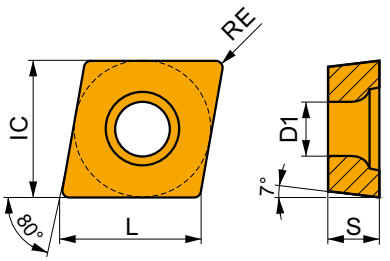
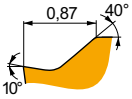
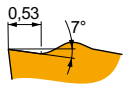
# CCMT

PRAMET

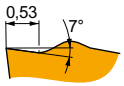
| | IC [mm] | D1 [mm] | L [mm] | S [mm] |
|---|---|---|---|---|
| 0602 | 6.350 | 2.80 | 6.40 | 2.38 |
| 0803 | 7.940 | 3.40 | 8.10 | 3.18 |
| 09T3 | 9.525 | 4.40 | 9.70 | 3.97 |
| 1204 | 12.700 | 5.50 | 12.90 | 4.76 |



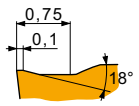

Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

| Product | | 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] |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
|  |   | | | | | | | | | | | | | | | | | | | |
| FF geometry with positive design for fine-finish to finish machining, and continuous to slightly interrupted cuts. | | | | | | | | | | | | | | | | | | | | |
| **CCMT 060202E-FF** | **T8315** | 0.2 | ◪ 195 | 0.10 | 1.0 | ◪ 115 | 0.09 | 1.0 | – | – | – | – | – | – | – | – | – | – | – | – |
| | **T8330** | 0.2 | ■ 185 | 0.10 | 1.0 | ◪ 110 | 0.09 | 1.0 | – | – | – | – | – | – | – | – | – | – | – | – |
| | **T8430** | 0.2 | ■ 230 | 0.10 | 1.0 | ◪ 125 | 0.09 | 1.0 | – | – | – | – | – | – | – | – | – | – | – | – |
| | **T9315** | 0.2 | ■ 315 | 0.10 | 1.0 | – | – | – | – | – | – | – | – | – | – | – | – | – | – | – |
| **CCMT 060204E-FF** | **T8315** | 0.4 | ◪ 195 | 0.12 | 1.0 | ◪ 115 | 0.11 | 1.0 | – | – | – | – | – | – | – | – | – | – | – | – |
| | **T8330** | 0.4 | ■ 185 | 0.12 | 1.0 | ◪ 110 | 0.11 | 1.0 | – | – | – | – | – | – | – | – | – | – | – | – |
| | **T8430** | 0.4 | ■ 225 | 0.12 | 1.0 | ◪ 120 | 0.11 | 1.0 | – | – | – | – | – | – | – | – | – | – | – | – |
| | **T9315** | 0.4 | ■ 310 | 0.12 | 1.0 | – | – | – | – | – | – | – | – | – | – | – | – | – | – | – |
| **CCMT 09T304E-FF** | **T8315** | 0.4 | ◪ 190 | 0.12 | 1.2 | ◪ 110 | 0.11 | 1.2 | – | – | – | – | – | – | – | – | – | – | – | – |
| | **T8330** | 0.4 | ■ 185 | 0.12 | 1.2 | ◪ 110 | 0.11 | 1.2 | – | – | – | – | – | – | – | – | – | – | – | – |
| | **T8430** | 0.4 | ■ 225 | 0.12 | 1.2 | ◪ 120 | 0.11 | 1.2 | – | – | – | – | – | – | – | – | – | – | – | – |
| | **T9315** | 0.4 | ■ 300 | 0.12 | 1.2 | – | – | – | – | – | – | – | – | – | – | – | – | – | – | – |
|  |   | | | | | | | | | | | | | | | | | | | |
| FF2 geometry with positive design for fine-finish to finish machining, and continuous to slightly interrupted cuts. | | | | | | | | | | | | | | | | | | | | |
| **CCMT 060202E-FF2** | **T7325** | 0.2 | ◪ 240 | 0.05 | 0.8 | – | – | – | – | – | – | – | – | – | – | – | – | – | – | – |
| | **T8330** | 0.2 | ■ 205 | 0.05 | 0.8 | – | – | – | ■ 190 | 0.05 | 0.8 | – | – | – | – | – | – | – | – | – |
| | **T8430** | 0.2 | ■ 280 | 0.05 | 0.8 | – | – | – | ◪ 230 | 0.05 | 0.8 | – | – | – | – | – | – | – | – | – |
| | **T9315** | 0.2 | ■ 390 | 0.05 | 0.8 | – | – | – | ◪ 370 | 0.05 | 0.8 | – | – | – | – | – | – | – | – | – |
| | **T9325** | 0.2 | ■ 350 | 0.05 | 0.8 | – | – | – | ◪ 330 | 0.05 | 0.8 | – | – | – | – | – | – | – | – | – |
| | **TT010** | 0.2 | ■ 345 | 0.05 | 0.5 | – | – | – | – | – | – | – | – | – | – | – | – | – | – | – |
| **CCMT 060204E-FF2** | **T7325** | 0.4 | ◪ 190 | 0.12 | 1.0 | – | – | – | – | – | – | – | – | – | – | – | – | – | – | – |
| | **T8330** | 0.4 | ■ 165 | 0.12 | 1.0 | – | – | – | ■ 155 | 0.12 | 1.0 | – | – | – | – | – | – | – | – | – |
| | **T8430** | 0.4 | ■ 205 | 0.12 | 1.0 | – | – | – | ◪ 170 | 0.12 | 1.0 | – | – | – | – | – | – | – | – | – |
| | **T9315** | 0.4 | ■ 280 | 0.12 | 1.0 | – | – | – | ◪ 265 | 0.12 | 1.0 | – | – | – | – | – | – | – | – | – |
| | **T9325** | 0.4 | ■ 255 | 0.12 | 1.0 | – | – | – | ◪ 240 | 0.12 | 1.0 | – | – | – | – | – | – | – | – | – |
| | **T9335** | 0.4 | ■ 215 | 0.12 | 1.0 | – | – | – | – | – | – | – | – | – | – | – | – | – | – | – |
| | **TT010** | 0.4 | ■ 280 | 0.12 | 0.5 | – | – | – | – | – | – | – | – | – | – | – | – | – | – | – |
| **CCMT 080302E-FF2** | **T7325** | 0.2 | ◪ 240 | 0.05 | 0.8 | – | – | – | – | – | – | – | – | – | – | – | – | – | – | – |
| | **T8330** | 0.2 | ■ 205 | 0.05 | 0.8 | – | – | – | ■ 190 | 0.05 | 0.8 | – | – | – | – | – | – | – | – | – |
| | **T8430** | 0.2 | ■ 280 | 0.05 | 0.8 | – | – | – | ◪ 230 | 0.05 | 0.8 | – | – | – | – | – | – | – | – | – |
| | **T9325** | 0.2 | ■ 350 | 0.05 | 0.8 | – | – | – | ◪ 330 | 0.05 | 0.8 | – | – | – | – | – | – | – | – | – |
| | **TT010** | 0.2 | ■ 345 | 0.05 | 0.5 | – | – | – | – | – | – | – | – | – | – | – | – | – | – | – |
| **CCMT 080304E-FF2** | **T7325** | 0.4 | ◪ 190 | 0.12 | 1.0 | – | – | – | – | – | – | – | – | – | – | – | – | – | – | – |
| | **T8330** | 0.4 | ■ 165 | 0.12 | 1.0 | – | – | – | ■ 155 | 0.12 | 1.0 | – | – | – | – | – | – | – | – | – |
| | **T8430** | 0.4 | ■ 205 | 0.12 | 1.0 | – | – | – | ◪ 170 | 0.12 | 1.0 | – | – | – | – | – | – | – | – | – |
| | **T9325** | 0.4 | ■ 255 | 0.12 | 1.0 | – | – | – | ◪ 240 | 0.12 | 1.0 | – | – | – | – | – | – | – | – | – |
| | **TT010** | 0.4 | ■ 350 | 0.06 | 0.5 | – | – | – | – | – | – | – | – | – | – | – | – | – | – | – |

