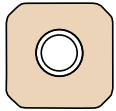




Eco line

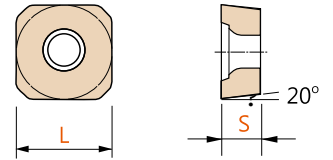
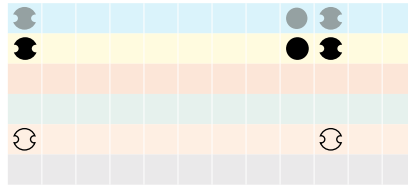


Square 90°

SEET 12

Milling Inserts

P	Steel
M	Stainless steel
K	Cast iron
N	Non-ferrous metal
S	Heat resistant alloy
H	Hardened steel



Size	L	S	d <sub>1</sub>
12T3	13.4	3.97	4.1

1G

Face milling

Medium

SEET 12T3-NM

Roughing

SEET 12T3-NR

	RE	MT-CVD			PVD			Ap (mm)			
		·	·	·	·	·	·				
		KM 8025				KM 2405	-	+			

Feed rate per tooth fz ( mm / tooth )

Grade	Condition	P	M	K	N	S	H
All	Stable	0.10 - 0.24	0.08 - 0.18	0.12 - 0.30	0.12 - 0.30		
	Unstable	0.10 - 0.20	0.08 - 0.15	0.12 - 0.25	0.12 - 0.25		
	Very unstable	0.10 - 0.12	0.08 - 0.09	0.12 - 0.15	0.12 - 0.15		

Cutting speed Vc ( m / min )

Grade	Working conditions	P			M			K			N			S	H
		P1	P2	P3	M1	M2	M3	K1	K2	K3	N1	N2	N3		
KM 8025	Stable	300	235	175											
	Unstable	280	210	160											
	Very unstable	260	185	140											
KM 2405	Stable	260	200	135	150	120	95	240	200	175					
	Unstable	225	170	120	140	105	80	215	185	155					
	Very unstable	195	145	95	130	95	70	185	160	135					
KM 2415	Stable	235	180	120	140	110	85	215	180	160					
	Unstable	200	155	105	130	95	72	190	165	140					
	Very unstable	175	130	85	120	85	63	165	145	125					
KM 10F	Stable										300	270	235		
	Unstable										255	230	200		
	Very unstable										225	200	175		