

#### R217/220.42 – Insert selection – Metric/ Inch

|                                          | SMG |                         |                          | $f_z$           |                 |                 |
|------------------------------------------|-----|-------------------------|--------------------------|-----------------|-----------------|-----------------|
|                                          |     |                         |                          | 100%            | 30%             | 10%             |
| Square shoulder and slot milling cutters | P1  | XOMX120408TR-M12 MP2501 | LNMU110408SR-M12 MP2501  | 0,14<br>0.0055  | 0,15<br>0.0060  | 0,22<br>0.0085  |
|                                          | P2  | XOMX120408TR-M12 MP2501 | LNMU110408SR-M12 MP2501  | 0,14<br>0.0055  | 0,15<br>0.0060  | 0,24<br>0.0095  |
| Helical milling cutters                  | P3  | XOMX120408TR-M12 MP2501 | LNMU110408SR-M12 MP2501  | 0,13<br>0.0050  | 0,14<br>0.0055  | 0,22<br>0.0085  |
|                                          | P4  | XOMX120408TR-M12 MP2501 | LNMU110408SR-M12 MP2501  | 0,13<br>0.0050  | 0,14<br>0.0055  | 0,22<br>0.0085  |
|                                          | P5  | XOEX120404R-M07 MP2501  | LNEU110408SR-M12 MP2501  | 0,095<br>0.0038 | 0,10<br>0.0040  | 0,16<br>0.0065  |
|                                          | P6  | XOEX120408R-M07 MP2501  | LNEU110408SR-M12 MP2501  | 0,095<br>0.0038 | 0,10<br>0.0040  | 0,16<br>0.0065  |
|                                          | P7  | XOEX120408R-M07 MP2501  | LNEU110408SR-M12 MP2501  | 0,095<br>0.0038 | 0,10<br>0.0040  | 0,16<br>0.0065  |
| Face milling cutters                     | P8  | XOEX120408R-M07 MP2501  | LNEU110408SR-M12 MP2501  | 0,10<br>0.0040  | 0,11<br>0.0044  | 0,16<br>0.0065  |
|                                          | P11 | XOEX120408R-M07 MP3501  | LNEU110408SR-M12 MP3501  | 0,095<br>0.0038 | 0,10<br>0.0040  | 0,16<br>0.0065  |
|                                          | P12 | XOEX120408R-M07 MP2501  | LNEU110408SR-M12 MP3501  | 0,065<br>0.0026 | 0,070<br>0.0028 | 0,11<br>0.0044  |
|                                          | M1  | XOEX120408R-M07 MS2050  | LNEU110408SR-ME07 MS2050 | 0,10<br>0.0040  | 0,11<br>0.0044  | 0,17<br>0.0065  |
| Disc milling cutters                     | M2  | XOEX120404R-M07 MS2050  | LNEU110408SR-ME07 MS2050 | 0,095<br>0.0038 | 0,10<br>0.0040  | 0,16<br>0.0065  |
|                                          | M3  | XOEX120404R-M07 MS2050  | LNEU110408SR-ME07 MS2050 | 0,075<br>0.0030 | 0,080<br>0.0032 | 0,13<br>0.0050  |
|                                          | M4  | XOEX120408R-M07 MP3501  | LNEU110408SR-M12 MP3501  | 0,065<br>0.0026 | 0,070<br>0.0028 | 0,11<br>0.0044  |
|                                          | M5  | XOEX120408R-M07 MP3501  | LNEU110408SR-M12 MP3501  | 0,065<br>0.0026 | 0,070<br>0.0028 | 0,11<br>0.0044  |
|                                          | K1  | XOMX120408TR-M12 MK2050 | LNMU110408SR-M12 MK2050  | 0,14<br>0.0055  | 0,15<br>0.0060  | 0,24<br>0.0095  |
| High feed milling cutters                | K2  | XOMX120408TR-M12 MK2050 | LNMU110408SR-M12 MK2050  | 0,13<br>0.0050  | 0,14<br>0.0055  | 0,20<br>0.0080  |
|                                          | K3  | XOMX120408TR-M12 MK2050 | LNMU110408SR-M12 MK2050  | 0,13<br>0.0050  | 0,14<br>0.0055  | 0,20<br>0.0080  |
|                                          | K4  | XOMX120408TR-M12 MK2050 | LNMU110408SR-M12 MK2050  | 0,13<br>0.0050  | 0,14<br>0.0055  | 0,20<br>0.0080  |
|                                          | K5  | XOMX120408TR-M12 MK2050 | LNMU110408SR-M12 MK2050  | 0,11<br>0.0044  | 0,12<br>0.0048  | 0,19<br>0.0075  |
|                                          | K6  | XOMX120408TR-M12 MK2050 | LNMU110408SR-M12 MK2050  | 0,13<br>0.0050  | 0,14<br>0.0055  | 0,20<br>0.0080  |
| Copy milling cutters                     | K7  | XOMX120408TR-M12 MK2050 | LNMU110408SR-M12 MK2050  | 0,11<br>0.0044  | 0,12<br>0.0048  | 0,19<br>0.0075  |
|                                          | S1  | XOMX120404TR-ME08 F40M  | LNMU110408SR-ME08 F40M   | 0,060<br>0.0024 | 0,065<br>0.0026 | 0,095<br>0.0038 |
|                                          | S2  | XOMX120404TR-ME08 F40M  | LNMU110408SR-ME08 F40M   | 0,060<br>0.0024 | 0,065<br>0.0026 | 0,095<br>0.0038 |
| Plunge milling cutters                   | S3  | XOMX120404TR-ME08 F40M  | LNMU110408SR-ME08 F40M   | 0,055<br>0.0022 | 0,060<br>0.0024 | 0,090<br>0.0036 |
|                                          | S11 | XOEX120404R-M07 MS2050  | LNEU110408ER-M07 MS2050  | 0,075<br>0.0030 | 0,080<br>0.0032 | 0,13<br>0.0050  |
|                                          | S12 | XOEX120404R-M07 MS2050  | LNEU110408ER-M07 MS2050  | 0,075<br>0.0030 | 0,080<br>0.0032 | 0,13<br>0.0050  |
|                                          | S13 | XOEX120404R-M07 MS2050  | LNMU110408ER-M07 MS2050  | 0,065<br>0.0026 | 0,070<br>0.0028 | 0,11<br>0.0044  |
|                                          | H5  | XOMX120408TR-M12 MP3501 | LNEU110408SR-M12 MP3501  | 0,085<br>0.0034 | 0,095<br>0.0038 | 0,14<br>0.0055  |
| Chamfer milling cutters                  | H8  | XOMX120408TR-M12 MP3501 | LNEU110408SR-M12 MP3501  | 0,065<br>0.0026 | 0,070<br>0.0028 | 0,11<br>0.0044  |
|                                          | H11 | XOMX120408TR-M12 MP3501 | XOMX120408TR-M12 MP3501  | 0,085<br>0.0034 | 0,095<br>0.0038 | 0,14<br>0.0055  |
|                                          | H12 | XOMX120408TR-M12 MP3501 | LNEU110408SR-M12 MP3501  | 0,065<br>0.0026 | 0,070<br>0.0028 | 0,11<br>0.0044  |
|                                          |     |                         |                          |                 |                 |                 |

SMG = Seco material group

$f_z$  = mm/tooth (in/tooth),  $v_c$  = m/min (sf/min),  $a_p/DC$  = %

All cutting data are start values