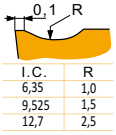
Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

| Product | | RE | P | | | M | | | K | | | N | | | S | | | H | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| | | | vc | f | ap | vc | f | ap | vc | f | ap | vc | f | ap | vc | f | ap | vc | f | ap |
| | | [mm] | [m/min] | [mm/rev] | [mm] | [m/min] | [mm/rev] | [mm] | [m/min] | [mm/rev] | [mm] | [m/min] | [mm/rev] | [mm] | [m/min] | [mm/rev] | [mm] | [m/min] | [mm/rev] | [mm] |
|  |  | | | | | | | | | | | | | | | | | | | |
| FF2 geometry with positive design for fine-finish to finish machining, and continuous to slightly interrupted cuts. | | | | | | | | | | | | | | | | | | | | |
| **CCMT 080308E-FF2** | **T7325** | 0.8 | 205 | 0.17 | 1.0 | – | – | – | – | – | – | – | – | – | – | – | – | – | – | – |
| | **T8330** | 0.8 | 180 | 0.17 | 1.0 | – | – | – | 170 | 0.17 | 1.0 | – | – | – | – | – | – | – | – | – |
| | **T8430** | 0.8 | 210 | 0.17 | 1.0 | – | – | – | 175 | 0.17 | 1.0 | – | – | – | – | – | – | – | – | – |
| | **T9325** | 0.8 | 260 | 0.17 | 1.0 | – | – | – | 245 | 0.17 | 1.0 | – | – | – | – | – | – | – | – | – |
| **CCMT 09T304E-FF2** | **T7325** | 0.4 | 190 | 0.12 | 1.2 | – | – | – | – | – | – | – | – | – | – | – | – | – | – | – |
| | **T8330** | 0.4 | 165 | 0.12 | 1.2 | – | – | – | 155 | 0.12 | 1.2 | – | – | – | – | – | – | – | – | – |
| | **T8430** | 0.4 | 200 | 0.12 | 1.2 | – | – | – | 165 | 0.12 | 1.2 | – | – | – | – | – | – | – | – | – |
| | **T9315** | 0.4 | 275 | 0.12 | 1.2 | – | – | – | 260 | 0.12 | 1.2 | – | – | – | – | – | – | – | – | – |
| | **T9325** | 0.4 | 250 | 0.12 | 1.2 | – | – | – | 235 | 0.12 | 1.2 | – | – | – | – | – | – | – | – | – |
| | **T9335** | 0.4 | 215 | 0.12 | 1.2 | – | – | – | – | – | – | – | – | – | – | – | – | – | – | – |
| | **TT010** | 0.4 | 350 | 0.06 | 0.5 | – | – | – | – | – | – | – | – | – | – | – | – | – | – | – |
| **CCMT 09T308E-FF2** | **T7325** | 0.8 | 205 | 0.17 | 1.2 | – | – | – | – | – | – | – | – | – | – | – | – | – | – | – |
| | **T8330** | 0.8 | 175 | 0.17 | 1.2 | – | – | – | 165 | 0.17 | 1.2 | – | – | – | – | – | – | – | – | – |
| | **T8430** | 0.8 | 205 | 0.17 | 1.2 | – | – | – | 170 | 0.17 | 1.2 | – | – | – | – | – | – | – | – | – |
| | **T9315** | 0.8 | 285 | 0.17 | 1.2 | – | – | – | 270 | 0.17 | 1.2 | – | – | – | – | – | – | – | – | – |
| | **T9325** | 0.8 | 255 | 0.17 | 1.2 | – | – | – | 240 | 0.17 | 1.2 | – | – | – | – | – | – | – | – | – |
| | **TT010** | 0.8 | 350 | 0.10 | 0.8 | – | – | – | – | – | – | – | – | – | – | – | – | – | – | – |
|  |  | | | | | | | | | | | | | | | | | | | |
| FM geometry for finish to semi-rough machining, and continuous to slightly interrupted cuts. | | | | | | | | | | | | | | | | | | | | |
| **CCMT 060202E-FM** | **T7325** | 0.2 | 210 | 0.10 | 1.0 | 160 | 0.09 | 1.0 | – | – | – | – | – | – | – | – | – | – | – | – |
| | **T7335** | 0.2 | 210 | 0.10 | 1.0 | 160 | 0.09 | 1.0 | – | – | – | – | – | – | – | – | – | – | – | – |
| | **T8315** | 0.2 | 195 | 0.10 | 1.0 | 115 | 0.09 | 1.0 | 185 | 0.10 | 1.0 | 585 | 0.12 | 1.0 | – | – | – | – | – | – |
| | **T8330** | 0.2 | 185 | 0.10 | 1.0 | 110 | 0.09 | 1.0 | 175 | 0.10 | 1.0 | 555 | 0.12 | 1.0 | – | – | – | – | – | – |
| | **T8430** | 0.2 | 230 | 0.10 | 1.0 | 125 | 0.09 | 1.0 | 185 | 0.10 | 1.0 | 630 | 0.12 | 1.0 | – | – | – | – | – | – |
| | **T9315** | 0.2 | 315 | 0.10 | 1.0 | – | – | – | 295 | 0.10 | 1.0 | – | – | – | – | – | – | – | – | – |
| | **T9325** | 0.2 | 285 | 0.10 | 1.0 | 170 | 0.09 | 1.0 | 270 | 0.10 | 1.0 | – | – | – | – | – | – | – | – | – |
| **CCMT 060204E-FM** | **T7325** | 0.4 | 200 | 0.15 | 1.0 | 155 | 0.15 | 1.0 | – | – | – | – | – | – | – | – | – | – | – | – |
| | **T7335** | 0.4 | 195 | 0.15 | 1.0 | 150 | 0.15 | 1.0 | – | – | – | – | – | – | – | – | – | – | – | – |
| | **T8315** | 0.4 | 185 | 0.15 | 1.0 | 110 | 0.14 | 1.0 | 175 | 0.15 | 1.0 | 555 | 0.18 | 1.0 | – | – | – | – | – | – |
| | **T8330** | 0.4 | 170 | 0.15 | 1.0 | 100 | 0.14 | 1.0 | 160 | 0.15 | 1.0 | 510 | 0.18 | 1.0 | – | – | – | – | – | – |
| | **T8430** | 0.4 | 205 | 0.15 | 1.0 | 110 | 0.14 | 1.0 | 170 | 0.15 | 1.0 | 570 | 0.18 | 1.0 | – | – | – | – | – | – |
| | **T9315** | 0.4 | 285 | 0.15 | 1.0 | – | – | – | 270 | 0.15 | 1.0 | – | – | – | – | – | – | – | – | – |
| | **T9325** | 0.4 | 250 | 0.15 | 1.0 | 150 | 0.15 | 1.0 | 235 | 0.15 | 1.0 | – | – | – | – | – | – | – | – | – |
| **CCMT 060208E-FM** | **T7325** | 0.8 | 220 | 0.20 | 1.0 | 170 | 0.18 | 1.0 | – | – | – | – | – | – | – | – | – | – | – | – |
| | **T8330** | 0.8 | 190 | 0.20 | 1.0 | 110 | 0.18 | 1.0 | 180 | 0.20 | 1.0 | 570 | 0.24 | 1.0 | – | – | – | – | – | – |
| | **T8430** | 0.8 | 220 | 0.20 | 1.0 | 120 | 0.18 | 1.0 | 180 | 0.20 | 1.0 | 600 | 0.24 | 1.0 | – | – | – | – | – | – |
| | **T9315** | 0.8 | 300 | 0.20 | 1.0 | – | – | – | 285 | 0.20 | 1.0 | – | – | – | – | – | – | – | – | – |
| | **T9325** | 0.8 | 265 | 0.20 | 1.0 | 155 | 0.18 | 1.0 | 250 | 0.20 | 1.0 | – | – | – | – | – | – | – | – | – |
| **CCMT 09T302E-FM** | **T7325** | 0.2 | 205 | 0.10 | 1.2 | 155 | 0.09 | 1.2 | – | – | – | – | – | – | – | – | – | – | – | – |
| | **T7335** | 0.2 | 205 | 0.10 | 1.2 | 155 | 0.09 | 1.2 | – | – | – | – | – | – | – | – | – | – | – | – |
| | **T8315** | 0.2 | 190 | 0.10 | 1.2 | 110 | 0.09 | 1.2 | 180 | 0.10 | 1.2 | 570 | 0.12 | 1.2 | – | – | – | – | – | – |
| | **T8330** | 0.2 | 180 | 0.10 | 1.2 | 105 | 0.09 | 1.2 | 170 | 0.10 | 1.2 | 540 | 0.12 | 1.2 | – | – | – | – | – | – |
| | **T8430** | 0.2 | 225 | 0.10 | 1.2 | 120 | 0.09 | 1.2 | 185 | 0.10 | 1.2 | 615 | 0.12 | 1.2 | – | – | – | – | – | – |
| | **T9315** | 0.2 | 310 | 0.10 | 1.2 | – | – | – | 290 | 0.10 | 1.2 | – | – | – | – | – | – | – | – | – |
| | **T9325** | 0.2 | 275 | 0.10 | 1.2 | 165 | 0.09 | 1.2 | 260 | 0.10 | 1.2 | – | – | – | – | – | – | – | – | – |
| **CCMT 09T304E-FM** | **T7325** | 0.4 | 195 | 0.15 | 1.2 | 150 | 0.15 | 1.2 | – | – | – | – | – | – | – | – | – | – | – | – |
| | **T7335** | 0.4 | 190 | 0.15 | 1.2 | 145 | 0.15 | 1.2 | – | – | – | – | – | – | – | – | – | – | – | – |
| | **T8315** | 0.4 | 180 | 0.15 | 1.2 | 105 | 0.14 | 1.2 | 170 | 0.15 | 1.2 | 540 | 0.18 | 1.2 | – | – | – | – | – | – |
| | **T8330** | 0.4 | 170 | 0.15 | 1.2 | 100 | 0.14 | 1.2 | 160 | 0.15 | 1.2 | 510 | 0.18 | 1.2 | – | – | – | – | – | – |
| | **T8430** | 0.4 | 200 | 0.15 | 1.2 | 110 | 0.14 | 1.2 | 165 | 0.15 | 1.2 | 555 | 0.18 | 1.2 | – | – | – | – | – | – |
| | **T9315** | 0.4 | 275 | 0.15 | 1.2 | – | – | – | 260 | 0.15 | 1.2 | – | – | – | – | – | – | – | – | – |
| | **T9325** | 0.4 | 245 | 0.15 | 1.2 | 145 | 0.15 | 1.2 | 230 | 0.15 | 1.2 | – | – | – | – | – | – | – | – | – |

