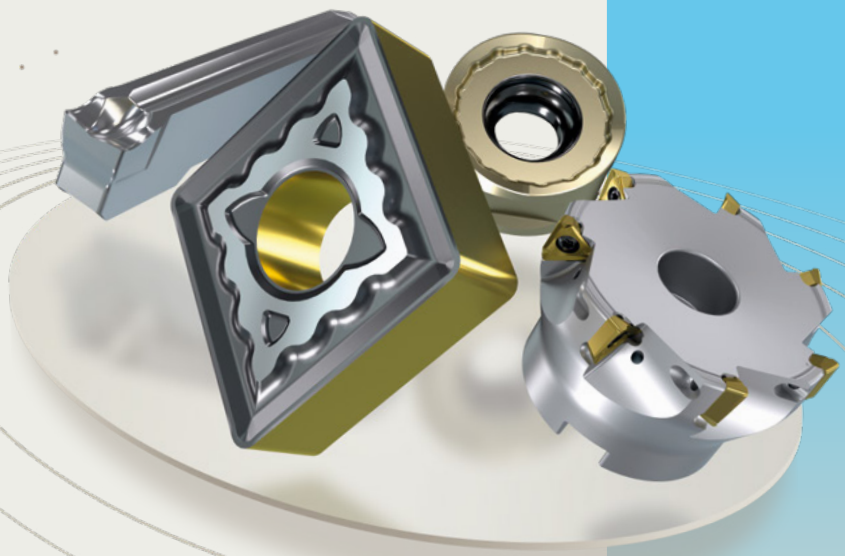
DORMER PRAMET™

New products 2025



Certainty at every turn™

dormerpramet.com

Foreword

Dear readers,

It is with great pride and excitement that I introduce you to our new products 2025. These offerings represent not only our latest technological advancements but also the unified strength of Dormer Pramet as a master brand.
It marks the beginning of a new era where our collective capabilities come together to deliver innovative, sustainable, and customer-focused solutions. At Dormer Pramet, our strength lies in our unity. By combining the expertise, heritage, and resources of our global teams under one cohesive brand, we are better equipped than ever to meet the challenges of today's dynamic marketplace.
This synergy enables us to provide unmatched reliability, innovation, and value for our customers - embodying our promise of **Certainty at every turn.**

With our new products 2025, we are here to help you go beyond limits. We introduce you to untapped performance potential and empower you to optimize productivity like never before. Tools such as the T5415 grade with the new KM chipbreaker are designed to elevate your operations, providing the precision and reliability needed to break through challenges and exceed expectations.

Dormer Pramet is more than just a name - it's a promise. A promise that we will continue to grow stronger together, innovate together, and achieve more together.

As you explore this brochure, I invite you to discover how our unified brand and new product portfolio will transform your operations and elevate your success.

Together, we are better.

Warm regards,
Eduardo Martin
President, Dormer Pramet

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New turning products

T5415 grade 8

KM chipbreaker 26

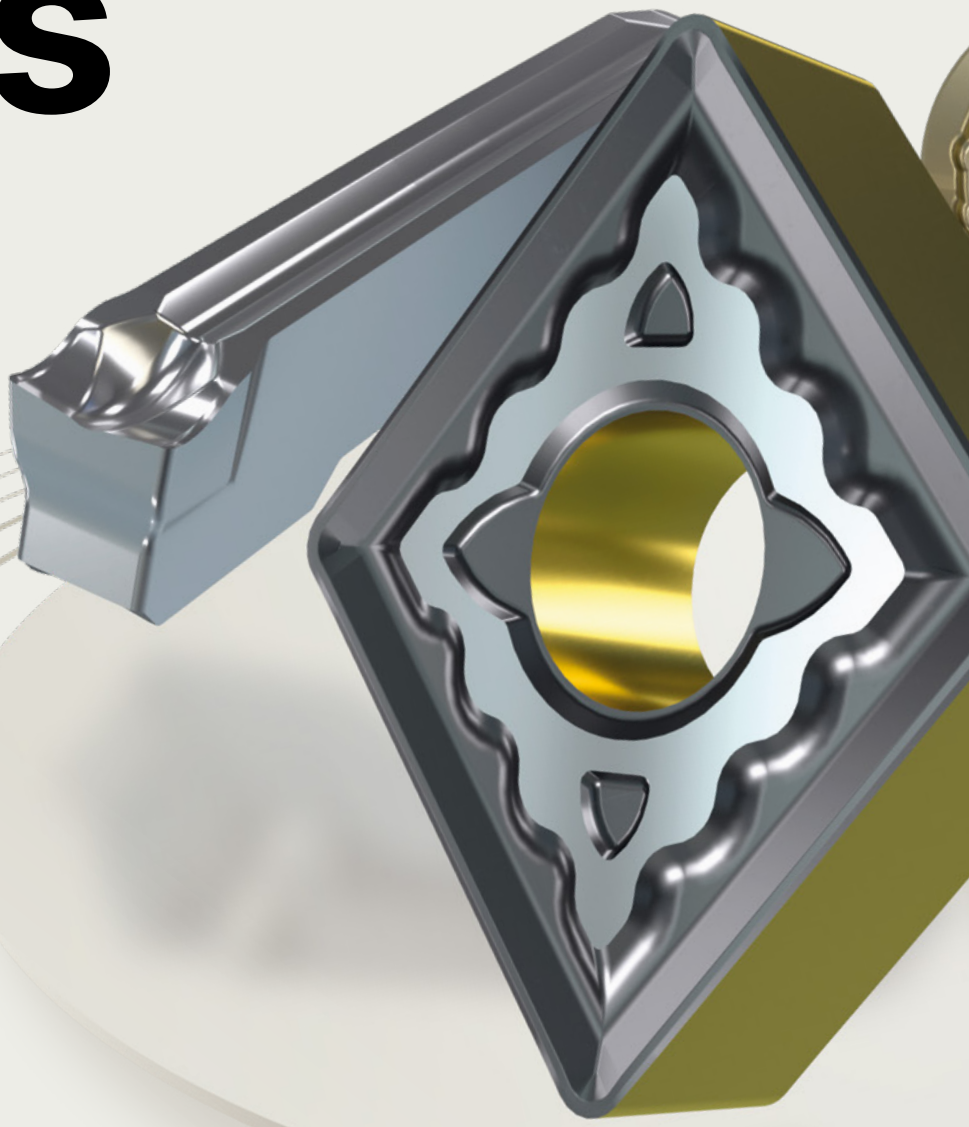
GL inserts 46

New milling products

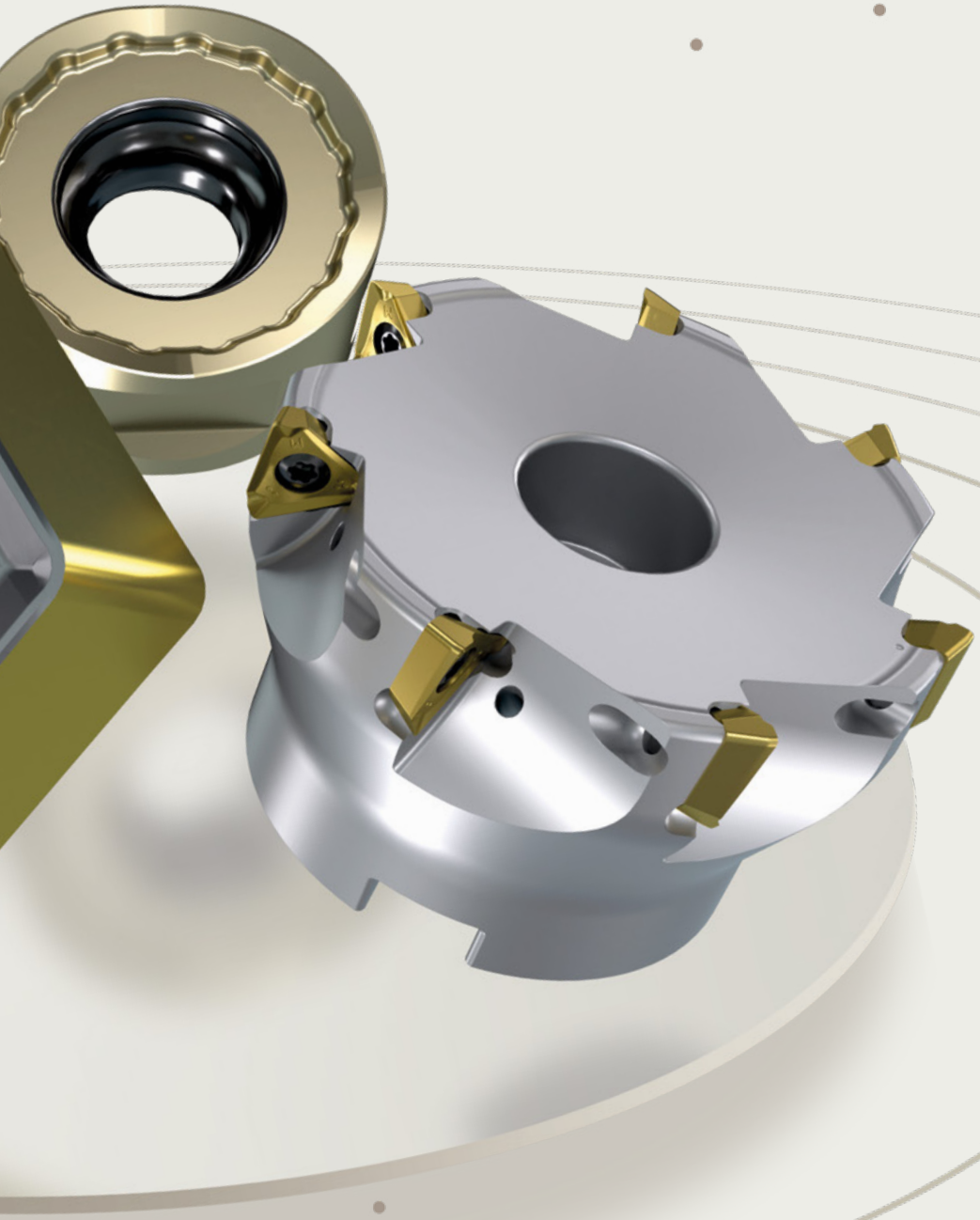
STD series 54

SRN series 66

Go beyond limits



Maximize productivity with our new high-performance indexable tools



Sustainability

Building a sustainable future together

For Dormer Pramet, sustainability isn't a challenge – it's an opportunity. But it's not something we can tackle alone.

Together with our customers, partners, and communities, we are navigating this journey, innovating, learning, and growing as one team.
Together, we can make a meaningful impact.
Our approach is simple: we're in this together.

Facing challenges, providing solutions

Our commitment to the planet and your business is grounded in five key pillars that drive every decision we make.

1. Circularity

We will ensure at least 90% material circularity for waste, products, and packaging.
With new customer projects, our focus will be on material and resource efficiency with new models designed for reuse and recycling.

2. CO_2 reduction

We will cut our 2016 to 2018 CO_2 emissions in half by 2030.
Our team systematically work on environmental improvement projects aimed at reducing our electricity consumption, which includes the use of solar panels.

3. Zero harm

We regularly raise health and safety awareness for our employees through workshops, nano learnings, and annual Safety Day celebrations.
By 2030, we want to halve our Total Recordable Injury Frequency Rate (TRIFR) recorded between 2016 and 2018.

Sustainability at the core of every tool

We know that making a sustainable choice isn't just about doing the right thing. It's about doing what's right for the business, too. Our tools are built to last longer, work harder, and be more efficient, helping you reduce your environmental footprint and improve your performance at the same time.

Longer tool life, less waste:

Our products are engineered for durability, meaning fewer replacements, less waste, and more value in the long run.
That's sustainability in action – keeping tools in circulation longer and conserving precious resources.

Reduced energy consumption, increased productivity:

We make products that help our customers use less energy while doing more.
With reduced cutting forces and enhanced productivity, we make your operation more efficient and eco-friendly.

4. Carbide recycling

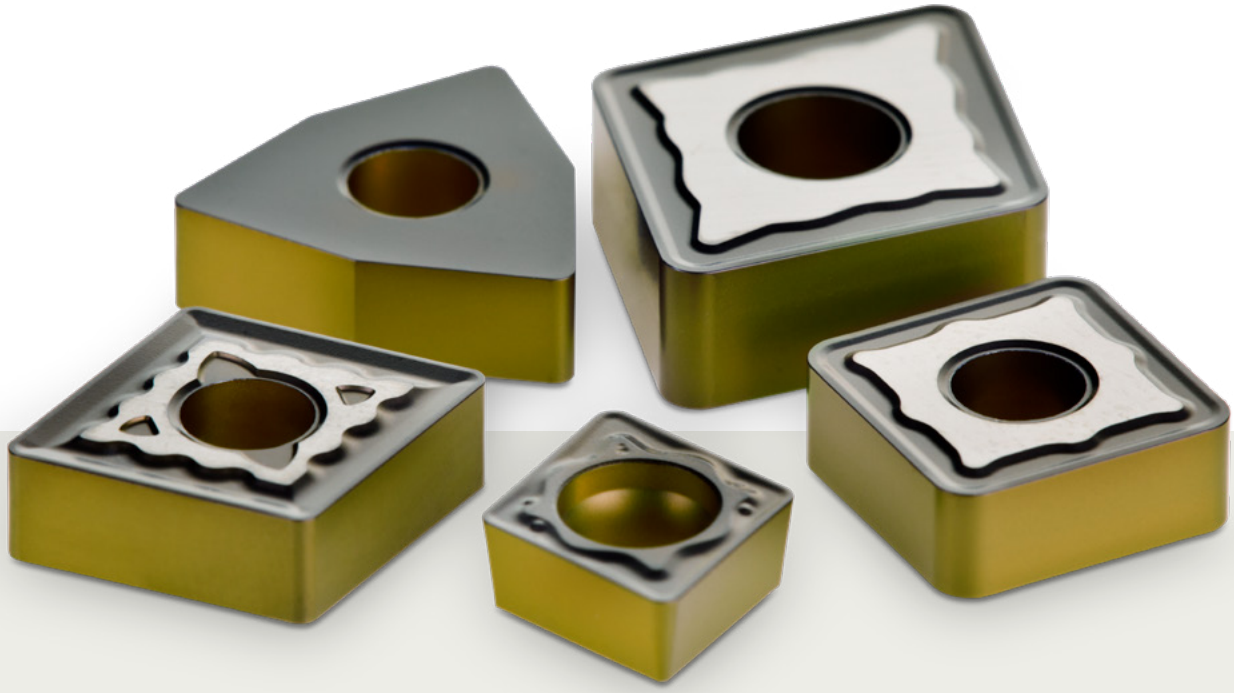
Our carbide recycling scheme allows customers to turn used carbide into cash. We provide free boxes for collecting carbide, pick up the box when it's full, and pay you the market price for how much you've collected. We'll then recycle the used carbide into new tools.

5. Packaging

Since switching to post-consumer recycled material in 2023, around 95% of products that leave our São Paulo production unit are packaged with recycled plastic. To date, we've recycled over 100 tons of original plastic and lowered our CO_2 emissions in São Paulo by 6.7%.

New unique CVD grade for nodular cast iron

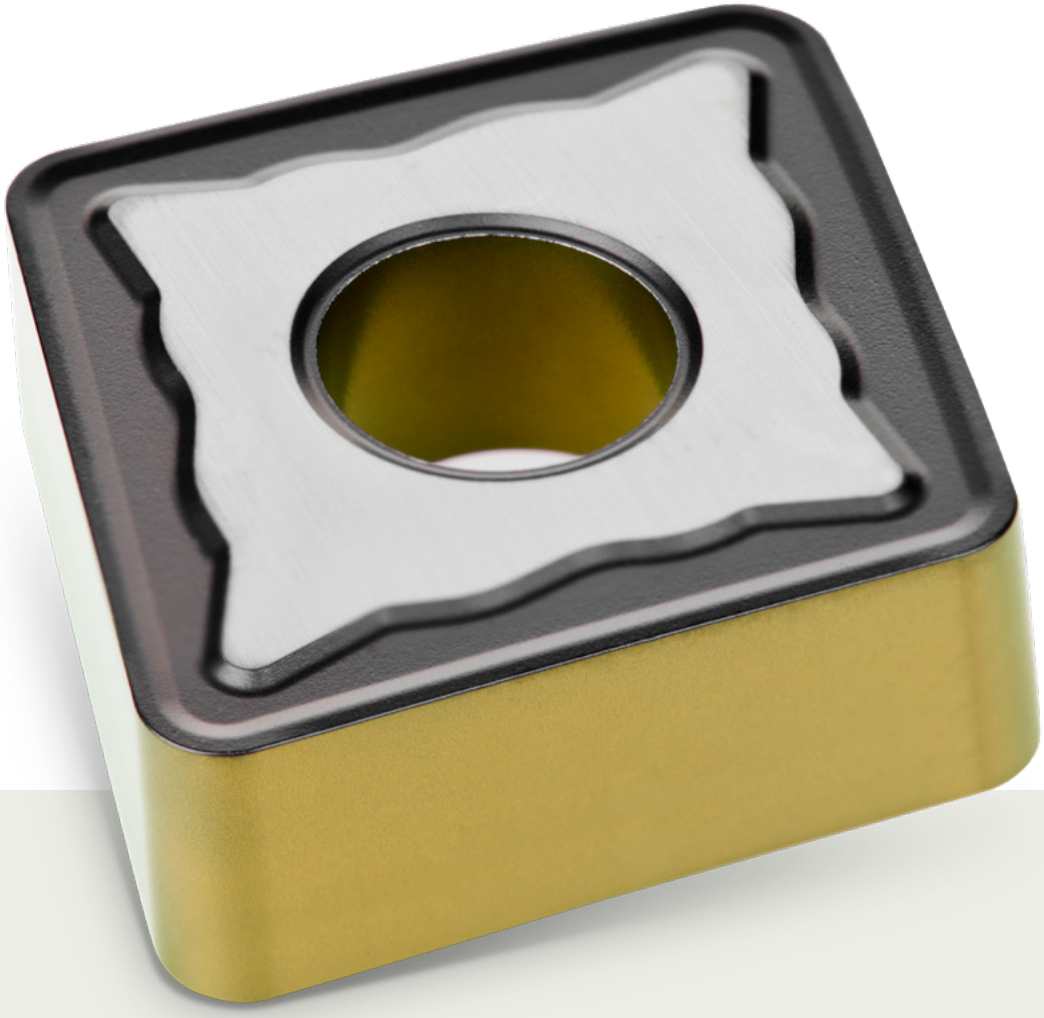
Productivity redefined for high-performance turning



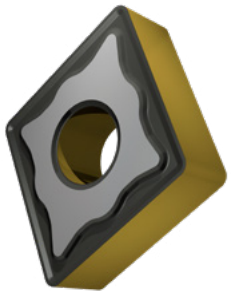
The T5415 sets a new standard in efficient, reliable turning for nodular cast iron and H-group materials. This advanced CVD grade offers exceptional stability and durability, especially in interrupted cuts, for consistent performance across all conditions.

With its next-gen coating and TiN-coated flanks for better wear detection, the T5415 is the first choice for demanding applications.

Related products



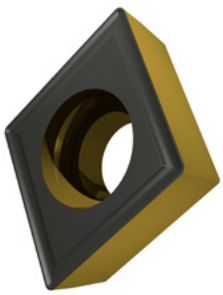
T5415



Negative inserts

Nodular cast iron
and H-group materials

T5415



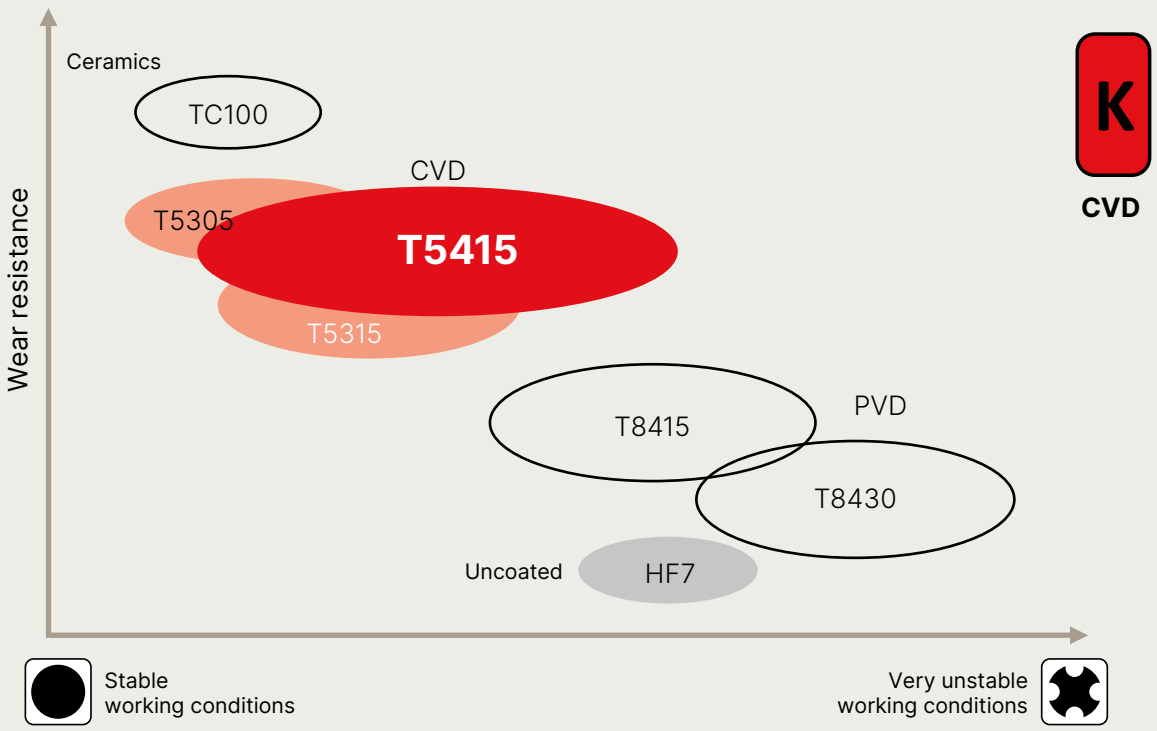
Positive inserts

Nodular cast iron
and H-group materials

Features and benefits

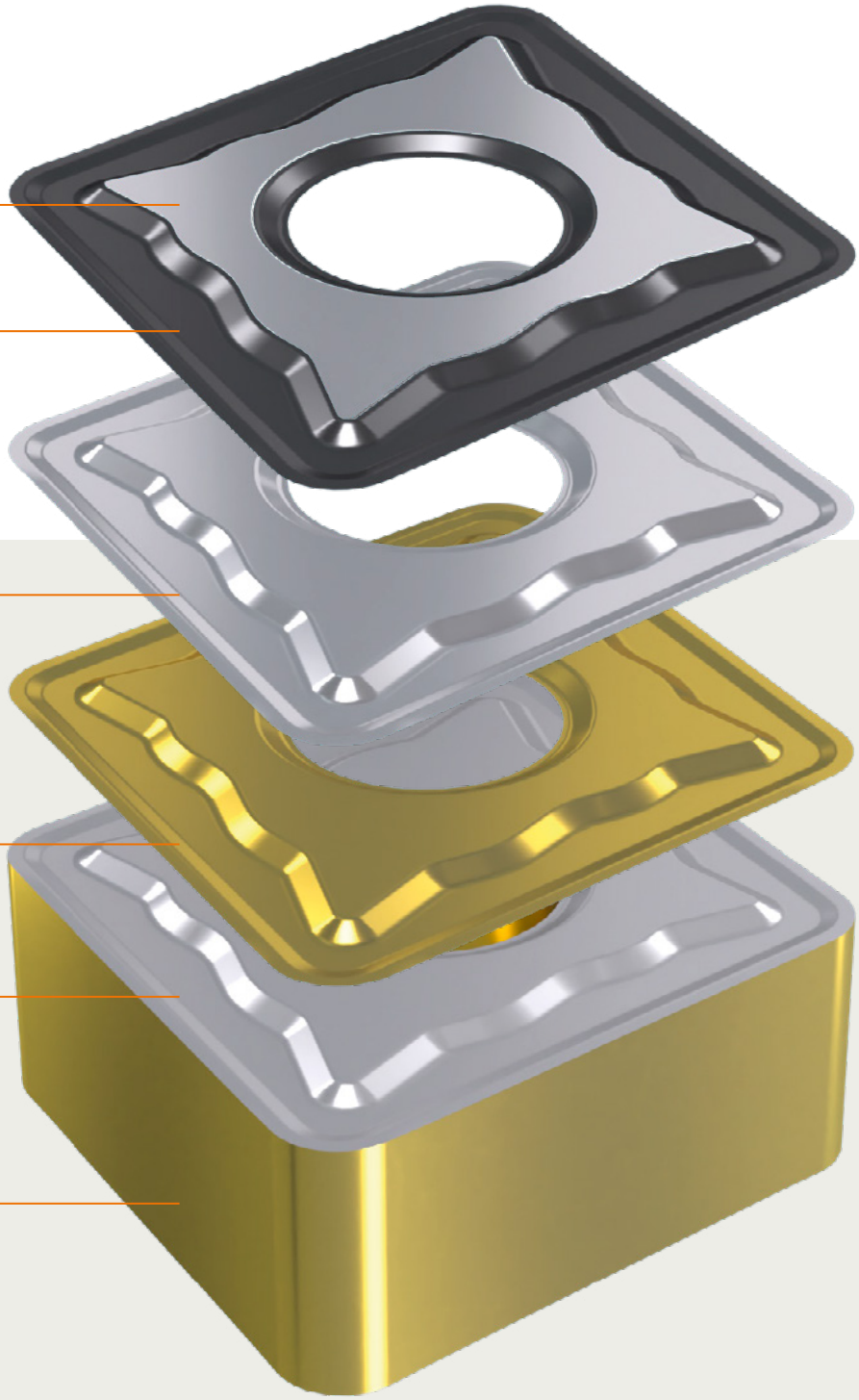
Thick MT-CVD coating layer enhances resistance to flank wear, crater wear, and plastic deformation.	**Extended tool life** significantly increases productivity.
The α-Al_2O_3 coating provides superior wear resistance and thermal stability.	**Precise cutting performance** improves efficiency in demanding operations.
New post-treatment process improves stability of cutting edge.	**Enhanced reliability** especially in unstable conditions.
Ground seating face provides larger contact area and optimizes heat transfer.	**Improved seating stability** ensures consistent high-quality performance.
Gold colored TiN coating on flanks helps with monitoring tool condition effectively.	**Easier wear detection** reduces downtime.

Application area of MT-CVD turning grades



Grade composition

30% thicker coating for enhanced durability



Machining examples

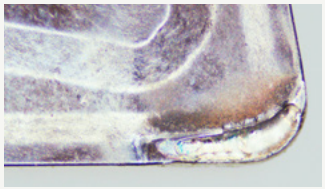
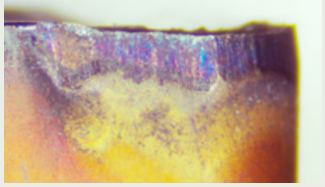
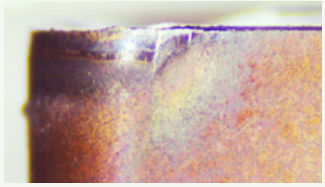
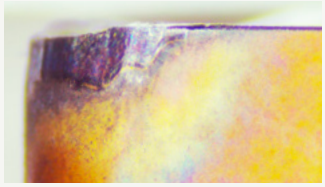
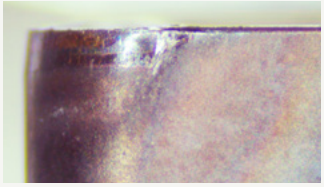
Superior performance for nodular cast iron machining

T5415 sets a new benchmark in nodular cast iron machining, offering up to 90% longer tool life than competitors. With 23.3 minutes of continual turning, it reduces downtime, lowers tool changes, and boosts productivity, making it ideal for demanding industrial applications.

