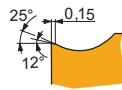




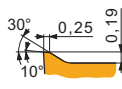
Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

| 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) |



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

| | | | | | | | | | | | | | | | | | | | | |
|------------------------|--------------|-----|-----|------|-----|-----|------|-----|-----|------|-----|-----|------|-----|------|------|-----|---|---|---|
| WNMG 080404E-NF | HF7 | 0.4 | – | – | – | 95 | 0.15 | 1.7 | 155 | 0.17 | 1.7 | 495 | 0.20 | 1.7 | – | – | – | – | – | – |
| | T6310 | 0.4 | 180 | 0.17 | 1.7 | 125 | 0.15 | 1.7 | 145 | 0.17 | 1.7 | 540 | 0.20 | 1.7 | 50 | 0.14 | 1.4 | – | – | – |
| | T7325 | 0.4 | 200 | 0.18 | 1.7 | 155 | 0.16 | 1.7 | – | – | – | – | – | – | 65 | 0.16 | 1.4 | – | – | – |
| | T7335 | 0.4 | 195 | 0.18 | 1.7 | 150 | 0.16 | 1.7 | – | – | – | – | – | – | 60 | 0.16 | 1.4 | – | – | – |
| | T8315 | 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 | – | – | – |
| | T8330 | 0.4 | 180 | 0.17 | 1.7 | 105 | 0.15 | 1.7 | 170 | 0.17 | 1.7 | 540 | 0.20 | 1.7 | 45 | 0.14 | 1.4 | – | – | – |
| | T8430 | 0.4 | 200 | 0.17 | 1.7 | 110 | 0.15 | 1.7 | 165 | 0.17 | 1.7 | 555 | 0.20 | 1.7 | 40 | 0.14 | 1.4 | – | – | – |
| | T9315 | 0.4 | 285 | 0.17 | 1.7 | – | – | – | 270 | 0.17 | 1.7 | – | – | – | – | – | – | – | – | – |
| | T9325 | 0.4 | 250 | 0.18 | 1.7 | 150 | 0.16 | 1.7 | 235 | 0.18 | 1.7 | – | – | – | 55 | 0.16 | 1.4 | – | – | – |
| WNMG 080408E-NF | HF7 | 0.8 | – | – | – | 110 | 0.17 | 1.7 | 180 | 0.19 | 1.7 | 570 | 0.23 | 1.7 | – | – | – | – | – | – |
| | T6310 | 0.8 | 200 | 0.19 | 1.7 | 140 | 0.17 | 1.7 | 160 | 0.19 | 1.7 | 600 | 0.23 | 1.7 | 60 | 0.15 | 1.4 | – | – | – |
| | T7325 | 0.8 | 235 | 0.19 | 1.7 | 180 | 0.17 | 1.7 | – | – | – | – | – | – | 75 | 0.15 | 1.4 | – | – | – |
| | T7335 | 0.8 | 225 | 0.19 | 1.7 | 175 | 0.17 | 1.7 | – | – | – | – | – | – | 70 | 0.15 | 1.4 | – | – | – |
| | T8315 | 0.8 | 215 | 0.19 | 1.7 | 125 | 0.17 | 1.7 | 200 | 0.19 | 1.7 | 645 | 0.23 | 1.7 | 50 | 0.15 | 1.4 | – | – | – |
| | T8330 | 0.8 | 200 | 0.19 | 1.7 | 120 | 0.17 | 1.7 | 190 | 0.19 | 1.7 | 600 | 0.23 | 1.7 | 50 | 0.15 | 1.4 | – | – | – |
| | T8430 | 0.8 | 235 | 0.19 | 1.7 | 125 | 0.17 | 1.7 | 190 | 0.19 | 1.7 | 645 | 0.23 | 1.7 | 50 | 0.15 | 1.4 | – | – | – |
| | T9315 | 0.8 | 320 | 0.19 | 1.7 | – | – | – | 300 | 0.19 | 1.7 | – | – | – | – | – | – | – | – | – |
| | T9325 | 0.8 | 285 | 0.19 | 1.7 | 170 | 0.17 | 1.7 | 270 | 0.19 | 1.7 | – | – | – | 60 | 0.15 | 1.4 | – | – | – |
| WNMG 080412E-NF | T6310 | 1.2 | 185 | 0.30 | 2.1 | 130 | 0.27 | 2.1 | 145 | 0.30 | 2.1 | 555 | 0.36 | 2.1 | 55 | 0.21 | 1.7 | – | – | – |
| | T7325 | 1.2 | 205 | 0.30 | 2.1 | 155 | 0.27 | 2.1 | – | – | – | – | – | 65 | 0.21 | 1.7 | – | – | – | |
| | T8430 | 1.2 | 200 | 0.30 | 2.1 | 110 | 0.27 | 2.1 | 165 | 0.30 | 2.1 | 555 | 0.36 | 2.1 | 40 | 0.21 | 1.7 | – | – | – |
| | T9315 | 1.2 | 275 | 0.30 | 2.1 | – | – | – | 260 | 0.30 | 2.1 | – | – | – | – | – | – | – | – | – |
| | T9325 | 1.2 | 245 | 0.30 | 2.1 | 145 | 0.27 | 2.1 | 230 | 0.30 | 2.1 | – | – | – | 55 | 0.21 | 1.7 | – | – | – |