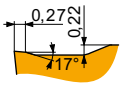
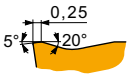
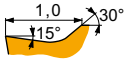
Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

| Product | | RE | P | | | M | | | K | | | N | | | S | | | H | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| | | | vc | f | ap | vc | f | ap | vc | f | ap | vc | f | ap | vc | f | ap | vc | f | ap |
| | | [mm] | [m/min] | [mm/rev] | [mm] | [m/min] | [mm/rev] | [mm] | [m/min] | [mm/rev] | [mm] | [m/min] | [mm/rev] | [mm] | [m/min] | [mm/rev] | [mm] | [m/min] | [mm/rev] | [mm] |
|  |  | | | | | | | | | | | | | | | | | | | |
| FM geometry for finish to semi-rough machining, and continuous to slightly interrupted cuts. | | | | | | | | | | | | | | | | | | | | |
| **CCMT 09T308E-FM** | **T7325** | 0.8 | 215 | 0.20 | 1.2 | 165 | 0.18 | 1.2 | – | – | – | – | – | – | – | – | – | – | – | – |
| | **T7335** | 0.8 | 205 | 0.20 | 1.2 | 155 | 0.18 | 1.2 | – | – | – | – | – | – | – | – | – | – | – | – |
| | **T8315** | 0.8 | 195 | 0.20 | 1.2 | 115 | 0.18 | 1.2 | 185 | 0.20 | 1.2 | 585 | 0.24 | 1.2 | – | – | – | – | – | – |
| | **T8330** | 0.8 | 185 | 0.20 | 1.2 | 110 | 0.18 | 1.2 | 175 | 0.20 | 1.2 | 555 | 0.24 | 1.2 | – | – | – | – | – | – |
| | **T8430** | 0.8 | 210 | 0.20 | 1.2 | 115 | 0.18 | 1.2 | 175 | 0.20 | 1.2 | 585 | 0.24 | 1.2 | – | – | – | – | – | – |
| | **T9315** | 0.8 | 290 | 0.20 | 1.2 | – | – | – | 275 | 0.20 | 1.2 | – | – | – | – | – | – | – | – | – |
| | **T9325** | 0.8 | 260 | 0.20 | 1.2 | 155 | 0.18 | 1.2 | 245 | 0.20 | 1.2 | – | – | – | – | – | – | – | – | – |
| **CCMT 120404E-FM** | **T7325** | 0.4 | 190 | 0.15 | 1.7 | 145 | 0.15 | 1.7 | – | – | – | – | – | – | – | – | – | – | – | – |
| | **T7335** | 0.4 | 185 | 0.15 | 1.7 | 140 | 0.15 | 1.7 | – | – | – | – | – | – | – | – | – | – | – | – |
| | **T8315** | 0.4 | 170 | 0.15 | 1.7 | 100 | 0.14 | 1.7 | 160 | 0.15 | 1.7 | 510 | 0.18 | 1.7 | – | – | – | – | – | – |
| | **T8330** | 0.4 | 165 | 0.15 | 1.7 | 95 | 0.14 | 1.7 | 155 | 0.15 | 1.7 | 495 | 0.18 | 1.7 | – | – | – | – | – | – |
| | **T8430** | 0.4 | 195 | 0.15 | 1.7 | 105 | 0.14 | 1.7 | 160 | 0.15 | 1.7 | 540 | 0.18 | 1.7 | – | – | – | – | – | – |
| | **T9315** | 0.4 | 265 | 0.15 | 1.7 | – | – | – | 250 | 0.15 | 1.7 | – | – | – | – | – | – | – | – | – |
| | **T9325** | 0.4 | 240 | 0.15 | 1.7 | 140 | 0.15 | 1.7 | 225 | 0.15 | 1.7 | – | – | – | – | – | – | – | – | – |
| **CCMT 120408E-FM** | **T7325** | 0.8 | 205 | 0.20 | 1.7 | 155 | 0.18 | 1.7 | – | – | – | – | – | – | – | – | – | – | – | – |
| | **T7335** | 0.8 | 200 | 0.20 | 1.7 | 155 | 0.18 | 1.7 | – | – | – | – | – | – | – | – | – | – | – | – |
| | **T8315** | 0.8 | 190 | 0.20 | 1.7 | 110 | 0.18 | 1.7 | 180 | 0.20 | 1.7 | 570 | 0.24 | 1.7 | – | – | – | – | – | – |
| | **T8330** | 0.8 | 180 | 0.20 | 1.7 | 105 | 0.18 | 1.7 | 170 | 0.20 | 1.7 | 540 | 0.24 | 1.7 | – | – | – | – | – | – |
| | **T8430** | 0.8 | 205 | 0.20 | 1.7 | 110 | 0.18 | 1.7 | 170 | 0.20 | 1.7 | 570 | 0.24 | 1.7 | – | – | – | – | – | – |
| | **T9315** | 0.8 | 280 | 0.20 | 1.7 | – | – | – | 265 | 0.20 | 1.7 | – | – | – | – | – | – | – | – | – |
| | **T9325** | 0.8 | 250 | 0.20 | 1.7 | 150 | 0.18 | 1.7 | 235 | 0.20 | 1.7 | – | – | – | – | – | – | – | – | – |
| **CCMT 120412E-FM** | **T8330** | 1.2 | 175 | 0.27 | 1.7 | 105 | 0.24 | 1.7 | 165 | 0.27 | 1.7 | 525 | 0.32 | 1.7 | – | – | – | – | – | – |
| | **T8430** | 1.2 | 190 | 0.27 | 1.7 | 105 | 0.24 | 1.7 | 155 | 0.27 | 1.7 | 525 | 0.32 | 1.7 | – | – | – | – | – | – |
| | **T9325** | 1.2 | 235 | 0.27 | 1.7 | 140 | 0.24 | 1.7 | 220 | 0.27 | 1.7 | – | – | – | – | – | – | – | – | – |
|  |  | | | | | | | | | | | | | | | | | | | |
| FM2 geometry for finish to medium machining, and continuous to interrupted cuts. | | | | | | | | | | | | | | | | | | | | |
| **CCMT 080304E-FM2** | **T8330** | 0.4 | 165 | 0.12 | 1.0 | 95 | 0.11 | 1.0 | 155 | 0.12 | 1.0 | – | – | – | – | – | – | – | – | – |
| | **T8430** | 0.4 | 205 | 0.12 | 1.0 | 110 | 0.11 | 1.0 | 170 | 0.12 | 1.0 | – | – | – | – | – | – | – | – | – |
| | **T9315** | 0.4 | 280 | 0.12 | 1.0 | – | – | – | 265 | 0.12 | 1.0 | – | – | – | – | – | – | – | – | – |
| | **T9325** | 0.4 | 255 | 0.12 | 1.0 | 150 | 0.11 | 1.0 | 240 | 0.12 | 1.0 | – | – | – | – | – | – | – | – | – |
| | **T9335** | 0.4 | 215 | 0.12 | 1.0 | 125 | 0.11 | 1.0 | – | – | – | – | – | – | – | – | – | – | – | – |
| **CCMT 080308E-FM2** | **T8330** | 0.8 | 180 | 0.17 | 1.0 | 105 | 0.15 | 1.0 | 170 | 0.17 | 1.0 | – | – | – | – | – | – | – | – | – |
| | **T8430** | 0.8 | 210 | 0.17 | 1.0 | 115 | 0.15 | 1.0 | 175 | 0.17 | 1.0 | – | – | – | – | – | – | – | – | – |
| | **T9325** | 0.8 | 260 | 0.17 | 1.0 | 155 | 0.15 | 1.0 | 245 | 0.17 | 1.0 | – | – | – | – | – | – | – | – | – |
| | **T9335** | 0.8 | 225 | 0.17 | 1.0 | 135 | 0.15 | 1.0 | – | – | – | – | – | – | – | – | – | – | – | – |
| **CCMT 09T304E-FM2** | **T6310** | 0.4 | 165 | 0.12 | 1.0 | 115 | 0.11 | 1.0 | 130 | 0.12 | 1.0 | – | – | – | – | – | – | – | – | – |
| | **T8330** | 0.4 | 165 | 0.12 | 1.0 | 95 | 0.11 | 1.0 | 155 | 0.12 | 1.0 | – | – | – | – | – | – | – | – | – |
| | **T8430** | 0.4 | 205 | 0.12 | 1.0 | 110 | 0.11 | 1.0 | 170 | 0.12 | 1.0 | – | – | – | – | – | – | – | – | – |
| | **T9315** | 0.4 | 280 | 0.12 | 1.0 | – | – | – | 265 | 0.12 | 1.0 | – | – | – | – | – | – | – | – | – |
| | **T9325** | 0.4 | 255 | 0.12 | 1.0 | 150 | 0.11 | 1.0 | 240 | 0.12 | 1.0 | – | – | – | – | – | – | – | – | – |
| **CCMT 09T308E-FM2** | **T6310** | 0.8 | 180 | 0.17 | 1.0 | 125 | 0.15 | 1.0 | 145 | 0.17 | 1.0 | – | – | – | – | – | – | – | – | – |
| | **T7325** | 0.8 | 205 | 0.17 | 1.0 | 155 | 0.15 | 1.0 | – | – | – | – | – | – | – | – | – | – | – | – |
| | **T8330** | 0.8 | 180 | 0.17 | 1.0 | 105 | 0.15 | 1.0 | 170 | 0.17 | 1.0 | – | – | – | – | – | – | – | – | – |
| | **T8430** | 0.8 | 210 | 0.17 | 1.0 | 115 | 0.15 | 1.0 | 175 | 0.17 | 1.0 | – | – | – | – | – | – | – | – | – |
| | **T9315** | 0.8 | 290 | 0.17 | 1.0 | – | – | – | 275 | 0.17 | 1.0 | – | – | – | – | – | – | – | – | – |
| | **T9325** | 0.8 | 260 | 0.17 | 1.0 | 155 | 0.15 | 1.0 | 245 | 0.17 | 1.0 | – | – | – | – | – | – | – | – | – |
| | **T9335** | 0.8 | 225 | 0.17 | 1.0 | 135 | 0.15 | 1.0 | – | – | – | – | – | – | – | – | – | – | – | – |
| **CCMT 120408E-FM2** | **T7325** | 0.8 | 190 | 0.20 | 1.5 | 145 | 0.18 | 1.5 | – | – | – | – | – | – | – | – | – | – | – | – |
| | **T8330** | 0.8 | 165 | 0.20 | 1.5 | 95 | 0.18 | 1.5 | 155 | 0.20 | 1.5 | – | – | – | – | – | – | – | – | – |
| | **T8430** | 0.8 | 190 | 0.20 | 1.5 | 105 | 0.18 | 1.5 | 155 | 0.20 | 1.5 | – | – | – | – | – | – | – | – | – |
| | **T9325** | 0.8 | 235 | 0.20 | 1.5 | 140 | 0.18 | 1.5 | 220 | 0.20 | 1.5 | – | – | – | – | – | – | – | – | – |
| | **T9335** | 0.8 | 200 | 0.20 | 1.5 | 120 | 0.18 | 1.5 | – | – | – | – | – | – | – | – | – | – | – | – |

