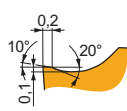




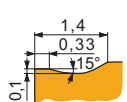
Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

Product	RE (mm)	P			M			K			N			S			H		
		vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)



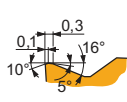
FM geometry with positive design for finish to semi-rough machining, and continuous to slightly interrupted cuts.

CNMG 090304E-FM	T7325	0.4	✓	195	0.20	1.4	✓	150	0.18	1.4	–	–	–	–	–	–	–	–	–					
	T8330	0.4	■	175	0.20	1.4	✓	105	0.18	1.4	■	165	0.20	1.4	–	–	–	■	40	0.14	1.1	–	–	–
	T8430	0.4	■	195	0.20	1.4	✓	105	0.18	1.4	■	160	0.20	1.4	–	–	–	■	40	0.14	1.1	–	–	–
	T9315	0.4	■	265	0.20	1.4	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	T9325	0.4	■	240	0.20	1.4	✓	140	0.18	1.4	■	225	0.20	1.4	–	–	–	■	50	0.16	1.1	–	–	–
CNMG 090308E-FM	T7325	0.8	✓	235	0.20	1.4	✓	180	0.18	1.4	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	T8330	0.8	■	205	0.20	1.4	✓	120	0.18	1.4	■	190	0.20	1.4	–	–	–	■	50	0.14	1.1	–	–	–
	T8430	0.8	■	235	0.20	1.4	✓	125	0.18	1.4	■	190	0.20	1.4	–	–	–	■	50	0.14	1.1	–	–	–
	T9315	0.8	■	315	0.20	1.4	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	T9325	0.8	■	285	0.20	1.4	✓	170	0.18	1.4	■	270	0.20	1.4	–	–	–	■	60	0.16	1.1	–	–	–
CNMG 120404E-FM	T7325	0.4	✓	185	0.20	2.1	✓	140	0.18	2.1	–	–	–	–	–	–	–	–	–	–	–	–	–	
	T7335	0.4	✓	180	0.20	2.1	✓	140	0.18	2.1	–	–	–	–	–	–	–	–	–	–	–	–	–	
	T8315	0.4	✓	175	0.20	2.1	✓	105	0.18	2.1	■	165	0.20	2.1	–	–	–	■	40	0.14	1.7	–	–	–
	T8330	0.4	■	165	0.20	2.1	✓	95	0.18	2.1	■	155	0.20	2.1	–	–	–	■	40	0.14	1.7	–	–	–
	T8430	0.4	■	190	0.20	2.1	✓	105	0.18	2.1	■	155	0.20	2.1	–	–	–	■	40	0.14	1.7	–	–	–
	T9310	0.4	■	285	0.20	2.1	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	T9315	0.4	■	255	0.20	2.1	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	T9325	0.4	■	230	0.20	2.1	✓	135	0.18	2.1	■	215	0.20	2.1	–	–	–	■	50	0.16	1.7	–	–	–
	TT310	0.4	■	260	0.20	2.1	✓	155	0.18	2.1	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	CNMG 120408E-FM	T7325	0.8	✓	220	0.20	2.1	✓	170	0.18	2.1	–	–	–	–	–	–	–	–	–	–	–	–	–
T7335		0.8	✓	215	0.20	2.1	✓	165	0.18	2.1	–	–	–	–	–	–	–	–	–	–	–	–	–	
T8315		0.8	✓	205	0.20	2.1	✓	120	0.18	2.1	■	190	0.20	2.1	–	–	–	■	50	0.16	1.7	–	–	–
T8330		0.8	■	195	0.20	2.1	✓	115	0.18	2.1	■	185	0.20	2.1	–	–	–	■	45	0.16	1.7	–	–	–
T8430		0.8	■	225	0.20	2.1	✓	120	0.18	2.1	■	185	0.20	2.1	–	–	–	■	45	0.16	1.7	–	–	–
T9310		0.8	■	335	0.20	2.1	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
T9315		0.8	■	305	0.20	2.1	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
T9325		0.8	■	275	0.20	2.1	✓	165	0.18	2.1	■	260	0.20	2.1	–	–	–	■	60	0.16	1.7	–	–	–
TT310		0.8	■	310	0.20	2.1	✓	185	0.18	2.1	–	–	–	–	–	–	–	–	–	–	–	–	–	–
CNMG 120412E-FM		T7325	1.2	✓	210	0.27	2.1	✓	160	0.24	2.1	–	–	–	–	–	–	–	–	–	–	–	–	–
	T9315	1.2	■	285	0.27	2.1	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	
	T9325	1.2	■	255	0.27	2.1	✓	150	0.24	2.1	■	240	0.27	2.1	–	–	–	■	55	0.19	1.7	–	–	–



KR geometry for semi-rough to rough machining, and continuous to interrupted cuts.