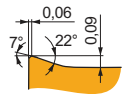
NM geometry with highly positive design for fine-finish, medium and rough machining, with continuous cuts.

| | | | | | | | | | | | | | | | | | | | | |
|------------------------|--------------|-----|------|------|-----|------|------|-----|---|---|---|-----|------|-----|------|------|-----|---|---|---|
| WNMG 060404E-NM | T7325 | 0.4 | 200 | 0.20 | 1.8 | 155 | 0.18 | 1.8 | – | – | – | – | – | 65 | 0.16 | 1.4 | – | – | – | |
| | T7335 | 0.4 | 195 | 0.20 | 1.8 | 150 | 0.18 | 1.8 | – | – | – | – | – | 60 | 0.16 | 1.4 | – | – | – | |
| | T8315 | 0.4 | 185 | 0.20 | 1.8 | 110 | 0.18 | 1.8 | – | – | – | 555 | 0.24 | 1.8 | 45 | 0.16 | 1.4 | – | – | – |
| | T8330 | 0.4 | 175 | 0.20 | 1.8 | 105 | 0.18 | 1.8 | – | – | – | 525 | 0.24 | 1.8 | 40 | 0.16 | 1.4 | – | – | – |
| | T8430 | 0.4 | 185 | 0.25 | 1.8 | 100 | 0.23 | 1.8 | – | – | – | 510 | 0.30 | 1.8 | 40 | 0.20 | 1.4 | – | – | – |
| | T9325 | 0.4 | 245 | 0.20 | 1.8 | 145 | 0.18 | 1.8 | – | – | – | – | – | – | 55 | 0.16 | 1.4 | – | – | – |
| WNMG 060408E-NM | T7325 | 0.8 | 220 | 0.25 | 1.8 | 170 | 0.23 | 1.8 | – | – | – | – | – | 70 | 0.20 | 1.4 | – | – | – | |
| | T7335 | 0.8 | 215 | 0.25 | 1.8 | 165 | 0.23 | 1.8 | – | – | – | – | – | 65 | 0.20 | 1.4 | – | – | – | |
| | T8315 | 0.8 | 205 | 0.25 | 1.8 | 120 | 0.23 | 1.8 | – | – | – | 615 | 0.30 | 1.8 | 50 | 0.20 | 1.4 | – | – | – |
| | T8330 | 0.8 | 195 | 0.25 | 1.8 | 115 | 0.23 | 1.8 | – | – | – | 585 | 0.30 | 1.8 | 45 | 0.20 | 1.4 | – | – | – |
| | T8430 | 0.8 | 220 | 0.25 | 1.8 | 120 | 0.23 | 1.8 | – | – | – | 600 | 0.30 | 1.8 | 45 | 0.20 | 1.4 | – | – | – |
| | T9315 | 0.8 | 290 | 0.25 | 1.8 | – | – | – | – | – | – | – | – | – | – | – | – | – | – | – |
| WNMG 060412E-NM | T9325 | 0.8 | 265 | 0.25 | 1.8 | 155 | 0.23 | 1.8 | – | – | – | – | – | 55 | 0.20 | 1.4 | – | – | – | |
| | T7325 | 1.2 | 220 | 0.30 | 1.8 | 170 | 0.27 | 1.8 | – | – | – | – | – | 70 | 0.24 | 1.4 | – | – | – | |
| | T7335 | 1.2 | 220 | 0.30 | 1.2 | 170 | 0.27 | 1.2 | – | – | – | – | – | 70 | 0.24 | 1.0 | – | – | – | |
| | T9315 | 1.2 | 285 | 0.30 | 1.8 | – | – | – | – | – | – | – | – | – | – | – | – | – | – | |
| WNMG 080404E-NM | T9325 | 1.2 | 255 | 0.30 | 1.8 | 150 | 0.27 | 1.8 | – | – | – | – | – | 55 | 0.24 | 1.4 | – | – | – | |
| | T7325 | 0.4 | 195 | 0.20 | 2.1 | 150 | 0.18 | 2.1 | – | – | – | – | – | 60 | 0.16 | 1.7 | – | – | – | |
| | T7335 | 0.4 | 190 | 0.20 | 2.1 | 145 | 0.18 | 2.1 | – | – | – | – | – | 60 | 0.16 | 1.7 | – | – | – | |
| | T8315 | 0.4 | 180 | 0.20 | 2.1 | 105 | 0.18 | 2.1 | – | – | – | 540 | 0.24 | 2.1 | 45 | 0.16 | 1.7 | – | – | – |
| | T8330 | 0.4 | 170 | 0.20 | 2.1 | 100 | 0.18 | 2.1 | – | – | – | 510 | 0.24 | 2.1 | 40 | 0.16 | 1.7 | – | – | – |
| | T8430 | 0.4 | 180 | 0.25 | 2.1 | 95 | 0.23 | 2.1 | – | – | – | 495 | 0.30 | 2.1 | 35 | 0.20 | 1.7 | – | – | – |
| | T9315 | 0.4 | 270 | 0.20 | 2.1 | – | – | – | – | – | – | – | – | – | – | – | – | – | – | – |
| T9325 | 0.4 | 240 | 0.20 | 2.1 | 140 | 0.18 | 2.1 | – | – | – | – | – | – | 50 | 0.16 | 1.7 | – | – | – | |