Machining:	Continuous cut
Application:	Turning
Material:	EN-GJS-500-7 (165 HB)
Coolant:	No

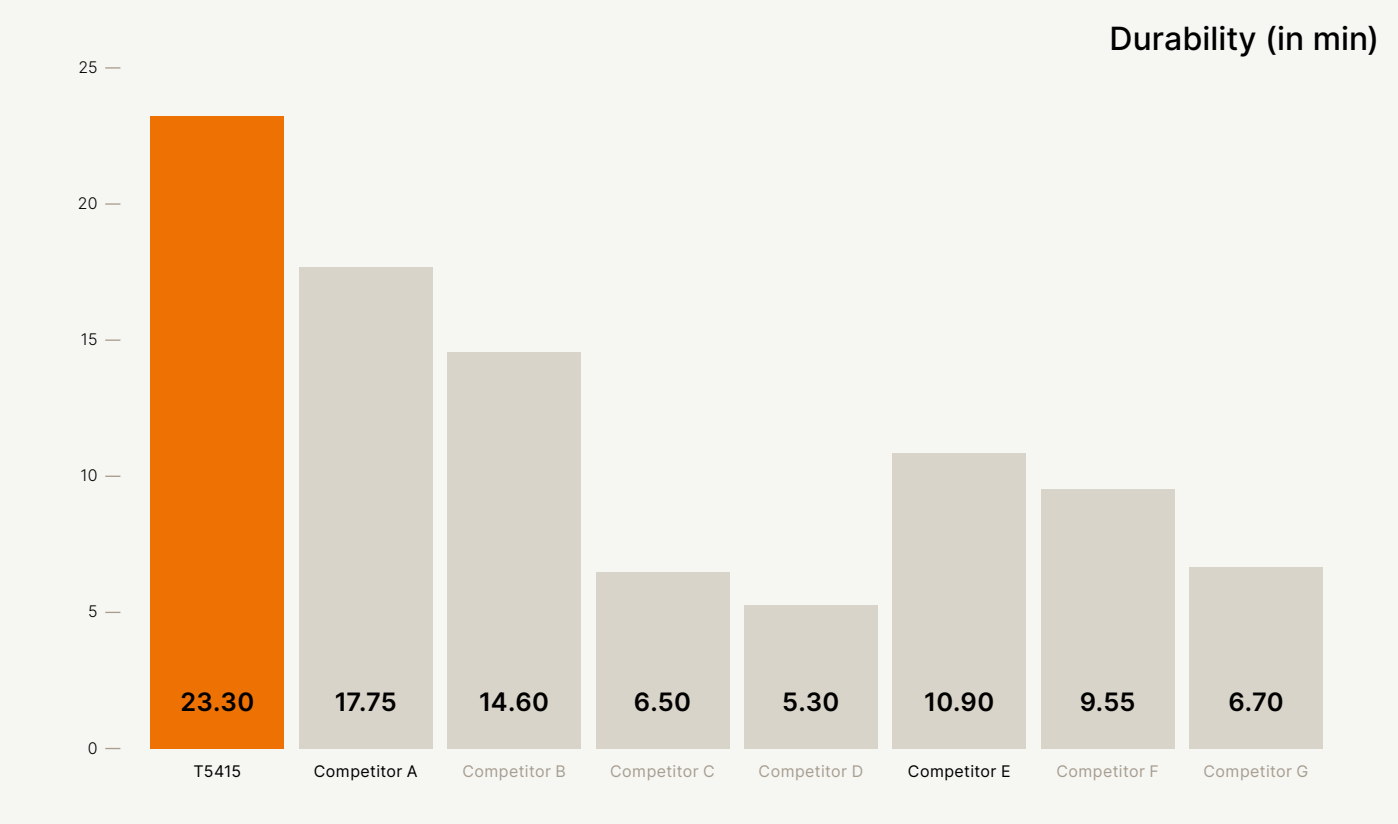
Dormer Pramet solution:		
CNMG 120408-KM		
Machining data:		
v_c	f_n	a_p
300	0.20	2.00

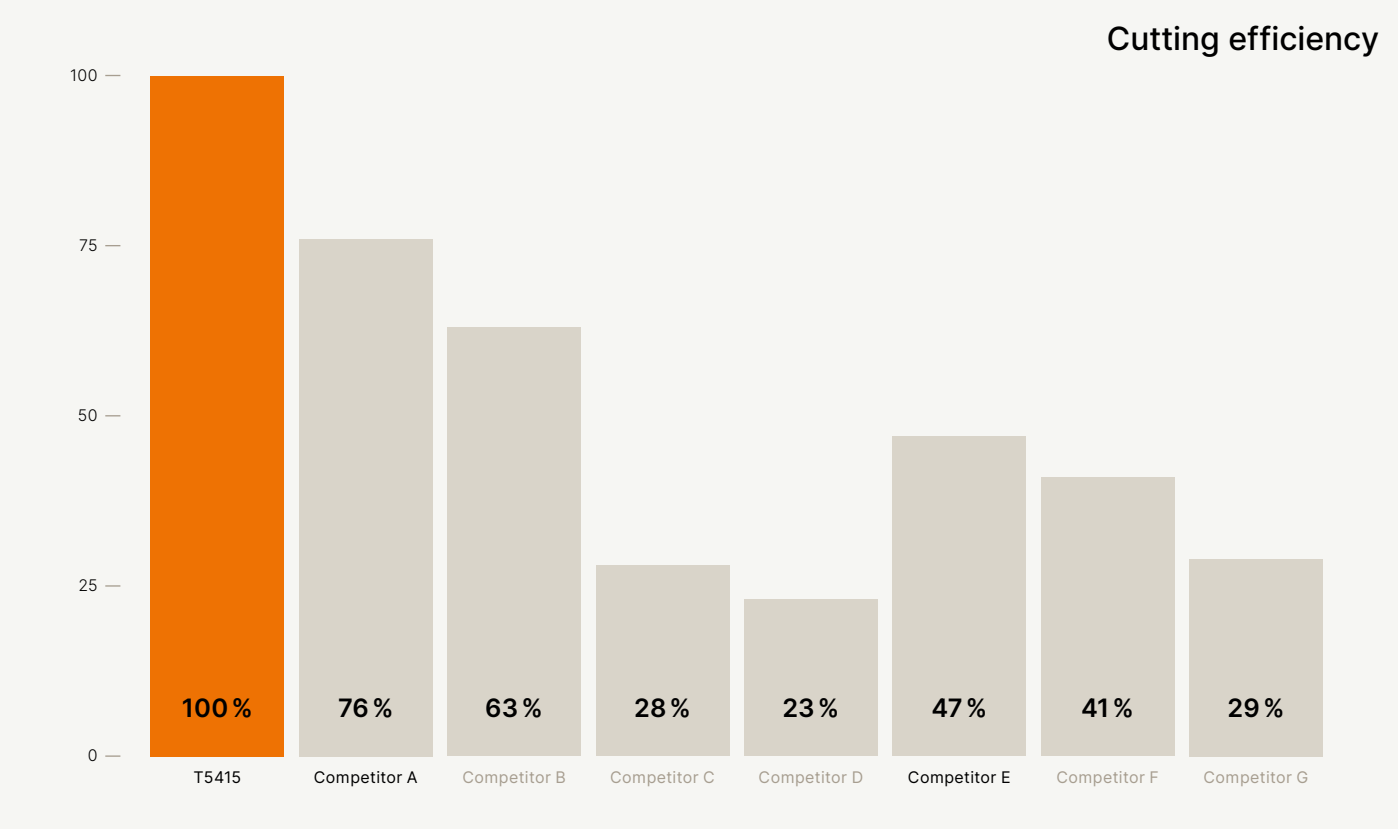
WMG K3.1

T5415	Competitor A	Competitor E
		
		
		
Photos from T5415. All taken after 20 minutes.	Photos from Competitor A. All taken after 20 minutes.	Photos from Competitor E. All taken after 10 minutes.

v_c = cutting speed (m/min), f_n = feed per revolution (mm/rev), a_p = axial depth of cut (mm)

Machining examples





Machining examples

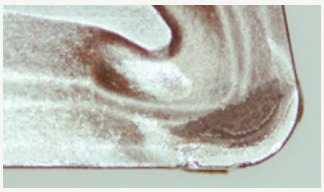
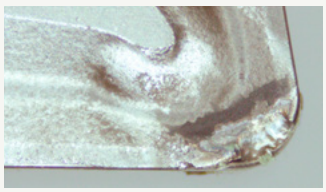
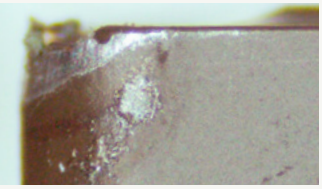
Optimized grade for maximum performance and efficiency

We’ve improved durability and efficiency with our new T5415 grade – offering more than two times longer tool life and 123% better cutting efficiency compared to the previous grade. Upgrade today for optimized productivity and reduced downtime.

Machining:	Continuous cut
Application:	Turning
Material:	X37CrMoV5-1 (53 HRC)
Coolant:	No

Dormer Pramet solution:		
CNMG 120408-KM		
Machining data:		
v_c	f_n	a_p
70	0.22	1.50

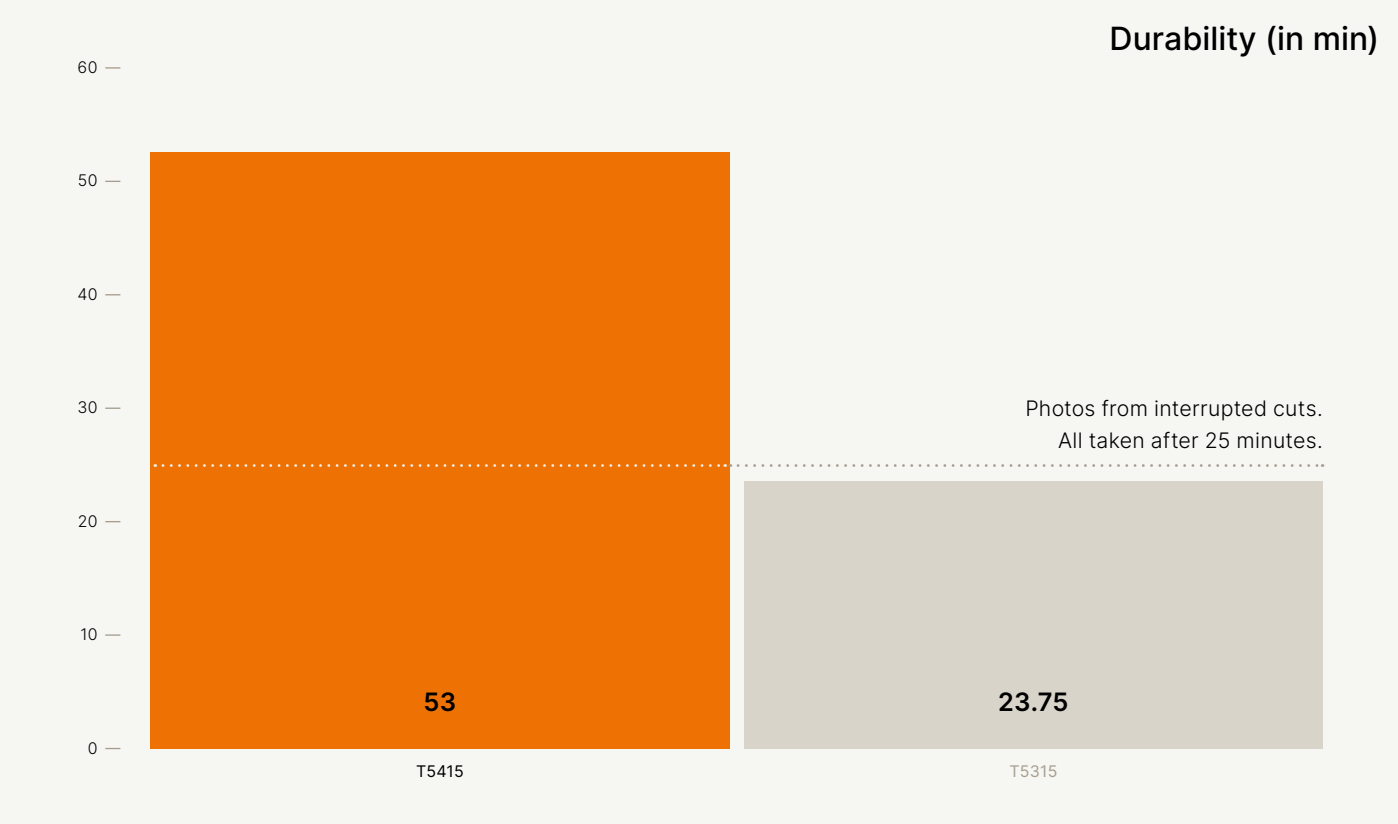
WMG H3.2

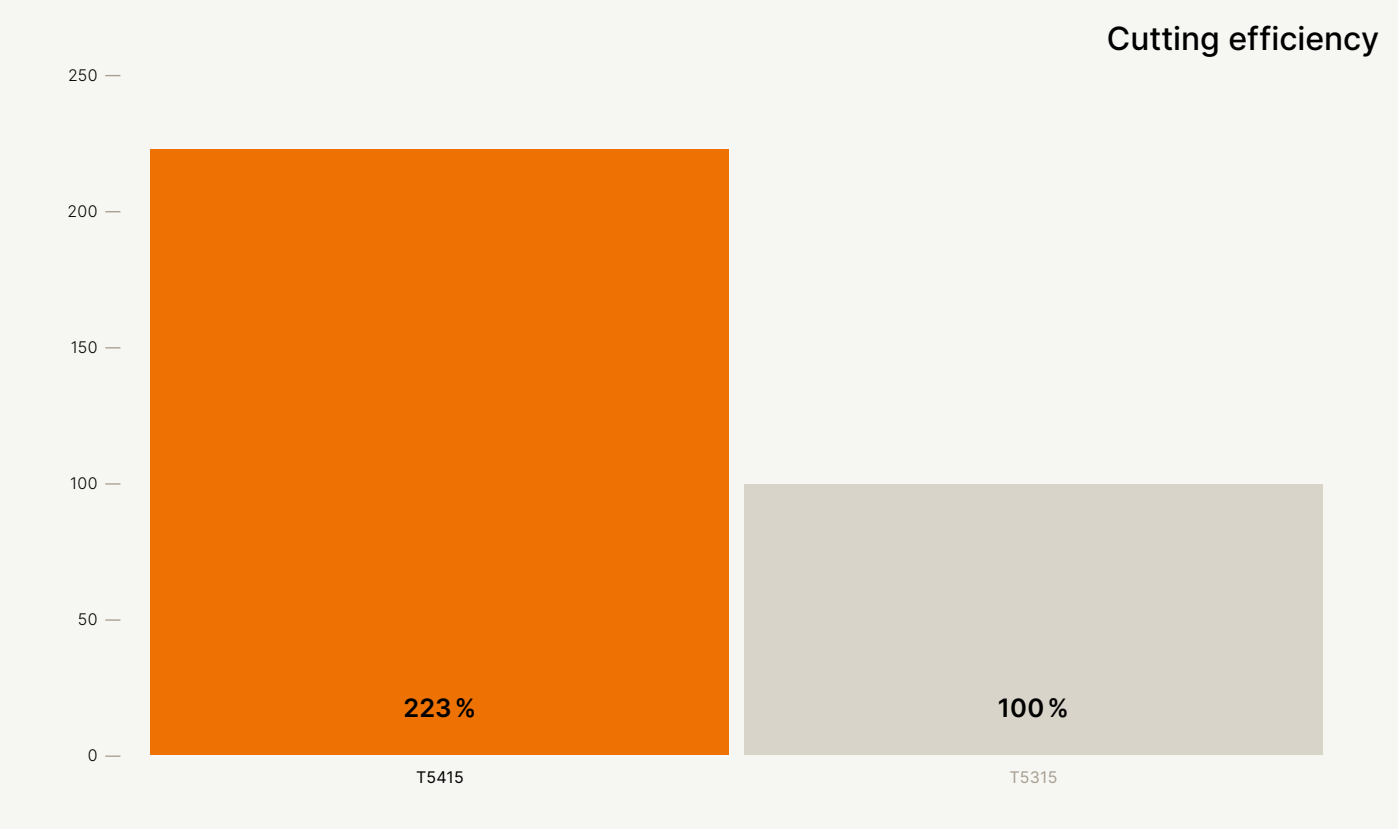
T5415	T5315
	
	

Photos from continuous cutting. All taken after 25 minutes.

v_c = cutting speed (m/min), f_n = feed per revolution (mm/rev), a_p = axial depth of cut (mm)

Machining examples





Machining examples

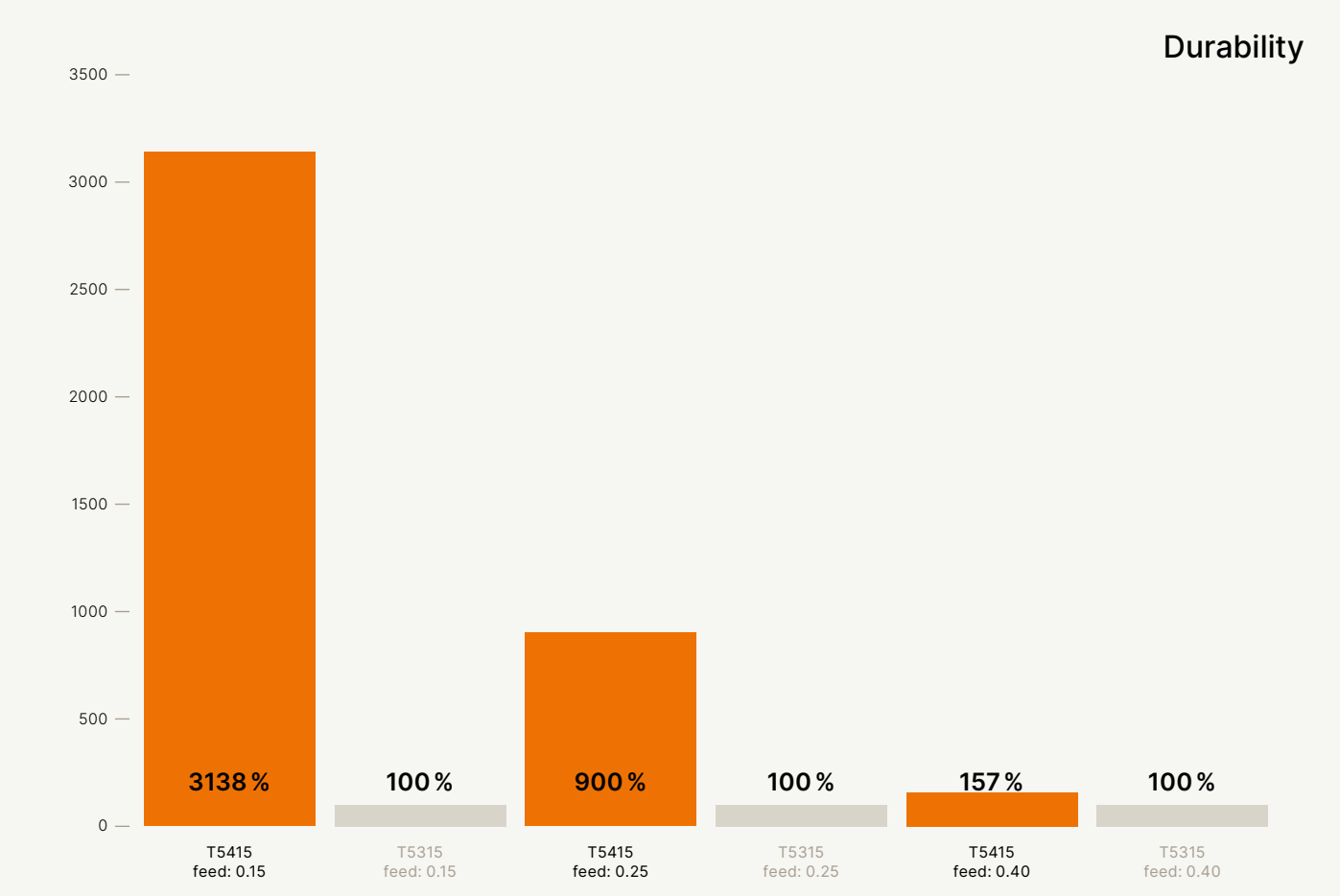
Enhanced efficiency for interrupted cuts

T5415 excels in unstable cutting conditions, thanks to its advanced post-treatment technology, ensuring unmatched reliability and durability.

Machining:	Interrupted cut
Application:	Turning
Material:	37Cr4
Coolant:	No

Dormer Pramet solution:		
CNMG 120408-KM		
Machining data:		
v_c	f_n	a_p
100	0.15	1.00
100	0.25	1.00
100	0.40	1.00

WMG P3.2

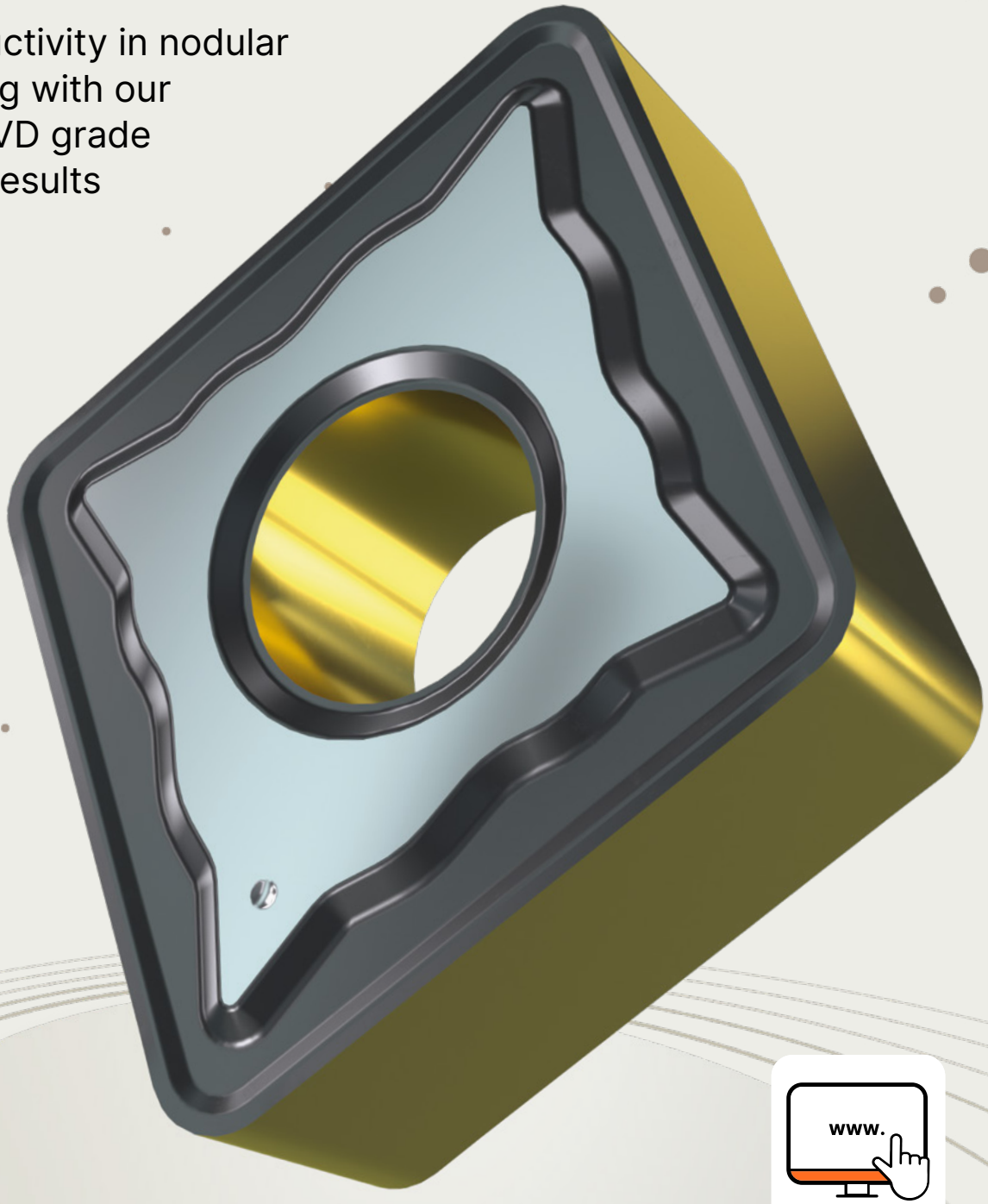


v_c = cutting speed (m/min), f_n = feed per revolution (mm/rev), a_p = axial depth of cut (mm)

T5415

Cut further. And further.

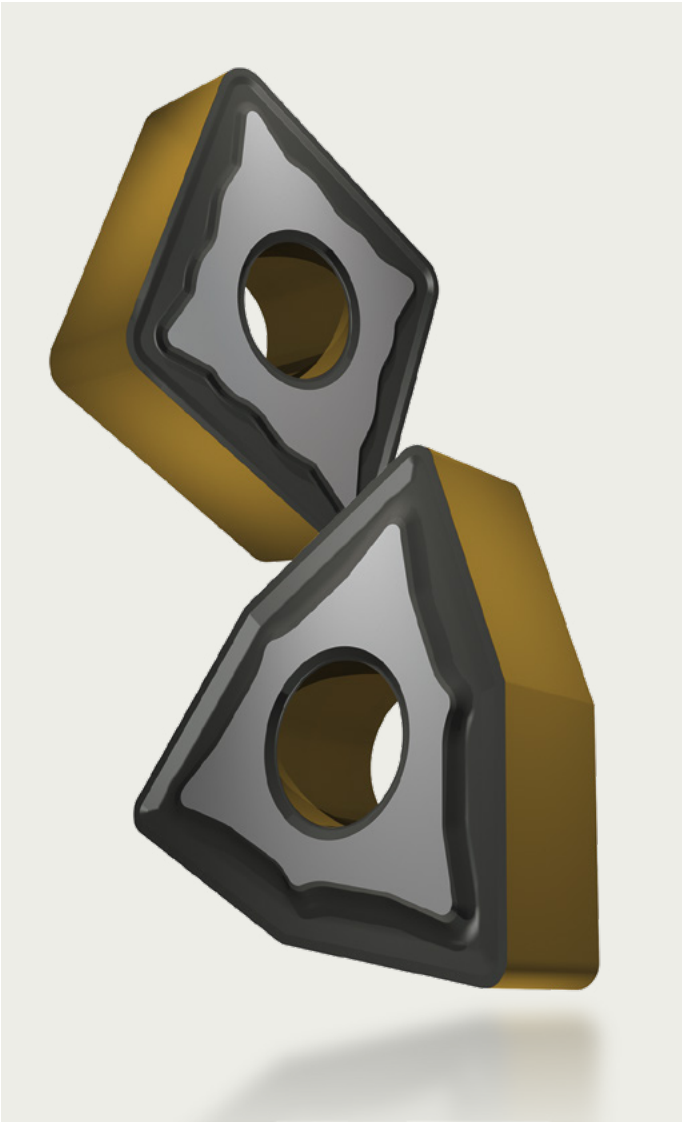
Optimize productivity in nodular cast iron turning with our new durable CVD grade for consistent results



Success stories

Boost durability by **87.5%** for roughing and **57%** for finishing operations

Customer result: The T5415 grade delivered unmatched efficiency in critical applications. For internal roughing with interrupted cutting, it boosted durabilty by 87.5%, adding seven extra workpieces. In finishing operations, it increased output by 57%, achieving 33 workpieces versus 21 with standard tools.



Segment:	Metalworking and precision engineering
Application:	Internal roughing with interrupted cutting and finishing
Material:	EN-GJS-400-15
Coolant:	Yes

Dormer Pramet solution:		
CNMG 160616E-KR:T5415 (for roughing) WNMG080408E-KR T5415 (for finishing)		
Machining data:		
v_c	f_n	a_p
190 / 220	0.35 / 0.25	5 / 0.5

WMG K3.2

v_c = cutting speed (m/min), f_n = feed per revolution (mm/rev), a_p = axial depth of cut (mm)

Success stories

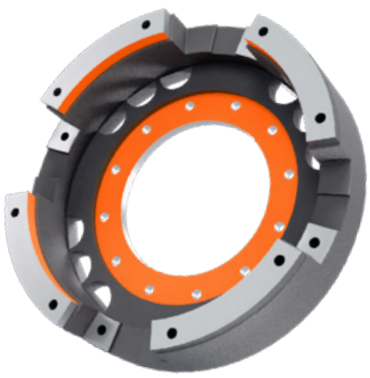
Achieve **100%** more productivity

Customer result: The tool showed strong durability during the interrupted cut and delivered consistent performance in uninterrupted cuts.
Overall, our customer noted a remarkable 100% increase in productivity and achieved high surface quality, demonstrating the tool's efficiency in machining automotive cast iron parts.