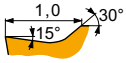
Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

| Product | | RE | P | | | M | | | K | | | N | | | S | | | H | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| | | | vc | f | ap | vc | f | ap | vc | f | ap | vc | f | ap | vc | f | ap | vc | f | ap |
| | | [mm] | [m/min] | [mm/rev] | [mm] | [m/min] | [mm/rev] | [mm] | [m/min] | [mm/rev] | [mm] | [m/min] | [mm/rev] | [mm] | [m/min] | [mm/rev] | [mm] | [m/min] | [mm/rev] | [mm] |
|  |  | | NF2 geometry with positive design for fine-finish to semi-rough machining, and continuous cuts. | | | | | | | | | | | | | | | | | |
| CCMT 060202E-NF2 | T6310 | 0.2 | 170 | 0.10 | 0.8 | 120 | 0.09 | 0.8 | 135 | 0.10 | 0.8 | 510 | 0.12 | 0.8 | 50 | 0.08 | 0.6 | – | – | – |
| | T7325 | 0.2 | 195 | 0.10 | 0.8 | 150 | 0.09 | 0.8 | – | – | – | – | – | – | 60 | 0.08 | 0.6 | – | – | – |
| | T8330 | 0.2 | 170 | 0.10 | 0.8 | 100 | 0.09 | 0.8 | 160 | 0.10 | 0.8 | 510 | 0.12 | 0.8 | 40 | 0.08 | 0.6 | – | – | – |
| | T8430 | 0.2 | 210 | 0.10 | 0.8 | 115 | 0.09 | 0.8 | 175 | 0.10 | 0.8 | 585 | 0.12 | 0.8 | 45 | 0.08 | 0.6 | – | – | – |
| | T9325 | 0.2 | 260 | 0.10 | 0.8 | 155 | 0.09 | 0.8 | 245 | 0.10 | 0.8 | – | – | – | 55 | 0.08 | 0.6 | – | – | – |
| CCMT 060204E-NF2 | H07 | 0.4 | – | – | – | 85 | 0.11 | 0.8 | 140 | 0.12 | 0.8 | 445 | 0.14 | 0.8 | 45 | 0.11 | 0.6 | – | – | – |
| | T6310 | 0.4 | 170 | 0.12 | 0.8 | 120 | 0.11 | 0.8 | 135 | 0.12 | 0.8 | 510 | 0.14 | 0.8 | 50 | 0.11 | 0.6 | – | – | – |
| | T7325 | 0.4 | 200 | 0.12 | 0.8 | 155 | 0.11 | 0.8 | – | – | – | – | – | – | 65 | 0.11 | 0.6 | – | – | – |
| | T8330 | 0.4 | 170 | 0.12 | 0.8 | 100 | 0.11 | 0.8 | 160 | 0.12 | 0.8 | 510 | 0.14 | 0.8 | 40 | 0.11 | 0.6 | – | – | – |
| | T8430 | 0.4 | 205 | 0.12 | 0.8 | 110 | 0.11 | 0.8 | 170 | 0.12 | 0.8 | 570 | 0.14 | 0.8 | 45 | 0.11 | 0.6 | – | – | – |
| | T9315 | 0.4 | 290 | 0.12 | 0.8 | – | – | – | 275 | 0.12 | 0.8 | – | – | – | – | – | – | – | – | – |
| | T9325 | 0.4 | 255 | 0.12 | 0.8 | 150 | 0.11 | 0.8 | 240 | 0.12 | 0.8 | – | – | – | 55 | 0.11 | 0.6 | – | – | – |
| | T9335 | 0.4 | 220 | 0.12 | 0.8 | 130 | 0.11 | 0.8 | – | – | – | – | – | – | 45 | 0.11 | 0.6 | – | – | – |
| CCMT 080304E-NF2 | T5315 | 0.4 | 280 | 0.12 | 1.0 | – | – | – | 265 | 0.12 | 1.0 | – | – | – | – | – | – | – | – | – |
| | T7325 | 0.4 | 190 | 0.12 | 1.0 | 145 | 0.11 | 1.0 | – | – | – | – | – | – | 60 | 0.11 | 0.8 | – | – | – |
| | T7335 | 0.4 | 190 | 0.12 | 1.0 | 145 | 0.11 | 1.0 | – | – | – | – | – | – | 60 | 0.11 | 0.8 | – | – | – |
| | T9315 | 0.4 | 280 | 0.12 | 1.0 | – | – | – | 265 | 0.12 | 1.0 | – | – | – | – | – | – | – | – | – |
| | T9325 | 0.4 | 255 | 0.12 | 1.0 | 150 | 0.11 | 1.0 | 240 | 0.12 | 1.0 | – | – | – | 55 | 0.11 | 0.8 | – | – | – |
| | T9335 | 0.4 | 215 | 0.12 | 1.2 | 125 | 0.11 | 1.2 | – | – | – | – | – | – | 45 | 0.11 | 1.0 | – | – | – |
| CCMT 080308E-NF2 | H07 | 0.8 | – | – | – | 95 | 0.13 | 1.2 | 150 | 0.14 | 1.2 | 485 | 0.17 | 1.2 | 45 | 0.13 | 1.0 | – | – | – |
| | T5315 | 0.8 | 295 | 0.17 | 1.0 | – | – | – | 280 | 0.17 | 1.0 | – | – | – | – | – | – | – | – | – |
| | T7325 | 0.8 | 205 | 0.17 | 1.0 | 155 | 0.15 | 1.0 | – | – | – | – | – | – | 65 | 0.14 | 0.8 | – | – | – |
| | T7335 | 0.8 | 205 | 0.17 | 1.0 | 155 | 0.15 | 1.0 | – | – | – | – | – | – | 65 | 0.14 | 0.8 | – | – | – |
| | T9325 | 0.8 | 260 | 0.17 | 1.0 | 155 | 0.15 | 1.0 | 245 | 0.17 | 1.0 | – | – | – | 55 | 0.14 | 0.8 | – | – | – |
| CCMT 09T304E-NF2 | H07 | 0.4 | – | – | – | 85 | 0.11 | 1.2 | 135 | 0.12 | 1.2 | 430 | 0.14 | 1.2 | 40 | 0.11 | 1.0 | – | – | – |
| | T6310 | 0.4 | 165 | 0.12 | 1.2 | 115 | 0.11 | 1.2 | 130 | 0.12 | 1.2 | 495 | 0.14 | 1.2 | 45 | 0.11 | 1.0 | – | – | – |
| | T7325 | 0.4 | 190 | 0.12 | 1.2 | 145 | 0.11 | 1.2 | – | – | – | – | – | – | 60 | 0.11 | 1.0 | – | – | – |
| | T8330 | 0.4 | 165 | 0.12 | 1.2 | 95 | 0.11 | 1.2 | 155 | 0.12 | 1.2 | 495 | 0.14 | 1.2 | 40 | 0.11 | 1.0 | – | – | – |
| | T8430 | 0.4 | 200 | 0.12 | 1.2 | 110 | 0.11 | 1.2 | 165 | 0.12 | 1.2 | 555 | 0.14 | 1.2 | 40 | 0.11 | 1.0 | – | – | – |
| | T9315 | 0.4 | 275 | 0.12 | 1.2 | – | – | – | 260 | 0.12 | 1.2 | – | – | – | – | – | – | – | – | – |
| | T9325 | 0.4 | 250 | 0.12 | 1.2 | 150 | 0.11 | 1.2 | 235 | 0.12 | 1.2 | – | – | – | 55 | 0.11 | 1.0 | – | – | – |
| | T9335 | 0.4 | 215 | 0.12 | 1.2 | 125 | 0.11 | 1.2 | – | – | – | – | – | – | 45 | 0.11 | 1.0 | – | – | – |
| CCMT 09T308E-NF2 | H07 | 0.8 | – | – | – | 95 | 0.13 | 1.2 | 150 | 0.14 | 1.2 | 485 | 0.17 | 1.2 | 45 | 0.13 | 1.0 | – | – | – |
| | T6310 | 0.8 | 190 | 0.14 | 1.2 | 135 | 0.13 | 1.2 | 150 | 0.14 | 1.2 | 570 | 0.17 | 1.2 | 55 | 0.13 | 1.0 | – | – | – |
| | T7325 | 0.8 | 215 | 0.14 | 1.2 | 165 | 0.13 | 1.2 | – | – | – | – | – | – | 65 | 0.13 | 1.0 | – | – | – |
| | T8330 | 0.8 | 190 | 0.14 | 1.2 | 110 | 0.13 | 1.2 | 180 | 0.14 | 1.2 | 570 | 0.17 | 1.2 | 45 | 0.13 | 1.0 | – | – | – |
| | T8430 | 0.8 | 225 | 0.14 | 1.2 | 120 | 0.13 | 1.2 | 185 | 0.14 | 1.2 | 615 | 0.17 | 1.2 | 45 | 0.13 | 1.0 | – | – | – |
| | T9315 | 0.8 | 310 | 0.14 | 1.2 | – | – | – | 290 | 0.14 | 1.2 | – | – | – | – | – | – | – | – | – |
| | T9325 | 0.8 | 275 | 0.14 | 1.2 | 165 | 0.13 | 1.2 | 260 | 0.14 | 1.2 | – | – | – | 60 | 0.13 | 1.0 | – | – | – |
| | T9335 | 0.8 | 235 | 0.14 | 1.2 | 140 | 0.13 | 1.2 | – | – | – | – | – | – | 50 | 0.13 | 1.0 | – | – | – |
|  |   I.C. / R: 6,35 / 1,0; 9,525 / 1,5; 12,7 / 2,5 | | RF geometry for semi-rough to rough machining, and continuous to interrupted cuts. | | | | | | | | | | | | | | | | | |
| CCMT 060202E-RF | T7335 | 0.2 | 150 | 0.15 | 1.0 | 115 | 0.14 | 1.0 | – | – | – | – | – | – | – | – | – | – | – | – |
| CCMT 060204E-RF | T5315 | 0.4 | 235 | 0.15 | 1.0 | – | – | – | 220 | 0.15 | 1.0 | – | – | – | – | – | – | 45 | 0.15 | 1.0 |
| | T7335 | 0.4 | 160 | 0.15 | 1.0 | 120 | 0.15 | 1.0 | – | – | – | – | – | – | – | – | – | – | – | – |
| | T9325 | 0.4 | 205 | 0.15 | 1.0 | 120 | 0.15 | 1.0 | 190 | 0.15 | 1.0 | – | – | – | – | – | – | – | – | – |
| CCMT 09T304E-RF | T7335 | 0.4 | 135 | 0.20 | 1.5 | 105 | 0.18 | 1.5 | – | – | – | – | – | – | – | – | – | – | – | – |
| | T9325 | 0.4 | 175 | 0.20 | 1.5 | 105 | 0.18 | 1.5 | 165 | 0.20 | 1.5 | – | – | – | – | – | – | – | – | – |
| CCMT 09T308E-RF | T5315 | 0.8 | 245 | 0.20 | 1.5 | – | – | – | 230 | 0.20 | 1.5 | – | – | – | – | – | – | 45 | 0.15 | 1.0 |
| | T7335 | 0.8 | 165 | 0.20 | 1.5 | 125 | 0.18 | 1.5 | – | – | – | – | – | – | – | – | – | – | – | – |
| | T9325 | 0.8 | 210 | 0.20 | 1.5 | 125 | 0.18 | 1.5 | 195 | 0.20 | 1.5 | – | – | – | – | – | – | – | – | – |
| CCMT 120408E-RF | T5315 | 0.8 | 230 | 0.22 | 2.2 | – | – | – | 215 | 0.22 | 2.2 | – | – | – | – | – | – | 45 | 0.15 | 1.0 |
| | T7335 | 0.8 | 150 | 0.22 | 2.2 | 115 | 0.22 | 2.2 | – | – | – | – | – | – | – | – | – | – | – | – |
| | T9325 | 0.8 | 195 | 0.22 | 2.2 | 115 | 0.22 | 2.2 | 185 | 0.22 | 2.2 | – | – | – | – | – | – | – | – | – |

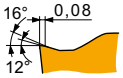
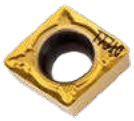
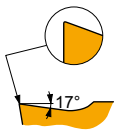
Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