CNMG 120408E-KR	T5305	0.8	✓	255	0.35	4.0	–	–	–	■	240	0.35	4.0	–	–	–	–	–	–	–	–	–	–	–
	T5315	0.8	✓	225	0.35	4.0	–	–	–	■	210	0.35	4.0	–	–	–	–	–	–	–	–	–	–	–
CNMG 120412E-KR	T5305	1.2	✓	255	0.40	4.0	–	–	–	■	240	0.40	4.0	–	–	–	–	–	–	–	–	–	–	–
	T5315	1.2	✓	230	0.40	4.0	–	–	–	■	215	0.40	4.0	–	–	–	–	–	–	–	–	–	–	–



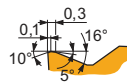
M geometry for finish to semi-rough machining, and continuous to interrupted cuts.

CNMG 090308E-M	T9315	0.8	■	230	0.32	1.8	–	–	–	■	215	0.32	1.8	–	–	–	–	–	–	–	–	–	–	–
	T9325	0.8	■	205	0.32	1.8	–	–	–	■	190	0.32	1.8	–	–	–	–	–	–	–	–	–	–	–
	T9335	0.8	■	180	0.32	1.8	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
CNMG 120404E-M	T5315	0.4	✓	245	0.20	2.1	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	T9310	0.4	■	260	0.20	2.1	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	T9315	0.4	■	235	0.20	2.1	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	T9325	0.4	■	210	0.20	2.1	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	T9335	0.4	■	180	0.20	2.1	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–



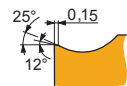
Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

Product	RE (mm)	P			M			K			N			S			H		
		vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)



M geometry for finish to semi-rough machining, and continuous to interrupted cuts.

