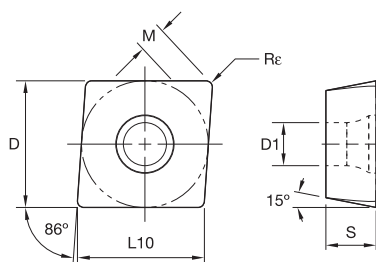
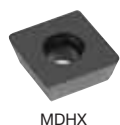


■ Insert Selection Guide

Material Group	Light Machining		General Purpose		Heavy Machining	
	Geometry	Grade	Geometry	Grade	Geometry	Grade
P1-P2	MDHX	WP40PM	MDHX	WP40PM	MDHX	WP40PM
P3-P4	MDHX	WP35CM	MDHX	WP35CM	MDHX	WP35CM
P5-P6	MDHX	WP35CM	MDHX	WP40PM	MDHX	WU35PM
M1-M2	MDHX	WP25PM	MDHX	WP25PM	MDHX	WU35PM
M3	MDHX	WP35CM	MDHX	WP40PM	MDHX	WU35PM
K1-K2	MDHX	WK15CM	MDHX	WK15CM	MDHX	WK15CM
K3	MDHX	WK15CM	MDHX	WP35CM	MDHX	WP35CM
N1-N2	-	-	-	-	-	-
N3	-	-	-	-	-	-
S1-S2	MDHX	WP25PM	MDHX	WU35PM	MDHX	WU35PM
S3	MDHX	WU35PM	MDHX	WU35PM	MDHX	WU35PM
S4	MDHX	WP25PM	MDHX	WU35PM	MDHX	WU35PM
H1	-	-	-	-	-	-

Inserts • MDH..



● first choice
○ alternate choice

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

■ MDHX

catalogue number	cutting edges	D	D1	L10	M	S	Re	WK15CM	WP25PM	WU35PM	WP35CM	WP40PM
MDHX09T308	2	9,53	3,40	9,55	1,85	3,97	0,80	5903706	5903722	5903710	5903708	5903704

Recommended Starting Feeds

■ Recommended Starting Feeds [mm]

Light Machining	General Purpose	Heavy Machining
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Insert Geometry	Programmed Feed per Tooth (fz) as a % of Radial Depth of Cut (ae)														Insert Geometry	
	5%		10%		20%		30%		40-100%							
MDHX	0,12	0,23	0,46	0,08	0,17	0,33	0,06	0,13	0,25	0,06	0,11	0,22	0,05	0,10	0,20	MDHX

NOTE: Use "Light Machining" value as starting feed rate.