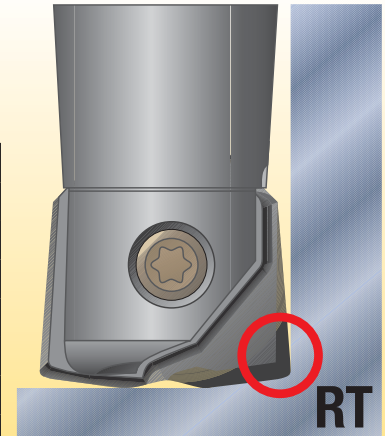


## ■ Application Advice for KDMT-HF Insert Style

For CAM programming, the tools can be programmed as a toroidal tool type requiring the diameter and the RT values only.

insert type	metric			
	Ap max	diameter	RT	max fz
KDMT0604SRHF	0,4	6	0,8	1
KDMT0806SRHF	0,5	8	1	1,3
KDMT1008SRHF	0,5	10	1	1,3
KDMT1210SRHF	0,6	12	1	1,3
KDMT1615SRHF	0,8	16	1,5	1,5
KDMT2020SRHF	1	20	2	1,5



## ■ Data for Face Milling, Pocketing, and Profiling Operations

### Starting Values

tool diameter	Ø6	Ø8	Ø10	Ø12	Ø16	Ø20
Ap max (mm)	0,4	0,5	0,5	0,6	0,8	1
fz recommended for 45 HRC (approximately)	0,4	0,45	0,45	0,5	0,55	0,65
fz recommended for 55 HRC (approximately)	0,3	0,35	0,35	0,4	0,5	0,55
fz recommended for general purpose	0,5	0,55	0,55	0,65	0,7	0,8

NOTE: Use two effective teeth for feed calculations.  
For materials above 45 HRC, we recommend to adjust the Ae max to 55% of cutting diameter.  
Steel shanks for roughing operations are recommended.