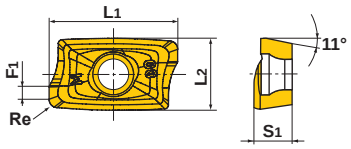
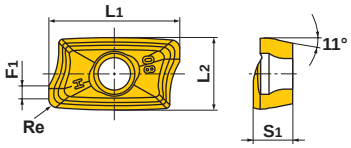
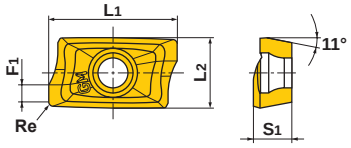
INSERTS

Work Material		
P	Steel	
M	Stainless Steel	
K	Cast Iron	
N	Non-ferrous Metal	
S	Heat-resistant Alloy, Titanium Alloy	
H	Hardened Steel	

Cutting Conditions (Guide):
●: Stable Cutting ◐: General Cutting ✲: Unstable Cutting

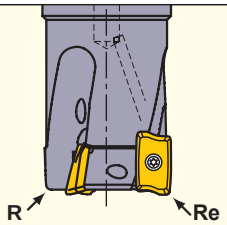
Honing:
E: Round F: Sharp T: Chamfer

Shape	Order Number	Class	Honing	Coated								Carbide		Dimensions (mm)					Geometry
				MC5020	MP6120	MP6130	MP7130	MP9120	MP9130	VP15TF	VP20RT	TF15		L1	L2	S1	F1	Re	
General **M** Breaker	**AOMT123602PEER-M**	M	E		●	●	●	●	●	●	●			12	6.6	3.6	1.8	0.2	
	123604PEER-M	M	E		●	●	●	●	●	●	●			12	6.6	3.6	1.6	0.4	
	123608PEER-M	M	E		●	●	●	●	●	●	●			12	6.6	3.6	1.2	0.8	
	123610PEER-M	M	E		●	●	●	●	●	●	●			12	6.6	3.6	1.0	1.0	
	123612PEER-M	M	E		●	●	●	●	●	●	●			12	6.6	3.6	0.8	1.2	
	**123616PEER-M**	M	E		●	●	●	●	●	●	●			12	6.6	3.6	0.4	1.6	
	123620PEER-M	M	E		●	●	●	●	●	●	●			12	6.6	3.6	0.4	2.0	
	123624PEER-M	M	E		●	●	●	●	●	●	●			12	6.6	3.6	0.4	2.4	
	123630PEER-M	M	E		●	●	●	●	●	●	●			12	6.6	3.6	0.4	3.0	
	123632PEER-M	M	E		●	●	●	●	●	●	●			12	6.6	3.6	0.4	3.2	
Strong Cutting Edge Type **H** Breaker	**AOMT123604PEER-H**	M	E	●	●	●	●	●	●	●	●			12	6.6	3.6	1.6	0.4	
	123608PEER-H	M	E	●	●	●	●	●	●	●	●			12	6.6	3.6	1.2	0.8	
	123616PEER-H	M	E	●	●	●	●	●	●	●	●			12	6.6	3.6	0.4	1.6	
																			
For Machining of Aluminium Alloys **GM** Breaker	**AOGT123602PEFR-GM**	G	F									●		12	6.6	3.6	1.8	0.2	
	123604PEFR-GM	G	F									●		12	6.6	3.6	1.6	0.4	
	123608PEFR-GM	G	F									●		12	6.6	3.6	1.2	0.8	
																			

■ = MIRACLE SIGMA

NOTE ON USE OF INSERTS WITH LARGE CORNER RADII

When using inserts with corner radius Re≥R2.4, please machine the holder with a radius form as shown on the right.



Re (mm)	R (mm)
2.4	1.9
3.0	2.5
3.2	2.7

R : Holder end radius
Re : Insert corner radius

ROTATING TOOLS

SCREW-IN ARBORS ➤ K118
SPARE PARTS ➤ M001
TECHNICAL DATA ➤ N001