

INSERTS

FOR HF, SHF TYPE

Machining Materials	GRADE				
	LT30				
P	△				
M	△				
K	△				
N					
S					
H					
TYPE	GRADE	DIMENSION			
	LT30	d	i	s	r
SNKX 09T3 - HF	V	-	-	0.146"	-

Cutting Conditions

Machining Materials		Grade	Vc(m/min)	fz(mm/rev)	Ap(mm)
P	Alloy Steels	LT30	120 ~ 280	0.25 ~ 2.0	0.1 ~ 1.0
M	Stainless Steels	LT30	100 ~ 210	0.15 ~ 1.35	0.1 ~ 1.0
K	Cast Iron	PL30	120 ~ 280	0.2 ~ 2.4	0.1 ~ 1.0

Product information:

- ▶ Spindle Revolution = $(1000 \times \text{cutting speed}) \div (3.14 \times \text{the external dia. of cutting tool})$
- ▶ Table feed(mm/min) = table feed of each tooth $\times$ total teeth of cutting tool $\times$ spindle revolution