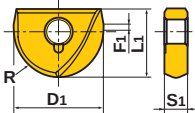
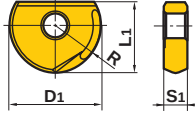


ROTATING TOOLS

INSERTS

Shape	Order Number	Coated			Dimensions (mm)					Geometry
		EP6120	VP15TF	MP8010	D ₁	R	L ₁	F ₁	S ₁	
	* SRFT10	●	●	●	10	5	8.5	0.5	2.6	
	* 12	●	●	●	12	6	10	0.5	3	
	* 16	●	●	●	16	8	12	1	4	
	* 20	●	●	●	20	10	15	1	5	
	* 25	●	●	●	25	12.5	18.5	1	6	
	* 30	●	●	●	30	15	22.5	1	7	
	* 32	●	●	●	32	16	23.5	1	7	
	SRBT10		●		10	5	8.5	—	2.6	
	12		●		12	6	10	—	3	
	16		●		16	8	12	—	4	
	20		●		20	10	15	—	5	
	25		●		25	12.5	18.5	—	6	
	30		●		30	15	22.5	—	7	
	32		●		32	16	23.5	—	7	

* 2 inserts supplied per case.



RECOMMENDED CUTTING CONDITIONS

	Work Material	Hardness	Grade	Cutting Speed vc (m/min)	Feed per Tooth fz (mm/tooth)	Depth of Cut ap (mm)
P	Carbon Steel Alloy Steel	180—280HB	EP6120 VP15TF	200 (80—300)	0.2 (0.1—0.3)	≤0.05D ₁
	Pre-Hardened Steel	≤45HRC	EP6120 VP15TF	150 (80—200)	0.2 (0.1—0.3)	≤0.05D ₁
	Alloy Tool Steel	180—380HB	EP6120 VP15TF	150 (80—200)	0.2 (0.1—0.3)	≤0.05D ₁
K	Gray Cast Iron	Tensile Strength ≤350MPa	MP8010	250 (180—450)	0.2 (0.1—0.3)	≤0.05D ₁
	Ductile Cast Iron	Tensile Strength ≤800MPa	MP8010	200 (80—300)	0.2 (0.1—0.3)	≤0.05D ₁
H	Hardened Steel	45—55HRC	MP8010	100 (60—120)	0.2 (0.1—0.3)	≤0.05D ₁
	Hardened Steel	55—65HRC	MP8010	80 (60—120)	0.2 (0.1—0.3)	≤0.01D ₁

(Note 1) The above values are average condition values at actual cutting speeds. The values change slightly according to the state of a machine to be used and method of workholding. Adjust the values depending on an actual machine condition, referring to the above values.

(Note 2) For end mills with a carbide shank, you will be able to set about 20 percent higher cutting conditions.

(Note 3) Please note the following when machining hardened steel with MP8010.

- Shorten tool overhang as much as possible.
- Use a carbide shank type.
- Depth of cut setting is important to prevent fracture.

● : Inventory maintained.