

CDTooling Milling Insert Application Chart

Cutting Data Application *

Chip Load Per Tooth → .002
1,050 ← Starting S.F.M

Insert Dimensions

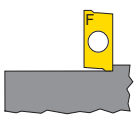
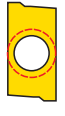
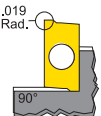

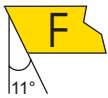
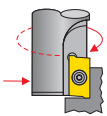
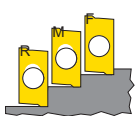
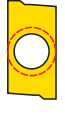
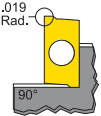


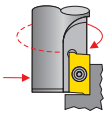


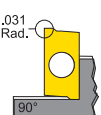


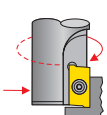
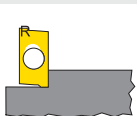

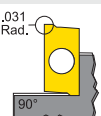


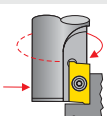
Steel Alloy Steel	Stainless Steel	Cast Iron	Aluminum	High Temp Alloy
P	M	K	K	K

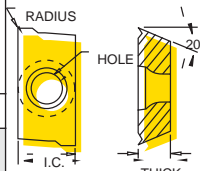
Cutting Application

Operation

Insert Specifications

I.C. Finish	Leading Angle	Chipbreaker	Edge Preparation / Relief Angle	Cutting Direction
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Finishing 	Ground / Polished 	15°, 30°, 45°, 75° & 90° 	Positive 	Sharp 	Right 
Finishing to Roughing 	Ground 	15°, 30°, 45°, 75° & 90° 	Positive 	Honed 	Right 
Finishing to Roughing 	Ground 	15°, 30°, 45°, 75° & 90° 	Positive 	Honed 	Right 
Roughing 	Ground 	15°, 30°, 45°, 75° & 90° 	Positive 	Honed 	Right 



.003 100	.008 1000	.002 1,050	.003 100	.003 180
.008 310	.008 1125	.008 330	.004 2250	.004 80
.007 675	.006 875	.006 875	.006 875	.004 120
.005 970	.004 480	.004 480	.004 425	.008 310
.008 310	.008 310	.008 330	.006 875	.004 120
.007 675	.008 475	.006 875	.004 480	.008 310
.005 970	.004 480	.006 875	.004 480	.008 475
.007 675	.008 475	.008 330	.004 480	.008 475
.005 970	.004 480	.008 330	.004 480	.008 475

* When setting initial cutting conditions, consider the following:

Suggested starting conditions are based on a .100 axial depth of cut. Cutting speed should be adjusted for a greater or lesser depth.