| Product | | RE | P | | | M | | | K | | | N | | | S | | | H | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| | | | vc | f | ap | vc | f | ap | vc | f | ap | vc | f | ap | vc | f | ap | vc | f | ap |
| | | [mm] | [m/min] | [mm/rev] | [mm] | [m/min] | [mm/rev] | [mm] | [m/min] | [mm/rev] | [mm] | [m/min] | [mm/rev] | [mm] | [m/min] | [mm/rev] | [mm] | [m/min] | [mm/rev] | [mm] |
|  |  | |  | | | | | | | | | | | | | | | | | |
| RM geometry for semi-rough to rough machining, and continuous to interrupted cuts. | | | | | | | | | | | | | | | | | | | | |
| **CCMT 09T304E-RM** | **T5305** | 0.4 | 260 | 0.27 | 2.2 | – | – | – | 245 | 0.27 | 2.2 | – | – | – | – | – | – | 50 | 0.15 | 1.0 |
| | **T5315** | 0.4 | 230 | 0.27 | 2.2 | – | – | – | 215 | 0.27 | 2.2 | – | – | – | – | – | – | 45 | 0.15 | 1.0 |
| | **T7335** | 0.4 | 155 | 0.27 | 2.2 | 120 | 0.24 | 2.2 | – | – | – | – | – | – | 50 | 0.19 | 1.8 | – | – | – |
| | **T8330** | 0.4 | 140 | 0.27 | 2.2 | 80 | 0.24 | 2.2 | 130 | 0.27 | 2.2 | – | – | – | 35 | 0.19 | 1.8 | 25 | 0.15 | 1.0 |
| | **T8430** | 0.4 | 150 | 0.27 | 2.2 | 80 | 0.24 | 2.2 | 125 | 0.27 | 2.2 | – | – | – | 30 | 0.19 | 1.8 | 25 | 0.15 | 1.0 |
| | **T9315** | 0.4 | 215 | 0.27 | 2.2 | – | – | – | 200 | 0.27 | 2.2 | – | – | – | – | – | – | 40 | 0.15 | 1.0 |
| | **T9325** | 0.4 | 190 | 0.27 | 2.2 | 110 | 0.24 | 2.2 | 180 | 0.27 | 2.2 | – | – | – | 40 | 0.19 | 1.8 | – | – | – |
| **CCMT 09T308E-RM** | **T5305** | 0.8 | 290 | 0.30 | 2.2 | – | – | – | 275 | 0.30 | 2.2 | – | – | – | – | – | – | 55 | 0.15 | 1.0 |
| | **T5315** | 0.8 | 265 | 0.30 | 2.2 | – | – | – | 250 | 0.30 | 2.2 | – | – | – | – | – | – | 50 | 0.15 | 1.0 |
| | **T7335** | 0.8 | 175 | 0.30 | 2.2 | 135 | 0.27 | 2.2 | – | – | – | – | – | – | 55 | 0.24 | 1.8 | – | – | – |
| | **T8330** | 0.8 | 165 | 0.30 | 2.2 | 95 | 0.27 | 2.2 | 155 | 0.30 | 2.2 | – | – | – | 40 | 0.24 | 1.8 | 30 | 0.15 | 1.0 |
| | **T8430** | 0.8 | 180 | 0.30 | 2.2 | 95 | 0.27 | 2.2 | 145 | 0.30 | 2.2 | – | – | – | 35 | 0.24 | 1.8 | 30 | 0.15 | 1.0 |
| | **T9315** | 0.8 | 240 | 0.30 | 2.2 | – | – | – | 225 | 0.30 | 2.2 | – | – | – | – | – | – | 45 | 0.15 | 1.0 |
| | **T9325** | 0.8 | 215 | 0.30 | 2.2 | 125 | 0.27 | 2.2 | 200 | 0.30 | 2.2 | – | – | – | 45 | 0.24 | 1.8 | – | – | – |
| **CCMT 120408E-RM** | **T5305** | 0.8 | 290 | 0.30 | 2.7 | – | – | – | 275 | 0.30 | 2.7 | – | – | – | – | – | – | 55 | 0.15 | 1.0 |
| | **T5315** | 0.8 | 260 | 0.30 | 2.7 | – | – | – | 245 | 0.30 | 2.7 | – | – | – | – | – | – | 50 | 0.15 | 1.0 |
| | **T7335** | 0.8 | 175 | 0.30 | 2.7 | 135 | 0.27 | 2.7 | – | – | – | – | – | – | 55 | 0.24 | 2.2 | – | – | – |
| | **T8330** | 0.8 | 160 | 0.30 | 2.7 | 95 | 0.27 | 2.7 | 150 | 0.30 | 2.7 | – | – | – | 40 | 0.24 | 2.2 | 30 | 0.15 | 1.0 |
| | **T8430** | 0.8 | 175 | 0.30 | 2.7 | 95 | 0.27 | 2.7 | 140 | 0.30 | 2.7 | – | – | – | 35 | 0.24 | 2.2 | 30 | 0.15 | 1.0 |
| | **T9315** | 0.8 | 235 | 0.30 | 2.7 | – | – | – | 220 | 0.30 | 2.7 | – | – | – | – | – | – | 45 | 0.15 | 1.0 |
| | **T9325** | 0.8 | 210 | 0.30 | 2.7 | 125 | 0.27 | 2.7 | 195 | 0.30 | 2.7 | – | – | – | 45 | 0.24 | 2.2 | – | – | – |
| **CCMT 120412E-RM** | **T8330** | 1.2 | 165 | 0.33 | 2.7 | 95 | 0.30 | 2.7 | 155 | 0.33 | 2.7 | – | – | – | 40 | 0.23 | 2.2 | 30 | 0.15 | 1.0 |
| | **T8430** | 1.2 | 180 | 0.33 | 2.7 | 95 | 0.30 | 2.7 | 145 | 0.33 | 2.7 | – | – | – | 35 | 0.23 | 2.2 | 30 | 0.15 | 1.0 |
| | **T9315** | 1.2 | 235 | 0.33 | 2.7 | – | – | – | 220 | 0.33 | 2.7 | – | – | – | – | – | – | 45 | 0.15 | 1.0 |
| | **T9325** | 1.2 | 215 | 0.33 | 2.7 | 125 | 0.30 | 2.7 | 200 | 0.33 | 2.7 | – | – | – | 45 | 0.23 | 2.2 | – | – | – |
|  |  | |  | | | | | | | | | | | | | | | | | |
| RM3 geometry for semi-rough to rough machining, and continuous to interrupted cuts. | | | | | | | | | | | | | | | | | | | | |
| **CCMT 120404E-RM3** | **T7325** | 0.4 | 140 | 0.25 | 2.5 | 105 | 0.25 | 2.5 | – | – | – | – | – | – | – | – | – | – | – | – |
| | **T9315** | 0.4 | 190 | 0.25 | 2.5 | – | – | – | 180 | 0.25 | 2.5 | – | – | – | – | – | – | 35 | 0.15 | 1.0 |
| | **T9325** | 0.4 | 165 | 0.25 | 2.5 | 95 | 0.25 | 2.5 | 155 | 0.25 | 2.5 | – | – | – | – | – | – | – | – | – |
| **CCMT 120408E-RM3** | **T6310** | 0.8 | 145 | 0.27 | 2.5 | 100 | 0.27 | 2.5 | 115 | 0.27 | 2.5 | – | – | – | – | – | – | 25 | 0.15 | 1.0 |
