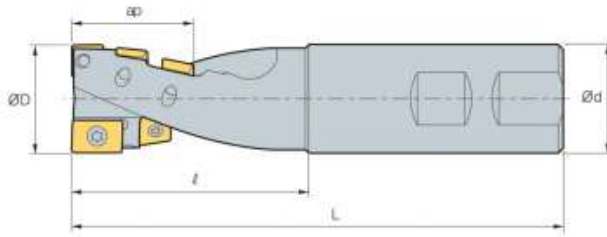


# THE



| Designation |     | ØD | Ød | l  | L   | ap | No. of flute |     | Available inserts  |                       |
|-------------|-----|----|----|----|-----|----|--------------|-----|--------------------|-----------------------|
|             |     |    |    |    |     |    |              |     | Lower cutting-edge | External cutting-edge |
| THE         | 25R | 25 | 25 | 55 | 120 | 25 | 2            | 0.4 | APLT070304R 1z     | SPMT060304 4z         |
|             | 32R | 32 | 32 | 70 | 145 | 40 | 2            | 0.5 | ADLT150308R 1z     | SDMT090308-MM 5z      |
|             | 40R | 40 | 42 | 88 | 175 | 54 | 2            | 1.3 | ZPMT1504PPSR-MM 1z | SPMT120408-MM 5z      |
|             | 50R | 50 | 42 | 85 | 175 | 54 | 4            | 1.4 | ZPMT1504PPSR-MM 2z | SPMT120408-MM 10z     |

(mm)

## Available inserts

|             |             | ADLT                                                                                |      | APLT                                                                                |        | SPMT-MM                                                                             |        | SPMT                                                                                |        | SDMT-MM                                                                              |        | ZPMT-MM                                                                               |        |          |        |        |      |       |     |                                 |
|-------------|-------------|-------------------------------------------------------------------------------------|------|-------------------------------------------------------------------------------------|--------|-------------------------------------------------------------------------------------|--------|-------------------------------------------------------------------------------------|--------|--------------------------------------------------------------------------------------|--------|---------------------------------------------------------------------------------------|--------|----------|--------|--------|------|-------|-----|---------------------------------|
|             |             |  |      |  |        |  |        |  |        |  |        |  |        |          |        |        |      |       |     |                                 |
| Designation |             | Cermet                                                                              |      | Coated                                                                              |        |                                                                                     |        |                                                                                     |        |                                                                                      |        |                                                                                       |        | Uncoated |        |        | page |       |     |                                 |
|             |             | CN2000                                                                              | CN30 | NCM325                                                                              | NC5330 | NCM535                                                                              | NCM545 | PC2505                                                                              | PC2510 | PC3600                                                                               | PC3700 | PC6510                                                                                | PC9530 | PC9540   | PC5300 | PC5400 |      | ST30A | G10 | H01                             |
| SPMT        | 060304      |                                                                                     |      | ●                                                                                   |        |                                                                                     |        |                                                                                     |        |                                                                                      |        |                                                                                       |        |          |        |        |      |       |     | E04<br>E05<br>E18<br>E25<br>E31 |
| SDMT        | 090308-MM   |                                                                                     |      |                                                                                     |        |                                                                                     |        |                                                                                     |        | ●                                                                                    |        |                                                                                       |        |          | ●      |        |      |       |     |                                 |
| SPMT        | 120408-MM   |                                                                                     |      |                                                                                     |        |                                                                                     |        |                                                                                     |        | ●                                                                                    |        |                                                                                       |        |          | ●      |        |      |       |     |                                 |
| APLT        | 070304R     |                                                                                     |      |                                                                                     |        |                                                                                     |        |                                                                                     |        |                                                                                      |        |                                                                                       |        |          | ●      |        |      |       |     |                                 |
| ADLT        | 150308R     |                                                                                     |      | ●                                                                                   |        |                                                                                     |        |                                                                                     |        |                                                                                      |        |                                                                                       |        |          | ●      |        |      |       |     |                                 |
| ZPMT        | 1504PPSR-MM |                                                                                     |      |                                                                                     |        |                                                                                     |        |                                                                                     |        |                                                                                      | ●      |                                                                                       |        |          | ●      |        |      |       |     |                                 |

## Recommended cutting condition

### Grooving

| Workpiece | Cutting Condition |           | Grades |
|-----------|-------------------|-----------|--------|
|           | vc (m/min)        | fz (mm/t) |        |
| P         | 90~140            | 0.05~0.2  | PC5300 |
| M         | 50~90             | 0.05~0.2  | PC5300 |
| K         | 70~120            | 0.05~0.25 | PC5300 |

### Side cutting

| Workpiece | Cutting Condition |           | Grades |
|-----------|-------------------|-----------|--------|
|           | vc (m/min)        | fz (mm/t) |        |
| P         | 150 ~240          | 0.05~0.2  | PC5300 |
| M         | 90~150            | 0.05~0.2  | PC5300 |
| K         | 120~200           | 0.10~0.25 | PC5300 |

## Parts

| Specification |           |       |       |
|---------------|-----------|-------|-------|
| Ø25           | ETNA02506 | TW07P | -     |
| Ø32           | ETNA0408  | -     | TW15S |
| Ø40           | ETNA0511  | -     | TW20S |
| Ø50           | ETNA0511  | -     | TW20S |

Available inserts E04, E05, E18, E25, E31