Segment:	Automotive
Application:	Interrupted cut
Material:	EN-GJS-400-15
Coolant:	No

Dormer Pramet solution:		
WNMG 080408E-KR:T5415		
Machining data:		
v_c	f_n	a_p
294	0.50	1.50

WMG K3.2



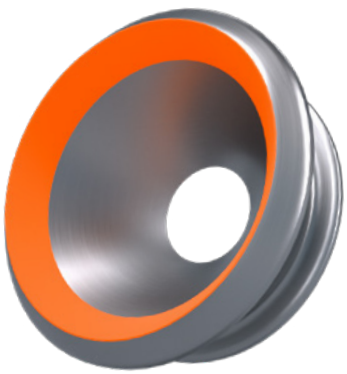
Increase durability by **50%** in demanding applications

Customer result: Customer noticed nearly 50% better wear resistance, completing almost three passes where the previous grade managed only two. This remarkable improvement leads to longer tool life, reduced downtime, and increased efficiency in demanding applications.

Segment:	Producer of machines
Application:	Heavy roughing
Material:	Nodular cast iron
Coolant:	No

Dormer Pramet solution:		
SNMA 250924S:T5415		
Machining data:		
v_c	f_n	a_p
30	1.40	5

WMG K3.3



v_c = cutting speed (m/min), f_n = feed per revolution (mm/rev), a_p = axial depth of cut (mm)

Success stories

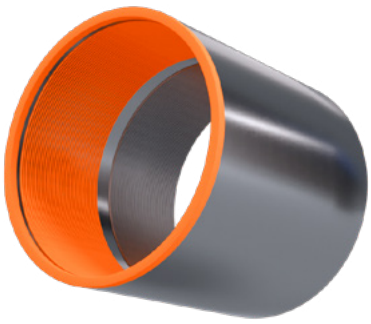
Enhance tool life by **33%** and cut costs by **4.9%**

Customer result: T5415 improved productivity by 7.39%, extended tool life by 33%, and reduced machining costs by 4.9%, offering better efficiency and cost savings compared to the previous tool. It's a reliable choice for optimizing performance and reducing expenses in demanding applications.

Segment:	General engineering
Application:	Roughing
Material:	EN-GJS-500-7 (170HB-210HB)
Coolant:	Yes

Dormer Pramet solution:		
WNMG 080408E-KR:T5415		
Machining data:		
v_c	f_n	a_p
220	0.35	3

WMG K3.2



Spend **33%** less time on tool changes

Customer result: T5415 with KM chipbreaker provided 33% longer tool life compared to competing tools. This resulted in fewer tool changes and more uptime. Achieve consistent performance and reliable finishes with this durable solution for roughing and finishing.

Segment:	Injection model machining
Application:	Roughing & finishing
Material:	EN-GJS-500-7 (180-210 HB)
Coolant:	Yes

Dormer Pramet solution:		
WNMG 080408-KM:T5415		
Machining data:		
v_c	f_n	a_p
215	0.30	2

WMG K3.2

v_c = cutting speed (m/min), f_n = feed per revolution (mm/rev), a_p = axial depth of cut (mm)

Success stories

Increase productivity with **53%** longer tool life

Customer result: T5415 with KM chipbreaker delivered 53% longer tool life and maintained consistent productivity in rough turning of cast iron. Choose this reliable solution for reduced costs and enhanced efficiency.

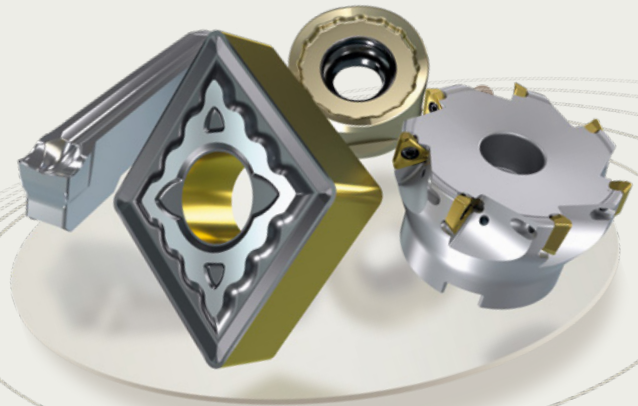
Segment:	Automotive
Application:	Roughing
Material:	EN-GJS-500-7
Coolant:	Yes

Dormer Pramet solution:		
WNMG 080412-KM:T5415		
Machining data:		
v_c	f_n	a_p
605	0.25	2.50

WMG K3.2

Go beyond limits

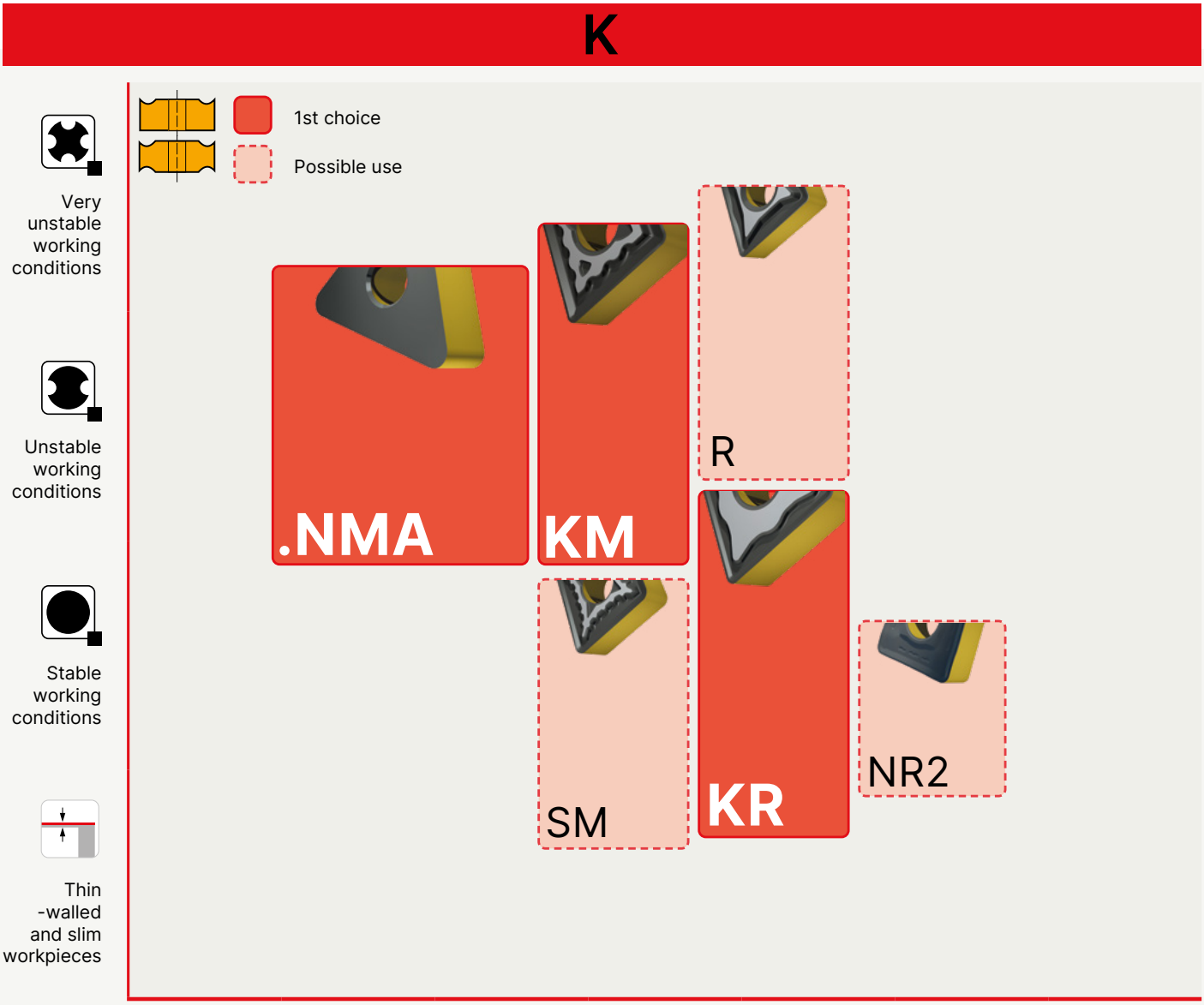
Maximize productivity with our new high-performance indexable tools



v_c = cutting speed (m/min), f_n = feed per revolution (mm/rev), a_p = axial depth of cut (mm)

Technical information

Chipbreakers for negative T5415 inserts



	FF	F	M	R	HR
f	0.05 – 0.2 mm/rev	0.05 – 0.2 mm/rev	0.2 – 0.4 mm/rev	0.4 – 1.0 mm/rev	> 1.0 mm/rev
a_p	0.05 – 2 mm	0.05 – 2 mm	2 – 4 mm	4 – 10 mm	> 10 mm

Technical information

Chipbreakers for positive T5415 inserts

K

Very unstable working conditions

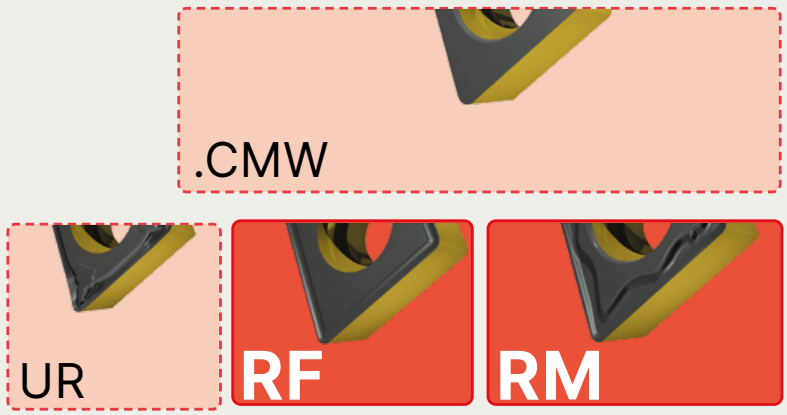
Unstable working conditions

Stable working conditions

Thin -walled and slim workpieces

1st choice

Possible use



FF	F	M	R	HR
0.05 – 0.2 mm/rev	0.05 – 0.2 mm/rev	0.2 – 0.4 mm/rev	0.4 – 1.0 mm/rev	> 1.0 mm/rev
0.05 – 2 mm	0.05 – 2 mm	2 – 4 mm	4 – 10 mm	> 10 mm

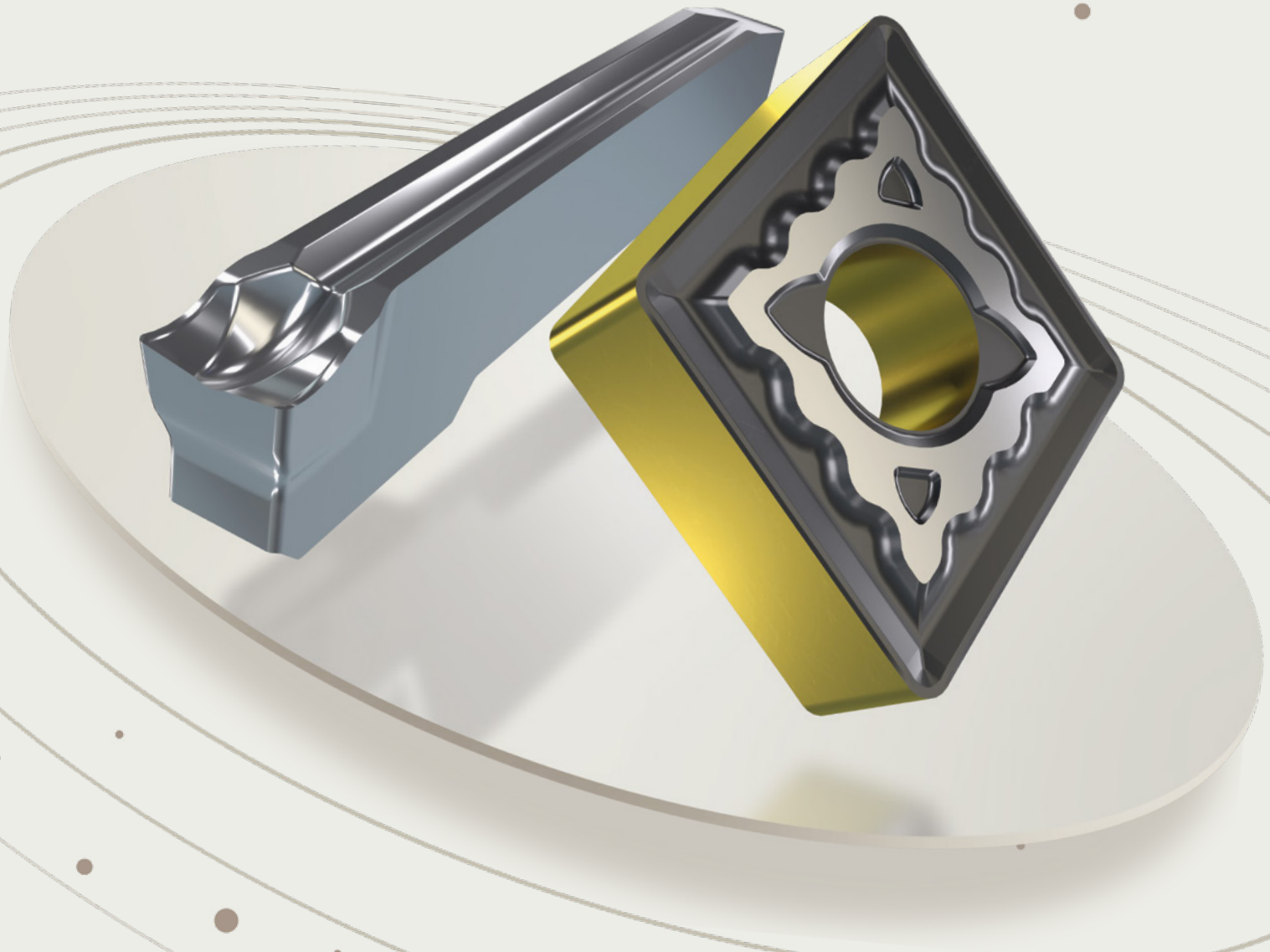
Technical information

Grade identification	Area of application	Application	Feed	Cutting speed	Resistance to adverse working conditions	Coating	Color	Substrate	Coolant benefit	Grade description
T5415	P10 - P25	◪				MT-CVD		H	++	Highly productive grade designed primarily for turning of nodular cast iron, as well as for machining of hardened and tempered materials. It can be also used for turning common carbon and alloy steels with higher strength and hardness. Despite its high abrasion resistance, it is also suitable for operations with unstable cutting conditions due to new post-treatment method. We recommend this material as the first choice for most turning operations, especially in the field of highly productive production.
	K10 - K25	■								
	H15 -H25	■								

New turning products

Level up.

Boost productivity with the tool of your choice



New chipbreaker for turning of cast iron

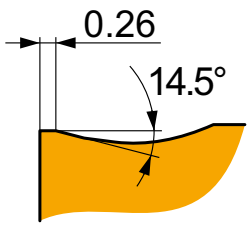
Elevate your turning performance

The new KM chipbreaker is specially engineered for cast iron (ISO K group materials) and is the go-to solution for medium turning applications. It features a stable, wide T-land and a slightly positive rake angle for smooth, consistent cuts.

Paired with the T5415 grade this combination brings stability and reliability, delivering exceptional productivity, performance, and process reliability in every operation.

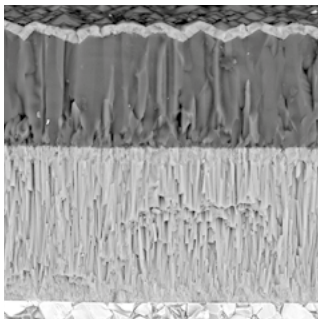
Related products

KM



Designed for medium and semi-rough machining, cast irons, potentially steel and hard materials, continuous and interrupted cuts.

T5415

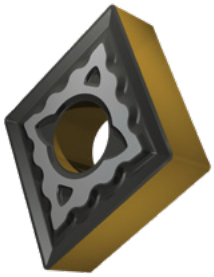


MT-CVD grade

Thick TiCN and Al_2O_3

Abrasion resistance

CNMG-KM

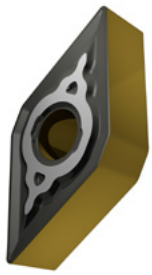


Productive insert

K materials

Medium to semi-rough cuts

DNMG-KM

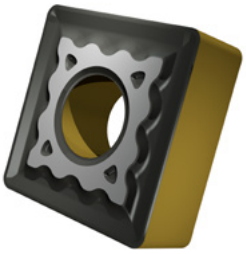


Versatile insert

K materials

Light to semi-rough cuts

SNMG-KM

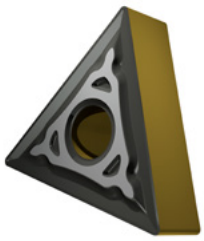


Semi-roughing insert

K materials

Medium to semi-rough cuts

TNMG-KM



Economical insert

K materials

Light to medium cuts

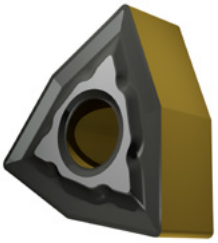
VNMG-KM

Versatile insert

K materials

Light to medium cuts

WNMG-KM



Versatile insert

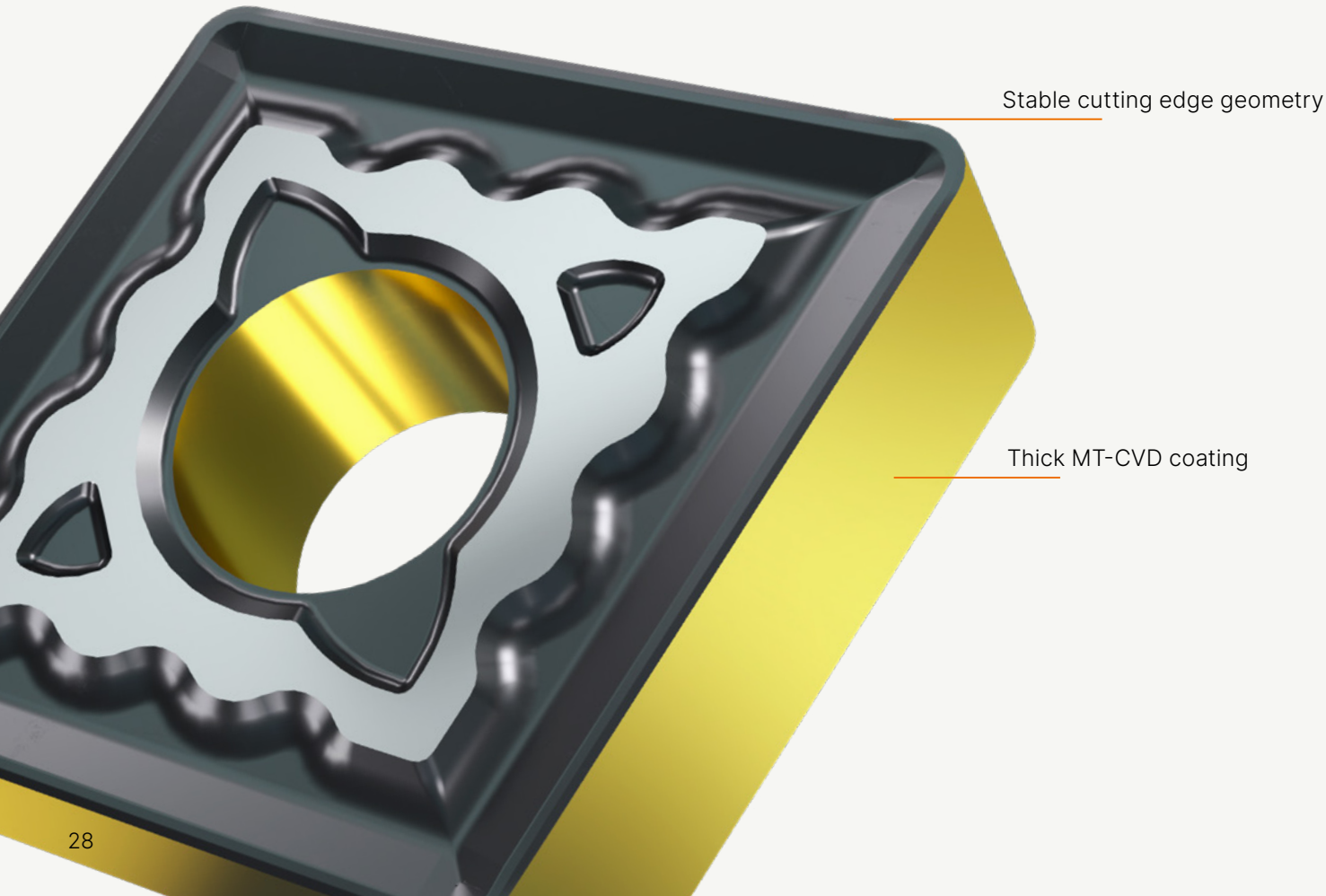
K materials

Medium to semi-rough cuts

Features and benefits

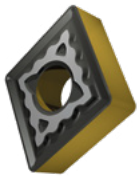
Advanced geometry delivers efficient chip breaking and evacuation.	**Improved process reliability** reduces machine downtime.
Stable, wide T-Land increases edge stability.	**Reliable performance** ensures high quality results in tough conditions.
Slightly positive rake angle reduces cutting forces, heat, and wear.	**Extended tool life** improves cost efficiency.
Available in CVD grade T5415 with thicker coating.	**Enhanced durability** boosts productivity.

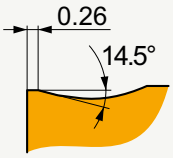
High performance and stability in cast iron turning

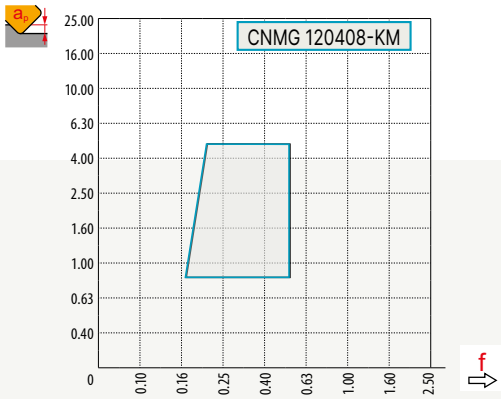


KM chipbreaker application range and material compatibility

KM

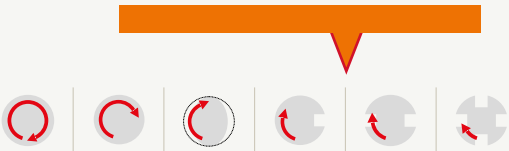




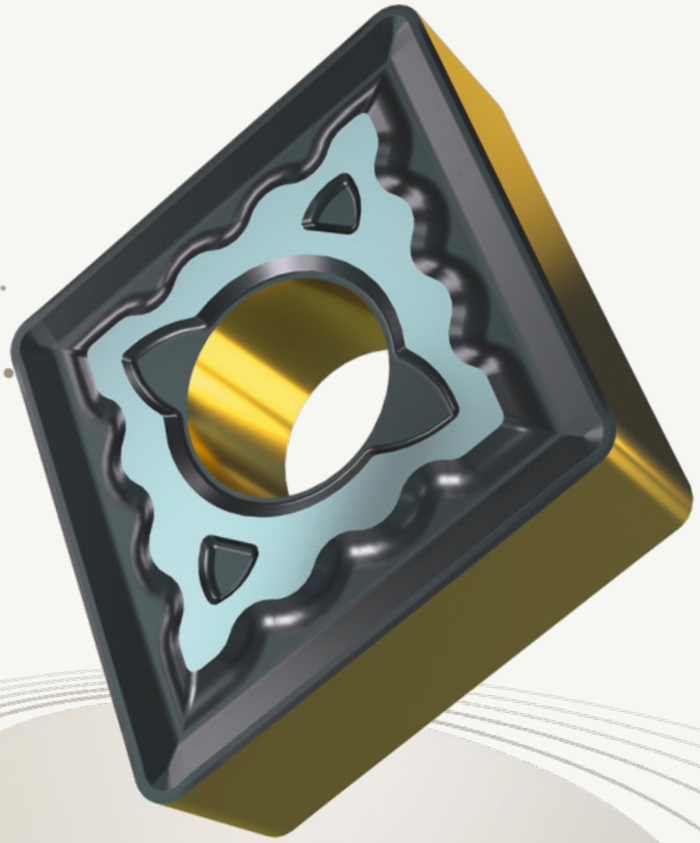


P	M	K	N	S	H
◪		■			◪

f	0.15 – 0.55
a_p	0.4 – 4.5

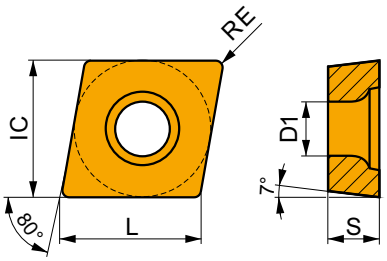


?	**CNMG, DNMG, SNMG, TNMG, VNMG, WNMG**

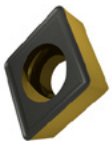
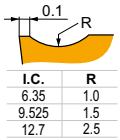
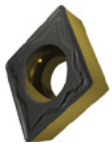
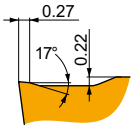
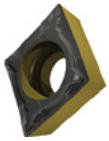
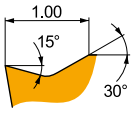


CCMT

	IC (mm)	D1 (mm)	L (mm)	S (mm)
0602	6.350	2.80	6.40	2.38
09T3	9.525	4.40	9.70	3.97
1204	12.700	5.50	12.90	4.76

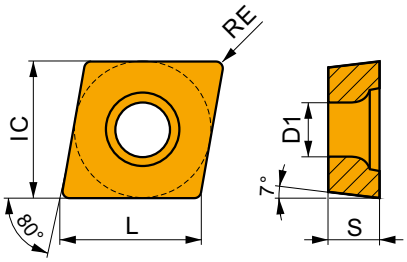


Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

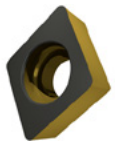
Product	Interrupted/ Continuous cut	RE (mm)	P vc (m/min)	P f (mm/rev)	P ap (mm)	M vc (m/min)	M f (mm/rev)	M ap (mm)	K vc (m/min)	K f (mm/rev)	K ap (mm)	N vc (m/min)	N f (mm/rev)	N ap (mm)	S vc (m/min)	S f (mm/rev)	S ap (mm)	H vc (m/min)	H f (mm/rev)	H ap (mm)
 																				
RF chip breaker is robust and the first choice for medium machining of Cast irons. It features slightly positive rake angle and stable, moderate T-land. It's also suitable for Steels, and conditionally for Stainless steels and Hard materials.																				
CCMT 060204E-RF:T5415	●	0.4	250	0.15	1.0	–	–	–	250	0.15	1.0	–	–	–	–	–	–	50	0.10	0.3
CCMT 09T308E-RF:T5415	●	0.8	260	0.20	1.5	–	–	–	260	0.20	1.5	–	–	–	–	–	–	55	0.14	0.7
CCMT 120408E-RF:T5415	●	0.8	240	0.22	2.2	–	–	–	240	0.22	2.2	–	–	–	–	–	–	50	0.13	0.7
 																				
RM chip breaker is robust and the first choice for roughing of Steels and Cast irons. It features positive rake angle and stable, wide T-land. It's also suitable for Stainless steels, and conditionally for Super-alloys and Hard materials.																				
CCMT 09T304E-RM:T5415	●	0.4	245	0.25	2.2	–	–	–	245	0.25	2.2	–	–	–	–	–	–	50	0.17	0.3
CCMT 09T308E-RM:T5415	⬌	0.8	280	0.30	2.2	–	–	–	280	0.30	2.2	–	–	–	–	–	–	55	0.15	0.7
CCMT 09T312E-RM:T5415	⬌	1.2	275	0.35	2.2	–	–	–	275	0.35	2.2	–	–	–	–	–	–	55	0.17	0.7
CCMT 120408E-RM:T5415	⬌	0.8	275	0.30	2.7	–	–	–	275	0.30	2.7	–	–	–	–	–	–	55	0.15	0.7
 																				
UR chip breaker is versatile and the first choice for finishing of Cast irons. It features positive rake angle without T-land. It's also suitable for Steels, and conditionally for Stainless steels.																				
CCMT 060204E-UR:T5415	●	0.4	265	0.15	1.0	–	–	–	265	0.15	1.0	–	–	–	–	–	–	–	–	–
CCMT 060208E-UR:T5415	●	0.8	285	0.20	1.0	–	–	–	285	0.20	1.0	–	–	–	–	–	–	–	–	–
CCMT 09T304E-UR:T5415	●	0.4	265	0.15	1.2	–	–	–	265	0.15	1.2	–	–	–	–	–	–	–	–	–
CCMT 09T308E-UR:T5415	●	0.8	285	0.20	1.2	–	–	–	285	0.20	1.2	–	–	–	–	–	–	–	–	–
CCMT 120404E-UR:T5415	●	0.4	255	0.15	1.7	–	–	–	255	0.15	1.7	–	–	–	–	–	–	–	–	–
CCMT 120408E-UR:T5415	●	0.8	270	0.20	1.7	–	–	–	270	0.20	1.7	–	–	–	–	–	–	–	–	–
CCMT 120412E-UR:T5415	●	1.2	255	0.27	1.7	–	–	–	255	0.27	1.7	–	–	–	–	–	–	–	–	–

CCMW

	IC (mm)	D1 (mm)	L (mm)	S (mm)
09T3	9.525	4.40	9.70	3.97



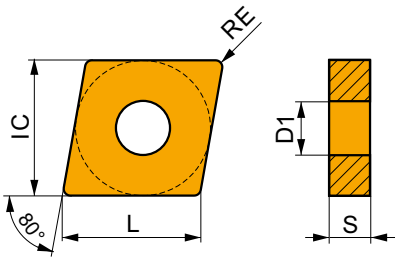
Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

Product	Interrupted/ Continuous cut	RE (mm)	P vc (m/min)	P f (mm/rev)	P ap (mm)	M vc (m/min)	M f (mm/rev)	M ap (mm)	K vc (m/min)	K f (mm/rev)	K ap (mm)	N vc (m/min)	N f (mm/rev)	N ap (mm)	S vc (m/min)	S f (mm/rev)	S ap (mm)	H vc (m/min)	H f (mm/rev)	H ap (mm)
																				
CCMW 09T308:T5415		0.8	–	–	–	–	–	–	195	0.20	3.0	–	–	–	–	–	–	40	0.11	0.7

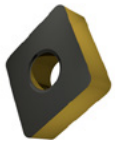
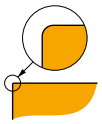
.CMW flat insert is designed for medium machining of Cast irons. It features neutral rake angle without T-land. It's also conditionally suitable for Hard materials.