| | **T7325** | 0.8 | 165 | 0.27 | 2.5 | 125 | 0.27 | 2.5 | – | – | – | – | – | – | – | – | – | – | – | – |
| | **T9315** | 0.8 | 215 | 0.27 | 2.5 | – | – | – | 200 | 0.27 | 2.5 | – | – | – | – | – | – | 40 | 0.15 | 1.0 |
| | **T9325** | 0.8 | 195 | 0.27 | 2.5 | 115 | 0.27 | 2.5 | 185 | 0.27 | 2.5 | – | – | – | – | – | – | – | – | – |
| **CCMT 120412E-RM3** | **T7325** | 1.2 | 170 | 0.30 | 2.5 | 130 | 0.27 | 2.5 | – | – | – | – | – | – | – | – | – | – | – | – |
| | **T9315** | 1.2 | 220 | 0.30 | 2.5 | – | – | – | 205 | 0.30 | 2.5 | – | – | – | – | – | – | 40 | 0.15 | 1.0 |
|  |  | |  | | | | | | | | | | | | | | | | | |
| UR geometry for fine to finish machining, and continuous to slightly interrupted cuts. | | | | | | | | | | | | | | | | | | | | |
| **CCMT 060202E-UR** | **T7325** | 0.2 | 185 | 0.10 | 0.8 | 140 | 0.09 | 0.8 | – | – | – | – | – | – | – | – | – | – | – | – |
| | **T7335** | 0.2 | 185 | 0.10 | 0.8 | 140 | 0.09 | 0.8 | – | – | – | – | – | – | – | – | – | – | – | – |
| | **T8315** | 0.2 | 170 | 0.10 | 0.8 | 100 | 0.09 | 0.8 | 160 | 0.10 | 0.8 | – | – | – | – | – | – | – | – | – |
| | **T8330** | 0.2 | 160 | 0.10 | 0.8 | 95 | 0.09 | 0.8 | 150 | 0.10 | 0.8 | – | – | – | – | – | – | – | – | – |
| | **T8430** | 0.2 | 200 | 0.10 | 0.8 | 110 | 0.09 | 0.8 | 165 | 0.10 | 0.8 | – | – | – | – | – | – | – | – | – |
| | **T9315** | 0.2 | 275 | 0.10 | 0.8 | – | – | – | 260 | 0.10 | 0.8 | – | – | – | – | – | – | – | – | – |
| | **T9325** | 0.2 | 250 | 0.10 | 0.8 | 150 | 0.09 | 0.8 | 235 | 0.10 | 0.8 | – | – | – | – | – | – | – | – | – |
| | **TT310** | 0.2 | 275 | 0.10 | 0.5 | 165 | 0.09 | 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 | | RE | P | | | M | | | K | | | N | | | S | | | H | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| | | | vc | f | ap | vc | f | ap | vc | f | ap | vc | f | ap | vc | f | ap | vc | f | ap |
| | | [mm] | [m/min] | [mm/rev] | [mm] | [m/min] | [mm/rev] | [mm] | [m/min] | [mm/rev] | [mm] | [m/min] | [mm/rev] | [mm] | [m/min] | [mm/rev] | [mm] | [m/min] | [mm/rev] | [mm] |
|  | | | | | | | | | | | | | | | | | | | | |
|  | | | | | | | | | | | | | | | | | | | | |
| UR geometry for fine to finish machining, and continuous to slightly interrupted cuts. | | | | | | | | | | | | | | | | | | | | |
| **CCMT 060204E-UR** | **T5315** | 0.4 | 245 | 0.15 | 1.0 | – | – | – | 230 | 0.15 | 1.0 | – | – | – | – | – | – | – | – | – |
| | **T7325** | 0.4 | 170 | 0.15 | 1.0 | 130 | 0.15 | 1.0 | – | – | – | – | – | – | – | – | – | – | – | – |
| | **T7335** | 0.4 | 170 | 0.15 | 1.0 | 130 | 0.15 | 1.0 | – | – | – | – | – | – | – | – | – | – | – | – |
| | **T8315** | 0.4 | 160 | 0.15 | 1.0 | 95 | 0.14 | 1.0 | 150 | 0.15 | 1.0 | – | – | – | – | – | – | – | – | – |
| | **T8330** | 0.4 | 150 | 0.15 | 1.0 | 90 | 0.14 | 1.0 | 140 | 0.15 | 1.0 | – | – | – | – | – | – | – | – | – |
| | **T8430** | 0.4 | 175 | 0.15 | 1.0 | 95 | 0.14 | 1.0 | 140 | 0.15 | 1.0 | – | – | – | – | – | – | – | – | – |
| | **T9315** | 0.4 | 245 | 0.15 | 1.0 | – | – | – | 230 | 0.15 | 1.0 | – | – | – | – | – | – | – | – | – |
| | **T9325** | 0.4 | 215 | 0.15 | 1.0 | 125 | 0.15 | 1.0 | 200 | 0.15 | 1.0 | – | – | – | – | – | – | – | – | – |
| | **TT310** | 0.4 | 255 | 0.15 | 0.5 | 150 | 0.14 | 0.5 | – | – | – | – | – | – | – | – | – | – | – | – |
| **CCMT 060208E-UR** | **T5315** | 0.8 | 270 | 0.20 | 1.0 | – | – | – | 255 | 0.20 | 1.0 | – | – | – | – | – | – | – | – | – |
| | **T7325** | 0.8 | 190 | 0.20 | 1.0 | 145 | 0.18 | 1.0 | – | – | – | – | – | – | – | – | – | – | – | – |
| | **T8330** | 0.8 | 165 | 0.20 | 1.0 | 95 | 0.18 | 1.0 | 155 | 0.20 | 1.0 | – | – | – | – | – | – | – | – | – |
| | **T8430** | 0.8 | 185 | 0.20 | 1.0 | 100 | 0.18 | 1.0 | 150 | 0.20 | 1.0 | – | – | – | – | – | – | – | – | – |
| | **T9315** | 0.8 | 255 | 0.20 | 1.0 | – | – | – | 240 | 0.20 | 1.0 | – | – | – | – | – | – | – | – | – |
| | **T9325** | 0.8 | 230 | 0.20 | 1.0 | 135 | 0.18 | 1.0 | 215 | 0.20 | 1.0 | – | – | – | – | – | – | – | – | – |
| **CCMT 09T302E-UR** | **T6310** | 0.2 | 160 | 0.10 | 1.0 | 115 | 0.09 | 1.0 | 125 | 0.10 | 1.0 | – | – | – | – | – | – | – | – | – |
| | **T8430** | 0.2 | 195 | 0.10 | 1.0 | 105 | 0.09 | 1.0 | 160 | 0.10 | 1.0 | – | – | – | – | – | – | – | – | – |
| | **TT310** | 0.2 | 255 | 0.10 | 1.0 | 150 | 0.09 | 1.0 | – | – | – | – | – | – | – | – | – | – | – | – |
