



## Turning Positive - Inch

Date compiled

Nov. 10 2016

CCMT 2(1.5)1-UF											
Material			Cutting conditions								
Group	Sub Group	Hardness (HB)	Feed (Inch/rev)			Speed Vc (SFM)			Depth Of Cut (Inch)		
			Min	Max	Recommend	Min	Max	Recommend	Min	Max	Recommend
P	Non Alloy	120	0.003	0.008	0.006	590	1085	985	0.008	0.083	0.040
	Low Alloy	200	0.003	0.007	0.005	395	920	820	0.008	0.071	0.040
	High Alloy	220	0.003	0.006	0.004	230	625	560	0.008	0.071	0.040
M	Austenitic	190	0.003	0.006	0.005	560	885	820	0.008	0.071	0.040
K	Grey Cast Iron	140	0.002	0.007	0.005	560	820	785	0.008	0.083	0.040
S	Heat resistant and super alloys	240	0.003	0.005	0.003	80	165	115	0.008	0.055	0.040
H	Hardened material	45HRc	0.002	0.004	0.003	165	330	245	0.008	0.051	0.030

CCMT 2(1.5)2-UG											
Material			Cutting conditions								
Group	Sub Group	Hardness (HB)	Feed (Inch/rev)			Speed Vc (SFM)			Depth Of Cut (Inch)		
			Min	Max	Recommend	Min	Max	Recommend	Min	Max	Recommend
P	Non Alloy	120	0.003	0.008	0.006	590	1085	820	0.016	0.083	0.050
	Low Alloy	200	0.003	0.007	0.005	395	920	655	0.016	0.071	0.050
	High Alloy	220	0.003	0.006	0.004	230	625	425	0.016	0.071	0.050
M	Austenitic	190	0.003	0.006	0.005	560	885	655	0.016	0.071	0.050
K	Grey Cast Iron	140	0.002	0.007	0.005	560	820	690	0.016	0.083	0.050
S	Heat resistant and super alloys	240	0.003	0.005	0.003	80	165	100	0.016	0.055	0.050
H	Hardened material	45HRc	0.002	0.004	0.003	165	330	245	0.016	0.051	0.030

CCMT 3(2.5)1-UF											
Material			Cutting conditions								
Group	Sub Group	Hardness (HB)	Feed (Inch/rev)			Speed Vc (SFM)			Depth Of Cut (Inch)		
			Min	Max	Recommend	Min	Max	Recommend	Min	Max	Recommend
P	Non Alloy	120	0.004	0.009	0.007	590	1085	985	0.008	0.118	0.080
	Low Alloy	200	0.004	0.008	0.006	395	920	820	0.008	0.098	0.080
	High Alloy	220	0.004	0.007	0.005	230	625	560	0.008	0.098	0.080
M	Austenitic	190	0.004	0.007	0.006	560	885	820	0.008	0.098	0.080
K	Grey Cast Iron	140	0.003	0.008	0.006	560	820	785	0.008	0.118	0.080
S	Heat resistant and super alloys	240	0.004	0.006	0.005	80	165	115	0.008	0.079	0.080
H	Hardened material	45HRc	0.002	0.005	0.003	165	330	245	0.008	0.071	0.060

CCMT 3(2.5)2-UG											
Material			Cutting conditions								
Group	Sub Group	Hardness (HB)	Feed (Inch/rev)			Speed Vc (SFM)			Depth Of Cut (Inch)		
			Min	Max	Recommend	Min	Max	Recommend	Min	Max	Recommend
P	Non Alloy	120	0.008	0.020	0.014	590	1085	835	0.020	0.197	0.120
	Low Alloy	200	0.008	0.018	0.013	395	920	655	0.020	0.197	0.120
	High Alloy	220	0.007	0.016	0.011	230	625	425	0.020	0.157	0.100
M	Austenitic	190	0.008	0.016	0.012	560	885	720	0.020	0.197	0.120
K	Grey Cast Iron	140	0.006	0.024	0.015	560	820	690	0.020	0.197	0.120
S	Heat resistant and super alloys	240	0.008	0.014	0.011	80	150	115	0.020	0.118	0.080
H	Hardened material	45HRc	0.004	0.012	0.008	165	330	245	0.020	0.098	0.080

