64	0.35	190	330	250	0.5	2.5	1.0
	Low Alloy	200	0.15	0.50	0.30	150	240	200	0.5	2.5	1.0
	High Alloy	220	0.12	0.44	0.25	90	150	120	0.5	1.8	0.8
K	Grey Cast Iron	140	0.18	0.64	0.35	150	240	200	0.5	2.5	1.0
H	Hardened material	45HRc	0.10	0.36	0.23	40	80	60	0.3	0.9	0.5

RDKW 1204 M0											
Material			Cutting conditions								
Group	Sub Group	Hardness (HB)	Feed Fz (mm/Tooth)			Speed Vc (m/min)			Depth Of Cut (mm)		
			Min	Max	Recommend	Min	Max	Recommend	Min	Max	Recommend
P	Non Alloy	120	0.18	0.64	0.35	190	330	250	0.5	2.5	1.3
	Low Alloy	200	0.15	0.50	0.30	150	240	200	0.5	2.5	1.3
	High Alloy	220	0.12	0.44	0.25	90	150	120	0.5	1.8	1.0
K	Grey Cast Iron	140	0.18	0.64	0.35	150	240	200	0.5	2.5	1.3
H	Hardened material	45HRc	0.14	0.41	0.28	40	80	60	0.3	1.1	0.7



RPMT 08T2 M0											
Material			Cutting conditions								
Group	Sub Group	Hardness (HB)	Feed Fz (mm/Tooth)			Speed Vc (m/min)			Depth Of Cut (mm)		
			Min	Max	Recommend	Min	Max	Recommend	Min	Max	Recommend
P	Non Alloy	120	0.18	0.64	0.41	190	330	250	0.5	2.5	0.8
	Low Alloy	200	0.15	0.50	0.33	150	240	195	0.5	2.5	0.8
	High Alloy	220	0.12	0.44	0.28	90	150	120	0.5	1.8	0.6
M	Austenitic	190	0.15	0.50	0.33	190	250	220	0.5	2.5	0.8
K	Grey Cast Iron	140	0.18	0.64	0.41	150	240	195	0.5	2.5	0.8
S	Heat resistant and super alloys	240	0.12	0.32	0.22	25	45	35	0.5	1.5	0.6
H	Hardened material	45HRc	0.10	0.32	0.21	40	80	60	0.3	0.7	0.4

RPMT 10T3 M0											
Material			Cutting conditions								
Group	Sub Group	Hardness (HB)	Feed Fz (mm/Tooth)			Speed Vc (m/min)			Depth Of Cut (mm)		
			Min	Max	Recommend	Min	Max	Recommend	Min	Max	Recommend
P	Non Alloy	120	0.18	0.64	0.35	190	330	250	0.5	2.5	1.0
	Low Alloy	200	0.15	0.50	0.30	150	240	200	0.5	2.5	1.0
	High Alloy	220	0.12	0.44	0.25	90	150	120	0.5	1.8	0.8
M	Austenitic	190	0.15	0.50	0.30	190	250	220	0.5	2.5	1.0
K	Grey Cast Iron	140	0.18	0.64	0.35	150	240	200	0.5	2.5	1.0
S	Heat resistant and super alloys	240	0.12	0.36	0.24	25	45	35	0.5	2.0	0.8
H	Hardened material	45HRc	0.10	0.36	0.23	40	80	60	0.3	0.9	0.5

RPMT 1204 M0											
Material			Cutting conditions								
Group	Sub Group	Hardness (HB)	Feed Fz (mm/Tooth)			Speed Vc (m/min)			Depth Of Cut (mm)		
			Min	Max	Recommend	Min	Max	Recommend	Min	Max	Recommend
P	Non Alloy	120	0.18	0.64	0.35	190	330	250	0.5	2.5	1.3
	Low Alloy	200	0.15	0.50	0.30	150	240	195	0.5	2.5	1.3
	High Alloy	220	0.12	0.44	0.25	90	150	120	0.5	1.8	1.0
M	Austenitic	190	0.15	0.50	0.30	190	250	220	0.5	2.5	1.3
K	Grey Cast Iron	140	0.18	0.64	0.35	150	240	195	0.5	2.5	1.3
S	Heat resistant and super alloys	240	0.13	0.30	0.29	25	50	38	0.5	2.4	1.5
H	Hardened material	45HRc	0.50	0.22	0.28	50	100	75	0.5	1.9	1.8

