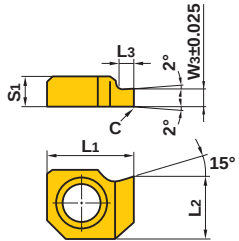
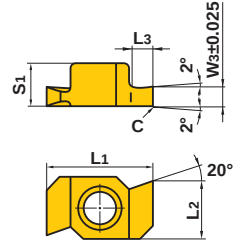
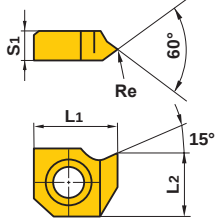


INSERTS

Application	Groove Width/ Thread Pitch W_3 (mm)	Order Number	Coated	Carbide	Dimensions (mm)						Geometry
			UP20M	UTi20T	L1	L2	L3	S1	Re	C	
Grooving	1.2	MLG1012L		●	7	5	1	2.38	—	0.1	MLG...L 
	1.5	1015L		●	7	5	1	2.38	—	0.1	
	2	1020L		●	7	5	1	2.38	—	0.1	
											MLG...L 
	1.5	MLG1415L		●	11.8	6.5	2	4.76	—	0.1	
	2	1420L		●	11.8	6.5	2	4.76	—	0.1	
	3	1430L		●	11.8	6.5	2	4.76	—	0.1	
	2	2020L		●	16.8	9.03	3	6.35	—	0.1	
	3	2030L		●	16.8	9.03	3	6.35	—	0.1	
	4	2040L		●	16.8	9.03	3	6.35	—	0.1	
Threading	Pitch 1.5—2.0	MLT1001L	★	●	7	5	—	2.38	0.1	—	MLT 
	Pitch 1.5—2.5	1401L	★	●	11.8	6.5	—	4.76	0.1	—	
	Pitch 1.5—3.5	2001L	★	●	16.8	9.03	—	6.35	0.1	—	

RECOMMENDED CUTTING CONDITIONS

Work Material	Hardness	Grade	Cutting Speed (m/min)	Feed (mm/rev)			
				1.2, 1.5mm	2.0mm	3.0mm	4.0mm
P Carbon Steel Alloy Steel	180—280HB	UP20M • UTi20T	90 (60—120)	0.05 (0.02—0.08)	0.05 (0.02—0.08)	0.05 (0.02—0.08)	0.05 (0.02—0.08)
	280—350HB	UP20M • UTi20T	80 (50—100)	0.03 (0.02—0.04)	0.03 (0.02—0.04)	0.03 (0.02—0.04)	0.03 (0.02—0.04)