| **CCMT 09T304E-UR** | **T5315** | 0.4 | 245 | 0.15 | 1.2 | – | – | – | 230 | 0.15 | 1.2 | – | – | – | – | – | – | – | – | – |
| | **T7325** | 0.4 | 170 | 0.15 | 1.2 | 130 | 0.15 | 1.2 | – | – | – | – | – | – | – | – | – | – | – | – |
| | **T7335** | 0.4 | 165 | 0.15 | 1.2 | 125 | 0.15 | 1.2 | – | – | – | – | – | – | – | – | – | – | – | – |
| | **T8315** | 0.4 | 155 | 0.15 | 1.2 | 90 | 0.14 | 1.2 | 145 | 0.15 | 1.2 | – | – | – | – | – | – | – | – | – |
| | **T8330** | 0.4 | 150 | 0.15 | 1.2 | 90 | 0.14 | 1.2 | 140 | 0.15 | 1.2 | – | – | – | – | – | – | – | – | – |
| | **T8430** | 0.4 | 175 | 0.15 | 1.2 | 95 | 0.14 | 1.2 | 140 | 0.15 | 1.2 | – | – | – | – | – | – | – | – | – |
| | **T9310** | 0.4 | 265 | 0.15 | 1.2 | – | – | – | 250 | 0.15 | 1.2 | – | – | – | – | – | – | – | – | – |
| | **T9315** | 0.4 | 235 | 0.15 | 1.2 | – | – | – | 220 | 0.15 | 1.2 | – | – | – | – | – | – | – | – | – |
| | **T9325** | 0.4 | 215 | 0.15 | 1.2 | 125 | 0.15 | 1.2 | 200 | 0.15 | 1.2 | – | – | – | – | – | – | – | – | – |
| | **TT310** | 0.4 | 235 | 0.15 | 1.2 | 140 | 0.14 | 1.2 | – | – | – | – | – | – | – | – | – | – | – | – |
| **CCMT 09T308E-UR** | **T5315** | 0.8 | 265 | 0.20 | 1.2 | – | – | – | 250 | 0.20 | 1.2 | – | – | – | – | – | – | – | – | – |
| | **T7325** | 0.8 | 185 | 0.20 | 1.2 | 140 | 0.18 | 1.2 | – | – | – | – | – | – | – | – | – | – | – | – |
| | **T7335** | 0.8 | 175 | 0.20 | 1.2 | 135 | 0.18 | 1.2 | – | – | – | – | – | – | – | – | – | – | – | – |
| | **T8315** | 0.8 | 170 | 0.20 | 1.2 | 100 | 0.18 | 1.2 | 160 | 0.20 | 1.2 | – | – | – | – | – | – | – | – | – |
| | **T8330** | 0.8 | 160 | 0.20 | 1.2 | 95 | 0.18 | 1.2 | 150 | 0.20 | 1.2 | – | – | – | – | – | – | – | – | – |
| | **T8430** | 0.8 | 185 | 0.20 | 1.2 | 100 | 0.18 | 1.2 | 150 | 0.20 | 1.2 | – | – | – | – | – | – | – | – | – |
| | **T9310** | 0.8 | 280 | 0.20 | 1.2 | – | – | – | 265 | 0.20 | 1.2 | – | – | – | – | – | – | – | – | – |
| | **T9315** | 0.8 | 250 | 0.20 | 1.2 | – | – | – | 235 | 0.20 | 1.2 | – | – | – | – | – | – | – | – | – |
| | **T9325** | 0.8 | 225 | 0.20 | 1.2 | 135 | 0.18 | 1.2 | 210 | 0.20 | 1.2 | – | – | – | – | – | – | – | – | – |
| | **TT310** | 0.8 | 255 | 0.20 | 1.2 | 150 | 0.18 | 1.2 | – | – | – | – | – | – | – | – | – | – | – | – |
| **CCMT 120404E-UR** | **T5315** | 0.4 | 235 | 0.15 | 1.7 | – | – | – | 220 | 0.15 | 1.7 | – | – | – | – | – | – | – | – | – |
| | **T7325** | 0.4 | 160 | 0.15 | 1.7 | 120 | 0.15 | 1.7 | – | – | – | – | – | – | – | – | – | – | – | – |
| | **T8330** | 0.4 | 140 | 0.15 | 1.7 | 80 | 0.14 | 1.7 | 130 | 0.15 | 1.7 | – | – | – | – | – | – | – | – | – |
| | **T8430** | 0.4 | 170 | 0.15 | 1.7 | 90 | 0.14 | 1.7 | 135 | 0.15 | 1.7 | – | – | – | – | – | – | – | – | – |
| | **T9315** | 0.4 | 230 | 0.15 | 1.7 | – | – | – | 215 | 0.15 | 1.7 | – | – | – | – | – | – | – | – | – |
| | **T9325** | 0.4 | 205 | 0.15 | 1.7 | 120 | 0.15 | 1.7 | 190 | 0.15 | 1.7 | – | – | – | – | – | – | – | – | – |
| **CCMT 120408E-UR** | **T5315** | 0.8 | 255 | 0.20 | 1.7 | – | – | – | 240 | 0.20 | 1.7 | – | – | – | – | – | – | – | – | – |
| | **T7325** | 0.8 | 175 | 0.20 | 1.7 | 135 | 0.18 | 1.7 | – | – | – | – | – | – | – | – | – | – | – | – |
| | **T7335** | 0.8 | 170 | 0.20 | 1.7 | 130 | 0.18 | 1.7 | – | – | – | – | – | – | – | – | – | – | – | – |
| | **T8330** | 0.8 | 155 | 0.20 | 1.7 | 90 | 0.18 | 1.7 | 145 | 0.20 | 1.7 | – | – | – | – | – | – | – | – | – |
| | **T8430** | 0.8 | 180 | 0.20 | 1.7 | 95 | 0.18 | 1.7 | 145 | 0.20 | 1.7 | – | – | – | – | – | – | – | – | – |
| | **T9315** | 0.8 | 240 | 0.20 | 1.7 | – | – | – | 225 | 0.20 | 1.7 | – | – | – | – | – | – | – | – | – |
| | **T9325** | 0.8 | 215 | 0.20 | 1.7 | 125 | 0.18 | 1.7 | 200 | 0.20 | 1.7 | – | – | – | – | – | – | – | – | – |
| **CCMT 120412E-UR** | **T5315** | 1.2 | 240 | 0.27 | 1.7 | – | – | – | 225 | 0.27 | 1.7 | – | – | – | – | – | – | – | – | – |
| | **T7325** | 1.2 | 170 | 0.27 | 1.7 | 130 | 0.24 | 1.7 | – | – | – | – | – | – | – | – | – | – | – | – |
| | **T8430** | 1.2 | 165 | 0.27 | 1.7 | 90 | 0.24 | 1.7 | 135 | 0.27 | 1.7 | – | – | – | – | – | – | – | – | – |
| | **T9315** | 1.2 | 225 | 0.27 | 1.7 | – | – | – | 210 | 0.27 | 1.7 | – | – | – | – | – | – | – | – | – |
| | **T9325** | 1.2 | 205 | 0.27 | 1.7 | 120 | 0.24 | 1.7 | 190 | 0.27 | 1.7 | – | – | – | – | – | – | – | – | – |