RPKW 10T3 M0											
Material			Cutting conditions								
Group	Sub Group	Hardness (HB)	Feed Fz (mm/Tooth)			Speed Vc (m/min)			Depth Of Cut (mm)		
			Min	Max	Recommend	Min	Max	Recommend	Min	Max	Recommend
P	Non Alloy	120	0.18	0.64	0.35	190	330	250	0.5	2.5	1.0
	Low Alloy	200	0.15	0.50	0.30	150	240	200	0.5	2.5	1.0
	High Alloy	220	0.12	0.44	0.25	90	150	120	0.5	1.8	0.8
K	Grey Cast Iron	140	0.18	0.64	0.35	150	240	200	0.5	2.5	1.0
H	Hardened material	45HRc	0.10	0.36	0.23	40	80	60	0.3	0.9	0.5

RPKW 1204 M0											
Material			Cutting conditions								
Group	Sub Group	Hardness (HB)	Feed Fz (mm/Tooth)			Speed Vc (m/min)			Depth Of Cut (mm)		
			Min	Max	Recommend	Min	Max	Recommend	Min	Max	Recommend
P	Non Alloy	120	0.18	0.64	0.35	190	330	250	0.5	2.5	1.3
	Low Alloy	200	0.15	0.50	0.30	150	240	200	0.5	2.5	1.3
	High Alloy	220	0.12	0.44	0.25	90	150	120	0.5	1.8	1.0
K	Grey Cast Iron	140	0.18	0.64	0.35	150	240	200	0.5	2.5	1.3
H	Hardened material	45HRc	0.14	0.41	0.28	40	80	60	0.3	1.1	0.7



SDKN 1203 AETN											
Material			Cutting conditions								
Group	Sub Group	Hardness (HB)	Feed Fz (mm/Tooth)			Speed Vc (m/min)			Depth Of Cut (mm)		
			Min	Max	Recommend	Min	Max	Recommend	Min	Max	Recommend
P	Non Alloy	120	0.18	0.46	0.32	190	330	250	0.5	7.0	3.0
	Low Alloy	200	0.15	0.36	0.26	150	240	195	0.5	7.0	3.0
	High Alloy	220	0.12	0.32	0.22	90	150	120	0.5	5.0	2.3
K	Grey Cast Iron	140	0.18	0.46	0.32	150	240	195	0.5	7.0	3.0
H	Hardened material	45HRc	0.10	0.24	0.17	40	80	60	0.5	2.5	1.5

SDKN 1504 AETN											
Material			Cutting conditions								
Group	Sub Group	Hardness (HB)	Feed Fz (mm/Tooth)			Speed Vc (m/min)			Depth Of Cut (mm)		
			Min	Max	Recommend	Min	Max	Recommend	Min	Max	Recommend
P	Non Alloy	120	0.18	0.43	0.31	190	330	250	0.5	9.0	4.0
	Low Alloy	200	0.15	0.34	0.25	150	240	195	0.5	9.0	4.0
	High Alloy	220	0.12	0.30	0.21	90	150	120	0.5	6.5	3.0
K	Grey Cast Iron	140	0.18	0.43	0.31	150	240	195	0.5	9.0	4.0
H	Hardened material	45HRc	0.10	0.24	0.17	40	80	60	0.5	3.2	2.0

SEKN 1203 AFTN											
Material			Cutting conditions								
Group	Sub Group	Hardness (HB)	Feed Fz (mm/Tooth)			Speed Vc (m/min)			Depth Of Cut (mm)		
			Min	Max	Recommend	Min	Max	Recommend	Min	Max	Recommend
P	Non Alloy	120	0.18	0.46	0.32	190	330	250	0.5	7.0	3.0
	Low Alloy	200	0.15	0.36	0.26	150	240	195	0.5	7.0	3.0
	High Alloy	220	0.12	0.32	0.22	90	150	120	0.5	5.0	2.3
M	Austenitic	190	0.15	0.32	0.24	190	250	220	0.5	7.0	3.0
K	Grey Cast Iron	140	0.18	0.46	0.32	150	240	195	0.5	7.0	3.0
S	Heat resistant and super alloys	240	0.10	0.26	0.18	25	45	35	0.5	5.0	2.3
H	Hardened material	45HRc	0.10	0.26	0.18	40	80	60	0.5	2.5	1.0

