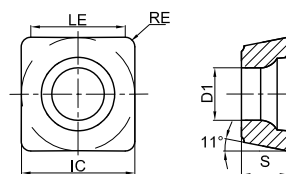




Chamfer Milling

SPMT

Chamfer Milling Insert



Ordering Code	Dimension(mm)					Coating Grade										Uncoated	Cermec					
	IC	LE	RE	S	D1	GA4225	GA4230	GA4325	GA4330	GP4225	GP2115	GM4135	GM2140	GK4125	GK2115			GS4130	GH4115	GN9125	GP01TM	
 SPMT09T308-CM	9.53	7.93	0.8	3.97	4.4	●	●							●	●							
 SPMT120408-CM	12.7	11.1	0.8	4.76	5.5	●	●							●	●							

● Stock ○ Available Upon Order

Chamfer Milling

MCA130

Side Clamp Type

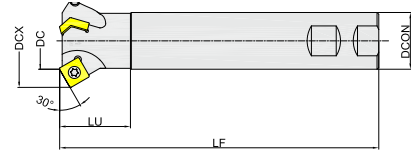


Fig1

Ordering Code	Dia-meter	Teeth	Dimension(mm)					APMX	Suitable for	Coolant	Shape	Stock
			DC	DCX	DCON	LF	LU					
MCA130025R02W25SP09	25	2	25	40	25	120	40	3	SPMT09T3	×	Fig1	●
MCA130032R03W32SP12	32	3	32	52	32	180	40	4.5	SPMT1204	×	Fig1	●

● Stock ○ Available Upon Order

MCA145

Side Clamp Type

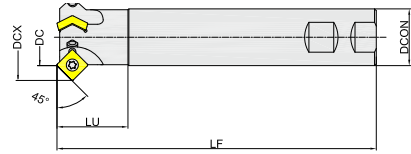


Fig2

Ordering Code	Dia-meter	Teeth	Dimension(mm)					APMX	Suitable for	Coolant	Shape	Stock
			DC	DCX	DCON	LF	LU					
MCA145025R02W25SP09	25	2	25	37	25	120	40	5	SPMT09T3	×	Fig2	●
MCA145032R03W32SP12	32	3	32	49	32	180	40	7	SPMT1204	×	Fig2	●

● Stock ○ Available Upon Order

MCA160

Side Clamp Type

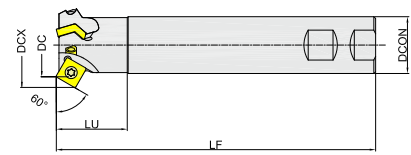

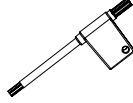


Fig3

Ordering Code	Dia-meter	Teeth	Dimension(mm)					APMX	Suitable for	Coolant	Shape	Stock
			DC	DCX	DCON	LF	LU					
MCA160025R02W25SP09	25	2	25	34	25	120	40	6	SPMT09T3	×	Fig3	●
MCA160036R03W32SP12	36	3	36	48	32	180	40	8	SPMT1204	×	Fig3	●

● Stock ○ Available Upon Order

Spare Parts

Part Name		Inserts Screw	Insert Screw Wrench
Inserts	Shape		
	SPMT09T3		
	Specification	SI60M4.0X8.9-05313S	TT15P
	Ordering Code	SI60M040089-05313S	TT15PQ
	SPMT1204		
	Specification	SI60M5.0X10.8-07209S	TT20P
	Ordering Code	SI60M050108-07209S	TT20PQ

Recommended Cutting Data

	Workpiece	Hardness	Grade	Specification	Cutting Speed Vc(m/min)	Feed Rate/Edges fz(mm)
						Medium Machining(M)
P	Soft Steel	≤ HB180	GA4225 GA4230	SPMT09T3	180 (140-220)	0.2 (0.15-0.25)
				SPMT1204	180 (140-220)	0.25 (0.2-0.3)
	Carbon Steel, Alloy Steel	HB180- 350	GA4225 GA4230 GP2115	SPMT09T3	160 (120-200)	0.2 (0.15-0.25)
				SPMT1204	160 (120-200)	0.25 (0.2-0.3)
	Pre-harden Steel	HRC35-45	GA4230 GA4225 GP2115	SPMT09T3	120 (80-160)	0.15 (0.1-0.2)
				SPMT1204	120 (80-160)	0.2 (0.15-0.25)
M	Stainless (Ferrite, Martensite)	≤ HB270	GM2140 GA4230	SPMT09T3	120 (80-160)	0.15 (0.1-0.2)
				SPMT1204	120 (80-160)	0.2 (0.15-0.25)
	Stainless (Austenite, Diphasic)	≤ HB270	GM2140	SPMT09T3	100 (60-140)	0.15 (0.1-0.2)
				SPMT1204	100 (60-140)	0.2 (0.15-0.25)
K	Grey Cast Iron	≤ HB280	GK2115 GK4125	SPMT09T3	160 (120-200)	0.2 (0.15-0.25)
				SPMT1204	160 (120-200)	0.25 (0.15-0.3)
	Nodular Cast Iron, Vermicular Graphite Cast Iron	≤ HB350	GK4125 GK2115	SPMT09T3	140 (100-180)	0.15 (0.1-0.2)
				SPMT1204	140 (100-180)	0.2 (0.15-0.25)