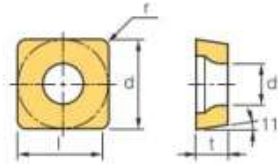


SP

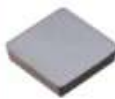


Square **90° Positive**
Relief Angle: 11°



Dimensions (mm)			
Size	d	t	d ₁
09	9.525	3.18	3.4-4.4
12	12.7	3.18	-
15	15.875	4.76	-
19	19.05	4.76	-
25	25.4	6.35	-

Workpiece	Steel																								Machining types		
	Stainless steel																										 Continuous cutting  General cutting  Interrupted cutting
	Cast iron																										
	Non-ferrous metal																										
	Heat resistant alloy, Titanium alloy																										
	Hardened steel																										

Inserts	Designation	Cermet		Coated		Coated										Uncoated		Cutting Condition										
		CN1500	CN2000	CN2500	CC1500	CC2500	NC3215	NC3120	NC3225	NC3030	NC5330	NC6310	NC6315	NC9115	NC9125	NC9135	PC5300	PC5400	PC8105	PC8110	PC8115	PC9030	H01	H05	f _n (mm/rev)	a _p (mm)		
Medium cutting		SPGR	090308-M																							0.10~0.40	1.00~3.50	
			120308-M																								0.20~0.40	1.50~4.00
Medium to finishing		SPGT	090304R																							0.08~0.23	0.30~3.00	
			090308R																							0.10~0.30	0.50~3.00	
			090304L	●																						0.08~0.23	0.30~3.00	
			090308L																							0.10~0.30	0.50~3.00	
Finishing		SPMR	090304-F																							0.05~0.20	0.30~2.00	
			120304-F						●	●																0.10~0.25	0.50~2.00	
Finishing		SPMT	09T304-VL																							0.04~0.18	0.20~1.40	
			09T308-VL																							0.08~0.22	0.20~1.40	
Finishing		SPMT	090304-VF																							0.05~0.20	0.30~1.50	
			090308-VF																							0.10~0.25	0.30~1.50	
Medium cutting		SPMR	090308-M						●	●																0.10~0.40	1.00~3.50	
			120308-M						●	●																0.10~0.40	1.50~4.00	
			120312-M							●																	0.20~0.40	1.50~4.00
Medium to finishing		SPUN	120304																							0.10~0.30	1.00~5.00	
			120308																							0.15~0.40	1.00~5.00	
			120308SN																							0.15~0.40	1.00~5.00	
			150412																							0.20~0.50	1.00~5.00	
			190412							●																	0.20~0.50	1.50~7.00
			190416																								0.25~0.60	2.00~7.00
			250620																								0.30~0.80	3.00~10.0

Cutting edge geometry **A52~A61**
 Recommended chip breaker **B04~B11**
 Code system **B26~B27**
 Stock item

Available tool holders			
Designation	Page	Designation	Page
CSDPN	B169	SSKPR/L	B208
CSKPR/L	B170		