CNMA

	IC (mm)	D1 (mm)	L (mm)	S (mm)
1204	12.700	5.16	12.90	4.76



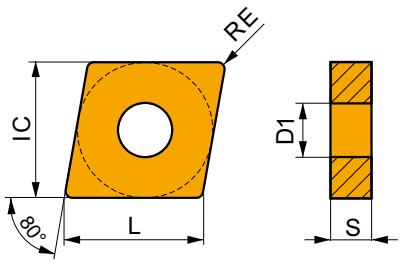
Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

Product	Interrupted/ Continuous cut	RE (mm)	P vc (m/min)	P f (mm/rev)	P ap (mm)	M vc (m/min)	M f (mm/rev)	M ap (mm)	K vc (m/min)	K f (mm/rev)	K ap (mm)	N vc (m/min)	N f (mm/rev)	N ap (mm)	S vc (m/min)	S f (mm/rev)	S ap (mm)	H vc (m/min)	H f (mm/rev)	H ap (mm)
																				
CNMA 120408:T5415		0.8	–	–	–	–	–	–	215	0.20	4.0	–	–	–	–	–	–	45	0.14	0.5
CNMA 120412:T5415		1.2	–	–	–	–	–	–	195	0.30	4.0	–	–	–	–	–	–	40	0.21	0.5
CNMA 120416:T5415		1.6	–	–	–	–	–	–	190	0.40	4.0	–	–	–	–	–	–	40	0.28	0.5

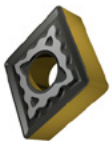
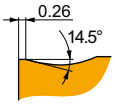
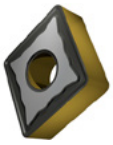
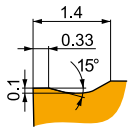
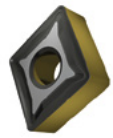
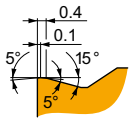
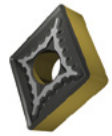
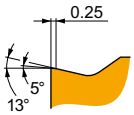
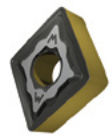
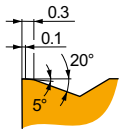
.NMA flat insert is designed for medium machining of Cast irons. It features neutral rake angle without T-land. It's also conditionally suitable for Hard materials.

CNMG

	IC (mm)	D1 (mm)	L (mm)	S (mm)
1204	12.700	5.16	12.90	4.76
1606	15.875	6.35	16.10	6.35
1906	19.050	7.94	19.30	6.35

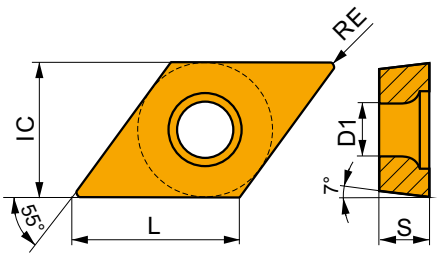


Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

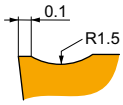
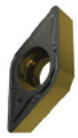
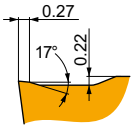
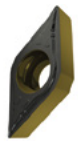
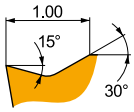
Product	Interrupted/ Continuous cut	RE (mm)	P vc (m/min)	P f (mm/rev)	P ap (mm)	M vc (m/min)	M f (mm/rev)	M ap (mm)	K vc (m/min)	K f (mm/rev)	K ap (mm)	N vc (m/min)	N f (mm/rev)	N ap (mm)	S vc (m/min)	S f (mm/rev)	S ap (mm)	H vc (m/min)	H f (mm/rev)	H ap (mm)
 																				
KM chip breaker is versatile and the first choice for medium machining of Cast irons. It features slightly positive rake angle and stable, wide T-land. It's also conditionally suitable for Steels and Hard materials.																				
CNMG 120404-KM:T5415	●	0.4	◪	265	0.20	2.1	–	–	–	■	265	0.20	2.1	–	–	–	–	–	–	◪ 55	0.14	0.8
CNMG 120408-KM:T5415	⚙	0.8	◪	265	0.32	2.1	–	–	–	■	265	0.32	2.1	–	–	–	–	–	–	◪ 55	0.22	0.8
CNMG 120412-KM:T5415	⚙	1.2	◪	260	0.40	2.1	–	–	–	■	260	0.40	2.1	–	–	–	–	–	–	◪ 55	0.28	0.8
 																				
KR chip breaker is robust and the first choice for roughing of Cast irons. It features slightly positive rake angle and , wide T-land. It's also suitable for Steels, and conditionally for Hard materials.																				
CNMG 120408E-KR:T5415	⚙	0.8	◪	240	0.35	4.0	–	–	–	■	240	0.35	4.0	–	–	–	–	–	–	◪ 50	0.17	0.7
CNMG 120412E-KR:T5415	⚙	1.2	◪	245	0.40	4.0	–	–	–	■	245	0.40	4.0	–	–	–	–	–	–	◪ 50	0.20	1.0
CNMG 120416E-KR:T5415	⚙	1.6	◪	245	0.45	4.0	–	–	–	■	245	0.45	4.0	–	–	–	–	–	–	◪ 50	0.32	0.8
CNMG 160608E-KR:T5415	⚙	0.8	◪	235	0.35	4.5	–	–	–	■	235	0.35	4.5	–	–	–	–	–	–	◪ 50	0.24	0.8
CNMG 160612E-KR:T5415	⚙	1.2	◪	230	0.45	4.5	–	–	–	■	230	0.45	4.5	–	–	–	–	–	–	◪ 45	0.32	0.8
CNMG 160616E-KR:T5415	⚙	1.6	◪	230	0.50	4.5	–	–	–	■	230	0.50	4.5	–	–	–	–	–	–	◪ 45	0.35	0.8
CNMG 190608E-KR:T5415	⚙	0.8	◪	225	0.35	7.0	–	–	–	■	225	0.35	7.0	–	–	–	–	–	–	◪ 45	0.24	0.8
CNMG 190612E-KR:T5415	⚙	1.2	◪	220	0.45	7.0	–	–	–	■	220	0.45	7.0	–	–	–	–	–	–	◪ 45	0.32	0.8
CNMG 190616E-KR:T5415	⚙	1.6	◪	220	0.50	7.0	–	–	–	■	220	0.50	7.0	–	–	–	–	–	–	◪ 45	0.35	0.8
 																				
R chip breaker is robust and designed for roughing of Steels and Cast irons. It features slightly positive rake angle and negative/stable, extra-wide double T-land. It's also conditionally suitable for Hard materials.																				
CNMG 120408E-R:T5415	⚙	0.8	◪	230	0.40	4.0	–	–	–	■	230	0.40	4.0	–	–	–	–	–	–	◪ 45	0.20	0.5
CNMG 160612E-R:T5415	⚙	1.2	◪	225	0.45	5.5	–	–	–	■	225	0.45	5.5	–	–	–	–	–	–	◪ 45	0.23	1.0
CNMG 190612E-R:T5415	⚙	1.2	◪	220	0.45	7.0	–	–	–	■	220	0.45	7.0	–	–	–	–	–	–	◪ 45	0.23	1.0
CNMG 190616E-R:T5415	⚙	1.6	◪	220	0.50	7.0	–	–	–	■	220	0.50	7.0	–	–	–	–	–	–	◪ 45	0.25	1.3
 																				
SM chip breaker is versatile and the first choice for medium machining of Steels and Super-alloys. It features slightly positive rake angle and stable, moderate T-land. It's also suitable for Stainless steels, Cast irons, and conditionally for Non-ferrous alloys and Hard materials.																				
CNMG 120412E-SM:T5415	⚙	1.2	◪	300	0.30	2.0	–	–	–	■	300	0.30	2.0	–	–	–	–	–	–	◪ 60	0.15	1.0
 																				
W-M chip breaker has wiper edge and is designed for finishing of Steels. It features positive rake angle and positive, moderate T-land. It's also conditionally suitable for Cast irons.																				
CNMG 120408W-M:T5415	⚙	0.8	◪	245	0.45	1.5	–	–	–	◪	245	0.45	1.5	–	–	–	–	–	–	–	–	–

DCMT

	IC (mm)	D1 (mm)	L (mm)	S (mm)
11T3	9.525	4.40	11.60	3.97



Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

Product	Interrupted/ Continuous cut	RE (mm)	P vc (m/min)	P f (mm/rev)	P ap (mm)	M vc (m/min)	M f (mm/rev)	M ap (mm)	K vc (m/min)	K f (mm/rev)	K ap (mm)	N vc (m/min)	N f (mm/rev)	N ap (mm)	S vc (m/min)	S f (mm/rev)	S ap (mm)	H vc (m/min)	H f (mm/rev)	H ap (mm)
																				
DCMT 11T304E-RF:T5415	●	0.4	185	0.20	0.8	–	–	–	185	0.20	0.8	–	–	–	–	–	–	35	0.14	0.3
 																				
DCMT 11T304E-RM:T5415	●	0.4	230	0.20	1.0	–	–	–	230	0.20	1.0	–	–	–	–	–	–	45	0.14	0.3
DCMT 11T308E-RM:T5415	●	0.8	255	0.27	0.8	–	–	–	255	0.27	0.8	–	–	–	–	–	–	50	0.14	0.7
 																				
DCMT 11T304E-UR:T5415	●	0.4	235	0.12	0.8	–	–	–	235	0.12	0.8	–	–	–	–	–	–	–	–	–
DCMT 11T308E-UR:T5415	●	0.8	245	0.17	0.8	–	–	–	245	0.17	0.8	–	–	–	–	–	–	–	–	–

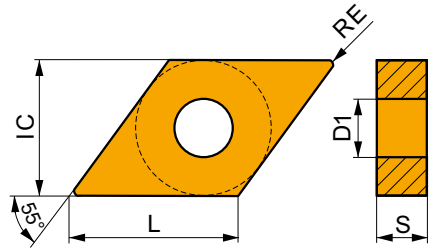
RF chip breaker is robust and the first choice for medium machining of Cast irons. It features slightly positive rake angle and stable, moderate T-land. It's also suitable for Steels, and conditionally for Stainless steels and Hard materials.

RM chip breaker is robust and the first choice for roughing of Steels and Cast irons. It features positive rake angle and stable, wide T-land. It's also suitable for Stainless steels, and conditionally for Super-alloys and Hard materials.

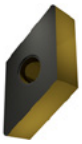
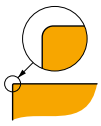
UR chip breaker is versatile and the first choice for finishing of Cast irons. It features positive rake angle without T-land. It's also suitable for Steels, and conditionally for Stainless steels.

DNMA

	IC (mm)	D1 (mm)	L (mm)	S (mm)
1506	12.700	5.16	15.50	6.35

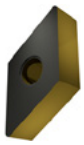
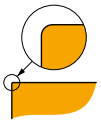


Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

Product	Interrupted/ Continuous cut	RE (mm)	P vc (m/min)	P f (mm/rev)	P ap (mm)	M vc (m/min)	M f (mm/rev)	M ap (mm)	K vc (m/min)	K f (mm/rev)	K ap (mm)	N vc (m/min)	N f (mm/rev)	N ap (mm)	S vc (m/min)	S f (mm/rev)	S ap (mm)	H vc (m/min)	H f (mm/rev)	H ap (mm)
 																				
DNMA 150608:T5415	●	0.8	–	–	–	–	–	–	190	0.20	1.7	–	–	–	–	–	–	40	0.14	0.5

.NMA flat insert is designed for medium machining of Cast irons. It features neutral rake angle without T-land. It's also conditionally suitable for Hard materials.

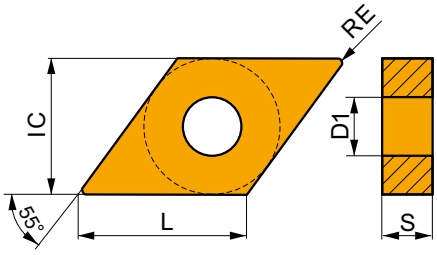
Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

Product	Interrupted/ Continuous cut	RE (mm)	P vc (m/min)	P f (mm/rev)	P ap (mm)	M vc (m/min)	M f (mm/rev)	M ap (mm)	K vc (m/min)	K f (mm/rev)	K ap (mm)	N vc (m/min)	N f (mm/rev)	N ap (mm)	S vc (m/min)	S f (mm/rev)	S ap (mm)	H vc (m/min)	H f (mm/rev)	H ap (mm)
 																				
.NMA flat insert is designed for medium machining of Cast irons. It features neutral rake angle without T-land. It's also conditionally suitable for Hard materials.																				
DNMA 150612:T5415	⬌	1.2	–	–	–	–	–	–	195	0.20	1.7	–	–	–	–	–	–	40	0.14	0.5

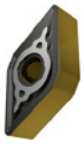
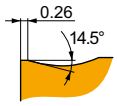
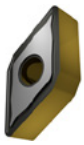
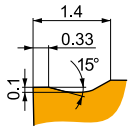
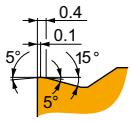
DNMG

DORMER PRAMET

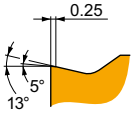
	IC (mm)	D1 (mm)	L (mm)	S (mm)
1104	9.525	4.40	11.60	4.76
1504	12.700	5.16	15.50	4.76
1506	12.700	5.16	15.50	6.35



Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

Product	Interrupted/ Continuous cut	RE (mm)	P vc (m/min)	P f (mm/rev)	P ap (mm)	M vc (m/min)	M f (mm/rev)	M ap (mm)	K vc (m/min)	K f (mm/rev)	K ap (mm)	N vc (m/min)	N f (mm/rev)	N ap (mm)	S vc (m/min)	S f (mm/rev)	S ap (mm)	H vc (m/min)	H f (mm/rev)	H ap (mm)
 																				
KM chip breaker is versatile and the first choice for medium machining of Cast irons. It features slightly positive rake angle and stable, wide T-land. It's also conditionally suitable for Steels and Hard materials.																				
DNMG 110404-KM:T5415	●	0.4	220	0.20	1.2	–	–	–	220	0.20	1.2	–	–	–	–	–	–	45	0.14	0.8
DNMG 110408-KM:T5415	●	0.8	225	0.30	1.2	–	–	–	225	0.30	1.2	–	–	–	–	–	–	45	0.21	0.8
DNMG 150404-KM:T5415	●	0.4	210	0.20	1.9	–	–	–	210	0.20	1.9	–	–	–	–	–	–	45	0.14	0.8
DNMG 150408-KM:T5415	●	0.8	215	0.30	1.9	–	–	–	215	0.30	1.9	–	–	–	–	–	–	45	0.21	0.8
DNMG 150412-KM:T5415	⬌	1.2	205	0.40	1.9	–	–	–	205	0.40	1.9	–	–	–	–	–	–	40	0.28	0.8
DNMG 150604-KM:T5415	●	0.4	210	0.20	1.9	–	–	–	210	0.20	1.9	–	–	–	–	–	–	45	0.14	0.8
DNMG 150608-KM:T5415	●	0.8	215	0.30	1.9	–	–	–	215	0.30	1.9	–	–	–	–	–	–	45	0.21	0.8
DNMG 150612-KM:T5415	⬌	1.2	205	0.40	1.9	–	–	–	205	0.40	1.9	–	–	–	–	–	–	40	0.28	0.8
 																				
KR chip breaker is robust and the first choice for roughing of Cast irons. It features slightly positive rake angle and , wide T-land. It's also suitable for Steels, and conditionally for Hard materials.																				
DNMG 150608E-KR:T5415	●	0.8	195	0.35	3.0	–	–	–	195	0.35	3.0	–	–	–	–	–	–	40	0.24	0.8
DNMG 150612E-KR:T5415	⬌	1.2	195	0.40	3.0	–	–	–	195	0.40	3.0	–	–	–	–	–	–	40	0.28	0.8
DNMG 150616E-KR:T5415	⬌	1.6	190	0.50	3.0	–	–	–	190	0.50	3.0	–	–	–	–	–	–	40	0.35	0.8
																				
R chip breaker is robust and designed for roughing of Steels and Cast irons. It features slightly positive rake angle and negative/stable, extra-wide double T-land. It's also conditionally suitable for Hard materials.																				
DNMG 150408E-R:T5415	●	0.8	190	0.40	3.0	–	–	–	190	0.40	3.0	–	–	–	–	–	–	40	0.20	0.7
DNMG 150608E-R:T5415	⬌	0.8	190	0.40	3.0	–	–	–	190	0.40	3.0	–	–	–	–	–	–	40	0.20	0.7
DNMG 150612E-R:T5415	⬌	1.2	195	0.40	3.0	–	–	–	195	0.40	3.0	–	–	–	–	–	–	40	0.20	0.9
DNMG 150616E-R:T5415	⬌	1.6	205	0.40	3.0	–	–	–	205	0.40	3.0	–	–	–	–	–	–	40	0.20	0.5

Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

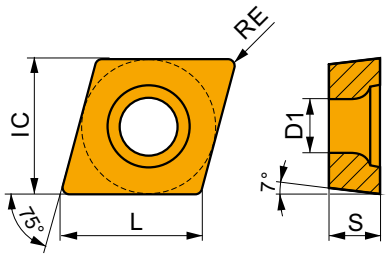
Product	Interrupted/ Continuous cut	RE (mm)	P vc (m/min)	P f (mm/rev)	P ap (mm)	M vc (m/min)	M f (mm/rev)	M ap (mm)	K vc (m/min)	K f (mm/rev)	K ap (mm)	N vc (m/min)	N f (mm/rev)	N ap (mm)	S vc (m/min)	S f (mm/rev)	S ap (mm)	H vc (m/min)	H f (mm/rev)	H ap (mm)
																				
DNMG 150612E-SM:T5415	●	1.2	245	0.30	1.7	–	–	–	245	0.30	1.7	–	–	–	–	–	–	50	0.15	0.9

SM chip breaker is versatile and the first choice for medium machining of Steels and Super-alloys. It features slightly positive rake angle and stable, moderate T-land. It's also suitable for Stainless steels, Cast irons, and conditionally for Non-ferrous alloys and Hard materials.

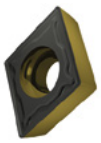
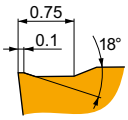
ECMT

DORMER PRAMET

	IC (mm)	D1 (mm)	L (mm)	S (mm)
0803	7.940	3.40	8.20	3.18



Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

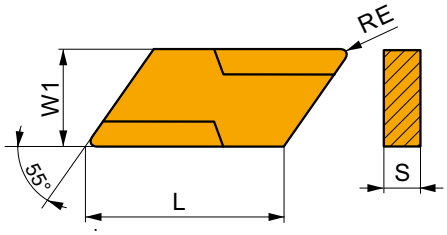
Product	Interrupted/ Continuous cut	RE (mm)	P vc (m/min)	P f (mm/rev)	P ap (mm)	M vc (m/min)	M f (mm/rev)	M ap (mm)	K vc (m/min)	K f (mm/rev)	K ap (mm)	N vc (m/min)	N f (mm/rev)	N ap (mm)	S vc (m/min)	S f (mm/rev)	S ap (mm)	H vc (m/min)	H f (mm/rev)	H ap (mm)
 																				
ECMT 080304E-FM2:T5415	●	0.4	275	0.12	1.0	–	–	–	275	0.12	1.0	–	–	–	–	–	–	–	–	–

FM2 chip breaker is robust and the first choice for medium machining of Steels. It features positive rake angle and stable, moderate T-land. It's also suitable for Cast irons, and conditionally for Stainless steels.

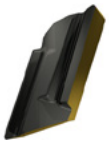
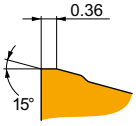
KNUX

DORMER PRAMET

	W1 (mm)	L (mm)	S (mm)
1604	9.525	19.50	4.76

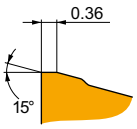
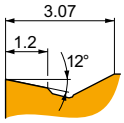
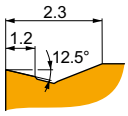


Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

Product	Interrupted/ Continuous cut	RE (mm)	P vc (m/min)	P f (mm/rev)	P ap (mm)	M vc (m/min)	M f (mm/rev)	M ap (mm)	K vc (m/min)	K f (mm/rev)	K ap (mm)	N vc (m/min)	N f (mm/rev)	N ap (mm)	S vc (m/min)	S f (mm/rev)	S ap (mm)	H vc (m/min)	H f (mm/rev)	H ap (mm)
 																				
KNUX 160405L-32:T5415	●	0.5	195	0.25	2.7	–	–	–	195	0.25	2.7	–	–	–	–	–	–	–	–	–

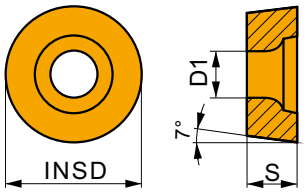
L-32 geometry with left-handed design for finish to semi-rough machining, and continuous cuts.

Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

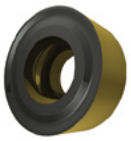
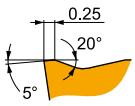
Product	Interrupted/ Continuous cut	RE (mm)	P vc (m/min)	P f (mm/rev)	P ap (mm)	M vc (m/min)	M f (mm/rev)	M ap (mm)	K vc (m/min)	K f (mm/rev)	K ap (mm)	N vc (m/min)	N f (mm/rev)	N ap (mm)	S vc (m/min)	S f (mm/rev)	S ap (mm)	H vc (m/min)	H f (mm/rev)	H ap (mm)
																				
KNUX 160405R-32:T5415	●	0.5	195	0.25	2.7	–	–	–	195	0.25	2.7	–	–	–	–	–	–	–	–	–
																				
KNUX 160405ER-72:T5415	●	0.5	270	0.20	2.0	–	–	–	270	0.20	2.0	–	–	–	–	–	–	–	–	–
																				
KNUX 160410SR-73:T5415	●	1.0	255	0.40	3.0	–	–	–	255	0.40	3.0	–	–	–	–	–	–	–	–	–

RCMT

	D1 (mm)	S (mm)
1606	5.50	6.35



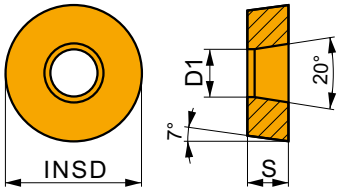
Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

Product	Interrupted/ Continuous cut	RE (mm)	P vc (m/min)	P f (mm/rev)	P ap (mm)	M vc (m/min)	M f (mm/rev)	M ap (mm)	K vc (m/min)	K f (mm/rev)	K ap (mm)	N vc (m/min)	N f (mm/rev)	N ap (mm)	S vc (m/min)	S f (mm/rev)	S ap (mm)	H vc (m/min)	H f (mm/rev)	H ap (mm)
 																				
RCMT 1606M0S-RM3:T5415	⚭	–	240	0.65	2.0	–	–	–	240	0.65	2.0	–	–	–	–	–	–	50	0.33	1.1

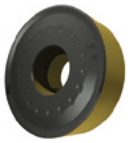
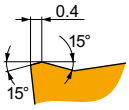
RM3 chip breaker is robust and designed for roughing of Steels and Cast irons. It features positive rake angle and negative, wide T-land. It's also conditionally suitable for Stainless steels and Hard materials.

