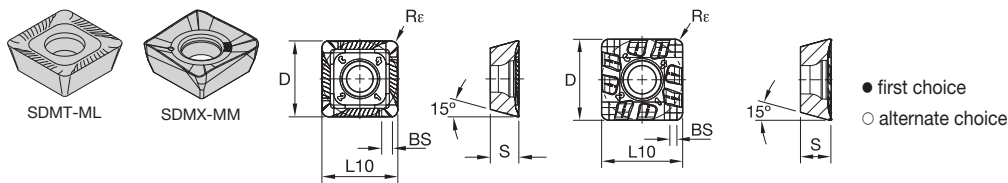


■ **Insert Selection Guide**

| Material Group | Light Machining | | General Purpose | | Heavy Machining | |
|----------------|-----------------|--------|-----------------|--------|-----------------|--------|
| | Geometry | Grade | Geometry | Grade | Geometry | Grade |
| P1-P2 | .E..ML | TN6540 | .S..MM | TN6540 | .S..MH | TN6540 |
| P3-P4 | .E..ML | TN7535 | .S..MM | TN6540 | .S..MH | TN6540 |
| P5-P6 | .E..ML | TN7535 | .S..MM | TN6540 | .S..MH | TN6540 |
| M1-M2 | .E..ML | TN6540 | .S..MM | TN6540 | .S..MH | TN6540 |
| M3 | .E..ML | TN7535 | .S..MM | TN7535 | .S..MH | TN7535 |
| K1-K2 | .E..ML | WK15CM | .E..ML | WK15CM | .S..MH | WK15CM |
| K3 | .E..ML | WK15CM | .S..MM | WK15CM | .S..MH | WK15CM |
| N1-N2 | - | - | - | - | - | - |
| N3 | - | - | - | - | - | - |
| S1-S2 | .E..ML | TN6540 | .S..MM | TN6540 | .S..MM | TN6540 |
| S3 | .E..ML | TN6540 | .S..MM | TN6540 | .S..MM | TN6540 |
| S4 | .E..ML | TN6540 | .S..MM | TN6540 | .S..MM | TN6540 |
| H1 | .S..MM | TN6540 | .S..MM | TN6540 | .S..MM | TN6540 |

Shoulder Mills

Inserts • SD1506..



| | | | | | |
|---|---|---|---|---|---|
| P | ○ | ● | ● | ● | ● |
| M | ● | ● | ○ | ○ | ○ |
| K | ● | ○ | ○ | ○ | ● |
| N | ○ | ○ | ○ | ○ | ○ |
| S | ○ | ● | ○ | ○ | ○ |
| H | ○ | ○ | ○ | ○ | ○ |

■ **SDMT-ML**

| catalogue number | cutting edges | D | L10 | S | BS | Rε | hm | TN2510 | TN6540 | TN7525 | TN7535 | WK15CM |
|------------------|---------------|-------|-------|------|------|------|------|--------|--------|--------|--------|--------|
| SDMT1506PDRML | 4 | 15,88 | 15,88 | 6,32 | 1,10 | 1,20 | 0,08 | ○ | ● | ○ | ○ | ○ |

■ **SDMX-MM**

| catalogue number | cutting edges | D | L10 | S | BS | Rε | hm | TN2510 | TN6540 | TN7525 | TN7535 | WK15CM |
|------------------|---------------|-------|-------|------|------|------|------|--------|--------|--------|--------|--------|
| SDMX150612RMM | 4 | 15,88 | 15,88 | 6,35 | 1,45 | 1,20 | 0,14 | ○ | ○ | ○ | ○ | ○ |