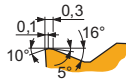


CN	DN	KN	LN	RN	SN	TN	VN	WN
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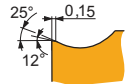
Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

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)



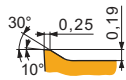
M geometry for finish to semi-rough machining, and continuous to interrupted cuts.

SNMG 120412E-M	T9315	1.2	230	0.40	2.1	–	–	–	215	0.40	2.1	–	–	–	–	–	–	–	–
	T9325	1.2	200	0.40	2.1	–	–	–	190	0.40	2.1	–	–	–	–	–	–	–	–
	T9335	1.2	175	0.40	2.1	–	–	–	–	–	–	–	–	–	–	–	–	–	–
SNMG 120416E-M	T9325	1.6	210	0.40	2.1	–	–	–	195	0.40	2.1	–	–	–	–	–	–	–	–
	T9315	1.2	220	0.40	3.4	–	–	–	205	0.40	3.4	–	–	–	–	–	–	–	–
SNMG 150612E-M	T9315	1.2	195	0.40	3.4	–	–	–	185	0.40	3.4	–	–	–	–	–	–	–	–
	T9335	1.2	170	0.40	3.4	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	T9325	1.2	170	0.40	3.4	–	–	–	–	–	–	–	–	–	–	–	–	–	–
SNMG 190612E-M	T9315	1.2	215	0.40	4.0	–	–	–	200	0.40	4.0	–	–	–	–	–	–	–	–
	T9325	1.2	190	0.40	4.0	–	–	–	180	0.40	4.0	–	–	–	–	–	–	–	–
	T9335	1.2	165	0.40	4.0	–	–	–	–	–	–	–	–	–	–	–	–	–	–
SNMG 190616E-M	T9315	1.6	225	0.40	4.0	–	–	–	210	0.40	4.0	–	–	–	–	–	–	–	–
	T9325	1.6	200	0.40	4.0	–	–	–	190	0.40	4.0	–	–	–	–	–	–	–	–
	T9335	1.6	175	0.40	4.0	–	–	–	–	–	–	–	–	–	–	–	–	–	–



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

SNMG 120404E-NF	T6310	0.4	185	0.17	1.7	130	0.15	1.7	145	0.17	1.7	555	0.20	1.7	55	0.14	1.4	–	–	–	
	T7325	0.4	210	0.18	1.7	160	0.16	1.7	–	–	–	–	–	–	65	0.16	1.4	–	–	–	
	T7335	0.4	205	0.18	1.7	155	0.16	1.7	–	–	–	–	–	–	65	0.16	1.4	–	–	–	
	T8330	0.4	185	0.17	1.7	110	0.15	1.7	175	0.17	1.7	555	0.20	1.7	45	0.14	1.4	–	–	–	
	T8430	0.4	210	0.17	1.7	115	0.15	1.7	175	0.17	1.7	585	0.20	1.7	45	0.14	1.4	–	–	–	
	T9315	0.4	300	0.17	1.7	–	–	–	285	0.17	1.7	–	–	–	–	–	–	–	–	–	
	T9325	0.4	260	0.18	1.7	155	0.16	1.7	245	0.18	1.7	–	–	–	55	0.16	1.4	–	–	–	
	SNMG 120408E-NF	HF7	0.8	–	–	–	120	0.17	1.7	190	0.19	1.7	600	0.23	1.7	–	–	–	–	–	–
		T6310	0.8	210	0.19	1.7	150	0.17	1.7	165	0.19	1.7	630	0.23	1.7	60	0.15	1.4	–	–	–
T7325		0.8	245	0.19	1.7	190	0.17	1.7	–	–	–	–	–	–	75	0.15	1.4	–	–	–	
T7335		0.8	240	0.19	1.7	185	0.17	1.7	–	–	–	–	–	–	75	0.15	1.4	–	–	–	
T8315		0.8	230	0.19	1.7	135	0.17	1.7	215	0.19	1.7	690	0.23	1.7	55	0.15	1.4	–	–	–	
T8330		0.8	210	0.19	1.7	125	0.17	1.7	195	0.19	1.7	630	0.23	1.7	50	0.15	1.4	–	–	–	
T8430		0.8	250	0.19	1.7	135	0.17	1.7	205	0.19	1.7	690	0.23	1.7	50	0.15	1.4	–	–	–	
T9315		0.8	340	0.19	1.7	–	–	–	320	0.19	1.7	–	–	–	–	–	–	–	–	–	
T9325		0.8	300	0.19	1.7	180	0.17	1.7	285	0.19	1.7	–	–	–	65	0.15	1.4	–	–	–	



NM geometry with highly positive design for fine-finish, medium and rough machining, in continuous cuts.

SNMG 120408E-NM	T7325	0.8	225	0.25	2.1	175	0.23	2.1	–	–	–	–	–	–	70	0.20	1.7	–	–	–
	T7335	0.8	220	0.25	2.1	170	0.23	2.1	–	–	–	–	–	–	70	0.20	1.7	–	–	–
	T8315	0.8	215	0.25	2.1	125	0.23	2.1	–	–	–	645	0.30	2.1	50	0.20	1.7	–	–	–
	T8330	0.8	205	0.25	2.1	120	0.23	2.1	–	–	–	615	0.30	2.1	50	0.20	1.7	–	–	–
	T8430	0.8	225	0.25	2.1	120	0.23	2.1	–	–	–	615	0.30	2.1	45	0.20	1.7	–	–	–
SNMG 120412E-NM	T9325	0.8	275	0.25	2.1	165	0.23	2.1	–	–	–	–	–	–	60	0.20	1.7	–	–	–
	T7325	1.2	225	0.30	2.1	175	0.27	2.1	–	–	–	–	–	–	70	0.24	1.7	–	–	–
	T7335	1.2	220	0.30	2.1	170	0.27	2.1	–	–	–	–	–	–	70	0.24	1.7	–	–	–
	T8315	1.2	215	0.30	2.1	125	0.27	2.1	–	–	–	645	0.36	2.1	50	0.24	1.7	–	–	–
	T9325	1.2	270	0.30	2.1	160	0.27	2.1	–	–	–	–	–	–	60	0.24	1.7	–	–	–