Applicable Inserts (common to MHD-SA / -SB / -C)

Toolholder	Applicable Inserts ➔ M18, M19				Applicable Inserts ➔ M18		
			 1-Notched	 2-Notched		 2-Notched	 3-Notched
MHD 32-S32-SA	NDKW 090304ER	NDKT 090304ER-V	NDKT 090304ER-N1	NDKT 090304ER-N2	-	-	-
MHD 20S-S20-C			-	-			
MHD 25-S25-C	-	-	NDKT 090304ER-N1	NDKT 090304ER-N2			
32-S32-C							
MHD 40-S32-SA	-	-	-	-	NDMM 12T308ER-T	NDMM 12T308ER-N2	NDMM 12T308ER-N3
40-S40-SA							
40-S42-SA							
50-S42-SA							
MHD 40-S42-SB							
50-S42-SB							
MHD 40-S42-C							
50-S42-C							
MHD 63-FMA-SA	-	-	-	-	-		
80-FMA-SA							
100-FMA-SA							
MHD 63-BT50-SA							
80-BT50-SA							
100-BT50-SA							

・For installation of nicked insert, make sure to see **M76**.

Recommended Cutting Conditions

Workpiece Material	fz (mm/t)		Recommended Insert Grade (Cutting Speed Vc: m/min)											
			Cermet			PVD Coated Carbide							Carbide	
	øD ø20~ø32	øD ø40~ø100	TN60	TN100M	TC60	PR630	PR730	PR830			PR660	PR905	PW30	KW10
Stainless Steel	0.05~0.13	0.05~0.18		☆ 100~200		☆ 80~180	☆ 80~180				★ 60~150			
Carbon Steel	0.05~0.15	0.05~0.2		★ 100~200		☆ 80~180	★ 80~180				☆ 60~150			
Alloy Steel	0.05~0.15	0.05~0.2		★ 80~180		☆ 80~180	★ 80~180				☆ 60~150			
Mold Steel	0.05~0.15	0.05~0.2		★ 80~180		☆ 60~150	★ 60~150				☆ 60~130			
Cast Iron	0.05~0.15	0.05~0.2										★ 60~150		☆ 60~130
Non-ferrous Metals	0.05~0.15	0.05~0.2												★ 100~300

・Reduce the ap by 20-50% when machining with long overhang length or using long shank types.
・Reduce the cutting speed by 20-50% when machining with multiple front pieces.
・Compressed air is recommended to aid in chip evacuation.