

# INSERTS FOR WD TYPE

Machining Materials	GRADE				
	PTE30				
<b>P</b>	△				
<b>M</b>	△				
<b>K</b>	△				
<b>N</b>					
<b>S</b>					
<b>H</b>					
TYPE	GRADE	DIMENSION			
	PTE30	d	i	s	r
WCMX030208 - M01	V	5.56	3.8	2.38	0.8
WCMX080412 - M01	V	12.7	8.7	4.76	1.2
WCMT040208 - M01	V	6.35	4.3	2.38	0.8
WCMT050308 - M01	V	7.94	5.4	3.18	0.8
WCMT06T308 - M01	V	9.525	6.5	3.97	0.8

## Cutting Conditions

Machining Materials	Grade	Vc(m/min)	fz(mm/rev)				
			φ 20	φ 20~φ 25	φ 25~φ 45	φ 45	
<b>P</b>	Low-Alloy Steels	PTE30	100 ~ 200	0.05 ~ 0.12	0.06 ~ 0.15	0.08 ~ 0.17	0.10 ~ 0.20
	Alloy Steels	PTE30	80 ~ 160	0.05 ~ 0.12	0.06 ~ 0.15	0.08 ~ 0.17	0.10 ~ 0.20
<b>M</b>	Stainless Steels	PTE30	70 ~ 140	0.05 ~ 0.12	0.06 ~ 0.12	0.08 ~ 0.15	0.10 ~ 0.20
<b>K</b>	Cast Iron	PTE30	70 ~ 180	0.06 ~ 0.10	0.08 ~ 0.15	0.08 ~ 0.20	0.10 ~ 0.30

### 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