RCMX

	INSD (mm)	D1 (mm)	S (mm)
3209	32.000	9.50	9.53

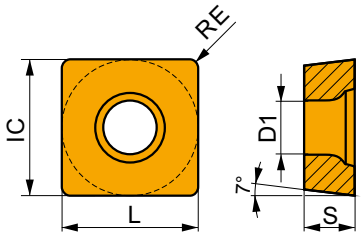


Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

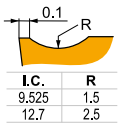
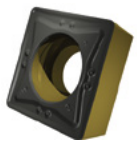
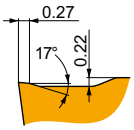
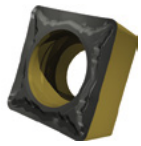
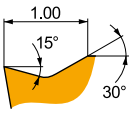
Product	Interrupted/ Continuous cut	RE (mm)	P vc (m/min)	P f (mm/rev)	P ap (mm)	M vc (m/min)	M f (mm/rev)	M ap (mm)	K vc (m/min)	K f (mm/rev)	K ap (mm)	N vc (m/min)	N f (mm/rev)	N ap (mm)	S vc (m/min)	S f (mm/rev)	S ap (mm)	H vc (m/min)	H f (mm/rev)	H ap (mm)
 																				
RM2 geometry for semi-rough to rough machining, and continuous to interrupted cuts.																				
RCMX 3209MO-RM2:T5415	◓	–	◪ 100	1.00	4.5	–	–	–	◪ 100	1.00	4.5	–	–	–	–	–	–	–	–	–

SCMT

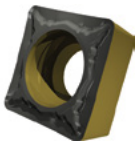
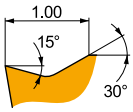
	IC (mm)	D1 (mm)	L (mm)	S (mm)
09T3	9.525	4.40	9.53	3.97
1204	12.700	5.50	12.70	4.76



Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

Product	Interrupted/ Continuous cut	RE (mm)	P vc (m/min)	P f (mm/rev)	P ap (mm)	M vc (m/min)	M f (mm/rev)	M ap (mm)	K vc (m/min)	K f (mm/rev)	K ap (mm)	N vc (m/min)	N f (mm/rev)	N ap (mm)	S vc (m/min)	S f (mm/rev)	S ap (mm)	H vc (m/min)	H f (mm/rev)	H ap (mm)
																				
I.C. 9.525 12.7 / R 1.5 2.5																				
RF chip breaker is robust and the first choice for medium machining of Cast irons. It features slightly positive rake angle and stable, moderate T-land. It's also suitable for Steels, and conditionally for Stainless steels and Hard materials.																				
SCMT 120408E-RF:T5415	●	0.8	◪ 255	0.22	2.2	–	–	–	■ 255	0.22	2.2	–	–	–	–	–	–	◪ 50	0.13	0.7
 																				
RM chip breaker is robust and the first choice for roughing of Steels and Cast irons. It features positive rake angle and stable, wide T-land. It's also suitable for Stainless steels, and conditionally for Super-alloys and Hard materials.																				
SCMT 09T308E-RM:T5415	◓	0.8	◪ 290	0.30	2.0	–	–	–	■ 290	0.30	2.0	–	–	–	–	–	–	◪ 60	0.15	0.7
SCMT 120408E-RM:T5415	◓	0.8	◪ 285	0.30	2.3	–	–	–	■ 285	0.30	2.3	–	–	–	–	–	–	◪ 60	0.15	0.7
 																				
UR chip breaker is versatile and the first choice for finishing of Cast irons. It features positive rake angle without T-land. It's also suitable for Steels, and conditionally for Stainless steels.																				
SCMT 09T308E-UR:T5415	●	0.8	◪ 295	0.20	1.2	–	–	–	■ 295	0.20	1.2	–	–	–	–	–	–	–	–	–
SCMT 120408E-UR:T5415	●	0.8	◪ 285	0.20	1.6	–	–	–	■ 285	0.20	1.6	–	–	–	–	–	–	–	–	–

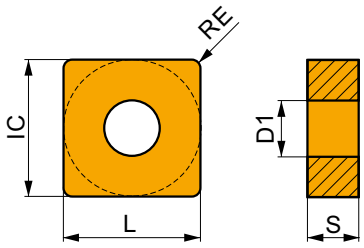
Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

Product	Interrupted/ Continuous cut	RE (mm)	P vc (m/min)	P f (mm/rev)	P ap (mm)	M vc (m/min)	M f (mm/rev)	M ap (mm)	K vc (m/min)	K f (mm/rev)	K ap (mm)	N vc (m/min)	N f (mm/rev)	N ap (mm)	S vc (m/min)	S f (mm/rev)	S ap (mm)	H vc (m/min)	H f (mm/rev)	H ap (mm)
 	**UR** chip breaker is versatile and the first choice for finishing of Cast irons. It features positive rake angle without T-land. It's also suitable for Steels, and conditionally for Stainless steels.																			
SCMT 120412E-UR:T5415	●	1.2	275	0.27	1.6	–	–	–	275	0.27	1.6	–	–	–	–	–	–	–	–	–

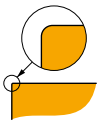
SNMA

DORMER PRAMET

	IC (mm)	D1 (mm)	L (mm)	S (mm)
1204	12.700	5.50	12.70	4.76
2509	25.400	9.12	25.40	9.53



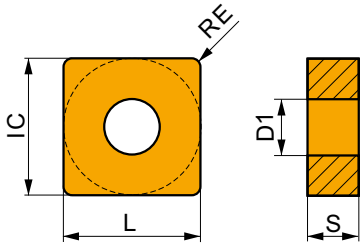
Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

Product	Interrupted/ Continuous cut	RE (mm)	P vc (m/min)	P f (mm/rev)	P ap (mm)	M vc (m/min)	M f (mm/rev)	M ap (mm)	K vc (m/min)	K f (mm/rev)	K ap (mm)	N vc (m/min)	N f (mm/rev)	N ap (mm)	S vc (m/min)	S f (mm/rev)	S ap (mm)	H vc (m/min)	H f (mm/rev)	H ap (mm)
	**.NMA** flat insert is designed for medium machining of Cast irons. It features neutral rake angle without T-land. It's also conditionally suitable for Hard materials.																			
SNMA 120412:T5415	⚙	1.2	–	–	–	–	–	–	205	0.30	4.0	–	–	–	–	–	–	40	0.15	1.0
SNMA 250924:T5415	⚙	2.4	–	–	–	–	–	–	105	0.60	8.0	–	–	–	–	–	–	20	0.30	2.0

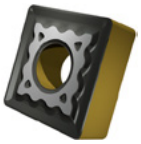
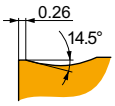
SNMG

DORMER PRAMET

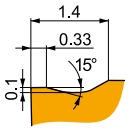
	IC (mm)	D1 (mm)	L (mm)	S (mm)
1204	12.700	5.16	12.70	4.76
1506	15.875	6.35	15.88	6.35
1906	19.050	7.94	19.05	6.35



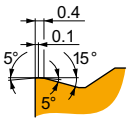
Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

Product	Interrupted/ Continuous cut	RE (mm)	P vc (m/min)	P f (mm/rev)	P ap (mm)	M vc (m/min)	M f (mm/rev)	M ap (mm)	K vc (m/min)	K f (mm/rev)	K ap (mm)	N vc (m/min)	N f (mm/rev)	N ap (mm)	S vc (m/min)	S f (mm/rev)	S ap (mm)	H vc (m/min)	H f (mm/rev)	H ap (mm)
 	**KM** chip breaker is versatile and the first choice for medium machining of Cast irons. It features slightly positive rake angle and stable, wide T-land. It's also conditionally suitable for Steels and Hard materials.																			
SNMG 120408-KM:T5415	⚙	0.8	275	0.32	2.1	–	–	–	275	0.32	2.1	–	–	–	–	–	–	55	0.22	0.8

Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

Product	Interrupted/ Continuous cut	RE (mm)	P vc (m/min)	P f (mm/rev)	P ap (mm)	M vc (m/min)	M f (mm/rev)	M ap (mm)	K vc (m/min)	K f (mm/rev)	K ap (mm)	N vc (m/min)	N f (mm/rev)	N ap (mm)	S vc (m/min)	S f (mm/rev)	S ap (mm)	H vc (m/min)	H f (mm/rev)	H ap (mm)
																				
SNMG 120408E-KR:T5415		0.8	250	0.35	3.8	–	–	–	250	0.35	3.8	–	–	–	–	–	–	50	0.17	0.7
SNMG 120412E-KR:T5415		1.2	255	0.40	3.8	–	–	–	255	0.40	3.8	–	–	–	–	–	–	50	0.20	1.0
SNMG 120416E-KR:T5415		1.6	260	0.45	3.8	–	–	–	260	0.45	3.8	–	–	–	–	–	–	55	0.32	0.8
SNMG 150612E-KR:T5415		1.2	240	0.45	4.5	–	–	–	240	0.45	4.5	–	–	–	–	–	–	50	0.32	0.8
SNMG 150616E-KR:T5415		1.6	240	0.50	4.5	–	–	–	240	0.50	4.5	–	–	–	–	–	–	50	0.35	0.8
SNMG 190612E-KR:T5415		1.2	230	0.45	7.0	–	–	–	230	0.45	7.0	–	–	–	–	–	–	45	0.32	0.8
SNMG 190616E-KR:T5415		1.6	230	0.50	7.0	–	–	–	230	0.50	7.0	–	–	–	–	–	–	45	0.35	0.8

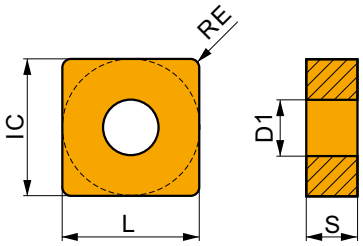
KR chip breaker is robust and the first choice for roughing of Cast irons. It features slightly positive rake angle and , wide T-land. It's also suitable for Steels, and conditionally for Hard materials.

																				
SNMG 150612E-R:T5415		1.2	240	0.45	4.5	–	–	–	240	0.45	4.5	–	–	–	–	–	–	50	0.23	1.0
SNMG 150616E-R:T5415		1.6	240	0.50	4.5	–	–	–	240	0.50	4.5	–	–	–	–	–	–	50	0.25	1.3

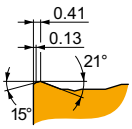
R chip breaker is robust and designed for roughing of Steels and Cast irons. It features slightly positive rake angle and negative/stable, extra-wide double T-land. It's also conditionally suitable for Hard materials.

SNMM

	IC (mm)	D1 (mm)	L (mm)	S (mm)
1906	19.050	7.94	19.05	6.35



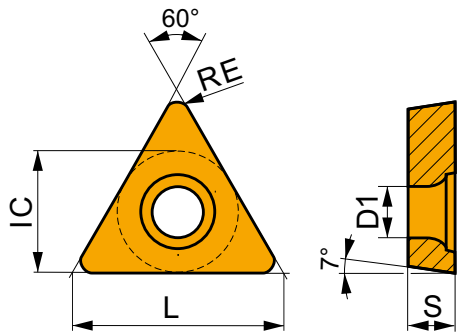
Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

Product	Interrupted/ Continuous cut	RE (mm)	P vc (m/min)	P f (mm/rev)	P ap (mm)	M vc (m/min)	M f (mm/rev)	M ap (mm)	K vc (m/min)	K f (mm/rev)	K ap (mm)	N vc (m/min)	N f (mm/rev)	N ap (mm)	S vc (m/min)	S f (mm/rev)	S ap (mm)	H vc (m/min)	H f (mm/rev)	H ap (mm)
																				
SNMM 190616E-NR2:T5415		1.6	255	0.50	8.0	–	–	–	255	0.50	8.0	–	–	–	–	–	–	–	–	–

NR2 chip breaker is robust and the first choice for heavy roughing of Stainless steels. It features positive rake angle and negative/negative, extra-wide double T-land. It's also suitable for Steels, and conditionally for Cast irons and Super-alloys.

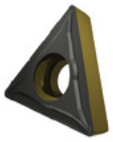
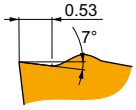
TCMT

	IC (mm)	D1 (mm)	L (mm)	S (mm)
0902	5.560	2.50	9.60	2.38
16T3	9.525	4.40	16.50	3.97

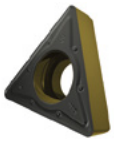
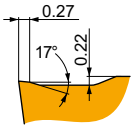


Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

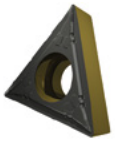
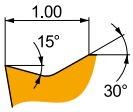
Product	Interrupted/ Continuous cut	RE (mm)	P vc (m/min)	P f (mm/rev)	P ap (mm)	M vc (m/min)	M f (mm/rev)	M ap (mm)	K vc (m/min)	K f (mm/rev)	K ap (mm)	N vc (m/min)	N f (mm/rev)	N ap (mm)	S vc (m/min)	S f (mm/rev)	S ap (mm)	H vc (m/min)	H f (mm/rev)	H ap (mm)
TCMT 090204E-FF2:T5415	●	0.4	260	0.12	1.0	–	–	–	260	0.12	1.0	–	–	–	–	–	–	–	–	–
TCMT 16T308E-RM:T5415	●	0.8	250	0.27	1.9	–	–	–	250	0.27	1.9	–	–	–	–	–	–	50	0.14	0.7
TCMT 16T312E-RM:T5415	●	1.2	265	0.27	1.9	–	–	–	265	0.27	1.9	–	–	–	–	–	–	55	0.14	0.9
TCMT 16T308E-UR:T5415	●	0.8	260	0.17	0.8	–	–	–	260	0.17	0.8	–	–	–	–	–	–	–	–	–

FF2 chip breaker is sharp and the first choice for fine-finishing of Steels. It features slightly positive rake angle without T-land. It's also suitable for Cast irons.

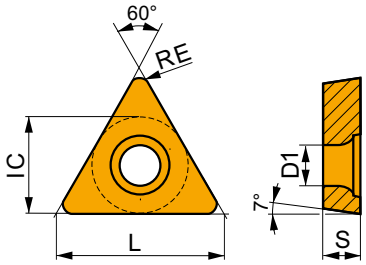
RM chip breaker is robust and the first choice for roughing of Steels and Cast irons. It features positive rake angle and stable, wide T-land. It's also suitable for Stainless steels, and conditionally for Super-alloys and Hard materials.

UR chip breaker is versatile and the first choice for finishing of Cast irons. It features positive rake angle without T-land. It's also suitable for Steels, and conditionally for Stainless steels.

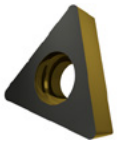
TCMW

	IC (mm)	D1 (mm)	L (mm)	S (mm)
16T3	9.525	4.40	16.50	3.97



Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

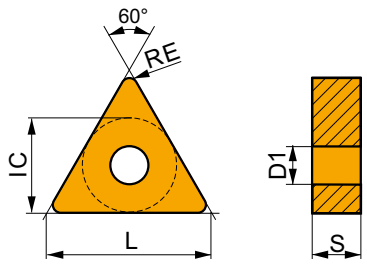
Product	Interrupted/ Continuous cut	RE (mm)	P vc (m/min)	P f (mm/rev)	P ap (mm)	M vc (m/min)	M f (mm/rev)	M ap (mm)	K vc (m/min)	K f (mm/rev)	K ap (mm)	N vc (m/min)	N f (mm/rev)	N ap (mm)	S vc (m/min)	S f (mm/rev)	S ap (mm)	H vc (m/min)	H f (mm/rev)	H ap (mm)
TCMW 16T308:T5415	●	0.8	–	–	–	–	–	–	190	0.18	1.5	–	–	–	–	–	–	40	0.11	0.7



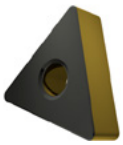
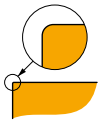
.CMW flat insert is designed for medium machining of Cast irons. It features neutral rake angle without T-land. It's also conditionally suitable for Hard materials.

TNMA

	IC (mm)	D1 (mm)	L (mm)	S (mm)
1604	9.525	3.81	16.50	4.76



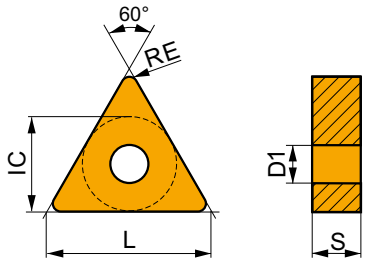
Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

Product	Interrupted/ Continuous cut	RE (mm)	P vc (m/min)	P f (mm/rev)	P ap (mm)	M vc (m/min)	M f (mm/rev)	M ap (mm)	K vc (m/min)	K f (mm/rev)	K ap (mm)	N vc (m/min)	N f (mm/rev)	N ap (mm)	S vc (m/min)	S f (mm/rev)	S ap (mm)	H vc (m/min)	H f (mm/rev)	H ap (mm)
																				
TNMA 160412:T5415	⚙	1.2	–	–	–	–	–	–	210	0.20	1.5	–	–	–	–	–	–	45	0.10	0.9

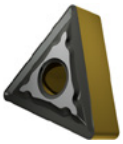
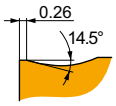
.NMA flat insert is designed for medium machining of Cast irons. It features neutral rake angle without T-land. It's also conditionally suitable for Hard materials.

TNMG

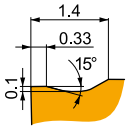
	IC (mm)	D1 (mm)	L (mm)	S (mm)
1604	9.525	3.81	16.50	4.76
2204	12.700	5.16	22.00	4.76



Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

Product	Interrupted/ Continuous cut	RE (mm)	P vc (m/min)	P f (mm/rev)	P ap (mm)	M vc (m/min)	M f (mm/rev)	M ap (mm)	K vc (m/min)	K f (mm/rev)	K ap (mm)	N vc (m/min)	N f (mm/rev)	N ap (mm)	S vc (m/min)	S f (mm/rev)	S ap (mm)	H vc (m/min)	H f (mm/rev)	H ap (mm)
																				
TNMG 160404-KM:T5415	●	0.4	225	0.20	1.6	–	–	–	225	0.20	1.6	–	–	–	–	–	–	45	0.14	0.8
TNMG 160408-KM:T5415	●	0.8	235	0.30	1.6	–	–	–	235	0.30	1.6	–	–	–	–	–	–	50	0.21	0.8
TNMG 160412-KM:T5415	⚙	1.2	225	0.40	1.6	–	–	–	225	0.40	1.6	–	–	–	–	–	–	45	0.28	0.8
TNMG 220408-KM:T5415	●	0.8	230	0.30	2.1	–	–	–	230	0.30	2.1	–	–	–	–	–	–	45	0.21	0.8
TNMG 220412-KM:T5415	⚙	1.2	215	0.40	2.1	–	–	–	215	0.40	2.1	–	–	–	–	–	–	45	0.28	0.8

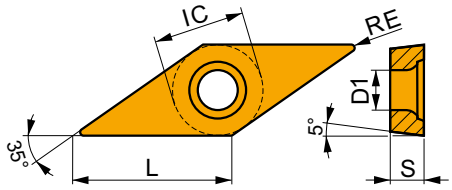
KM chip breaker is versatile and the first choice for medium machining of Cast irons. It features slightly positive rake angle and stable, wide T-land. It's also conditionally suitable for Steels and Hard materials.

Product	Interrupted/ Continuous cut	RE (mm)	P vc (m/min)	P f (mm/rev)	P ap (mm)	M vc (m/min)	M f (mm/rev)	M ap (mm)	K vc (m/min)	K f (mm/rev)	K ap (mm)	N vc (m/min)	N f (mm/rev)	N ap (mm)	S vc (m/min)	S f (mm/rev)	S ap (mm)	H vc (m/min)	H f (mm/rev)	H ap (mm)
																				
TNMG 160408E-KR:T5415	●	0.8	210	0.35	3.0	–	–	–	210	0.35	3.0	–	–	–	–	–	–	45	0.17	0.7
TNMG 220408E-KR:T5415	●	0.8	200	0.35	4.0	–	–	–	200	0.35	4.0	–	–	–	–	–	–	40	0.24	0.8
TNMG 220412E-KR:T5415	⚙	1.2	205	0.40	4.0	–	–	–	205	0.40	4.0	–	–	–	–	–	–	40	0.28	0.8

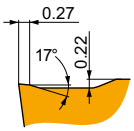
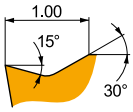
KR chip breaker is robust and the first choice for roughing of Cast irons. It features slightly positive rake angle and , wide T-land. It's also suitable for Steels, and conditionally for Hard materials.

VBMT

	IC (mm)	D1 (mm)	L (mm)	S (mm)
1604	9.525	4.40	16.60	4.76

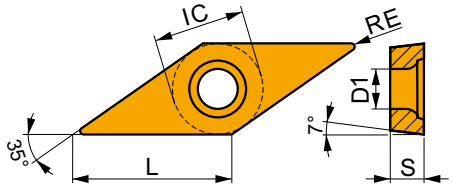


Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

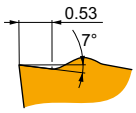
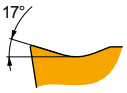
Product	Interrupted/ Continuous cut	RE (mm)	P vc (m/min)	P f (mm/rev)	P ap (mm)	M vc (m/min)	M f (mm/rev)	M ap (mm)	K vc (m/min)	K f (mm/rev)	K ap (mm)	N vc (m/min)	N f (mm/rev)	N ap (mm)	S vc (m/min)	S f (mm/rev)	S ap (mm)	H vc (m/min)	H f (mm/rev)	H ap (mm)
																				
RM chip breaker is robust and the first choice for roughing of Steels and Cast irons. It features positive rake angle and stable, wide T-land. It's also suitable for Stainless steels, and conditionally for Super-alloys and Hard materials.																				
VBMT 160404E-RM:T5415	●	0.4	◪ 250	0.12	1.2	–	–	–	■ 250	0.12	1.2	–	–	–	–	–	–	◪ 50	0.12	0.3
VBMT 160408E-RM:T5415	●	0.8	◪ 265	0.17	1.2	–	–	–	■ 265	0.17	1.2	–	–	–	–	–	–	◪ 55	0.11	0.7
																				
UR chip breaker is versatile and the first choice for finishing of Cast irons. It features positive rake angle without T-land. It's also suitable for Steels, and conditionally for Stainless steels.																				
VBMT 160404E-UR:T5415	●	0.4	◪ 205	0.12	1.2	–	–	–	■ 205	0.12	1.2	–	–	–	–	–	–	–	–	–
VBMT 160408E-UR:T5415	●	0.8	◪ 215	0.17	1.2	–	–	–	■ 215	0.17	1.2	–	–	–	–	–	–	–	–	–

VCGT

	IC (mm)	D1 (mm)	L (mm)	S (mm)
1303	7.940	3.40	13.80	3.18

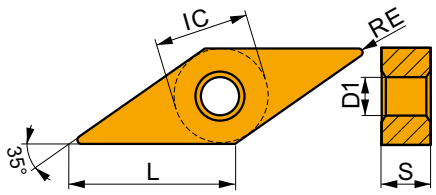


Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

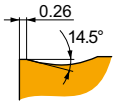
Product	Interrupted/ Continuous cut	RE (mm)	P vc (m/min)	P f (mm/rev)	P ap (mm)	M vc (m/min)	M f (mm/rev)	M ap (mm)	K vc (m/min)	K f (mm/rev)	K ap (mm)	N vc (m/min)	N f (mm/rev)	N ap (mm)	S vc (m/min)	S f (mm/rev)	S ap (mm)	H vc (m/min)	H f (mm/rev)	H ap (mm)
																				
FF2 chip breaker is sharp and the first choice for fine-finishing of Steels. It features slightly positive rake angle without T-land. It's also suitable for Cast irons.																				
VCGT 130304E-FF2:T5415	●	0.4	◪ 210	0.12	1.0	–	–	–	■ 210	0.12	1.0	–	–	–	–	–	–	–	–	–
																				
NF2 chip breaker is sharp and the first choice for finishing of Stainless steels. It features positive rake angle without T-land. It's also suitable for Super-alloys, and conditionally for Steels, Cast irons and Non-ferrous alloys.																				
VCGT 130308E-NF2:T5415	●	0.8	◪ 220	0.17	1.0	–	–	–	◪ 220	0.17	1.0	–	–	–	–	–	–	–	–	–

VNMG

	IC (mm)	D1 (mm)	L (mm)	S (mm)
1604	9.525	3.81	16.60	4.76



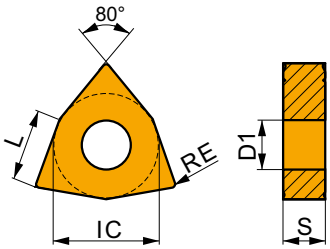
Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

Product	Interrupted/ Continuous cut	RE (mm)	P vc (m/min)	P f (mm/rev)	P ap (mm)	M vc (m/min)	M f (mm/rev)	M ap (mm)	K vc (m/min)	K f (mm/rev)	K ap (mm)	N vc (m/min)	N f (mm/rev)	N ap (mm)	S vc (m/min)	S f (mm/rev)	S ap (mm)	H vc (m/min)	H f (mm/rev)	H ap (mm)
																				
VNMG 160404-KM:T5415	●	0.4	190	0.20	1.2	–	–	–	190	0.20	1.2	–	–	–	–	–	–	40	0.14	0.8
VNMG 160408-KM:T5415	●	0.8	190	0.30	1.4	–	–	–	190	0.30	1.4	–	–	–	–	–	–	40	0.21	0.8

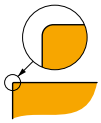
KM chip breaker is versatile and the first choice for medium machining of Cast irons. It features slightly positive rake angle and stable, wide T-land. It's also conditionally suitable for Steels and Hard materials.

WNMA

	IC (mm)	D1 (mm)	L (mm)	S (mm)
0804	12.700	5.16	8.70	4.76



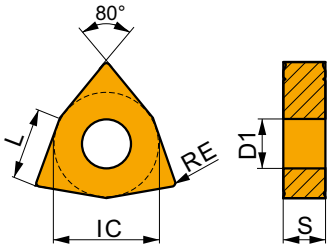
Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

Product	Interrupted/ Continuous cut	RE (mm)	P vc (m/min)	P f (mm/rev)	P ap (mm)	M vc (m/min)	M f (mm/rev)	M ap (mm)	K vc (m/min)	K f (mm/rev)	K ap (mm)	N vc (m/min)	N f (mm/rev)	N ap (mm)	S vc (m/min)	S f (mm/rev)	S ap (mm)	H vc (m/min)	H f (mm/rev)	H ap (mm)
																				
WNMA 080408:T5415	⚙	0.8	–	–	–	–	–	–	215	0.20	4.0	–	–	–	–	–	–	45	0.10	0.7
WNMA 080412:T5415	⚙	1.2	–	–	–	–	–	–	195	0.30	4.0	–	–	–	–	–	–	40	0.15	1.0

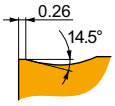
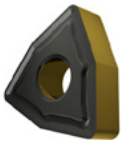
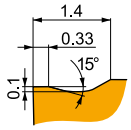
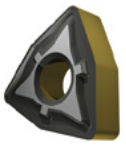
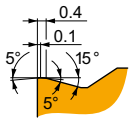
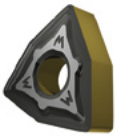
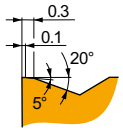
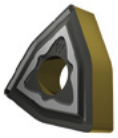
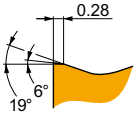
.NMA flat insert is designed for medium machining of Cast irons. It features neutral rake angle without T-land. It's also conditionally suitable for Hard materials.

