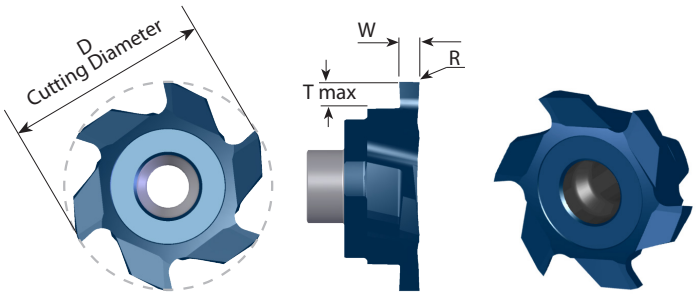
Groove Milling

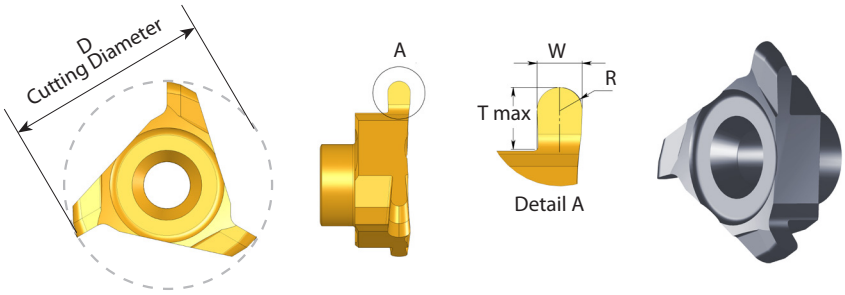
Multi Flute

DIN 471/472



Insert Type	Ordering Code	D	Nom` groove width	W -0.04	T Max.	R	Groove Dia. (min)	No. of Flutes	Holder Code*
S20	**SG200 F W121**	20.0	1.10	1.21	4.0	0	Ø > 20	6	H5.1, 5.2, 21
	SG200 F W141	20.0	1.30	1.41	4.0	0.1	Ø > 20	6	
	SG200 F W171	20.0	1.60	1.71	4.0	0.1	Ø > 20	6	
	SG200 F W196	20.0	1.85	1.96	4.0	0.1	Ø > 20	6	

Full Radius Groove Milling



Insert Type	Ordering Code	D	R	W ±0.02	T Max.	Groove Dia. (min)	Holder Code*
C12	**C12 R11**	12.4	1.1	2.2	1.7	Ø >12.4	H3, 4, 5, 18, 20
C18	**C18 R08**	17.8	0.8	1.6	2.9	Ø >17.8	H5.1, 5.2, 21
	C18 R11	17.8	1.1	2.2	2.9	Ø >17.8	

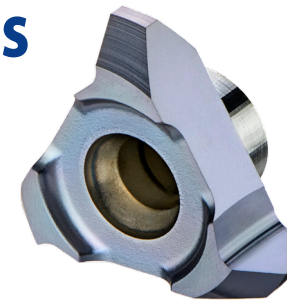
* For complete toolholder description see pages B07-22 and 23

CMT
Vertical Milling

Advantages

- Ground profile inserts for high precision and excellent performance.
- Working at high machining parameters, with high surface quality.
- Solid and accurate clamping method enables full repeatability.
- Same insert and holder for right-hand or left-hand threads.
- Toolholders include weldon shank and coolant bore.

CMT Straight Flute Inserts

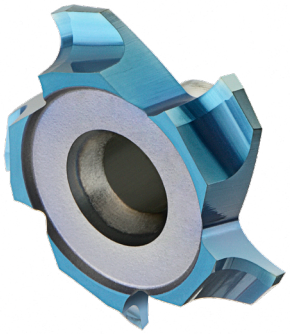


Carbide Grade: MT7

Inserts are available in MT7 Sub-Micron Grade with Titanium Aluminum Nitride multi-layer coating (ISO K10 - K20). This is a general purpose grade, covering a very wide range of materials.

CMT Spiral Multi Flute Inserts

- Multi flute: 4-8 cutting edges
- Spiral flute for smooth cutting



The new cutters are designed for large range of materials including hardened steel up to 62 HRc.

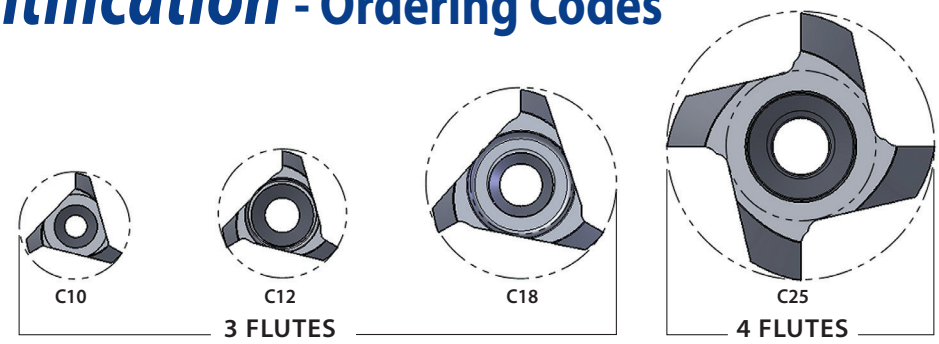
Advantages

- Longer tool life
- High material removal and higher feeds results increased productivity
- Excellent surface finish
- Reduced cycle time
- Low cutting forces due to the spiral multi flutes

Carbide Grade: MT8

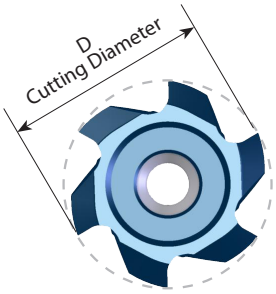
Sub Micron grade with advanced PVD triple coating (ISO K10-K20).
Extremely high heat resistant and smooth cutting operation, high performance, for all machining conditions.

Product Identification - Ordering Codes



C	18	I	12	UN	MT7
CMT Line	Cutting Diameter 10 = 10.0 mm 12 = 12.0 mm 18 = 17.8 mm 25 = 25.0 mm	I = Internal	Thread Pitch A, D, G, N, Q = Partial Profile C = Chamfering and Grooving CR = Corner Rounding F = Face Milling and Finishing W = Grooving	Thread Profile 60° & 55° ISO UN Whitworth Trapez Acme Chamfering	Carbide Grade

CMT Spiral Multi Flute Inserts



S	178	H	1.0	ISO	MT8
Spiral CMT line Multi flute	Cutting Diameter 178 = Ø17.8 mm 189 = Ø18.9 mm 200 = Ø20.0 mm 350 = Ø35.0 mm	Number of Flutes D = 4 E = 5 F = 6 H = 8	Thread Pitch G, N = Partial Profile H = Chamfering, Grooving and Boring W = Grooving R = Radius Groove Milling CR = Corner Rounding	Thread Profile Partial 60° & 55° ISO UN	Carbide Grade