

INSERTS FOR SPD TYPE

Machining Materials	GRADE				
	RM4030	RM4025	RM3130	RM5005	RM5060
P	△	△			
M	△	△			
K		△	△		
N				△	△
S					
H					

TYPE	GRADE					DIMENSION			
	RM4030	RM4025	RM3130	RM5005	RM5060	d	i	s	r
SPGT050204 - M02	V					5	-	2.38	0.4
SPGT060204 - M02	V					6	-	2.38	0.4
SPGT07T308 - M02	V					7.94	-	3.97	0.8
SPGT090408 - M02	V					9.8	-	4.3	0.8
SPGT110408 - M02	V					11.5	-	4.76	0.8
SPGT140512 - M02	V					14.3	-	5.2	1.2
SPMT050204 - M01		V				5	-	2.38	0.4
SPMT060204 - M01		V				6	-	2.38	0.4
SPMT07T308 - M01		V				7.94	-	3.97	0.8
SPMT090408 - M01		V				9.8	-	4.3	0.8
SPMT110408 - M01		V				11.5	-	4.76	0.8
SPMT140512 - M01		V				14.3	-	5.2	1.2
SPMT060204 - M03		V	V			6	-	2.38	0.4
SPMT050204 - MT				V	V	5	-	2.38	0.4
SPMT060204 - MT				V	V	6	-	2.38	0.4
SPMT07T308 - MT				V	V	7.94	-	3.97	0.8
SPMT090408 - MT				V	V	9.8	-	4.3	0.8
SPMT110408 - MT				V	V	11.5	-	4.76	0.8
SPMT140512 - MT				V	V	14.3	-	5.2	1.2

Cutting Conditions

Machining Materials	Grade	Vc(m/min)	fz(mm/rev)					
			φ 13~φ 15	φ 16~φ 22	φ 23~φ 33	φ 34~φ 41	φ 42~φ 50	
P	Low-Alloy Steels	RM4030	180 ~ 260	0.06 ~ 0.12	0.06 ~ 0.10	0.06 ~ 0.12	0.12 ~ 0.24	0.12 ~ 0.25
		RM4025	160 ~ 250	0.06 ~ 0.12	0.06 ~ 0.10	0.06 ~ 0.12	0.12 ~ 0.24	0.12 ~ 0.25
M	Alloy Steels	RM4030	140 ~ 200	0.05 ~ 0.08	0.08 ~ 0.15	0.10 ~ 0.18	0.08 ~ 0.15	0.10 ~ 0.18
		RM4025	120 ~ 180	0.05 ~ 0.08	0.08 ~ 0.15	0.10 ~ 0.18	0.08 ~ 0.15	0.10 ~ 0.18
M	Stainless Steels	RM4030	120 ~ 180	0.05 ~ 0.10	0.06 ~ 0.12	0.08 ~ 0.15	0.10 ~ 0.17	0.12 ~ 0.20
		RM4025	120 ~ 180	0.05 ~ 0.10	0.06 ~ 0.12	0.08 ~ 0.15	0.10 ~ 0.17	0.12 ~ 0.20
K	Cast Iron	RM4025	160 ~ 220	0.06 ~ 0.12	0.08 ~ 0.16	0.12 ~ 0.20	0.16 ~ 0.25	0.18 ~ 0.26
		RM3130	120 ~ 180	0.05 ~ 0.10	0.06 ~ 0.12	0.08 ~ 0.15	0.10 ~ 0.17	0.12 ~ 0.20

Product information:

- ▶ Spindle Revolution = (1000 × cutting speed) ÷ (3.14 × the external dia. of cutting tool)
- ▶ Table feed(mm/min) = table feed of each tooth × total teeth of cutting tool × spindle revolution