WNMG

	IC (mm)	D1 (mm)	L (mm)	S (mm)
0604	9.525	3.81	6.50	4.76
0804	12.700	5.16	8.70	4.76



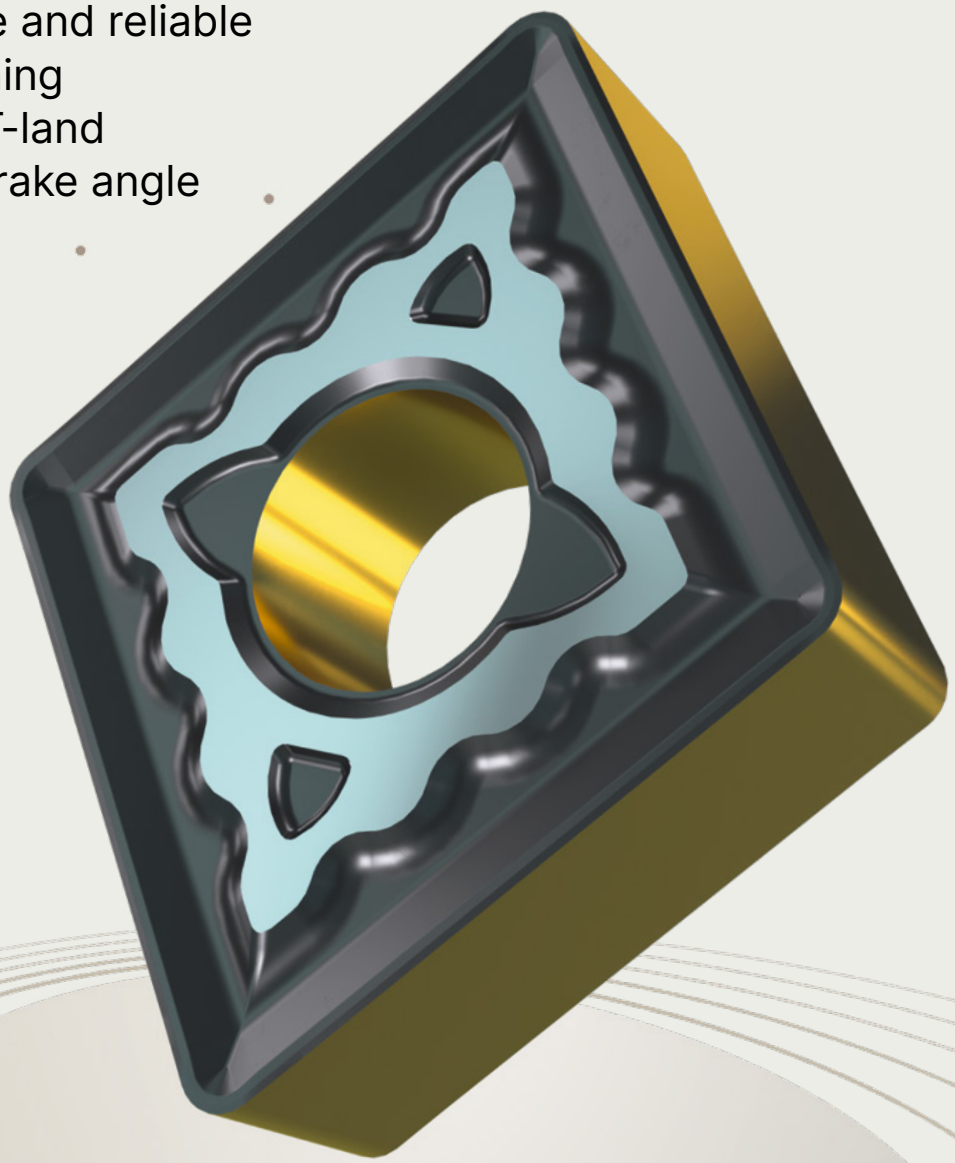
Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

Product	Interrupted/ Continuous cut	RE (mm)	P vc (m/min)	P f (mm/rev)	P ap (mm)	M vc (m/min)	M f (mm/rev)	M ap (mm)	K vc (m/min)	K f (mm/rev)	K ap (mm)	N vc (m/min)	N f (mm/rev)	N ap (mm)	S vc (m/min)	S f (mm/rev)	S ap (mm)	H vc (m/min)	H f (mm/rev)	H ap (mm)
																				
KM chip breaker is versatile and the first choice for medium machining of Cast irons. It features slightly positive rake angle and stable, wide T-land. It's also conditionally suitable for Steels and Hard materials.																				
WNMG 060404-KM:T5415	●	0.4	265	0.20	1.8	–	–	–	265	0.20	1.8	–	–	–	–	–	–	55	0.14	0.8
WNMG 060408-KM:T5415	⚙	0.8	270	0.32	1.8	–	–	–	270	0.32	1.8	–	–	–	–	–	–	55	0.22	0.8
WNMG 080404-KM:T5415	●	0.4	265	0.20	2.1	–	–	–	265	0.20	2.1	–	–	–	–	–	–	55	0.14	0.8
WNMG 080408-KM:T5415	⚙	–	265	0.32	2.1	–	–	–	265	0.32	2.1	–	–	–	–	–	–	55	0.22	0.8
WNMG 080412-KM:T5415	⚙	1.2	260	0.40	2.1	–	–	–	260	0.40	2.1	–	–	–	–	–	–	55	0.28	0.8
 																				
KR chip breaker is robust and the first choice for roughing of Cast irons. It features slightly positive rake angle and , wide T-land. It's also suitable for Steels, and conditionally for Hard materials.																				
WNMG 080408E-KR:T5415	⚙	0.8	245	0.35	3.5	–	–	–	245	0.35	3.5	–	–	–	–	–	–	50	0.17	0.7
WNMG 080412E-KR:T5415	⚙	1.2	245	0.40	3.5	–	–	–	245	0.40	3.5	–	–	–	–	–	–	50	0.20	1.0
WNMG 080416E-KR:T5415	⚙	–	235	0.50	3.5	–	–	–	235	0.50	3.5	–	–	–	–	–	–	50	0.35	0.5
 																				
R chip breaker is robust and designed for roughing of Steels and Cast irons. It features slightly positive rake angle and negative/stable, extra-wide double T-land. It's also conditionally suitable for Hard materials.																				
WNMG 080408E-R:T5415	⚙	0.8	230	0.40	3.5	–	–	–	230	0.40	3.5	–	–	–	–	–	–	45	0.20	0.7
WNMG 080412E-R:T5415	⚙	1.2	235	0.45	3.5	–	–	–	235	0.45	3.5	–	–	–	–	–	–	50	0.23	1.0
WNMG 080416E-R:T5415	⚙	1.6	235	0.50	3.5	–	–	–	235	0.50	3.5	–	–	–	–	–	–	50	0.25	1.3
 																				
W-M chip breaker has wiper edge and is designed for finishing of Steels. It features positive rake angle and positive, moderate T-land. It's also conditionally suitable for Cast irons.																				
WNMG 060412W-M:T5415	⚙	1.2	245	0.55	1.2	–	–	–	245	0.55	1.2	–	–	–	–	–	–	–	–	–
 																				
W-MR chip breaker has wiper edge and is designed for finishing of Steels. It features positive rake angle and stable, wide T-land. It's also conditionally suitable for Stainless steels and Cast irons.																				
WNMG 080412W-MR:T5415	⚙	1.2	240	0.55	1.5	–	–	–	240	0.55	1.5	–	–	–	–	–	–	–	–	–

KM chipbreaker

Extend tool life. Cut downtime.

Ensure stable and reliable cast iron turning with a wide T-land and positive rake angle



Polished precision GL. S-PM inserts for P&G ISO N materials

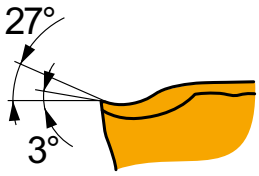
Boost productivity with cost-effective parting solutions

Introducing new GL. S-PM inserts – designed for deep parting-off and grooving of non-ferrous materials and titanium-based superalloys. These single-sided inserts feature a highly positive rake angle and a polished chipbreaker, ensuring superior chip control and smooth evacuation in continuous to slightly interrupted cuts.

Crafted with the H07 grade uncoated WC-Co carbide, these inserts excel in fine to medium machining, delivering exceptional wear resistance and extended tool life. Available in widths of 2, 3, and 4 mm, they provide precision with a cutting width tolerance of ±0.05 mm, making them ideal for high-volume production environments.

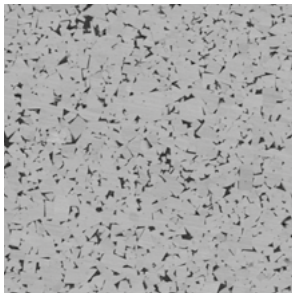
Related products

PM



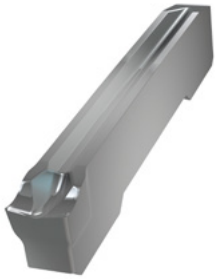
PM geometry with a highly positive rake on a single-sided insert, first choice for deep parting-off and continuous to slightly interrupted cuts.

H07



Uncoated WC-Co carbide within ISO ranges N10–N30 and S01–S20, designed for fine to medium machining of non-ferrous metals and Ti-based superalloys

GL. S-PM



Single-sided insert

0.2 mm corner radii

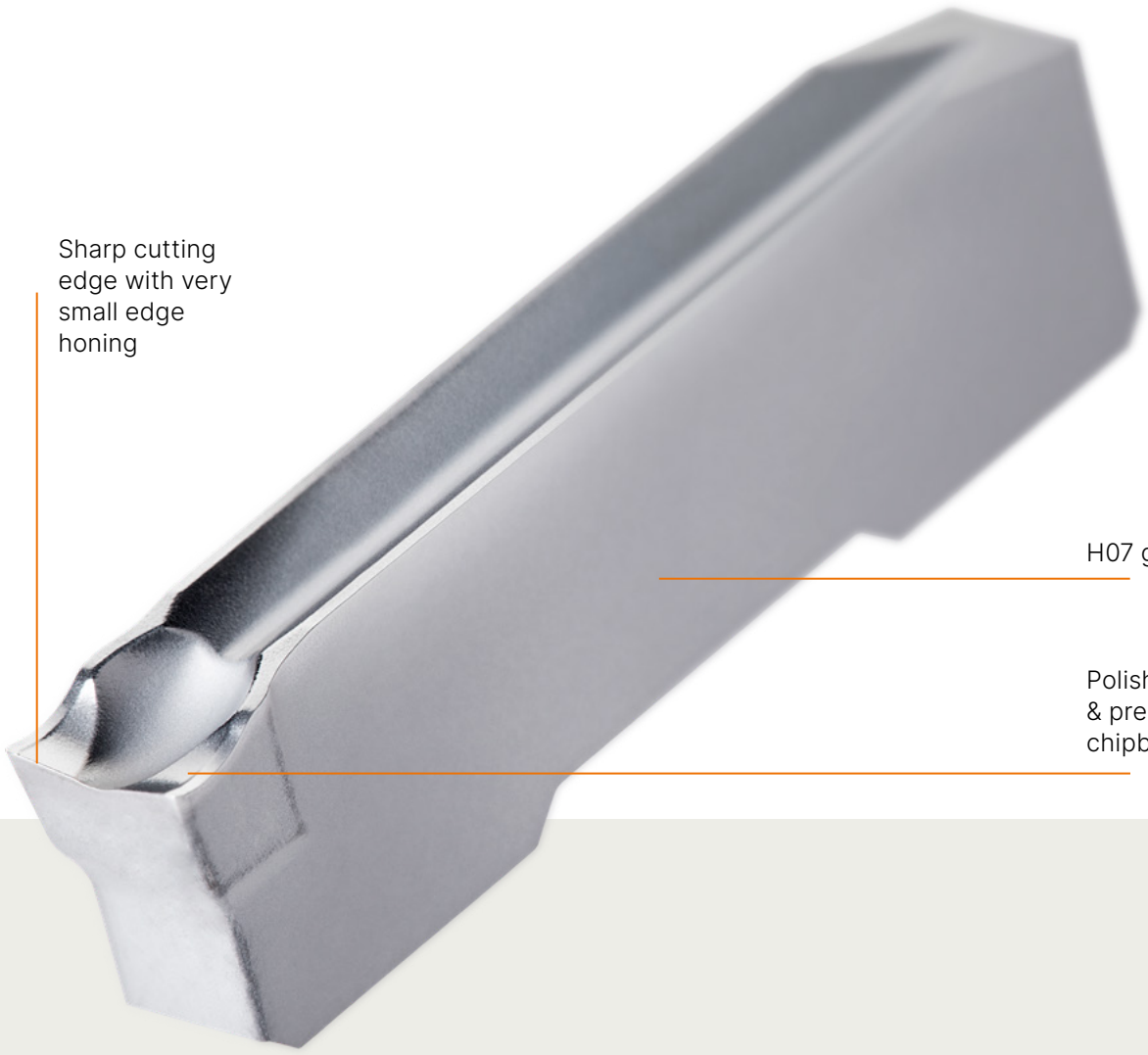
± 0.05 mm cutting width tolerance

Features and benefits

Pressed chipbreaker promotes chipforming and improves chip control during deep cuts.	**Secure chip evacuation** increases process reliability.
Polished chipbreaker reduces chip adhesion and enhances cutting performance.	**Minimized chip sticking** ensures smooth, uninterrupted cutting.
Single-sided design offers great cutting flexibility.	**Unlimited cut-off depth** provides versatility for various parting applications.
Perfect compatibility with all available GL holders and blades.	**Seamless integration** enhances efficiency.
Code designation facilitates quick matching of holders and inserts.	**Easy identification** ensures fast tool selection.
Sharp cutting edge.	**Minimized cutting forces** improve performance even in soft materials.

Features and benefits

Precision redefined for superior parting and grooving



Success stories

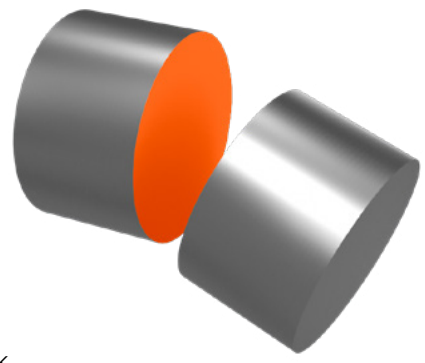
Cut faster and save **40%** on cutting time

Customer result: Our uncoated polished insert significantly enhanced productivity, reducing cutting time by 40% and enabling an increase in cutting speed due to lower cutting forces. This improvement facilitates more efficient machining without the need for higher power equipment.

Segment:	General engineering
Application:	Parting off
Material:	6082 AlMgSi1
Coolant:	Yes

Dormer Pramet solution:		
GL3-S300M02-PM:H07		
Machining data:		
v_c	f_n	CD
100	0.13	35

WMG N1.3



Bar blank

v_c = cutting speed (m/min), f_n = feed per revolution (mm/rev), CD = cutting depth (mm)

Success stories

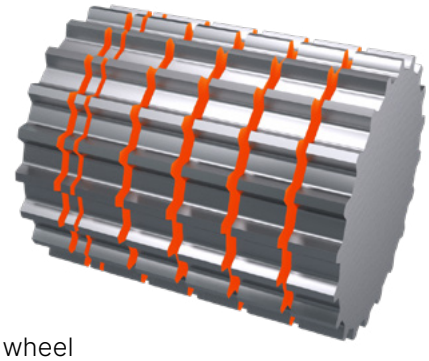
Unlock superior chip control in aluminum machining

Customer result: The new GL inserts delivered excellent chip control and a clean finish even in deep cuts (CD = 35 mm) and interrupted conditions. They ensured smooth performance, durability, and high productivity. Perfect for high-speed machining of non-ferrous materials.

Segment:	General engineering
Application:	Deep grooving
Material:	6082 AlMgSi1
Coolant:	Yes

Dormer Pramet solution:		
GL3-S300M02-PM:H07		
Machining data:		
v_c	f_n	CD
350	0.13	35

WMG N1.3



Sprocket wheel

Enhance precision and efficiency in plastic machining

Customer result: The GL. S-PM inserts showed precise and reliable performance in plastic machining, achieving the customer's goals with ease.
The inserts ensured smooth cutting, efficient chip control, and excellent results, even in deep machining applications. Perfect for precision machining of softer materials.

Segment:	General engineering
Application:	Parting off
Material:	Plastic
Coolant:	Yes

Dormer Pramet solution:		
GL3-S300M02-PM:H07		
Machining data:		
v_c	f_n	CD
250	0.10	40

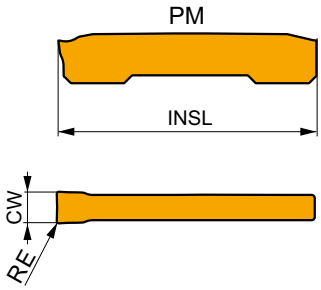
WMG N4.1

Cover disc

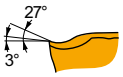
v_c = cutting speed (m/min), f_n = feed per revolution (mm/rev), CD = cutting depth (mm)

GL. S - PM

	CW (mm)	CWTOLL (mm)	CWTOLU (mm)	INSL (mm)
200	2.00	-0.05	0.05	24.5
300	3.00	-0.05	0.05	24.5
400	4.00	-0.05	0.05	24.3



Suitability and starting values for cutting speed (vc) and feed (f). Refer to our Machining Calculator app for further calculations.

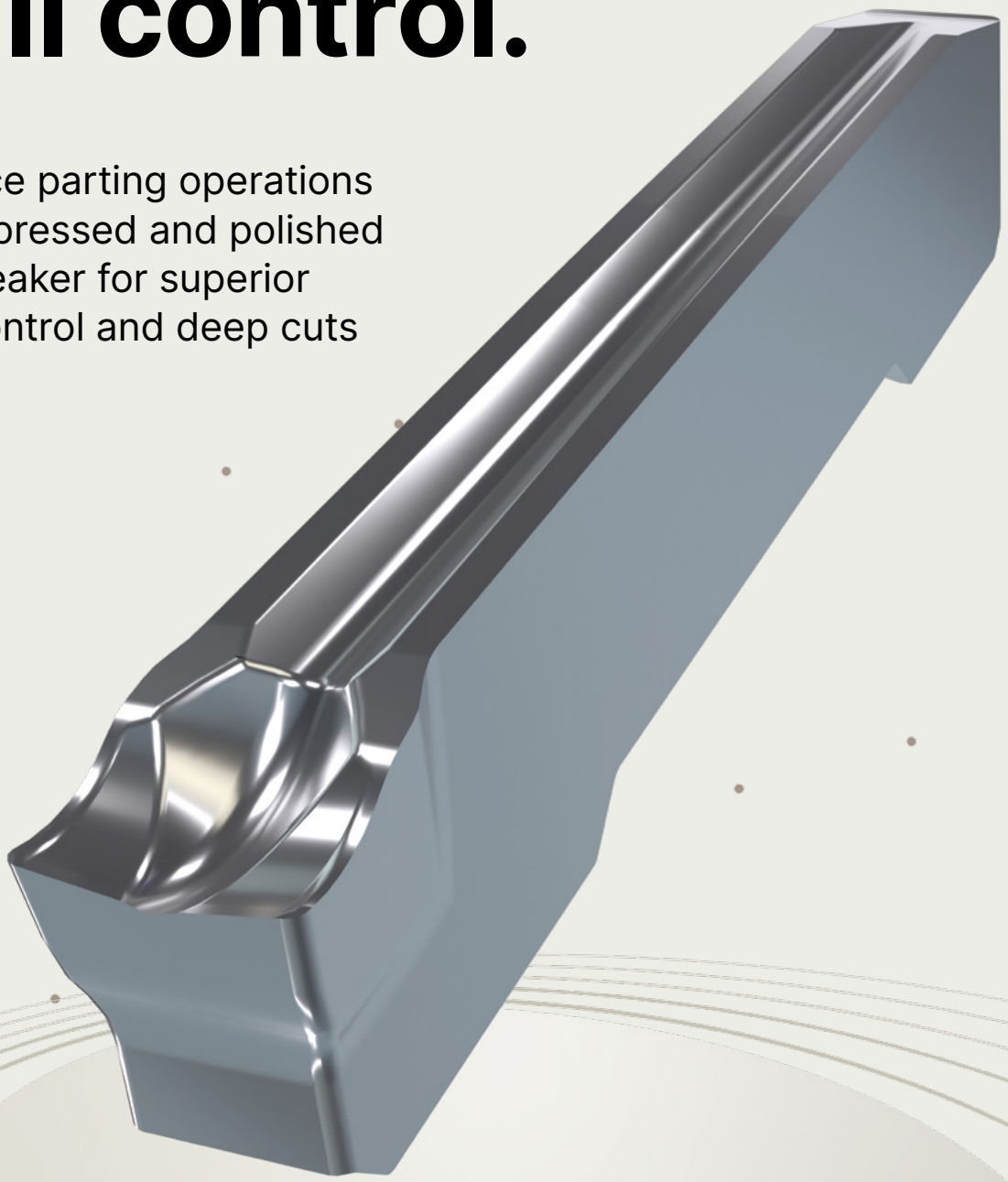
Product	Interrupted/ Continuous cut	RE (mm)	P vc (m/min)	P f (mm/rev)	M vc (m/min)	M f (mm/rev)	K vc (m/min)	K f (mm/rev)	N vc (m/min)	N f (mm/rev)	S vc (m/min)	S f (mm/rev)	H vc (m/min)	H f (mm/rev)	PSIRR (°)	PSIRL (°)
																
GL2-S200M02-PM:H07	●	0.2	–	–	◪ 50	0.07	◪ 85	0.08	■ 270	0.10	◪ 25	0.06	–	–	–	–
GL3-S300M02-PM:H07	●	0.2	–	–	◪ 50	0.09	◪ 85	0.10	■ 270	0.12	◪ 25	0.07	–	–	–	–
GL4-S400M02-PM:H07	●	0.2	–	–	◪ 50	0.11	◪ 85	0.12	■ 270	0.14	◪ 25	0.10	–	–	–	–

PM geometry with highly positive rake on single sided insert, first choice for deep parting-off, and continuous to slightly interrupted cuts.

GL. S-PM inserts

Deep cuts. Full control.

Enhance parting operations with a pressed and polished chipbreaker for superior chip control and deep cuts



Versatile shoulder milling series

Versatility with economy in every cut

Unlock versatility and cost-efficiency with our new shoulder milling family. The STD range features four adaptable carriers and four triangular inserts. Each insert has three cutting edges and provides lower cost per workpiece, thanks to a higher performance.

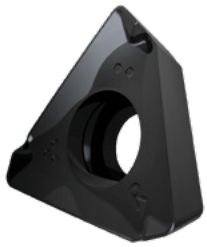
With four specialized geometries for light, medium, rough cuts, and efficient aluminium machining, this assortment handles depths of cut up to 11 mm and suits a wide range of applications.

Related products

TDET-M

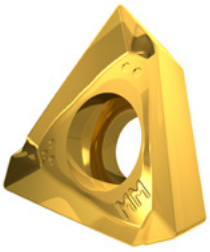
Precision ground insert
Steel, stainless steel and cast iron
Medium cuts

TDET-R



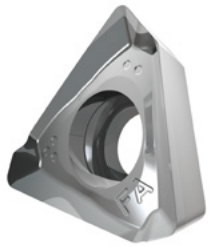
Precision ground insert
Steel, cast iron and hard materials
Rough cuts

TDET-MM



Precision ground insert
Stainless steel and super alloys
Light to medium cuts

TDET-FA



Precision ground insert
Non-ferrous materials
Light to rough cuts

STD 17

Weldon shank
Metric range: 32 - 40 mm

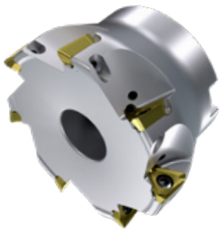
STD 17

Cylindrical shank
Metric range: 32 - 42 mm

STD 17

Modular shank
Metric range: 32 - 40 mm

STD 17

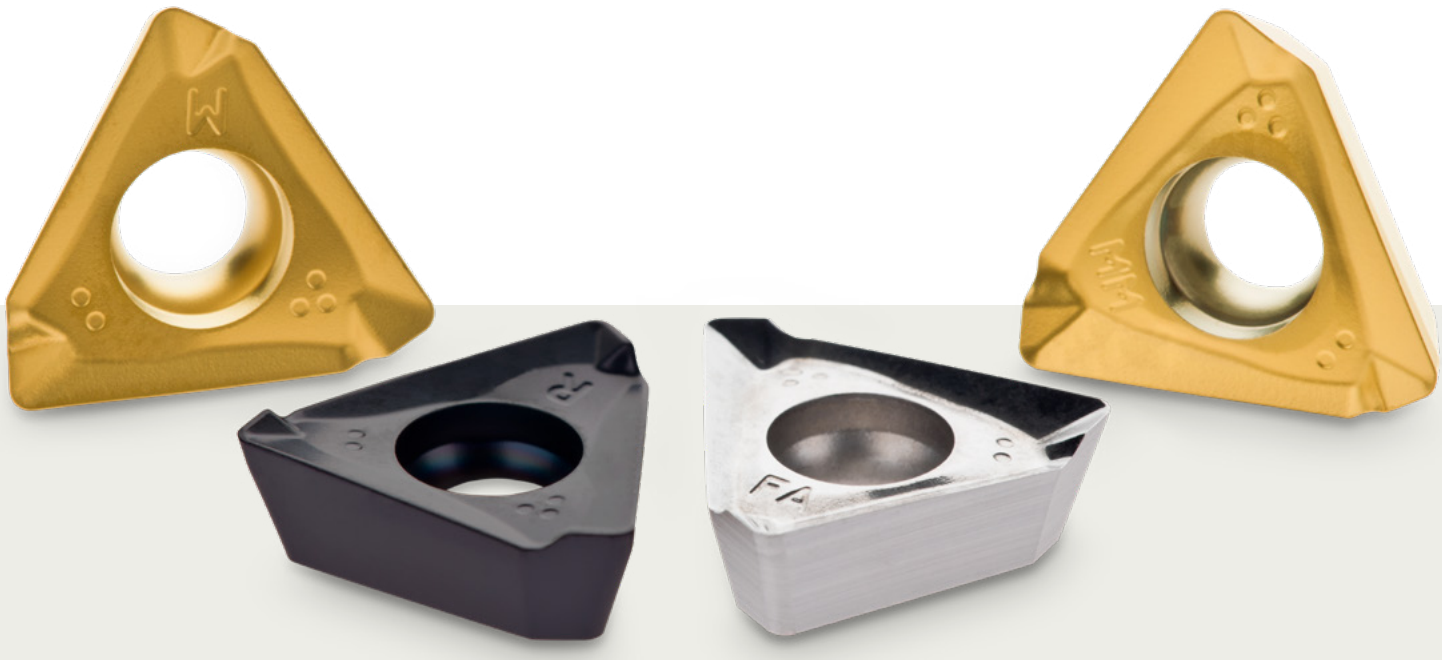


Shell body
Metric range: 42 - 200 mm

Features and benefits

Inserts

Design enables a wide range of applications, including ramping, helical interpolation, slotting, plunging, and square shoulder milling.	**Operational versatility** reduces downtime and tool costs.
Trigonal, precicion ground positive inserts with three cutting edges	**Increased economy** leads to lower costs per workpiece.
Positive rake angle design leads to smoother cutting and improved surface finishes.	**Optimized efficiency** while reducing energy consumption.
MM geometry leads to smooth machining of HRSA.	**Improved durability** ensures process stability.
Four reliable geometries M, MM, R and FA.	**Easy tool selection** for light, medium, rough cuts and efficient aluminum machining.



Features and benefits

Cutters

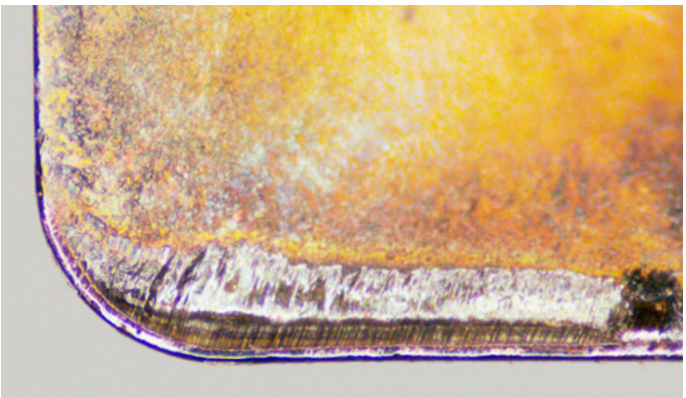
Weldon, cylindrical, modular and shell style cutters.	**Multiple choices** for a wide range of machine sizes.
Optimized shape of insert pocket.	**Simple and safe** clamping of insert.
Internal coolant on entire assortment, including large-sized diameters.	**Improved tool life** and better chip evacuation.
Shell type cutters available in wide diameter range and various tooth pitches.	**Various options** for a broad range of applications.
Cutter body made of high quality, nickelized tool steel	**High durability** of hardened cutter body.

Machining examples

Workpiece:	Carbon steel plate (193 HB)
Cutter:	32A3R040B32-STD17D-C
Insert:	TDET 170408SR-M:M8330
Material:	1.1191 / C45
Coolant:	Compressed air

Machining data:				
v_c	f_z	a_p	a_e	**Tool life** (min)
270	0.20	2.50	24	**36**

WMG P2.2

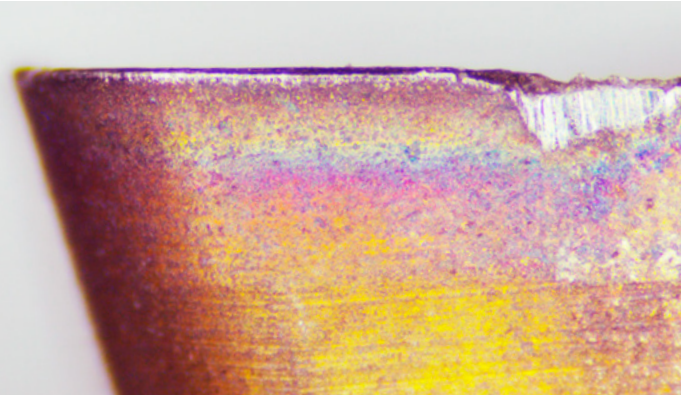


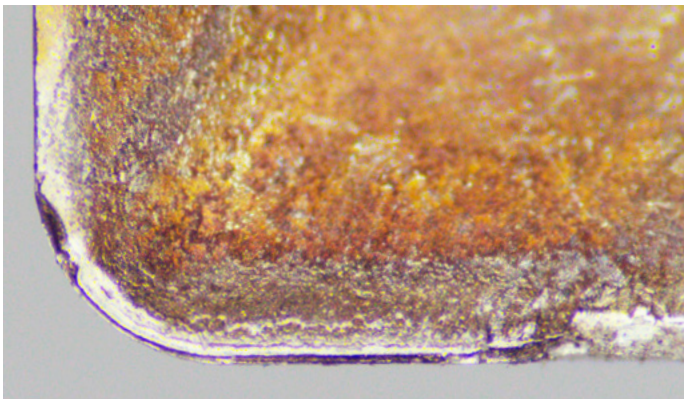
Photos from TDET 170408SR-M:M8330, taken after 36 minutes.

