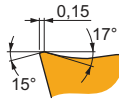




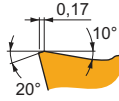
Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

Product	RE [mm]	P			M			K			N			S			H		
		vc [m/min]	f [mm/tooth]	ap [mm]	vc [m/min]	f [mm/tooth]	ap [mm]	vc [m/min]	f [mm/tooth]	ap [mm]	vc [m/min]	f [mm/tooth]	ap [mm]	vc [m/min]	f [mm/tooth]	ap [mm]	vc [m/min]	f [mm/tooth]	ap [mm]



FM geometry, 90° shoulder milling insert, with positive design for medium machining.

SDMT 120508SN-FM	M8345	0.8	175	0.15	4.0	105	0.15	4.0	-	-	-	-	-	-	-	-	-	-
-------------------------	--------------	-----	-----	------	-----	-----	------	-----	---	---	---	---	---	---	---	---	---	---



R geometry, 90° shoulder milling insert, with positive design for unstable cutting conditions.

SDMT 120508SN-R	M8330	0.8	225	0.20	4.0	-	-	-	210	0.20	4.0	-	-	-	-	-	-	-
	M8345	0.8	165	0.20	4.0	-	-	-	-	-	-	-	-	-	-	-	-	-
	M9340	0.8	250	0.20	4.0	-	-	-	-	-	-	-	-	-	-	-	-	-
SDMT 1205AESN-R	M8330	-	265	0.20	4.0	-	-	-	250	0.20	4.0	-	-	-	-	-	-	-
	M8340	-	240	0.20	4.0	-	-	-	225	0.20	4.0	-	-	-	-	-	-	-