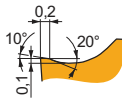
Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

| 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) |



FF geometry with highly positive design for fine-finish machining, and continuous to slightly interrupted cuts.

| | | | | | | | | | | | | | | | | | | |
|-----------------|-------|-----|-----|------|-----|-----|------|-----|-----|------|-----|---|---|---|---|---|---|---|
| WNMG 080404E-FF | T7325 | 0.4 | 235 | 0.12 | 1.0 | 180 | 0.11 | 1.0 | - | - | - | - | - | - | - | - | - | - |
| | T8315 | 0.4 | 220 | 0.12 | 1.0 | 130 | 0.11 | 1.0 | 205 | 0.12 | 1.0 | - | - | - | - | - | - | - |
| WNMG 080408E-FF | T7325 | 0.8 | 265 | 0.15 | 1.0 | - | - | - | - | - | - | - | - | - | - | - | - | - |
| | T8315 | 0.8 | 245 | 0.15 | 1.0 | 145 | 0.14 | 1.0 | 230 | 0.15 | 1.0 | - | - | - | - | - | - | - |



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

| | | | | | | | | | | | | | | | | | | | |
|-----------------|-----------------|-------|-----|------|------|-----|------|------|-----|------|------|-----|---|----|------|------|-----|---|---|
| WNMG 060404E-FM | T7325 | 0.4 | 195 | 0.20 | 1.4 | 150 | 0.18 | 1.4 | - | - | - | - | - | 60 | 0.16 | 1.1 | - | - | - |
| | T8315 | 0.4 | 180 | 0.20 | 1.4 | 105 | 0.18 | 1.4 | 170 | 0.20 | 1.4 | - | - | 45 | 0.14 | 1.1 | - | - | - |
| | 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 | - | - | - | 250 | 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 | - | - | - |
| | TT310 | 0.4 | 275 | 0.20 | 1.4 | 165 | 0.18 | 1.4 | - | - | - | - | - | - | - | - | - | - | - |
| WNMG 060408E-FM | T7325 | 0.8 | 235 | 0.20 | 1.4 | 180 | 0.18 | 1.4 | - | - | - | - | - | 75 | 0.16 | 1.1 | - | - | - |
| | 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 | - | - | - | 295 | 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 | - | - | - |
| WNMG 060412E-FM | T9315 | 1.2 | 300 | 0.27 | 1.2 | - | - | - | 285 | 0.27 | 1.2 | - | - | - | - | - | - | - | - |
| WNMG 06T304E-FM | T7325 | 0.4 | 195 | 0.20 | 1.4 | 150 | 0.18 | 1.4 | - | - | - | - | - | 60 | 0.16 | 1.1 | - | - | - |
| | 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 | - | - | - |
| | T9325 | 0.4 | 240 | 0.20 | 1.4 | 140 | 0.18 | 1.4 | 225 | 0.20 | 1.4 | - | - | 50 | 0.16 | 1.1 | - | - | - |
| | WNMG 06T308E-FM | 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 | - | - | - |
| T9325 | | 0.8 | 285 | 0.20 | 1.4 | 170 | 0.18 | 1.4 | 270 | 0.20 | 1.4 | - | - | 60 | 0.16 | 1.1 | - | - | - |