Workpiece:	Stainless steel plate (141 HB)
Cutter:	32A3R040B32-STD17D-C
Insert:	TDET 170408SR-MM:M6330
Material:	1.4404 / 316L
Coolant:	Compressed air

Machining data:				
v_c	f_z	a_p	a_e	**Tool life** (min)
170	0.15	2.50	24	**33**

WMG M3.1





Photos from TDET 170408SR-MM:M6330, taken after 33 minutes.

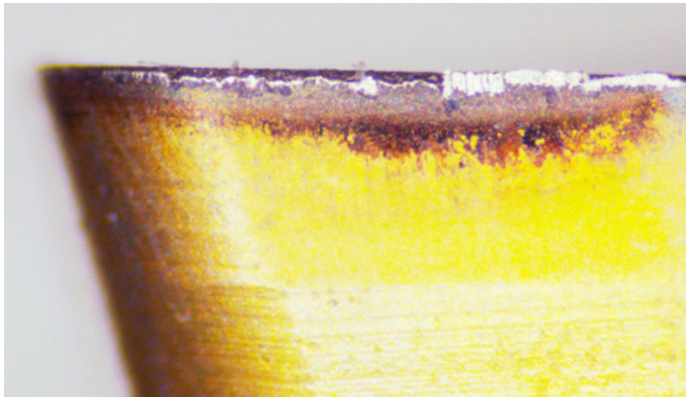
v_c = cutting speed (m/min), f_z = feed per tooth (mm), a_p = axial depth of cut (mm), a_e = radial depth of cut (mm)

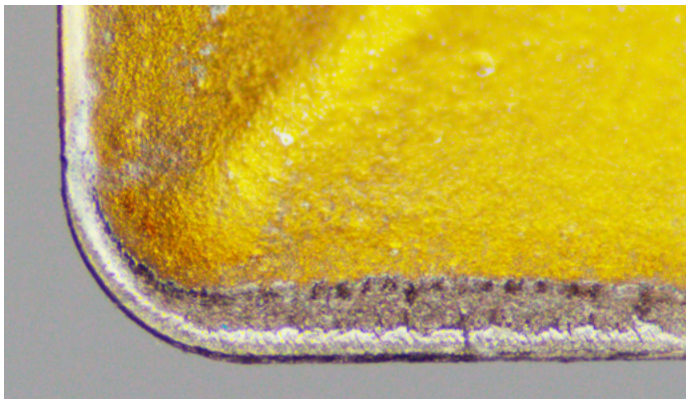
Machining examples

Workpiece:	Stainless steel plate (147 HB)
Cutter:	32A3R040B32-STD17D-C
Insert:	TDET 170408SR-MM:M6330
Material:	1.4404 / 316L
Coolant:	Soluble oil emulsion (10%)

Machining data:				
v_c	f_z	a_p	a_e	**Tool life** (min)
90	0.12	2.5	24	**46**

WMG M3.1



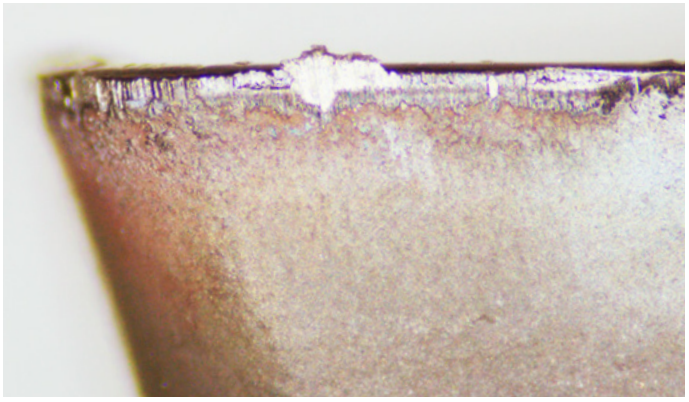


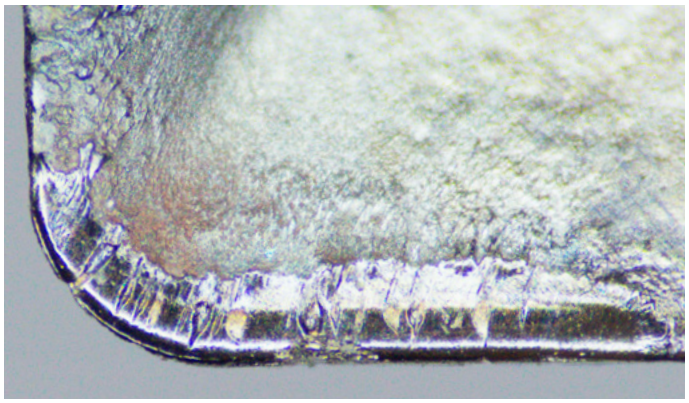
Photos from TDET 170408SR-MM:M6330, taken after 46 minutes.

Workpiece:	Cast iron plate (219 HB)
Cutter:	50A05R-S90TD17D-C
Insert:	TDET 170408PR-R:M5315
Material:	GG25 / FC250
Coolant:	Soluble oil emulsion (10%)

Machining data:				
v_c	f_z	a_p	a_e	**Tool life** (min)
340	0.25	2.5	40	**55**

WMG K1.2





Photos from TDET 170408PR-R:M5315, taken after 55 minutes.

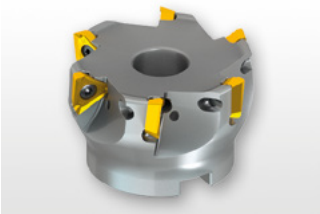
v_c = cutting speed (m/min), f_z = feed per tooth (mm), a_p = axial depth of cut (mm), a_e = radial depth of cut (mm)

STD17

P M K N S H

DORMER PRAMET

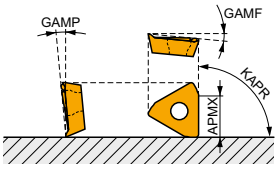
S

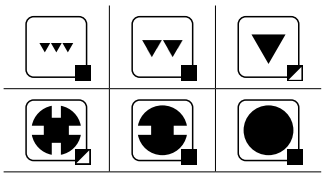


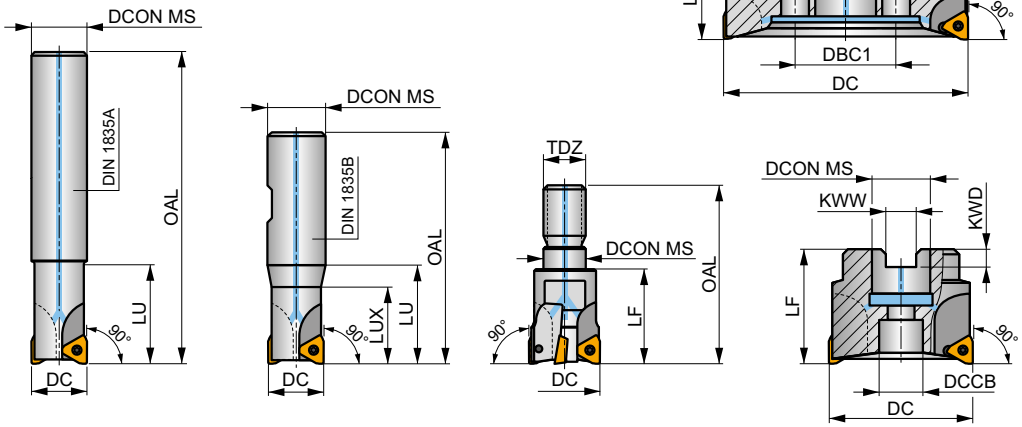
VER TD17 90° Square Shoulder Mill with Positive Design and Internal Coolant

Versatile 90° square shoulder mill utilizing single sided TD.. 17 style insert with APMX of 11.0 mm. Suited for a wide range of applications in any workpiece material. Cylindrical, Weldon, modular and arbor style available, with differential tooth pitch. Body treated for longer tool life.

KAPR	90°
APMX	11 mm







h_m	0.04-0.4
h_m	0.04-0.4

Product		DC (mm)	OAL (mm)	DCON MS (mm)	DCCB (mm)	DBC1 (mm)	LU (mm)	LUX (mm)	LF (mm)	TDZ	KWW (mm)	KWD (mm)	GAMF (°)	GAMP (°)			max.		kg		
DIN 1835A	32A2R034A32-STD17D-C	32	195	32	–	–	34	–	–	–	–	–	-9	6	2	–	17700	✓	1.09	GI113	C0411
	32A3R034A32-STD17D-C	32	195	32	–	–	34	–	–	–	–	–	-9	6	3	–	17700	✓	1.06	GI113	C0411
	32A3R080A32-STD17D-C	32	195	32	–	–	80	–	–	–	–	–	-9	6	3	–	17700	✓	1.01	GI113	C0411
	35A3R034A32-STD17D-C	35	195	32	–	–	34	–	–	–	–	–	-9	6	3	–	17000	✓	1.09	GI113	C0411
	42A4R080A32-STD17D-C	42	195	32	–	–	80	–	–	–	–	–	-8.5	6	4	✓	15500	✓	1.12	GI113	C0411
DIN 1835B	32A2R042B32-STD17D-C	32	110	32	–	–	42	38	–	–	–	–	-9	6	2	–	17700	✓	0.57	GI113	C0411
	32A3R042B32-STD17D-C	32	110	32	–	–	42	38	–	–	–	–	-9	6	3	–	17700	✓	0.55	GI113	C0411
	40A3R050B32-STD17D-C	40	120	32	–	–	50	48	–	–	–	–	-8.5	6	3	–	15900	✓	0.68	GI113	C0411
	40A4R050B32-STD17D-C	40	120	32	–	–	50	48	–	–	–	–	-8.5	6	4	✓	15900	✓	0.67	GI113	C0411
MODULAR	32A2R043M16-STD17D-C	32	66	17	–	–	–	–	43	M16	–	–	-9	6	2	–	17700	✓	0.20	GI113	C0411
	32A3R043M16-STD17D-C	32	66	17	–	–	–	–	43	M16	–	–	-9	6	3	–	17700	✓	0.18	GI113	C0411
	40A3R043M16-STD17D-C	40	66	17	–	–	–	–	43	M16	–	–	-8.5	6	3	–	15900	✓	0.24	GI113	C0411
	40A4R043M16-STD17D-C	40	66	17	–	–	–	–	43	M16	–	–	-8.5	6	4	✓	15900	✓	0.24	GI113	C0411
ISO 6462 DIN 8030	42A04R-S90TD17D-C	42	–	16	12.4	–	–	–	40	–	8.4	5.6	-8.5	6	4	✓	15500	✓	0.22	GI113	C0412
	50A04R-S90TD17D-C	50	–	22	18.1	–	–	–	40	–	10.4	6.3	-8	6	4	✓	14200	✓	0.33	GI113	C0413
	50A05R-S90TD17D-C	50	–	22	18.1	–	–	–	40	–	10.4	6.3	-8	6	5	✓	14200	✓	0.32	GI113	C0413
	52A05R-S90TD17D-C	52	–	22	18.1	–	–	–	40	–	10.4	6.3	-8	6	5	✓	13900	✓	0.34	GI113	C0413
	63A04R-S90TD17D-C	63	–	22	18.1	–	–	–	40	–	10.4	6.3	-7.5	6	4	✓	12600	✓	0.48	GI113	C0413
	63A06R-S90TD17D-C	63	–	22	18.1	–	–	–	40	–	10.4	6.3	-7.5	6	6	✓	12600	✓	0.49	GI113	C0413
	66A06R-S90TD17D-C	66	–	22	18.1	–	–	–	40	–	10.4	6.3	-7.5	6	6	✓	12300	✓	0.52	GI113	C0413
	80A07R-S90TD17D-C	80	–	27	22.1	–	–	–	50	–	12.4	7	-7	6	7	✓	11200	✓	1.06	GI113	C0414
	80A08R-S90TD17D-C	80	–	27	22.1	–	–	–	50	–	12.4	7	-7	6	8	✓	11200	✓	1.03	GI113	C0414
	100A08R-S90TD17D-C	100	–	32	45.1	–	–	–	50	–	14.4	8	-6.5	6	8	✓	10000	✓	1.66	GI113	C0415
	100A10R-S90TD17D-C	100	–	32	45.1	–	–	–	50	–	14.4	8	-6.5	6	10	✓	10000	✓	1.62	GI113	C0415
	115A10R-S90TD17D-C	115	–	32	45.1	–	–	–	50	–	14.4	8	-6.5	6	10	✓	9300	✓	2.03	GI113	C0415
	125A10R-S90TD17D-C	125	–	40	56.1	–	–	–	63	–	16.4	9	-6.5	6	10	✓	8900	✓	3.00	GI113	C0415
	125A12R-S90TD17D-C	125	–	40	56.1	–	–	–	63	–	16.4	9	-6.5	6	12	✓	8900	✓	2.98	GI113	C0415

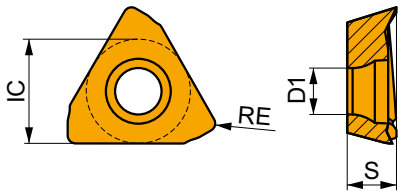
Product		DC (mm)	OAL (mm)	DCON MS (mm)	DCCB (mm)	DBC1 (mm)	LU (mm)	LUX (mm)	LF (mm)	TDZ	KWW (mm)	KWD (mm)	GAMF (°)	GAMP (°)			max.		kg		
ISO 6462 DIN 8030	**140A12R-S90TD17D-C**	140	–	40	56.1	–	–	–	63	–	16.4	9	-4	6	12	✓	8400	✓	3.56	GI113	C0415
	160C13R-S90TD17D-C	160	–	40	–	66.7	–	–	63	–	16.4	9.25	-5	6	13	✓	7900	✓	4.96	GI113	C0416
	175C14R-S90TD17D-C	175	–	40	–	66.7	–	–	63	–	16.4	9.25	-5	6	14	✓	7500	✓	5.66	GI113	C0416
	200C15R-S90TD17D-C	200	–	60	–	101.6	–	–	63	–	25.7	14.25	-5	6	15	✓	7000	✓	8.12	GI113	C0417

GI113	TD.T 1704..

		Nm								
C0411	US 4008-T15P	3.5	M 4	8	Flag T15P	–	–	–	–	–
C0412	US 4008-T15P	3.5	M 4	8	–	SDR T15P-T	HCS 0840C	–	–	–
C0413	US 4008-T15P	3.5	M 4	8	–	SDR T15P-T	HS 1030C	–	–	–
C0414	US 4008-T15P	3.5	M 4	8	–	SDR T15P-T	HS 1230C	–	–	–
C0415	US 4008-T15P	3.5	M 4	8	–	SDR T15P-T	–	–	–	–
C0416	US 4008-T15P	3.5	M 4	8	–	SDR T15P-T	HS 1240C	HSD 0825C	CAC 160C	HXK 5
C0417	US 4008-T15P	3.5	M 4	8	–	SDR T15P-T	HS 1655C	HSD 1025C	CAC 200C	HXK 7

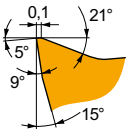
TDET 17

	IC (mm)	D1 (mm)	S (mm)
1704	10.300	4.40	4.76



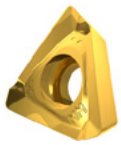
Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

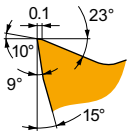
Product	Interrupted/ Continuous cut	RE (mm)	P vc (m/min)	P f (mm/tooth)	P ap (mm)	M vc (m/min)	M f (mm/tooth)	M ap (mm)	K vc (m/min)	K f (mm/tooth)	K ap (mm)	N vc (m/min)	N f (mm/tooth)	N ap (mm)	S vc (m/min)	S f (mm/tooth)	S ap (mm)	H vc (m/min)	H f (mm/tooth)	H ap (mm)
TDET 170404SR-M:M8330	●	0.4	165	0.14	4.0	95	0.13	4.0	155	0.14	4.0	–	–	–	40	0.11	3.2	–	–	–
TDET 170404SR-M:M8340	●	0.4	150	0.14	4.0	90	0.13	4.0	140	0.14	4.0	–	–	–	35	0.11	3.2	–	–	–
TDET 170408SR-M:8215	⬌	0.8	200	0.14	4.0	120	0.13	4.0	190	0.14	4.0	–	–	–	50	0.11	3.2	–	–	–
TDET 170408SR-M:M6330	⬌	0.8	170	0.14	4.0	120	0.13	4.0	–	–	–	–	–	–	50	0.11	3.2	–	–	–
TDET 170408SR-M:M8310	⬌	0.8	220	0.14	4.0	110	0.13	4.0	205	0.14	4.0	–	–	–	–	–	–	–	–	–
TDET 170408SR-M:M8330	⬌	0.8	195	0.14	4.0	115	0.13	4.0	185	0.14	4.0	–	–	–	45	0.11	3.2	–	–	–
TDET 170408SR-M:M8340	⬌	0.8	180	0.14	4.0	105	0.13	4.0	170	0.14	4.0	–	–	–	45	0.11	3.2	–	–	–
TDET 170408SR-M:M9325	●	0.8	250	0.14	4.0	–	–	–	235	0.14	4.0	–	–	–	–	–	–	–	–	–
TDET 170416SR-M:M8330	⬌	1.6	220	0.14	4.0	130	0.13	4.0	205	0.14	4.0	–	–	–	55	0.11	3.2	–	–	–
TDET 170416SR-M:M8340	⬌	1.6	200	0.14	4.0	120	0.13	4.0	190	0.14	4.0	–	–	–	50	0.11	3.2	–	–	–



M geometry is versatile and the first choice for a wide range of working conditions. Designed with positive rake, medium T-land and rounding of cutting edge for medium machining.

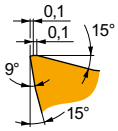
Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.





MM geometry is sharp and used for finishing, suitable for large overhang or thin walled and slim workpiece applications. Designed with highly positive rake, narrow T-land and rounding of cutting edge for light machining.

Product	Interrupted/ Continuous cut	RE (mm)	P vc (m/min)	P f (mm/tooth)	P ap (mm)	M vc (m/min)	M f (mm/tooth)	M ap (mm)	K vc (m/min)	K f (mm/tooth)	K ap (mm)	N vc (m/min)	N f (mm/tooth)	N ap (mm)	S vc (m/min)	S f (mm/tooth)	S ap (mm)	H vc (m/min)	H f (mm/tooth)	H ap (mm)
TDET 170404SR-MM:M6330	●	0.4	145	0.13	4.0	105	0.12	4.0	–	–	–	–	–	–	40	0.10	3.2	–	–	–
TDET 170404SR-MM:M8340	●	0.4	155	0.13	4.0	90	0.12	4.0	–	–	–	–	–	–	35	0.10	3.2	–	–	–
TDET 170408SR-MM:M6330	⬌	0.8	170	0.13	4.0	120	0.12	4.0	–	–	–	–	–	–	50	0.10	3.2	–	–	–
TDET 170408SR-MM:M8330	⬌	0.8	205	0.13	4.0	120	0.12	4.0	–	–	–	615	0.16	4.0	50	0.10	3.2	–	–	–
TDET 170408SR-MM:M8340	⬌	0.8	185	0.13	4.0	110	0.12	4.0	–	–	–	–	–	–	45	0.10	3.2	–	–	–
TDET 170408SR-MM:M8345	⬌	0.8	145	0.13	4.0	85	0.12	4.0	–	–	–	–	–	–	35	0.10	3.2	–	–	–
TDET 170408SR-MM:M9340	⬌	0.8	235	0.13	4.0	140	0.12	4.0	–	–	–	–	–	–	55	0.10	3.2	–	–	–
TDET 170416SR-MM:M6330	⬌	1.6	195	0.13	4.0	135	0.12	4.0	–	–	–	–	–	–	55	0.10	3.2	–	–	–
TDET 170416SR-MM:M8340	⬌	1.6	200	0.13	4.0	120	0.12	4.0	–	–	–	–	–	–	50	0.10	3.2	–	–	–

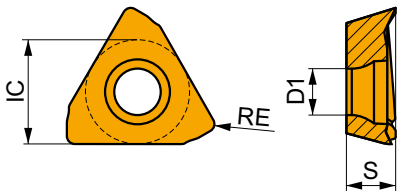


R geometry is strong and used for roughing and heavy working conditions. Designed with slightly positive rake, wide T-land and rounding of cutting edge for rough machining.

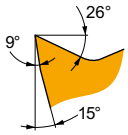
Product	Interrupted/ Continuous cut	RE (mm)	P vc (m/min)	P f (mm/tooth)	P ap (mm)	M vc (m/min)	M f (mm/tooth)	M ap (mm)	K vc (m/min)	K f (mm/tooth)	K ap (mm)	N vc (m/min)	N f (mm/tooth)	N ap (mm)	S vc (m/min)	S f (mm/tooth)	S ap (mm)	H vc (m/min)	H f (mm/tooth)	H ap (mm)
TDET 170408PR-R:8215	⬌	0.8	185	0.20	4.0	110	0.18	4.0	175	0.20	4.0	–	–	–	45	0.18	3.2	35	0.13	1.1
TDET 170408PR-R:M5315	⬌	0.8	240	0.20	4.0	–	–	–	225	0.20	4.0	–	–	–	–	–	–	45	0.13	1.1
TDET 170408PR-R:M8310	⬌	0.8	200	0.20	4.0	100	0.18	4.0	190	0.20	4.0	–	–	–	–	–	–	40	0.13	1.1
TDET 170408PR-R:M8330	✱	0.8	185	0.20	4.0	110	0.18	4.0	175	0.20	4.0	–	–	–	45	0.18	3.2	35	0.13	1.1
TDET 170408PR-R:M9325	⬌	0.8	225	0.20	4.0	–	–	–	210	0.20	4.0	–	–	–	–	–	–	45	0.13	1.1
TDET 170416PR-R:M5315	⬌	1.6	265	0.20	4.0	–	–	–	250	0.20	4.0	–	–	–	–	–	–	50	0.13	1.1
TDET 170416PR-R:M8330	✱	1.6	200	0.20	4.0	120	0.18	4.0	190	0.20	4.0	–	–	–	50	0.18	3.2	40	0.13	1.1

TDET 17-FA

	IC (mm)	D1 (mm)	S (mm)
1704	10.300	4.40	4.76



Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

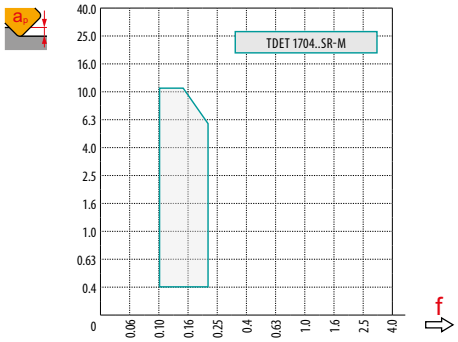


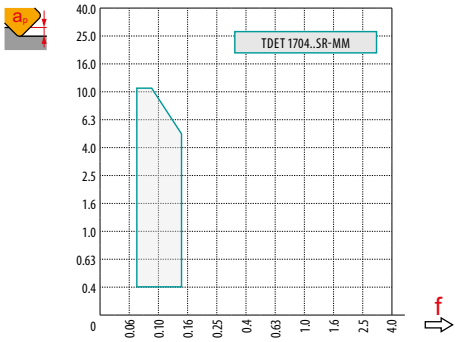
FA geometry is sharp and used for non-ferrous alloys machining, suitable for large overhang or thin walled and slim workpiece applications. Polished and ground design with highly positive rake.

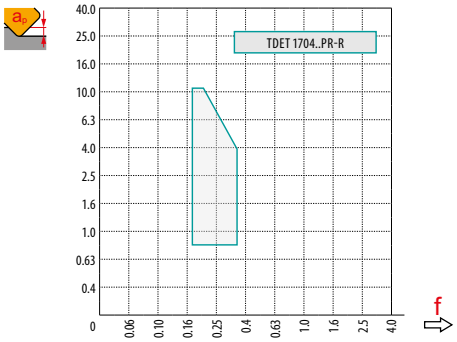
Product	Interrupted/ Continuous cut	RE (mm)	P vc (m/min)	P f (mm/tooth)	P ap (mm)	M vc (m/min)	M f (mm/tooth)	M ap (mm)	K vc (m/min)	K f (mm/tooth)	K ap (mm)	N vc (m/min)	N f (mm/tooth)	N ap (mm)	S vc (m/min)	S f (mm/tooth)	S ap (mm)	H vc (m/min)	H f (mm/tooth)	H ap (mm)
TDET 170408FR-FA:HF7	●	0.8	–	–	–	–	–	–	–	–	–	210	0.24	4.0	–	–	–	–	–	–
TDET 170408FR-FA:M0315	●	0.8	–	–	–	–	–	–	–	–	–	480	0.24	4.0	–	–	–	–	–	–

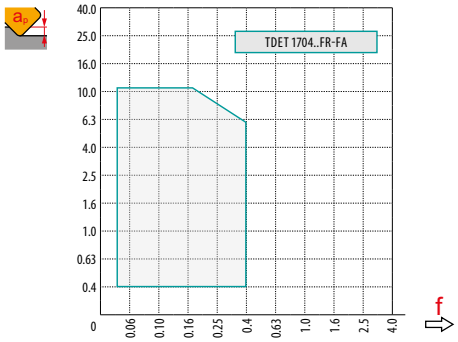
a_e/DC	5 %	10 %	15 %	20 %	25 %	30 %	40 %	50 %	60 %	70 %	75 %	80 %	90 %	100 %
X.V	1.48	1.35	1.27	1.22	1.19	1.16	1.11	1.08	1.05	1.03	1.00	1.00	1.00	1.00
⇨ x.f	2.20	1.60	1.35	1.20	1.10	0.95	0.85	0.75	0.85	0.95	1.00	1.00	1.00	1.00
⇨ x.f	0.64	0.64	0.64	0.64	0.64	0.65	0.65	0.67	0.68	0.71	0.72	0.74	0.79	1.00

	TDET 17-M			TDET 17-MM			TDET 17-R		TDET 17-FA
RE	0.4	0.8	1.6	0.4	0.8	1.6	0.8	1.6	0.8
BS	1.7	1.3	0.5	1.7	1.3	0.5	1.3	0.5	1.3









a_p	1.00	2.00	3.00	4.00	5.00	6.00	7.00	8.00	9.00	10.00	11.00
⇨ f	0.20	0.19	0.18	0.17	0.16	0.15	0.14	0.13	0.12	0.11	0.10

DC	RPMX	APMX/l
32	2.3°	3.9/100
35	2.1°	3.5/100
40	2.0°	3.3/100
42	2.0°	3.3/100
50	1.0°	1.6/100
52	1.0°	1.6/100
63	1.0°	1.6/100
66	0.8°	1.2/100

DC	RPMX	APMX/l
80	0.8°	1.2/100
100	0.7°	1.1/100
115	0.5°	0.7/100
125	0.5°	0.7/100
140	0.4°	0.5/100
160	0.4°	0.5/100
175	0.4°	0.5/100
200	0.3°	0.4/100

DC	DMIN	DMAX	SMAX DMIN	SMAX DMAX
32	54.1	63.0	2.8	3.9
35	63.7	69.0	3.3	3.9
40	70.5	79.0	3.3	4.3
42	74.5	83.0	3.6	4.5
50	90.3	99.0	2.2	2.7
52	94.3	103.0	2.3	2.8
63	116.1	125.0	2.9	3.4
66	122.1	131.0	2.5	2.9

DC	DMIN	DMAX	SMAX DMIN	SMAX DMAX
80	150.0	159.0	3.1	3.5
100	190.0	199.0	3.5	3.8
115	220.0	229.0	2.9	3.1
125	240.0	249.0	3.2	3.4
140	270.0	279.0	2.9	3.0
160	310.0	319.0	3.3	3.5
175	340.0	349.0	3.6	3.8
200	390.0	399.0	3.1	3.3

DC	a_p	f_{max}
32	1.2	0.14
35	1.2	0.14
40	1.2	0.13
42	1.2	0.13
50	1.2	0.13
52	1.2	0.13
63	1.2	0.12
66	1.2	0.12

DC	a_p	f_{max}
80	1.2	0.12
100	1.2	0.11
115	1.2	0.11
125	1.2	0.11
140	1.2	0.10
160	1.2	0.10
175	1.2	0.10
200	1.2	0.10

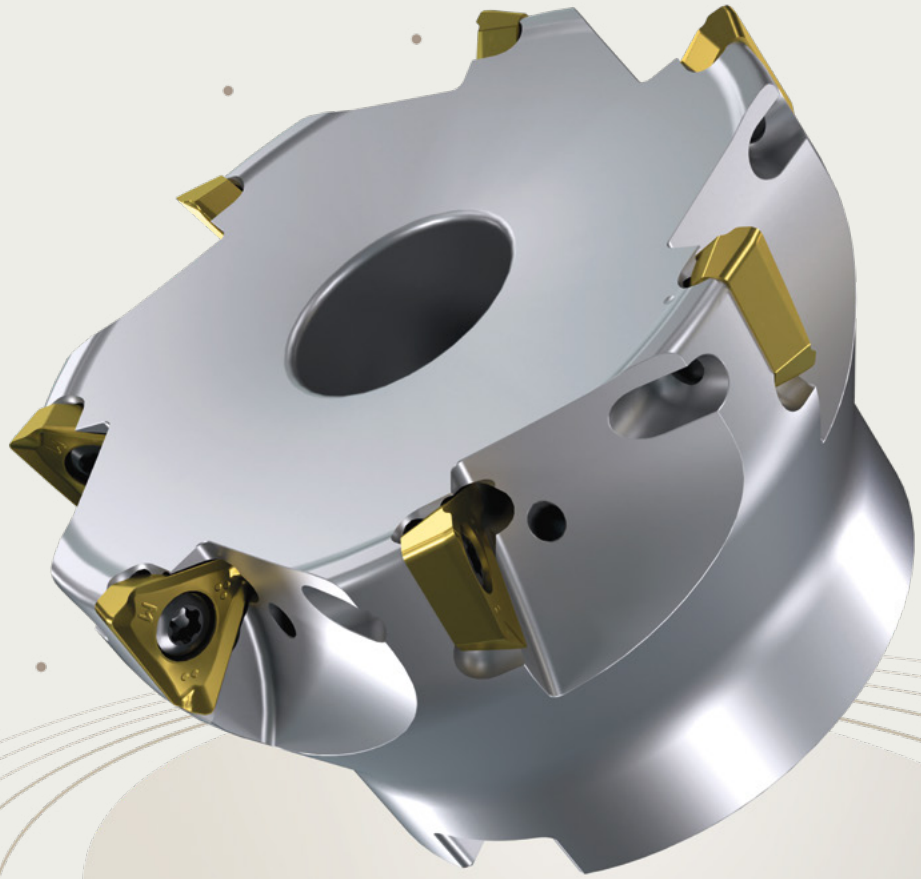
DC	$a_{e\,max}$	f_{max}
32	2.5	0.10
35	2.5	0.10
40	2.5	0.10
42	2.5	0.10
50	2.5	0.10
52	2.5	0.10
63	2.5	0.11
66	2.5	0.11

DC	$a_{e\,max}$	f_{max}
80	2.5	0.11
100	2.5	0.12
115	2.5	0.12
125	2.5	0.12
140	2.5	0.13
160	2.5	0.13
175	2.5	0.13
200	2.5	0.13

STD series

Cut more. Spend less.

