



New products

2016.1



SPECIAL GRADE FOR MILLING STAINLESS STEELS

The M6330 grade has been developed specifically to achieve longer cutting edge durability and reliability in stainless steels and difficult-to-machine materials.

Particularly suited to coolant-fed applications and adverse cutting conditions.

BENEFITS

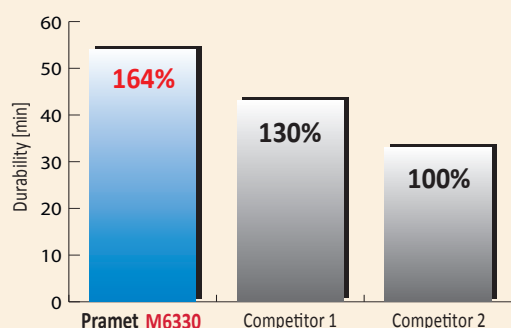
- **High insert durability** when machining stainless steels with and without coolant
- **Improved abrasion resistance** thanks to the combination of the new substrate and PVD coating
- Higher resistance to heat-related cracks
- Higher operational reliability
- Better dissipation of heat from the cutting area

MACHINING EXAMPLE USING M6330 GRADE

Material: 17349.4 (155 HB)
Material group: M3
Insert: ADMX 160608SR-MM: M6330
Coolant: **No**

Cutting speed	v_c	140	m per min
Feed per tooth	f_z	0,15	mm per tooth
Axial length of cut	a_p	2,5	mm

PRAMET M6330	Competitor 1	Competitor 2
		
54 min	43 min	33 min



Where should M6330 be used?

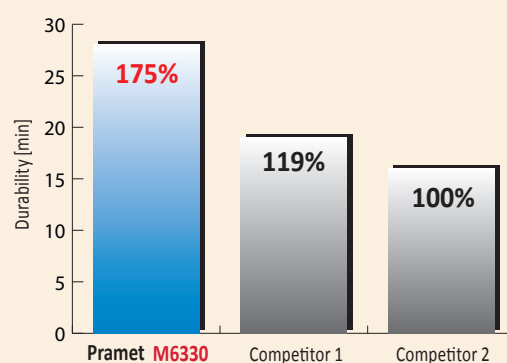
- When the use of coolant leads to the onset of **thermal shocks**.
- In applications with **adverse cutting conditions**, such as interrupted cutting.

MACHINING EXAMPLE USING M6330 GRADE

Material: 17349.4 (155 HB)
Material group: M3
Insert: ADMX 160608SR-MM: M6330
Coolant: **Yes** (technical reason)

Cutting speed	v_c	70	m per min
Feed per tooth	f_z	0,12	mm per tooth
Axial length of cut	a_p	4	mm

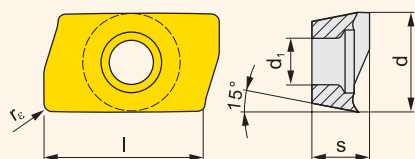
PRAMET M6330	Competitor 1	Competitor 2
		
28 min	19 min	16 min



- For milling stainless steels in combination with the new MF and MM insert geometries.

INDEXABLE CUTTING INSERTS FOR MILLING

ADMX 16



Dimensions	L	d	d ₁	s	
1606	16,000	9,950	4,50	6,25	

Geometry	ISO	Grade												Radius	Feed/tooth		Depth of cut				
		M5315	M9315	M9325	M9340	M8310	M8340	M8345	M6330	8215	8230	8240					r _ε	f _{min}	f _{max}	a _{p min}	a _{p max}
	ADMX 160608SR-F				●	●	●			●	●	●					0,8	0,07	0,15	0,3	13,0
	ADMX 160604SR-M						●			●	●						0,4	0,10	0,25	0,3	13,0
	ADMX 160608SR-M	●	●	●	●	●	●			●	●	●					0,8	0,10	0,25	0,3	13,0
	ADMX 160616SR-M			●		●	●			●	●	●					1,6	0,10	0,30	0,3	13,0
	ADMX 160620SR-M						●				●						2,0	0,10	0,25	0,3	13,0
	ADMX 160630SR-M						●				●						3,0	0,10	0,25	0,3	13,0
	ADMX 160632SR-M			●			●			●	●	●					3,2	0,10	0,30	0,3	13,0
	ADMX 160640SR-M						●				●						4,0	0,10	0,25	0,3	13,0
	ADMX 160650SR-M						●				●						5,0	0,10	0,25	0,3	13,0
	ADMX 160608PR-R	●	●	●		●	●			●	●	●					0,8	0,17	0,35	1,0	13,0
	ADMX 160616PR-R	●	●	●			●			●	●						1,6	0,17	0,35	1,0	13,0
	ADMX 160608SR-MF				●		●		●								0,8	0,05	0,16	0,3	13,0
	ADMX 160604SR-MM				●		●		●								0,4	0,14	0,22	0,3	13,0
	ADMX 160608SR-MM				●		●	●	●								0,8	0,14	0,22	0,3	13,0
	ADMX 160616SR-MM				●		●	●	●								1,6	0,14	0,22	0,3	13,0
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● New item in the assortment

● Stock assortment ○ Non-stock assortment All dimensions [mm]
See latest price list for current stock information

MILLING TOOLS

MILLING INSERTS

TURNING TOOLS

TURNING INSERTS

TECHNICAL SECTION