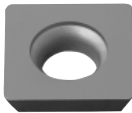


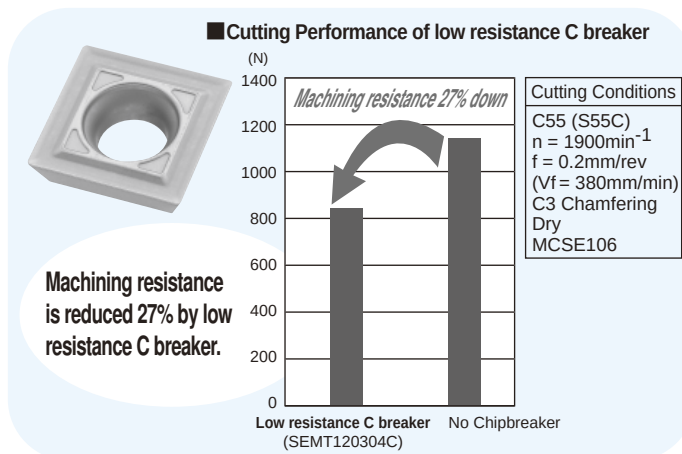
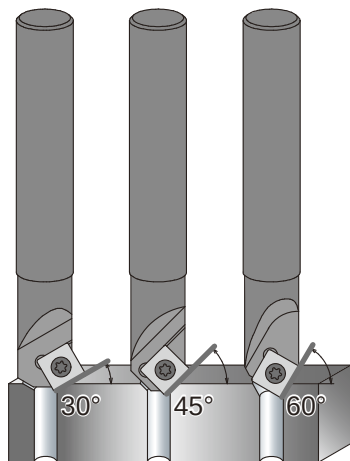
● Applicable Inserts

Description	Applicable Inserts ➡ M13		
			
MCSE 104 104-30D	SDKW 09T204TN	SDKW 09T204FN	SDMT 09T204C
MCSE 106 (-W) 115 (-W) 227 (-W) 336 (-W)	SEKW 120304TN 120308TN	SEKW 120304FN 120308FN	SEMT 120304C
MCSE 108-30D 110-30D			
MCSE 108-60D 120-60D			

◆ Recommended Cutting Conditions

Workpiece Material	fz (mm/t)		Recommended Insert Grade (Cutting Speed Vc: m/min)											
			Cermet			PVD Coated Carbide						Carbide		
	∅Ds (∅4~∅20)	∅Ds (∅27~∅36)	TN60	TN100M	TC60	PR630	PR730	PR830			PR660	PR905	PW30	KW10
Stainless Steel	0.05~0.2	0.1~0.3		☆ 100~180	☆ 80~160	☆ 100~180	★ 100~180							
Carbon Steel	0.05~0.25	0.2~0.4		★ 100~180	☆ 80~160	☆ 100~180	★ 100~180							
Alloy Steel	0.05~0.25	0.2~0.4		★ 100~180	☆ 80~160	☆ 80~150	★ 80~150							
Mold Steel	0.05~0.25	0.2~0.4		★ 100~150	☆ 80~130	☆ 60~130	★ 60~130							
Cast Iron	0.1~0.3	0.3~0.5											★ 80~150	
Non-ferrous Metals	0.1~0.3	0.3~0.5											★ 100~300	

★ : 1st Recommendation ☆ : 2nd Recommendation



M



Milling