SEKR 1203 AFTN											
Material			Cutting conditions								
Group	Sub Group	Hardness (HB)	Feed Fz (mm/Tooth)			Speed Vc (m/min)			Depth Of Cut (mm)		
			Min	Max	Recommend	Min	Max	Recommend	Min	Max	Recommend
P	Non Alloy	120	0.18	0.46	0.32	190	330	250	0.5	7.0	3.0
	Low Alloy	200	0.15	0.36	0.26	150	240	195	0.5	7.0	3.0
	High Alloy	220	0.12	0.32	0.22	90	150	120	0.5	5.0	2.3
M	Austenitic	190	0.15	0.32	0.24	190	250	220	0.5	7.0	3.0
K	Grey Cast Iron	140	0.18	0.46	0.32	150	240	195	0.5	7.0	3.0
S	Heat resistant and super alloys	240	0.12	0.26	0.19	25	45	35	0.5	5.0	2.3
H	Hardened material	45HRc	0.10	0.26	0.18	40	80	60	0.5	2.5	1.5

SEKT 1204 AFTN											
Material			Cutting conditions								
Group	Sub Group	Hardness (HB)	Feed Fz (mm/Tooth)			Speed Vc (m/min)			Depth Of Cut (mm)		
			Min	Max	Recommend	Min	Max	Recommend	Min	Max	Recommend
P	Non Alloy	120	0.18	0.46	0.30	190	330	250	0.5	7.0	3.0
	Low Alloy	200	0.15	0.36	0.25	150	240	200	0.5	7.0	3.0
	High Alloy	220	0.12	0.32	0.22	90	150	120	0.5	5.0	2.0
M	Austenitic	190	0.15	0.32	0.25	190	250	220	0.5	7.0	3.0
K	Grey Cast Iron	140	0.18	0.46	0.30	150	240	200	0.5	7.0	3.0
S	Heat resistant and super alloys	240	0.12	0.26	0.19	25	45	35	0.5	5.0	2.3
H	Hardened material	45HRc	0.10	0.26	0.18	40	80	60	0.5	2.5	1.5

SEKT 12T3 AGTN											
Material			Cutting conditions								
Group	Sub Group	Hardness (HB)	Feed Fz (mm/Tooth)			Speed Vc (m/min)			Depth Of Cut (mm)		
			Min	Max	Recommend	Min	Max	Recommend	Min	Max	Recommend
P	Non Alloy	120	0.18	0.46	0.30	190	330	250	0.5	7.0	3.0
	Low Alloy	200	0.15	0.36	0.25	150	240	200	0.5	7.0	3.0
	High Alloy	220	0.12	0.32	0.22	90	150	120	0.5	5.0	2.0
M	Austenitic	190	0.15	0.32	0.25	190	250	220	0.5	7.0	3.0
K	Grey Cast Iron	140	0.18	0.46	0.30	150	240	200	0.5	7.0	3.0
S	Heat resistant and super alloys	240	0.12	0.26	0.19	25	45	35	0.5	5.0	2.3
H	Hardened material	45HRc	0.10	0.26	0.18	40	80	60	0.5	2.5	1.5



SPKN 1203 EDTR											
Material			Cutting conditions								
Group	Sub Group	Hardness (HB)	Feed Fz (mm/Tooth)			Speed Vc (m/min)			Depth Of Cut (mm)		
			Min	Max	Recommend	Min	Max	Recommend	Min	Max	Recommend
P	Non Alloy	120	0.18	0.43	0.30	190	330	250	0.5	7.0	3.0
	Low Alloy	200	0.15	0.34	0.25	150	240	200	0.5	7.0	3.0
	High Alloy	220	0.12	0.30	0.20	90	150	120	0.5	5.0	2.5
K	Grey Cast Iron	140	0.18	0.43	0.30	150	240	200	0.5	7.0	3.0
H	Hardened material	45HRc	0.10	0.24	0.17	40	80	60	0.5	2.5	1.5

SPKN 1504 EDTR											
Material			Cutting conditions								
Group	Sub Group	Hardness (HB)	Feed Fz (mm/Tooth)			Speed Vc (m/min)			Depth Of Cut (mm)		
			Min	Max	Recommend	Min	Max	Recommend	Min	Max	Recommend
P	Non Alloy	120	0.18	0.43	0.31	190	330	260	0.5	9.0	4.0
	Low Alloy	200	0.15	0.34	0.25	150	240	195	0.5	9.0	4.0
	High Alloy	220	0.12	0.30	0.21	90	150	120	0.5	6.5	3.0
K	Grey Cast Iron	140	0.18	0.43	0.31	150	240	195	0.5	9.0	4.0
H	Hardened material	45HRc	0.10	0.24	0.17	40	80	60	0.5	3.2	2.0