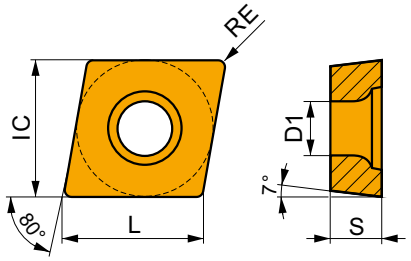
Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

| Product | | RE | P | | | M | | | K | | | N | | | S | | | H | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| | | | vc | f | ap | vc | f | ap | vc | f | ap | vc | f | ap | vc | f | ap | vc | f | ap |
| | | [mm] | [m/min] | [mm/rev] | [mm] | [m/min] | [mm/rev] | [mm] | [m/min] | [mm/rev] | [mm] | [m/min] | [mm/rev] | [mm] | [m/min] | [mm/rev] | [mm] | [m/min] | [mm/rev] | [mm] |
|  |  | | | | | | | | | | | | | | | | | | | |
| | | | W-FM wiper geometry for fine to finish machining with increased feed rates and improved surface finish. | | | | | | | | | | | | | | | | | |
| **CCMT 060204W-FM** | **T7325** | 0.4 | 165 | 0.30 | 0.8 | 125 | 0.27 | 0.8 | – | – | – | – | – | – | – | – | – | – | – | – |
| | **T8430** | 0.4 | 165 | 0.30 | 0.8 | 90 | 0.27 | 0.8 | 135 | 0.30 | 0.8 | – | – | – | – | – | – | – | – | – |
| | **T9315** | 0.4 | 215 | 0.30 | 0.8 | – | – | – | 200 | 0.30 | 0.8 | – | – | – | – | – | – | – | – | – |
| | **T9325** | 0.4 | 190 | 0.30 | 0.8 | 110 | 0.27 | 0.8 | 180 | 0.30 | 0.8 | – | – | – | – | – | – | – | – | – |
| **CCMT 09T304W-FM** | **T7325** | 0.4 | 165 | 0.30 | 0.8 | 125 | 0.27 | 0.8 | – | – | – | – | – | – | – | – | – | – | – | – |
| | **T8330** | 0.4 | 145 | 0.30 | 0.8 | 85 | 0.27 | 0.8 | 135 | 0.30 | 0.8 | – | – | – | – | – | – | – | – | – |
| | **T8430** | 0.4 | 165 | 0.30 | 0.8 | 90 | 0.27 | 0.8 | 135 | 0.30 | 0.8 | – | – | – | – | – | – | – | – | – |
| | **T9315** | 0.4 | 215 | 0.30 | 0.8 | – | – | – | 200 | 0.30 | 0.8 | – | – | – | – | – | – | – | – | – |
| | **T9325** | 0.4 | 190 | 0.30 | 0.8 | 110 | 0.27 | 0.8 | 180 | 0.30 | 0.8 | – | – | – | – | – | – | – | – | – |
| **CCMT 09T308W-FM** | **T8330** | 0.8 | 155 | 0.40 | 1.0 | 90 | 0.36 | 1.0 | 145 | 0.40 | 1.0 | – | – | – | – | – | – | – | – | – |
| | **T8430** | 0.8 | 170 | 0.40 | 1.0 | 90 | 0.36 | 1.0 | 135 | 0.40 | 1.0 | – | – | – | – | – | – | – | – | – |
| | **T9315** | 0.8 | 220 | 0.40 | 1.0 | – | – | – | 205 | 0.40 | 1.0 | – | – | – | – | – | – | – | – | – |
| | **T9325** | 0.8 | 200 | 0.40 | 1.0 | 120 | 0.36 | 1.0 | 190 | 0.40 | 1.0 | – | – | – | – | – | – | – | – | – |
|  |  | | | | | | | | | | | | | | | | | | | |
| | | | W-UR wiper geometry for fine to finish machining with increased feed rates and improved surface finish. | | | | | | | | | | | | | | | | | |
| **CCMT 060204W-UR** | **TT310** | 0.4 | 255 | 0.15 | 0.5 | 150 | 0.14 | 0.5 | – | – | – | – | – | – | – | – | – | – | – | – |
| **CCMT 09T308W-UR** | **TT310** | 0.8 | 255 | 0.20 | 1.2 | 150 | 0.18 | 1.2 | – | – | – | – | – | – | – | – | – | – | – | – |

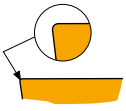
# CCMW

PRAMET

| | IC | D1 | L | S |
|---|---|---|---|---|
| | [mm] | [mm] | [mm] | [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 | | RE | P | | | M | | | K | | | N | | | S | | | H | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| | | | vc | f | ap | vc | f | ap | vc | f | ap | vc | f | ap | vc | f | ap | vc | f | ap |
| | | [mm] | [m/min] | [mm/rev] | [mm] | [m/min] | [mm/rev] | [mm] | [m/min] | [mm/rev] | [mm] | [m/min] | [mm/rev] | [mm] | [m/min] | [mm/rev] | [mm] | [m/min] | [mm/rev] | [mm] |
|  |  | | | | | | | | | | | | | | | | | | | |
| | | | For fine-finish to semi-rough machining, and continuous to slightly interrupted cuts. | | | | | | | | | | | | | | | | | |
| **CCMW 060202** | **T5305** | 0.2 | – | – | – | – | – | – | 230 | 0.08 | 2.0 | – | – | – | – | – | – | 45 | 0.15 | 1.0 |
| | **T6310** | 0.2 | – | – | – | – | – | – | 100 | 0.08 | 2.0 | – | – | – | – | – | – | 25 | 0.15 | 1.0 |
| **CCMW 060204** | **T5305** | 0.4 | – | – | – | – | – | – | 230 | 0.10 | 2.0 | – | – | – | – | – | – | 45 | 0.15 | 1.0 |
| | **T5315** | 0.4 | – | – | – | – | – | – | 195 | 0.10 | 2.0 | – | – | – | – | – | – | 40 | 0.15 | 1.0 |
| | **T6310** | 0.4 | – | – | – | – | – | – | 95 | 0.10 | 2.0 | – | – | – | – | – | – | 20 | 0.15 | 1.0 |
| **CCMW 09T304** | **T5305** | 0.4 | – | – | – | – | – | – | 215 | 0.10 | 3.0 | – | – | – | – | – | – | 45 | 0.15 | 1.0 |
| | **T5315** | 0.4 | – | – | – | – | – | – | 190 | 0.10 | 3.0 | – | – | – | – | – | – | 40 | 0.15 | 1.0 |
| | **T6310** | 0.4 | – | – | – | – | – | – | 95 | 0.10 | 3.0 | – | – | – | – | – | – | 20 | 0.15 | 1.0 |
| **CCMW 09T308** | **T5305** | 0.8 | – | – | – | – | – | – | 200 | 0.20 | 3.0 | – | – | – | – | – | – | 40 | 0.15 | 1.0 |
| | **T5315** | 0.8 | – | – | – | – | – | – | 180 | 0.20 | 3.0 | – | – | – | – | – | – | 35 | 0.15 | 1.0 |
| | **T6310** | 0.8 | – | – | – | – | – | – | 90 | 0.20 | 3.0 | – | – | – | – | – | – | 20 | 0.15 | 1.0 |