CCMT 332-UG											
Material			Cutting conditions								
Group	Sub Group	Hardness (HB)	Feed (Inch/rev)			Speed Vc (SFM)			Depth Of Cut (Inch)		
			Min	Max	Recommend	Min	Max	Recommend	Min	Max	Recommend
P	Non Alloy	120	0.008	0.020	0.014	590	1085	835	0.020	0.197	0.120
	Low Alloy	200	0.008	0.018	0.013	395	920	655	0.020	0.197	0.120
	High Alloy	220	0.007	0.016	0.011	230	625	425	0.020	0.157	0.100
M	Austenitic	190	0.008	0.016	0.012	560	885	655	0.020	0.197	0.120
K	Grey Cast Iron	140	0.006	0.024	0.015	560	820	690	0.020	0.197	0.120
S	Heat resistant and super alloys	240	0.008	0.014	0.011	80	150	115	0.020	0.118	0.080
H	Hardened material	45HRc	0.004	0.012	0.008	165	330	245	0.020	0.098	0.080



DCMT 2(1.51)-UF											
Material			Cutting conditions								
Group	Sub Group	Hardness (HB)	Feed (Inch/rev)			Speed Vc (SFM)			Depth Of Cut (Inch)		
			Min	Max	Recommend	Min	Max	Recommend	Min	Max	Recommend
P	Non Alloy	120	0.003	0.008	0.006	590	1085	985	0.008	0.083	0.040
	Low Alloy	200	0.003	0.007	0.005	395	920	820	0.008	0.071	0.040
	High Alloy	220	0.003	0.006	0.004	230	625	560	0.008	0.071	0.040
M	Austenitic	190	0.003	0.006	0.005	560	885	820	0.008	0.071	0.040
K	Grey Cast Iron	140	0.002	0.007	0.005	560	820	785	0.008	0.083	0.040
S	Heat resistant and super alloys	240	0.003	0.005	0.004	80	165	115	0.008	0.055	0.040
H	Hardened material	45HRc	0.002	0.004	0.003	165	330	245	0.008	0.051	0.030

DCMT 3(2.51)-UF											
Material			Cutting conditions								
Group	Sub Group	Hardness (HB)	Feed (Inch/rev)			Speed Vc (SFM)			Depth Of Cut (Inch)		
			Min	Max	Recommend	Min	Max	Recommend	Min	Max	Recommend
P	Non Alloy	120	0.004	0.009	0.007	590	1085	985	0.008	0.118	0.080
	Low Alloy	200	0.004	0.008	0.006	395	920	820	0.008	0.098	0.080
	High Alloy	220	0.004	0.007	0.005	230	625	560	0.008	0.098	0.080
M	Austenitic	190	0.004	0.007	0.006	560	885	820	0.008	0.098	0.080
K	Grey Cast Iron	140	0.003	0.008	0.006	560	820	785	0.008	0.118	0.080
S	Heat resistant and super alloys	240	0.004	0.006	0.005	80	165	115	0.008	0.079	0.080
H	Hardened material	45HRc	0.002	0.005	0.003	165	330	245	0.008	0.071	0.060