SPKR 1203 EDTR											
Material			Cutting conditions								
Group	Sub Group	Hardness (HB)	Feed Fz (mm/Tooth)			Speed Vc (m/min)			Depth Of Cut (mm)		
			Min	Max	Recommend	Min	Max	Recommend	Min	Max	Recommend
P	Non Alloy	120	0.18	0.38	0.25	190	330	250	0.5	7.0	3.0
	Low Alloy	200	0.15	0.30	0.20	150	240	200	0.5	7.0	3.0
	High Alloy	220	0.12	0.26	0.17	90	150	120	0.5	5.0	2.5
M	Austenitic	190	0.15	0.26	0.20	190	250	220	0.5	7.0	3.0
K	Grey Cast Iron	140	0.18	0.38	0.30	150	240	200	0.5	7.0	3.0
S	Heat resistant and super alloys	240	0.12	0.22	0.17	25	45	35	0.5	5.0	2.3
H	Hardened material	45HRc	0.10	0.22	0.16	40	80	60	0.5	2.5	1.5

TPKN 1603 PDTR											
Material			Cutting conditions								
Group	Sub Group	Hardness (HB)	Feed Fz (mm/Tooth)			Speed Vc (m/min)			Depth Of Cut (mm)		
			Min	Max	Recommend	Min	Max	Recommend	Min	Max	Recommend
P	Non Alloy	120	0.14	0.27	0.21	190	330	260	0.5	12.0	3.0
	Low Alloy	200	0.12	0.21	0.17	150	240	195	0.5	12.0	3.0
	High Alloy	220	0.10	0.19	0.15	90	150	120	0.5	8.6	2.5
K	Grey Cast Iron	140	0.14	0.27	0.21	150	240	195	0.5	12.0	3.0
H	Hardened material	45HRc	0.08	0.15	0.12	40	80	60	0.5	4.3	1.5

TPKN 2204 PDTR											
Material			Cutting conditions								
Group	Sub Group	Hardness (HB)	Feed Fz (mm/Tooth)			Speed Vc (m/min)			Depth Of Cut (mm)		
			Min	Max	Recommend	Min	Max	Recommend	Min	Max	Recommend
P	Non Alloy	120	0.16	0.27	0.22	190	330	260	0.5	18.0	4.0
	Low Alloy	200	0.14	0.21	0.18	150	240	195	0.5	18.0	4.0
	High Alloy	220	0.11	0.19	0.15	90	150	120	0.5	12.9	3.0
K	Grey Cast Iron	140	0.16	0.27	0.22	150	240	195	0.5	18.0	4.0
H	Hardened material	45HRc	0.09	0.15	0.12	40	80	60	0.5	6.4	2.0

TPKR 1603 PDTR											
Material			Cutting conditions								
Group	Sub Group	Hardness (HB)	Feed Fz (mm/Tooth)			Speed Vc (m/min)			Depth Of Cut (mm)		
			Min	Max	Recommend	Min	Max	Recommend	Min	Max	Recommend
P	Non Alloy	120	0.16	0.22	0.19	190	330	260	0.5	12.0	3.0
	Low Alloy	200	0.14	0.18	0.16	150	240	195	0.5	12.0	3.0
	High Alloy	220	0.11	0.15	0.13	90	150	120	0.5	8.6	2.5
M	Austenitic	190	0.14	0.15	0.15	190	250	220	0.5	12.0	3.0
K	Grey Cast Iron	140	0.16	0.22	0.19	150	240	195	0.5	12.0	3.0
S	Heat resistant and super alloys	240	0.11	0.13	0.12	25	45	35	0.5	8.6	2.3
H	Hardened material	45HRc	0.09	0.13	0.11	40	80	60	0.5	3.4	1.5

TPKR 2204 PDTR											
Material			Cutting conditions								
Group	Sub Group	Hardness (HB)	Feed Fz (mm/Tooth)			Speed Vc (m/min)			Depth Of Cut (mm)		
			Min	Max	Recommend	Min	Max	Recommend	Min	Max	Recommend
P	Non Alloy	120	0.16	0.22	0.19	190	330	260	0.5	18.0	4.0
	Low Alloy	200	0.14	0.18	0.16	150	240	195	0.5	18.0	4.0
	High Alloy	220	0.11	0.15	0.13	90	150	120	0.5	12.9	3.0
M	Austenitic	190	0.14	0.15	0.15	190	250	220	0.5	18.0	4.0
K	Grey Cast Iron	140	0.16	0.22	0.19	150	240	195	0.5	18.0	4.0
S	Heat resistant and super alloys	240	0.11	0.13	0.12	25	45	35	0.5	12.9	3.0
H	Hardened material	45HRc	0.09	0.13	0.11	40	80	60	0.5	6.4	2.0