| WNMG 080404E-FM | T7325 | 0.4 | 190 | 0.20 | 1.9 | 145 | 0.18 | 1.9 | - | - | - | - | - | 60 | 0.16 | 1.5 | - | - | - |
| | T7335 | 0.4 | 180 | 0.20 | 1.9 | 140 | 0.18 | 1.9 | - | - | - | - | - | 55 | 0.16 | 1.5 | - | - | - |
| | T8315 | 0.4 | 180 | 0.20 | 1.9 | 105 | 0.18 | 1.9 | 170 | 0.20 | 1.9 | - | - | 45 | 0.14 | 1.5 | - | - | - |
| | T8330 | 0.4 | 165 | 0.20 | 1.9 | 95 | 0.18 | 1.9 | 155 | 0.20 | 1.9 | - | - | 40 | 0.14 | 1.5 | - | - | - |
| | T8430 | 0.4 | 190 | 0.20 | 1.9 | 105 | 0.18 | 1.9 | 155 | 0.20 | 1.9 | - | - | 40 | 0.14 | 1.5 | - | - | - |
| | T9310 | 0.4 | 285 | 0.20 | 1.9 | - | - | - | 270 | 0.20 | 1.9 | - | - | - | - | - | - | - | - |
| | T9315 | 0.4 | 270 | 0.20 | 1.2 | - | - | - | 255 | 0.20 | 1.2 | - | - | - | - | - | - | - | - |
| | T9325 | 0.4 | 245 | 0.20 | 1.2 | 145 | 0.18 | 1.2 | 230 | 0.20 | 1.2 | - | - | 55 | 0.16 | 1.0 | - | - | - |
| | WNMG 080408E-FM | T7325 | 0.8 | 225 | 0.20 | 1.9 | 175 | 0.18 | 1.9 | - | - | - | - | - | 70 | 0.16 | 1.5 | - | - |
| T7335 | | 0.8 | 215 | 0.20 | 1.9 | 165 | 0.18 | 1.9 | - | - | - | - | - | 65 | 0.16 | 1.5 | - | - | - |
| T8315 | | 0.8 | 210 | 0.20 | 1.9 | 125 | 0.18 | 1.9 | 195 | 0.20 | 1.9 | - | - | 50 | 0.16 | 1.5 | - | - | - |
| T8330 | | 0.8 | 195 | 0.20 | 1.9 | 115 | 0.18 | 1.9 | 185 | 0.20 | 1.9 | - | - | 45 | 0.16 | 1.5 | - | - | - |
| T8430 | | 0.8 | 225 | 0.20 | 1.9 | 120 | 0.18 | 1.9 | 185 | 0.20 | 1.9 | - | - | 45 | 0.16 | 1.5 | - | - | - |
| T9310 | | 0.8 | 335 | 0.20 | 1.9 | - | - | - | 315 | 0.20 | 1.9 | - | - | - | - | - | - | - | - |
| T9315 | | 0.8 | 310 | 0.20 | 1.9 | - | - | - | 290 | 0.20 | 1.9 | - | - | - | - | - | - | - | - |
| T9325 | | 0.8 | 280 | 0.20 | 1.9 | 165 | 0.18 | 1.9 | 265 | 0.20 | 1.9 | - | - | 60 | 0.16 | 1.5 | - | - | - |
| WNMG 080412E-FM | | T7325 | 1.2 | 220 | 0.27 | 1.9 | 170 | 0.24 | 1.9 | - | - | - | - | - | 70 | 0.19 | 1.5 | - | - |
| | T7335 | 1.2 | 205 | 0.27 | 1.9 | 155 | 0.24 | 1.9 | - | - | - | - | - | 65 | 0.19 | 1.5 | - | - | - |
| | T8330 | 1.2 | 190 | 0.27 | 1.9 | 110 | 0.24 | 1.9 | 180 | 0.27 | 1.9 | - | - | 45 | 0.19 | 1.5 | - | - | - |
| | T8430 | 1.2 | 210 | 0.27 | 1.9 | 115 | 0.24 | 1.9 | 175 | 0.27 | 1.9 | - | - | 45 | 0.19 | 1.5 | - | - | - |
| | T9310 | 1.2 | 310 | 0.27 | 1.9 | - | - | - | 290 | 0.27 | 1.9 | - | - | - | - | - | - | - | - |
| | T9315 | 1.2 | 285 | 0.27 | 1.9 | - | - | - | 270 | 0.27 | 1.9 | - | - | - | - | - | - | - | - |
| | T9325 | 1.2 | 255 | 0.27 | 1.9 | 150 | 0.24 | 1.9 | 240 | 0.27 | 1.9 | - | - | 55 | 0.19 | 1.5 | - | - | - |