DCMT 3(2.52)-UG											
Material			Cutting conditions								
Group	Sub Group	Hardness (HB)	Feed (Inch/rev)			Speed Vc (SFM)			Depth Of Cut (Inch)		
			Min	Max	Recommend	Min	Max	Recommend	Min	Max	Recommend
P	Non Alloy	120	0.008	0.020	0.014	590	1085	835	0.020	0.157	0.120
	Low Alloy	200	0.008	0.018	0.013	395	920	655	0.020	0.157	0.120
	High Alloy	220	0.007	0.016	0.011	230	625	425	0.020	0.126	0.100
M	Austenitic	190	0.008	0.016	0.012	560	885	655	0.020	0.157	0.120
K	Grey Cast Iron	140	0.006	0.024	0.015	560	820	690	0.020	0.157	0.120
S	Heat resistant and super alloys	240	0.008	0.014	0.011	80	150	115	0.020	0.094	0.080
H	Hardened material	45HRc	0.004	0.012	0.008	165	330	245	0.020	0.079	0.080

RCMT 0803 M0											
Material			Cutting conditions								
Group	Sub Group	Hardness (HB)	Feed (Inch/rev)			Speed Vc (SFM)			Depth Of Cut (Inch)		
			Min	Max	Recommend	Min	Max	Recommend	Min	Max	Recommend
P	Non Alloy	120	0.006	0.016	0.013	590	1085	835	0.020	0.094	0.050
	Low Alloy	200	0.006	0.014	0.011	395	920	655	0.020	0.094	0.050
	High Alloy	220	0.005	0.014	0.011	230	625	425	0.020	0.094	0.050
M	Austenitic	190	0.006	0.014	0.012	560	885	720	0.020	0.094	0.050
K	Grey Cast Iron	140	0.004	0.018	0.013	560	820	690	0.020	0.094	0.050
S	Heat resistant and super alloys	240	0.005	0.012	0.010	80	165	125	0.020	0.071	0.050
H	Hardened material	45HRc	0.002	0.009	0.005	165	330	245	0.020	0.055	0.040

RCMT 10T3 M0											
Material			Cutting conditions								
Group	Sub Group	Hardness (HB)	Feed (Inch/rev)			Speed Vc (SFM)			Depth Of Cut (Inch)		
			Min	Max	Recommend	Min	Max	Recommend	Min	Max	Recommend
P	Non Alloy	120	0.006	0.016	0.013	590	1085	835	0.020	0.110	0.060
	Low Alloy	200	0.006	0.014	0.011	395	920	655	0.020	0.110	0.060
	High Alloy	220	0.005	0.014	0.011	230	625	425	0.020	0.110	0.060
M	Austenitic	190	0.006	0.014	0.012	560	885	720	0.020	0.110	0.060
K	Grey Cast Iron	140	0.004	0.018	0.013	560	820	690	0.020	0.110	0.060
S	Heat resistant and super alloys	240	0.005	0.012	0.010	80	165	125	0.020	0.083	0.060
H	Hardened material	45HRc	0.002	0.009	0.005	165	330	245	0.020	0.067	0.050

RCMT 1204 M0											
Material			Cutting conditions								
Group	Sub Group	Hardness (HB)	Feed (Inch/rev)			Speed Vc (SFM)			Depth Of Cut (Inch)		
			Min	Max	Recommend	Min	Max	Recommend	Min	Max	Recommend
P	Non Alloy	120	0.006	0.016	0.016	590	1085	835	0.020	0.126	0.080
	Low Alloy	200	0.006	0.014	0.014	395	920	655	0.020	0.126	0.080
	High Alloy	220	0.005	0.014	0.014	230	625	425	0.020	0.126	0.080
M	Austenitic	190	0.006	0.014	0.014	560	885	720	0.020	0.126	0.080
K	Grey Cast Iron	140	0.004	0.018	0.016	560	820	690	0.020	0.126	0.080
S	Heat resistant and super alloys	240	0.005	0.012	0.012	80	165	125	0.020	0.094	0.060
H	Hardened material	45HRc	0.002	0.009	0.008	165	330	245	0.020	0.075	0.070



