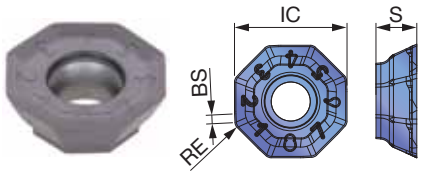
INSERT

OWMT05T3AFER-MM



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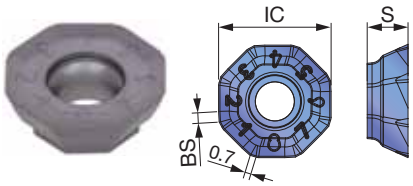
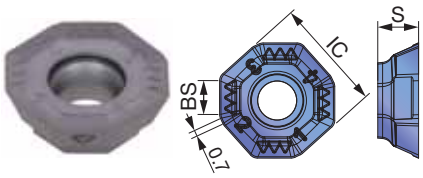


OWHT05T3C07AFER-MW



P	Steel	☆	★
M	Stainless		★
K	Cast iron	★	☆
N	Non-ferrous		
S	Superalloys	★	☆
H	Hard materials		

★ : First choice
☆ : Second choice

Designation	RE	APMX	Coated AH120	Coated AH3135	IC	S	BS
OWMT05T3AFER-MM	0.8	3	●	●	12.42	4.5	1
OWHT05T3C07AFER-MM	-	3	●	●	12.4	4.5	1.15
OWHT05T3C07AFER-MW	-	3	●	●	12.4	4.5	3.7

●: Line up

STANDARD CUTTING CONDITIONS

ISO	Workpiece material	Hardness	Priority	Grade	Chip-breaker	Cutting speed *Vc* (m/min)	Feed per tooth *fz* (mm/t)
P	Low carbon steel (C15, etc.)	- 200 HB	First choice	AH3135	MM	100 - 300	0.05 - 0.35
			Wear resistance	AH120	MM	100 - 300	0.05 - 0.35
	High carbon and alloy steel (S55C / C55, SCM440 / 42CrMo4, etc.)	- 300 HB	First choice	AH3135	MM	100 - 250	0.05 - 0.3
			Wear resistance	AH120	MM	100 - 250	0.05 - 0.3
	Prehardened steel (NAK80, PX5, etc.)	30 - 40 HRC	First choice	AH3135	MM	80 - 200	0.05 - 0.3
			Wear resistance	AH120	MM	80 - 200	0.05 - 0.3
M	Austenitic stainless steel (SUS304 / 1.4301, SUS316 / 1.4401, etc.)	- 200 HB	First choice	AH3135	MM	100 - 200	0.05 - 0.35
			Wear resistance	AH120	MM	100 - 200	0.05 - 0.35
	Martensitic stainless steel (X20Cr13, etc.)	- 220 HB	First choice	AH3135	MM	100 - 300	0.05 - 0.3
			Wear resistance	AH120	MM	100 - 300	0.05 - 0.3
K	Gray cast iron (FC250 / 250, etc.)	150 - 250 HB	First choice	AH120	MM	100 - 300	0.05 - 0.35
			Fracture resistance	AH3135	MM	100 - 300	0.05 - 0.35
	Ductile cast iron (FCD400 / 400-15, FCD600 / 600-3, etc.)	150 - 250 HB	First choice	AH120	MM	80 - 250	0.05 - 0.3
			Fracture resistance	AH3135	MM	80 - 250	0.05 - 0.3
S	Titanium alloys (Ti-6Al-4V, etc.)	-	First choice	AH3135	MM	30 - 60	0.05 - 0.2
			Wear resistance	AH120	MM	30 - 60	0.05 - 0.2
	Heat-resistant alloys (Inconel718, etc.)	-	First choice	AH120	MM	20 - 50	0.05 - 0.15
			Fracture resistance	AH3135	MM	20 - 50	0.05 - 0.15
H	Hardened steel (SKD61 / X40CrMoV51, etc.)	40 - 50 HRC	First choice	AH3135	MM	70 - 130	0.05 - 0.15
			Wear resistance	AH120	MM	70 - 130	0.05 - 0.15