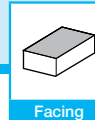


# MSRS15 HEAVY MILLING



## ● Applicable Inserts

Applicable Inserts <b>B23</b> (Right-hand Shown)				
Part Number	 2-Notch	 3-Notch	 2-Notch / Tough Edge	 3-Notch / Tough Edge
MSRS... MSRS...M	SPMT 1806EDER-NB2	SPMT 1806EDER-NB3	SPMT 1806EDSR-NB2T	SPMT 1806EDSR-NB3T
For Custom Ordered Left-hand Cutter	-	-	SPMT 1806EDSL-NB2T	SPMT 1806EDSL-NB3T
Applicable Inserts <b>B23</b>				
Part Number	 4-Notch / Low Cutting Force	 5-Notch / Low Cutting Force	 Without Notch	
MSRS... MSRS...M	SPMT 1806EDER-NB2P	SPMT 1806EDER-NB3P	SPMT 1806EDER-V	

Chipbreaker Selection **D2**

## ◆ Recommended Cutting Conditions

Part Number	Feed Rate fz (ipt)			Recommended Insert Grades (Cutting Speed Vc: sfm)			
	NB2P + NB3P	NB2 + NB3	NB2T + NB3T	MEGACOAT			PVD Coated Carbide
				PR1225	PR1230	PR1210	PR830
Carbon Steel	0.006	0.008	0.012	☆ 400 ~ <b>600</b> ~ 820	★ 400 ~ <b>600</b> ~ 725	-	☆ 400 ~ <b>575</b> ~ 725
Alloy Steel	0.006	0.008	0.012	☆ 400 ~ <b>600</b> ~ 820	★ 400 ~ <b>600</b> ~ 725	-	☆ 400 ~ <b>575</b> ~ 725
Mold Steel	0.004	0.006	0.008	☆ 325 ~ <b>525</b> ~ 725	★ 325 ~ <b>525</b> ~ 675	-	☆ 325 ~ <b>500</b> ~ 675
Gray Cast Iron	0.008	0.010	0.014	-	-	★ 400 ~ <b>600</b> ~ 820	-
Nodular Cast Iron	0.006	0.008	0.012	-	-	★ 325 ~ <b>525</b> ~ 725	-
Stainless Steel	Not Recommended						
Aluminum / Copper	Not Recommended						

★ : 1st Recommendation ☆ : 2nd Recommendation

D  
75° LEAD