CNMG 120408E-M	6640	0.8	165	0.32	2.1	—	—	—	155	0.32	2.1	—	—	—	—	—	—	—	—
	T5305	0.8	280	0.32	2.1	—	—	—	265	0.32	2.1	—	—	—	—	—	55	0.15	1.0
	T5315	0.8	250	0.32	2.1	—	—	—	235	0.32	2.1	—	—	—	—	—	50	0.15	1.0
	T8330	0.8	155	0.32	2.1	—	—	—	145	0.32	2.1	—	—	—	—	—	30	0.15	1.0
	T8430	0.8	170	0.32	2.1	—	—	—	135	0.32	2.1	—	—	—	—	—	25	0.15	1.0
	T9310	0.8	245	0.32	2.1	—	—	—	230	0.32	2.1	—	—	—	—	—	45	0.15	1.0
	T9315	0.8	225	0.32	2.1	—	—	—	210	0.32	2.1	—	—	—	—	—	45	0.15	1.0
	T9325	0.8	200	0.32	2.1	—	—	—	190	0.32	2.1	—	—	—	—	—	—	—	—
	T9335	0.8	180	0.32	2.1	—	—	—	—	—	—	—	—	—	—	—	—	—	—
CNMG 120412E-M	T5305	1.2	275	0.40	2.1	—	—	—	260	0.40	2.1	—	—	—	—	—	55	0.15	1.0
	T5315	1.2	245	0.40	2.1	—	—	—	230	0.40	2.1	—	—	—	—	—	45	0.15	1.0
	T9310	1.2	235	0.40	2.1	—	—	—	220	0.40	2.1	—	—	—	—	—	45	0.15	1.0
	T9315	1.2	220	0.40	2.1	—	—	—	205	0.40	2.1	—	—	—	—	—	40	0.15	1.0
	T9325	1.2	195	0.40	2.1	—	—	—	185	0.40	2.1	—	—	—	—	—	—	—	—
CNMG 120416E-M	T9325	1.6	200	0.40	2.1	—	—	—	190	0.40	2.1	—	—	—	—	—	—	—	—
	T9335	1.6	175	0.40	2.1	—	—	—	—	—	—	—	—	—	—	—	—	—	—
CNMG 160608E-M	T9310	0.8	235	0.32	3.6	—	—	—	220	0.32	3.6	—	—	—	—	—	45	0.15	1.0
	T9315	0.8	215	0.32	3.6	—	—	—	200	0.32	3.6	—	—	—	—	—	40	0.15	1.0
	T9325	0.8	190	0.32	3.6	—	—	—	180	0.32	3.6	—	—	—	—	—	—	—	—
CNMG 160612E-M	T9315	1.2	210	0.40	3.6	—	—	—	195	0.40	3.6	—	—	—	—	—	40	0.15	1.0
	T9325	1.2	185	0.40	3.6	—	—	—	175	0.40	3.6	—	—	—	—	—	—	—	—
	T9335	1.2	160	0.40	3.6	—	—	—	—	—	—	—	—	—	—	—	—	—	—
CNMG 160616E-M	T9325	1.6	190	0.40	3.6	—	—	—	180	0.40	3.6	—	—	—	—	—	—	—	—
	T9335	1.6	165	0.40	3.6	—	—	—	—	—	—	—	—	—	—	—	—	—	—
CNMG 190608E-M	T9315	0.8	210	0.32	4.2	—	—	—	195	0.32	4.2	—	—	—	—	—	40	0.15	1.0
	T9325	0.8	190	0.32	4.2	—	—	—	180	0.32	4.2	—	—	—	—	—	—	—	—
	T9335	0.8	165	0.32	4.2	—	—	—	—	—	—	—	—	—	—	—	—	—	—
CNMG 190612E-M	6640	1.2	145	0.40	4.2	—	—	—	135	0.40	4.2	—	—	—	—	—	—	—	—
	T9310	1.2	220	0.40	4.2	—	—	—	205	0.40	4.2	—	—	—	—	—	40	0.15	1.0
	T9315	1.2	205	0.40	4.2	—	—	—	190	0.40	4.2	—	—	—	—	—	40	0.15	1.0
	T9325	1.2	185	0.40	4.2	—	—	—	175	0.40	4.2	—	—	—	—	—	—	—	—
CNMG 190616E-M	T9310	1.6	230	0.40	4.2	—	—	—	215	0.40	4.2	—	—	—	—	—	45	0.15	1.0
	T9315	1.6	215	0.40	4.2	—	—	—	200	0.40	4.2	—	—	—	—	—	40	0.15	1.0
	T9325	1.6	190	0.40	4.2	—	—	—	180	0.40	4.2	—	—	—	—	—	—	—	—
	T9335	1.6	165	0.40	4.2	—	—	—	—	—	—	—	—	—	—	—	—	—	—



NF geometry with highly positive design for fine-finish to medium machining, and continuous cuts.

CNMG 090304E-NF	T6310	0.4	190	0.17	0.8	135	0.15	0.8	150	0.17	0.8	570	0.20	0.8	55	0.12	0.6	—	—
	T7335	0.4	210	0.18	0.8	160	0.16	0.8	—	—	—	—	—	—	65	0.16	0.6	—	—
	T8315	0.4	200	0.17	0.8	120	0.15	0.8	190	0.17	0.8	600	0.20	0.8	50	0.12	0.6	—	—
	T8430	0.4	225	0.17	0.8	120	0.15	0.8	185	0.17	0.8	615	0.20	0.8	45	0.12	0.6	—	—
	T9325	0.4	265	0.18	0.8	155	0.16	0.8	250	0.18	0.8	—	—	—	55	0.16	0.6	—	—
CNMG 090308E-NF	T6310	0.8	215	0.19	1.0	150	0.17	1.0	170	0.19	1.0	645	0.23	1.0	60	0.15	0.8	—	—
	T7335	0.8	240	0.19	1.0	185	0.17	1.0	—	—	—	—	—	—	75	0.15	0.8	—	—
	T8330	0.8	215	0.19	1.0	125	0.17	1.0	200	0.19	1.0	645	0.23	1.0	50	0.15	0.8	—	—
	T8430	0.8	245	0.19	1.0	135	0.17	1.0	200	0.19	1.0	675	0.23	1.0	50	0.15	0.8	—	—
	T9325	0.8	300	0.19	1.0	180	0.17	1.0	285	0.19	1.0	—	—	—	65	0.15	0.8	—	—