

INSERTS

Type	Shape	Order Number	Class	Coated				Cermet	Carbide	Dimensions (mm)								Geometry
				F7030	VP15TF	VP20RT	VP30RT			R	L1	L2	S1	F1	Re	B3	B9	
Inner	Strong Cutting Edge Type	SRG16C	G	●						8	16	8.2	3.5	—	—	11°	—	
		20C	G	●						10	19	10.2	4.6	—	—	10°	18°	
		25C	G	●						12.5	24	12.8	5.5	—	—	10°	18°	
		30C	G	●						15	28	15.3	7	—	—	10°	18°	
		32C	G	●						16	28	16.3	7	—	—	10°	18°	
Outer	Strong Cutting Edge Type	SRG16E	G	●						8	13.5	6.7	3.5	—	—	11°	—	
		20E	G	●						10	15.5	8.5	4.6	—	—	9°	—	
		25E	G	●						12.5	20.5	10.2	5.5	—	—	9°	—	
		30E	G	●						15	25.2	12.2	7	—	—	9°	—	
		32E	G	●						16	26.1	13.1	7	—	—	9°	—	
Inner	Low Resistance Type	SRM16C-M	M	●						8	16	8.2	3.5	—	—	11°	—	
		20C-M	M	●						10	19	10.2	4.6	—	—	10°	18°	
		25C-M	M	●						12.5	24	12.8	5.5	—	—	10°	18°	
		30C-M	M	●						15	28	15.3	7	—	—	10°	18°	
		32C-M	M	●						16	28	16.3	7	—	—	10°	18°	
Outer	Low Resistance Type	SRM16E-M	M	●						8	13.5	6.7	3.5	—	—	11°	—	
		20E-M	M	●						10	15.5	8.5	4.6	—	—	9°	—	
		25E-M	M	●						12.5	20.5	10.2	5.5	—	—	9°	—	
		30E-M	M	●						15	25.2	12.2	7	—	—	9°	—	
		32E-M	M	●						16	26.1	13.1	7	—	—	9°	—	
Inner		*2 SRG40C	G	●	●	●				20	36	20.5	8.0	—	—	11°	—	
		*2 50C	G	●	●	●				25	40	26	8.5	—	—	11°	—	
Outer		*2 SRG40E	G	●	●	●				20	32	16.6	8.0	—	—	11°	—	
		*2 50E	G	●	●	●				25	35.8	20	8.5	—	—	11°	—	
Peripheral	Strong Cutting Edge Type	APMT1135PDER-H2	M	●	●			●	●	—	11	6.35	3.5	1.2	0.8	11°	—	
		1604PDER-H2	M	●	●			●	●	—	16.5	9.525	4.76	1.4	0.8	11°	—	
	Low Resistance Type	APMT1135PDER-M2	M	●	●			●		—	11	6.35	3.5	1.2	0.8	11°	—	
		1604PDER-M2	M	●	●			●		—	16.5	9.525	4.76	1.4	0.8	11°	—	

(Low-resistance inner or outer inserts are precision M class type.)

*1 Selection guide for peripheral cutting edges : The first recommendation is the super sharp M breaker (APMT...PDER-M2).

When cutting edge strength is particularly important, use the H breaker (APMT...PDER-H2).

*2 2 inserts supplied per case.

RECOMMENDED CUTTING CONDITIONS

Work Material	Hardness	Grade	Cutting Speed (m/min)	Feed per Tooth (mm/tooth)	Cutting Mode
P	Alloy Tool Steel (ASTM D2)	VP20RT VP30RT	160 (120—200)	0.12 (0.08—0.2)	A
				0.2 (0.1—0.4)	B
				0.15 (0.1—0.3)	C
	Alloy Tool Steel	VP20RT VP30RT	200 (160—250)	0.2 (0.1—0.3)	A
				0.3 (0.1—0.4)	B
				0.2 (0.1—0.4)	C
	Cast Tool Steel	VP20RT	200 (160—250)	0.2 (0.1—0.3)	A
				0.3 (0.1—0.4)	B
				0.2 (0.1—0.4)	C
K	Ductile Cast Iron	VP15TF VP20RT	200 (160—300)	0.25 (0.1—0.4)	A
				0.35 (0.1—0.45)	B
				0.25 (0.1—0.45)	C
	Cast Iron	VP15TF VP20RT	200 (160—300)	0.25 (0.1—0.4)	A
				0.35 (0.1—0.45)	B
				0.25 (0.1—0.4)	C

Cutting Mode	A : Slot Milling
	B : Shoulder Milling (Standard Type)
	C : Shoulder Milling (Long Cutting Edge Type)