SCMT 3(2.5)1-UF											
Material			Cutting conditions								
Group	Sub Group	Hardness (HB)	Feed (Inch/rev)			Speed Vc (SFM)			Depth Of Cut (Inch)		
			Min	Max	Recommend	Min	Max	Recommend	Min	Max	Recommend
P	Non Alloy	120	0.004	0.010	0.007	590	1085	985	0.008	0.157	0.100
	Low Alloy	200	0.004	0.009	0.006	395	920	820	0.008	0.130	0.100
	High Alloy	220	0.004	0.008	0.006	230	625	560	0.008	0.130	0.100
M	Austenitic	190	0.004	0.008	0.006	560	885	820	0.008	0.130	0.100
K	Grey Cast Iron	140	0.003	0.009	0.006	560	820	785	0.008	0.157	0.100
S	Heat resistant and super alloys	240	0.004	0.007	0.005	80	165	115	0.008	0.106	0.080
H	Hardened material	45HRc	0.002	0.006	0.004	165	330	245	0.008	0.094	0.070

SCMT 3(2.5)2-UG											
Material			Cutting conditions								
Group	Sub Group	Hardness (HB)	Feed (Inch/rev)			Speed Vc (SFM)			Depth Of Cut (Inch)		
			Min	Max	Recommend	Min	Max	Recommend	Min	Max	Recommend
P	Non Alloy	120	0.008	0.020	0.014	590	1085	835	0.020	0.157	0.120
	Low Alloy	200	0.008	0.018	0.013	395	920	655	0.020	0.157	0.120
	High Alloy	220	0.007	0.016	0.011	230	625	425	0.020	0.126	0.100
M	Austenitic	190	0.008	0.016	0.012	560	885	720	0.020	0.157	0.120
K	Grey Cast Iron	140	0.006	0.024	0.015	560	820	690	0.020	0.157	0.120
S	Heat resistant and super alloys	240	0.008	0.014	0.011	80	150	115	0.020	0.094	0.080
H	Hardened material	45HRc	0.004	0.012	0.008	165	330	245	0.020	0.079	0.080

TCMT 2(1.5)1-UF											
Material			Cutting conditions								
Group	Sub Group	Hardness (HB)	Feed (Inch/rev)			Speed Vc (SFM)			Depth Of Cut (Inch)		
			Min	Max	Recommend	Min	Max	Recommend	Min	Max	Recommend
P	Non Alloy	120	0.003	0.008	0.006	590	1085	985	0.008	0.083	0.040
	Low Alloy	200	0.003	0.007	0.005	395	920	820	0.008	0.071	0.040
	High Alloy	220	0.003	0.006	0.004	230	625	560	0.008	0.071	0.040
M	Austenitic	190	0.003	0.006	0.005	560	885	820	0.008	0.071	0.040
K	Grey Cast Iron	140	0.002	0.007	0.005	560	820	785	0.008	0.083	0.040
S	Heat resistant and super alloys	240	0.003	0.005	0.004	80	165	115	0.008	0.055	0.040
H	Hardened material	45HRc	0.002	0.004	0.003	165	330	245	0.008	0.051	0.030

TCMT 3(2.5)1-UF											
Material			Cutting conditions								
Group	Sub Group	Hardness (HB)	Feed (Inch/rev)			Speed Vc (SFM)			Depth Of Cut (Inch)		
			Min	Max	Recommend	Min	Max	Recommend	Min	Max	Recommend
P	Non Alloy	120	0.004	0.009	0.008	590	1085	985	0.008	0.118	0.080
	Low Alloy	200	0.004	0.008	0.006	395	920	820	0.008	0.098	0.080
	High Alloy	220	0.004	0.007	0.005	230	625	560	0.008	0.098	0.080
M	Austenitic	190	0.004	0.007	0.006	560	885	820	0.008	0.098	0.080
K	Grey Cast Iron	140	0.003	0.008	0.006	560	820	785	0.008	0.118	0.080
S	Heat resistant and super alloys	240	0.004	0.006	0.004	80	150	115	0.008	0.079	0.080
H	Hardened material	45HRc	0.002	0.005	0.004	165	330	245	0.008	0.071	0.060