Achieve versatile milling performance with triangular inserts and four adaptable cutters



Double-sided round inserts for copy milling

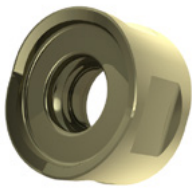
Maximize efficiency while reducing cost per piece

Introducing SRN – our new copy milling family designed for demanding applications. Featuring economical double-sided round inserts with eight cutting edges, SRN maximizes material removal rates while reducing material costs by up to 20%. The positive geometries ensure smooth, efficient cutting, while enhanced stability delivers precision machining, even of high-temperature alloys.

Available in both light and medium cutting geometries, SRN is the ideal solution for aerospace, energy, and other industries requiring high-performance machining.

Related products

RNMU-MM

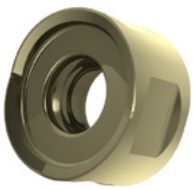


Economic double-sided round insert

Soft steels, stainless steels, HRSA

Medium machining

RNMU-MF



Economic double-sided round insert

Soft steels, stainless steels, HRSA

Light machining

SRN 10

Cylindrical shank

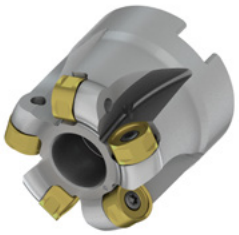
Metric range: 25 - 32 mm

SRN 10

Modular shank

Metric range: 25 - 42 mm

SRN 10



Shell body

Metric range: 40 - 52 mm

SRN 12

Modular shank

Metric range: 32 - 40 mm

SRN 12

Shell body

Metric range: 50 - 80 mm

Features and benefits

Inserts

Double-sided round insert with eight cutting edges.	**Maximized efficiency** reduces material costs by up to 20%.
Positive cutting geometries ensure smooth, low-resistance cutting.	**Improved performance** while minimizing power consumption.
The indexing on the clearance face improves clamping stability.	**Increased reliability** improves machining process security.
Geometries MM and MF allow for easy tool choice.	**Optimized precision** even in demanding environments.

Features and benefits

Cutters

Cylindrical, modular and shell style cutters.	**Multiple choices** for a wide range of machine sizes.
Optimized shape of insert pocket.	**Simple and safe** clamping of insert.
Internal coolant on entire assortment.	**Improved tool life** and better chip evacuation.
Cutter body made of high quality, nickelized tool steel.	**High durability** of hardened cutter body.

Feature details

Machining examples

Achieve **30%** longer tool life with cleaner operations

For steel plate face milling, RNMU 1004OT-MM:M6040 delivered 64 minutes of tool life –30% longer than the competitor. Soluble oil emulsion improved chip evacuation and ensured smoother, more efficient performance.

Workpiece:	Steel plate
Cutter:	25E3R060A20-SRN10-C
Insert:	RNMU 1004MOT-MM:M6040
Material:	X37CrMo5-1 / 1.2343 (280 HB)
Coolant:	Soluble oil emulsion

Machining data:					
v_c	f_z	a_p	a_e	TOH	**Tool life** (min)
200	0.20	1.50	10	90	**64** (+30%)

WMG P4.2

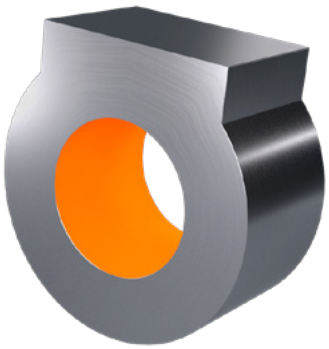
Boost tool life by **20%** with enhanced stability

The RNMU 1004MOT-MF:M6040 cutter extended tool life to 30 minutes, resulting in a 20% improvement. Its sharp geometry provided reliable stability, even under challenging tool overhang conditions.

Workpiece:	Stainless steel part
Cutter:	25E3R035M12-SRN10-C
Insert:	RNMU 1004MOT-MF:M6040
Material:	X5CrNi18-10 / 1.4301 (160 HB)
Coolant:	Soluble oil emulsion

Machining data:					
v_c	f_z	a_p	a_e	TOH	**Tool life** (min)
110	0.20	2.50	15	145	**30** (+20%)

WMG M3.1



v_c = cutting speed (m/min), f_z = feed per tooth (mm),
a_p = axial depth of cut (mm), a_e = radial depth of cut (mm), TOH = total overhang (mm)

Machining examples

Maximize productivity with **40%** longer tool life

The RNMU 1205MOT-MF:M6040 cutter achieved a 50-minute tool life, outperforming competitors by 40%. Soluble oil emulsion ensured smooth machining and excellent chip control.

Workpiece:	Stainless steel turbine blade
Cutter:	63A07R-SMORN12-C
Insert:	RNMU 1205MOT-MF:M6040
Material:	X3CrNiMo13-4 / 1.4313 (170 HB)
Coolant:	Soluble oil emulsion

Machining data:					
v_c	f_z	a_p	a_e	TOH	**Tool life** (min)
120	0.13	3	35	120	**50** (+40%)

WMG M2.1

Cut smarter with **20%** more tool life and smoother results

The RNMU 1205MOT-MF:M6040 cutter reached 44 minutes of tool life, 20% more than competitors. Compressed air-cooling enhanced chip control and process consistency.

Workpiece:	Cast steel blade
Cutter:	63A07R-SMORN12-C
Insert:	RNMU 1205MOT-MM:M6040
Material:	G20Mn5 / 1.6220 (190 HB)
Coolant:	Compressed air

Machining data:					
v_c	f_z	a_p	a_e	TOH	**Tool life** (min)
210	0.18	3.5	40	80	**44** (+20%)

WMG P3.2

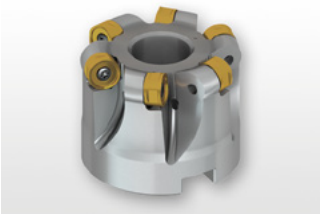
v_c = cutting speed (m/min), f_z = feed per tooth (mm),
a_p = axial depth of cut (mm), a_e = radial depth of cut (mm), TOH = total overhang (mm)

SRN10

P M S

DORMER PRAMET

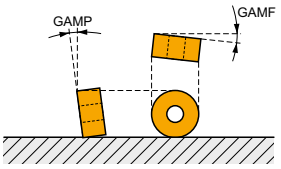
S

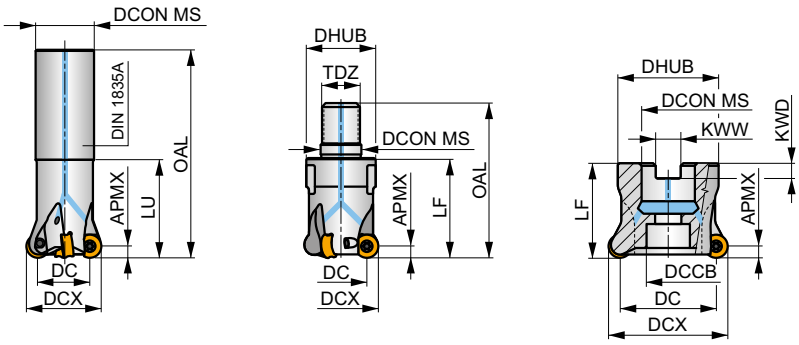


ECON RN10 Copy Mill with Double Negative Design and Internal Coolant

Economical copy mill utilizing double-sided negative inserts RNMU 10 with APMX of 4.5 mm. Suitable for face milling, copy milling and high-feed cutting. Available in cylindrical, modular and arbor style. Body treated for longer tool life.

APMX	4.5 mm





h_m	0.08 - 0.23
h_m	0.08 - 0.23

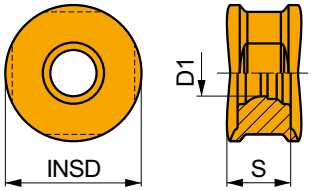
	Product	DCX (mm)	DC (mm)	OAL (mm)	DCON MS (mm)	DHUB (mm)	DCCB (mm)	LU (mm)	LF (mm)	TDZ	KWW (mm)	KWD (mm)	GAMF (°)	GAMP (°)			max.		kg		
DIN 1835A	25E3R060A25-SRN10-C	25	15	150	25	–	–	60	–	–	–	–	-14	-4	3	–	18500	✓	0.48	GI110	C0404
	32E4R070A32-SRN10-C	32	22	131	32	–	–	70	–	–	–	–	-12	-4	4	–	16300	✓	0.67	GI110	C0404
MODULAR	25E3R032M12-SRN10-C	25	15	54	12.5	22	–	–	32	M12	–	–	-14	-4	3	–	18500	✓	0.08	GI110	C0404
	32E4R042M16-SRN10-C	32	22	65	17	29	–	–	42	M16	–	–	-12	-4	4	–	16300	✓	0.20	GI110	C0404
	35E4R042M16-SRN10-C	35	25	65	17	29	–	–	42	M16	–	–	-12	-4	4	–	15600	✓	0.21	GI110	C0404
	42E5R042M16-SRN10-C	42	32	65	17	29	–	–	42	M16	–	–	-12	-4	5	–	14200	✓	0.24	GI110	C0404
ISO 6462 DIN 8030	40A05R-SMORN10-C	40	30	–	16	38	14.1	–	40	–	5.6	8.4	-12	-4	5	–	14600	✓	0.22	GI110	C0405
	50A06R-SMORN10-C	50	40	–	22	48	18.1	–	40	–	6.3	10.4	-12	-4	6	–	13000	✓	0.35	GI110	C0406
	52A06R-SMORN10-C	52	42	–	22	48	18.1	–	40	–	6.3	10.4	-12	-4	6	–	12800	✓	0.36	GI110	C0406

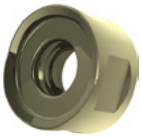
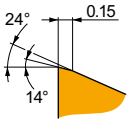
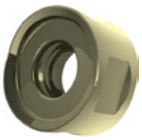
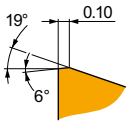
GI110	RNMU 1004..

		Nm						
C0404	US63009A-T09P	2.0	M3	9	FLAG T09P	–	–	–
C0405	US63009A-T09P	2.0	M3	9	–	D-T07P/T09P	FG-15	HS 0830C
C0406	US63009A-T09P	2.0	M3	9	–	D-T07P/T09P	FG-15	HS 1030C

RNMU10

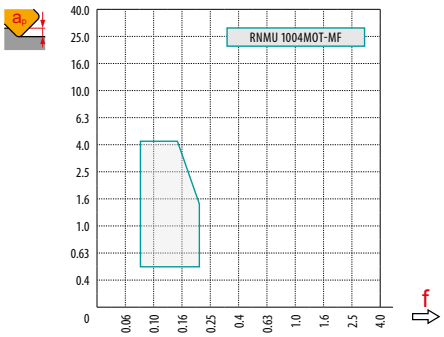
	INSD (mm)	D1 (mm)	S (mm)
1004	10.000	3.40	4.45

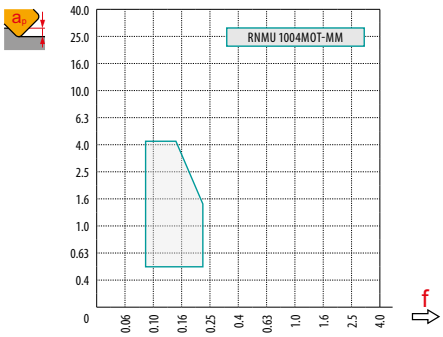


Product	Interrupted/ Continuous cut	RE (mm)	P vc (m/min)	P f (mm/tooth)	P ap (mm)	M vc (m/min)	M f (mm/tooth)	M ap (mm)	K vc (m/min)	K f (mm/tooth)	K ap (mm)	N vc (m/min)	N f (mm/tooth)	N ap (mm)	S vc (m/min)	S f (mm/tooth)	S ap (mm)	H vc (m/min)	H f (mm/tooth)	H ap (mm)
  **MF** geometry with highly positive design for light machining.																				
RNMU 1004M0T-MF:M6030	✱	–	–	–	–	■ 140	0.10	3.0	–	–	–	–	–	–	■ 55	0.08	2.4	–	–	–
RNMU 1004M0T-MF:M6040	✱	–	■ 205	0.11	3.0	■ 120	0.10	3.0	–	–	–	–	–	–	■ 50	0.08	2.4	–	–	–
  **MM** geometry with negative T-land and positive design for medium machining.																				
RNMU 1004M0T-MM:M6030	✱	–	–	–	–	■ 130	0.12	3.0	–	–	–	–	–	–	■ 55	0.09	2.4	–	–	–
RNMU 1004M0T-MM:M6040	✱	–	■ 195	0.13	3.0	■ 115	0.12	3.0	–	–	–	–	–	–	■ 45	0.09	2.4	–	–	–

a_e / DCX	5 %	10 %	15 %	20 %	25 %	30 %	40 %	50 %	60 %	70 %	75 %	80 %	90 %	100 %
X.V	1.48	1.35	1.27	1.22	1.19	1.16	1.11	1.08	1.05	1.03	1.00	1.00	1.00	1.00
⇨ x.f	2.20	1.60	1.35	1.20	1.10	0.95	0.85	0.75	0.85	0.95	1.00	1.00	1.00	1.00
⇨ x.f	0.64	0.64	0.64	0.64	0.64	0.65	0.65	0.67	0.68	0.71	0.72	0.74	0.79	1.00

	RNMU 10-MF	RNMU 10-MM
RE	5.0	5.0
BS	–	–





DCX	a_p	0.00	0.15	0.30	0.50	1.00	1.50	2.00	2.50	3.00	3.50	4.00	4.50
25	DEF	15.00	17.43	18.41	19.36	21.00	22.14	23.00	23.66	24.17	24.54	24.80	24.95
32		22.00	24.43	25.41	26.36	28.00	29.14	30.00	30.66	31.17	31.54	31.80	31.95
35		25.00	27.43	28.41	29.36	31.00	32.14	33.00	33.66	34.17	34.54	34.80	34.95
40		30.00	32.43	33.41	34.36	36.00	37.14	38.00	38.66	39.17	39.54	39.80	39.95
42		32.00	34.43	35.41	36.36	38.00	39.14	40.00	40.66	41.17	41.54	41.80	41.95
50		40.00	42.43	43.41	44.36	46.00	47.14	48.00	48.66	49.17	49.54	49.80	49.95
52		42.00	44.43	45.41	46.36	48.00	49.14	50.00	50.66	51.17	51.54	51.80	51.95
	a_p	0.00	0.15	0.30	0.50	1.00	1.50	2.00	2.50	3.00	3.50	4.00	4.50
	1 ⇨ f	-	0.20	0.19	0.18	0.17	0.16	0.15	0.14	0.13	0.12	0.11	0.10

DCX	µm	3	5	10	15	20	30	40	50	60	80	100
25	FE	0.548	0.707	1.000	1.225	1.414	1.732	2.000	2.236	2.449	2.828	3.162
32		0.620	0.800	1.131	1.386	1.600	1.960	2.263	2.530	2.771	3.200	3.578
35		0.648	0.837	1.183	1.449	1.673	2.049	2.366	2.646	2.898	3.347	3.742
40		0.693	0.894	1.265	1.549	1.789	2.191	2.530	2.828	3.098	3.578	4.000
42		0.710	0.917	1.296	1.587	1.833	2.245	2.592	2.898	3.175	3.666	4.099
50		0.775	1.000	1.414	1.732	2.000	2.449	2.828	3.162	3.464	4.000	4.472
52		0.790	1.020	1.442	1.766	2.040	2.498	2.884	3.225	3.533	4.079	4.561
RE	µm	3	5	10	15	20	30	40	50	60	80	100
5.0	FE	0.346	0.447	0.632	0.775	0.894	1.095	1.265	1.414	1.549	1.789	2.000

SRN12

P M S

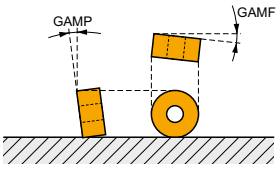
DORMER PRAMET

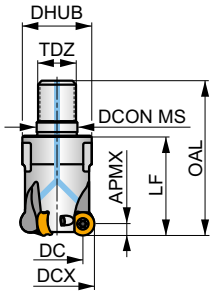
S

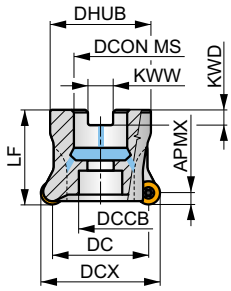
ECON RN12 Copy Mill with Double Negative Design and Internal Coolant

Economical copy mill utilizing double-sided negative inserts RNMU 12 with APMX of 5.5 mm. Suitable for face milling, copy milling and high-feed cutting. Available in modular and arbor style. Body treated for longer tool life.

APMX	5.5 mm







h_m	0.11-0.31
h_m	0.11-0.31

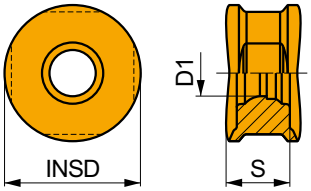
	Product	DCX (mm)	DC (mm)	OAL (mm)	DCON MS (mm)	DHUB (mm)	DCCB (mm)	LF (mm)	TDZ	KWW (mm)	KWD (mm)	GAMF (°)	GAMP (°)			max.		kg		
MODULAR	32E3R042M16-SRN12-C	32	20	65	17	29	–	42	M16	–	–	-14	-4	3	–	16600	✓	0.19	GI111	CO400
MODULAR	40E4R042M16-SRN12-C	40	28	65	17	29	–	42	M16	–	–	-12	-4	4	–	14800	✓	0.24	GI111	CO400
ISO 6462 DIN 8030	50A05R-SMORN12-C	50	38	–	22	48	18.1	40	–	10.4	6.3	-11	-4	5	–	13200	✓	0.31	GI111	CO401
ISO 6462 DIN 8030	50A06R-SMORN12-C	50	38	–	22	48	18.1	40	–	10.4	6.3	-11	-4	6	–	13200	✓	0.32	GI111	CO401
ISO 6462 DIN 8030	52A05R-SMORN12-C	52	40	–	22	48	18.1	40	–	10.4	6.3	-11	-4	5	–	13000	✓	0.33	GI111	CO401
ISO 6462 DIN 8030	52A06R-SMORN12-C	52	40	–	22	48	18.1	40	–	10.4	6.3	-11	-4	6	–	13000	✓	0.34	GI111	CO401
ISO 6462 DIN 8030	63A07R-SMORN12-C	63	51	–	27	58	22.1	50	–	12.4	7	-11	-4	7	–	11800	✓	0.68	GI111	CO402
ISO 6462 DIN 8030	66A07R-SMORN12-C	66	54	–	27	58	22.1	50	–	12.4	7	-11	-4	7	–	11500	✓	0.73	GI111	CO402
ISO 6462 DIN 8030	80A08R-SMORN12-C	80	68	–	27	58	22.1	50	–	12.4	7	-10	-4	8	–	10500	✓	0.98	GI111	CO402

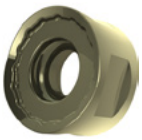
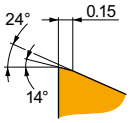
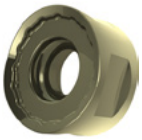
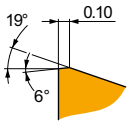
GI111	RNMU 1205..

		Nm					
CO400	US64010A-T15P	3.5	M4	10	FLAG T15P	–	–
CO401	US64010A-T15P	3.5	M4	10	–	SDR T15P-T	HS 1030C
CO402	US64010A-T15P	3.5	M4	10	–	SDR T15P-T	HS 1230C

RNMU12

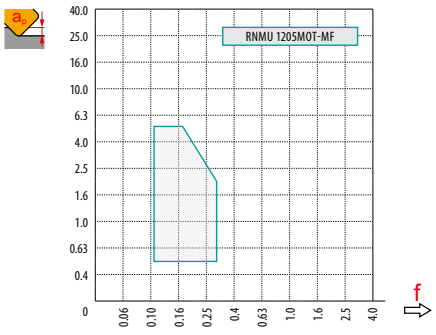
	INSD (mm)	D1 (mm)	S (mm)
1205	12.000	4.40	5.40

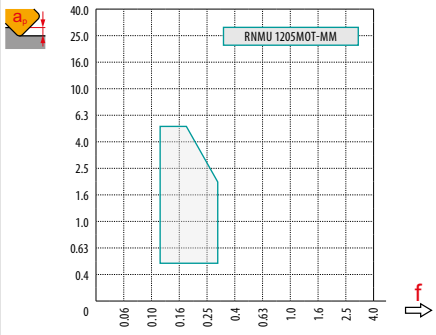


Product	Interrupted/ Continuous cut	RE (mm)	P vc (m/min)	P f (mm/tooth)	P ap (mm)	M vc (m/min)	M f (mm/tooth)	M ap (mm)	K vc (m/min)	K f (mm/tooth)	K ap (mm)	N vc (m/min)	N f (mm/tooth)	N ap (mm)	S vc (m/min)	S f (mm/tooth)	S ap (mm)	H vc (m/min)	H f (mm/tooth)	H ap (mm)
 																				
MF geometry with highly positive design for light machining.																				
RNMU 1205MOT-MF:M6030	✱	–	–	–	–	■ 125	0.14	4.0	–	–	–	–	–	–	■ 50	0.11	3.2	–	–	–
RNMU 1205MOT-MF:M6040	✱	–	■ 190	0.15	4.0	■ 110	0.14	4.0	–	–	–	–	–	–	■ 45	0.11	3.2	–	–	–
 																				
MM geometry with negative T-land and positive design for medium machining.																				
RNMU 1205MOT-MM:M6030	✱	–	–	–	–	■ 120	0.15	4.0	–	–	–	–	–	–	■ 50	0.12	3.2	–	–	–
RNMU 1205MOT-MM:M6040	✱	–	■ 185	0.17	4.0	■ 110	0.15	4.0	–	–	–	–	–	–	■ 45	0.12	3.2	–	–	–

a_e/DCX	5 %	10 %	15 %	20 %	25 %	30 %	40 %	50 %	60 %	70 %	75 %	80 %	90 %	100 %
X.V	1.48	1.35	1.27	1.22	1.19	1.16	1.11	1.08	1.05	1.03	1.00	1.00	1.00	1.00
⇨ x.f	2.20	1.60	1.35	1.20	1.10	0.95	0.85	0.75	0.85	0.95	1.00	1.00	1.00	1.00
⇨ x.f	0.64	0.64	0.64	0.64	0.64	0.65	0.65	0.67	0.68	0.71	0.72	0.74	0.79	1.00

	RNMU 12-MF	RNMU 12-MM
RE	6.0	6.0
BS	–	–





DCX	a_p	0.00	0.50	1.00	1.50	2.00	2.50	3.00	3.50	4.00	4.50	5.00	5.50
32	DEF	20.00	24.80	26.63	27.94	28.94	29.75	30.39	30.91	31.31	31.62	31.83	31.96
40		28.00	32.80	34.63	35.94	36.94	37.75	38.39	38.91	39.31	39.62	39.83	39.96
50		38.00	42.80	44.63	45.94	46.94	47.75	48.39	48.91	49.31	49.62	49.83	49.96
52		40.00	44.80	46.63	47.94	48.94	49.75	50.39	50.91	51.31	51.62	51.83	51.96
63		51.00	55.80	57.63	58.94	59.94	60.75	61.39	61.91	62.31	62.62	62.83	62.96
66		54.00	58.80	60.63	61.94	62.94	63.75	64.39	64.91	65.31	65.62	65.83	65.96
80		68.00	72.80	74.63	75.94	76.94	77.75	78.39	78.91	79.31	79.62	79.83	79.96
	a_p	0.00	0.50	1.00	1.50	2.00	2.50	3.00	3.50	4.00	4.50	5.00	5.50
	1 ⇨f	-	0.26	0.24	0.22	0.20	0.18	0.16	0.15	0.14	0.13	0.12	0.11

DCX	µm	3	5	10	15	20	30	40	50	60	80	100
32	FE	0.620	0.800	1.131	1.386	1.600	1.960	2.263	2.530	2.771	3.200	3.578
40		0.693	0.894	1.265	1.549	1.789	2.191	2.530	2.828	3.098	3.578	4.000
50		0.775	1.000	1.414	1.732	2.000	2.449	2.828	3.162	3.464	4.000	4.472
52		0.790	1.020	1.442	1.766	2.040	2.498	2.884	3.225	3.533	4.079	4.561
63		0.869	1.122	1.587	1.944	2.245	2.750	3.175	3.550	3.888	4.490	5.020
66		0.890	1.149	1.625	1.990	2.298	2.814	3.250	3.633	3.980	4.596	5.138
80		0.980	1.265	1.789	2.191	2.530	3.098	3.578	4.000	4.382	5.060	5.657
RE	µm	3	5	10	15	20	30	40	50	60	80	100
6.0	FE	0.379	0.490	0.693	0.849	0.980	1.200	1.386	1.549	1.697	1.960	2.191

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