TCMT 3(2.5)2-UG											
Material			Cutting conditions								
Group	Sub Group	Hardness (HB)	Feed (Inch/rev)			Speed Vc (SFM)			Depth Of Cut (Inch)		
			Min	Max	Recommend	Min	Max	Recommend	Min	Max	Recommend
P	Non Alloy	120	0.004	0.009	0.008	590	1085	820	0.008	0.118	0.120
	Low Alloy	200	0.004	0.008	0.006	395	920	655	0.008	0.098	0.120
	High Alloy	220	0.004	0.007	0.005	230	625	425	0.008	0.098	0.100
M	Austenitic	190	0.004	0.007	0.006	560	885	720	0.008	0.098	0.120
K	Grey Cast Iron	140	0.003	0.008	0.006	560	820	690	0.008	0.098	0.120
S	Heat resistant and super alloys	240	0.008	0.012	0.010	80	150	115	0.020	0.118	0.080
H	Hardened material	45HRc	0.004	0.010	0.007	165	330	245	0.020	0.098	0.080

VBMT 331-UF											
Material			Cutting conditions								
Group	Sub Group	Hardness (HB)	Feed (Inch/rev)			Speed Vc (SFM)			Depth Of Cut (Inch)		
			Min	Max	Recommend	Min	Max	Recommend	Min	Max	Recommend
P	Non Alloy	120	0.004	0.009	0.007	590	1085	835	0.008	0.118	0.080
	Low Alloy	200	0.004	0.008	0.006	395	920	655	0.008	0.098	0.080
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M	Austenitic	190	0.004	0.007	0.006	560	885	720	0.008	0.098	0.080
K	Grey Cast Iron	140	0.003	0.008	0.006	560	820	690	0.008	0.118	0.080
S	Heat resistant and super alloys	240	0.004	0.006	0.005	80	165	125	0.008	0.079	0.080
H	Hardened material	45HRc	0.002	0.005	0.003	165	330	245	0.008	0.071	0.060



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Group	Sub Group	Hardness (HB)	Feed (Inch/rev)			Speed Vc (SFM)			Depth Of Cut (Inch)		
			Min	Max	Recommend	Min	Max	Recommend	Min	Max	Recommend
P	Non Alloy	120	0.007	0.016	0.012	590	1085	835	0.020	0.138	0.100
	Low Alloy	200	0.007	0.014	0.011	395	920	655	0.020	0.138	0.100
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VCMT 331-UF											
Material			Cutting conditions								
Group	Sub Group	Hardness (HB)	Feed (Inch/rev)			Speed Vc (SFM)			Depth Of Cut (Inch)		
			Min	Max	Recommend	Min	Max	Recommend	Min	Max	Recommend
P	Non Alloy	120	0.004	0.009	0.007	590	1085	835	0.008	0.118	0.080
	Low Alloy	200	0.004	0.008	0.006	395	920	655	0.008	0.098	0.080
	High Alloy	220	0.004	0.007	0.005	230	625	425	0.008	0.098	0.080
M	Austenitic	190	0.004	0.007	0.006	560	885	720	0.008	0.098	0.080
K	Grey Cast Iron	140	0.003	0.008	0.006	560	820	690	0.008	0.118	0.080
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Material			Cutting conditions								
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P	Non Alloy	120	0.007	0.016	0.012	590	1085	835	0.020	0.138	0.100
	Low Alloy	200	0.007	0.014	0.011	395	920	655	0.020	0.138	0.100
	High Alloy	220	0.006	0.013	0.009	230	625	425	0.020	0.110	0.080
M	Austenitic	190	0.007	0.013	0.010	560	885	720	0.020	0.138	0.100
K	Grey Cast Iron	140	0.006	0.019	0.012	560	820	690	0.020	0.138	0.100
S	Heat resistant and super alloys	240	0.007	0.011	0.009	80	150	115	0.020	0.083	0.080
H	Hardened material	45HRc	0.004	0.009	0.007	165	330	245	0.020	0.071	0.060