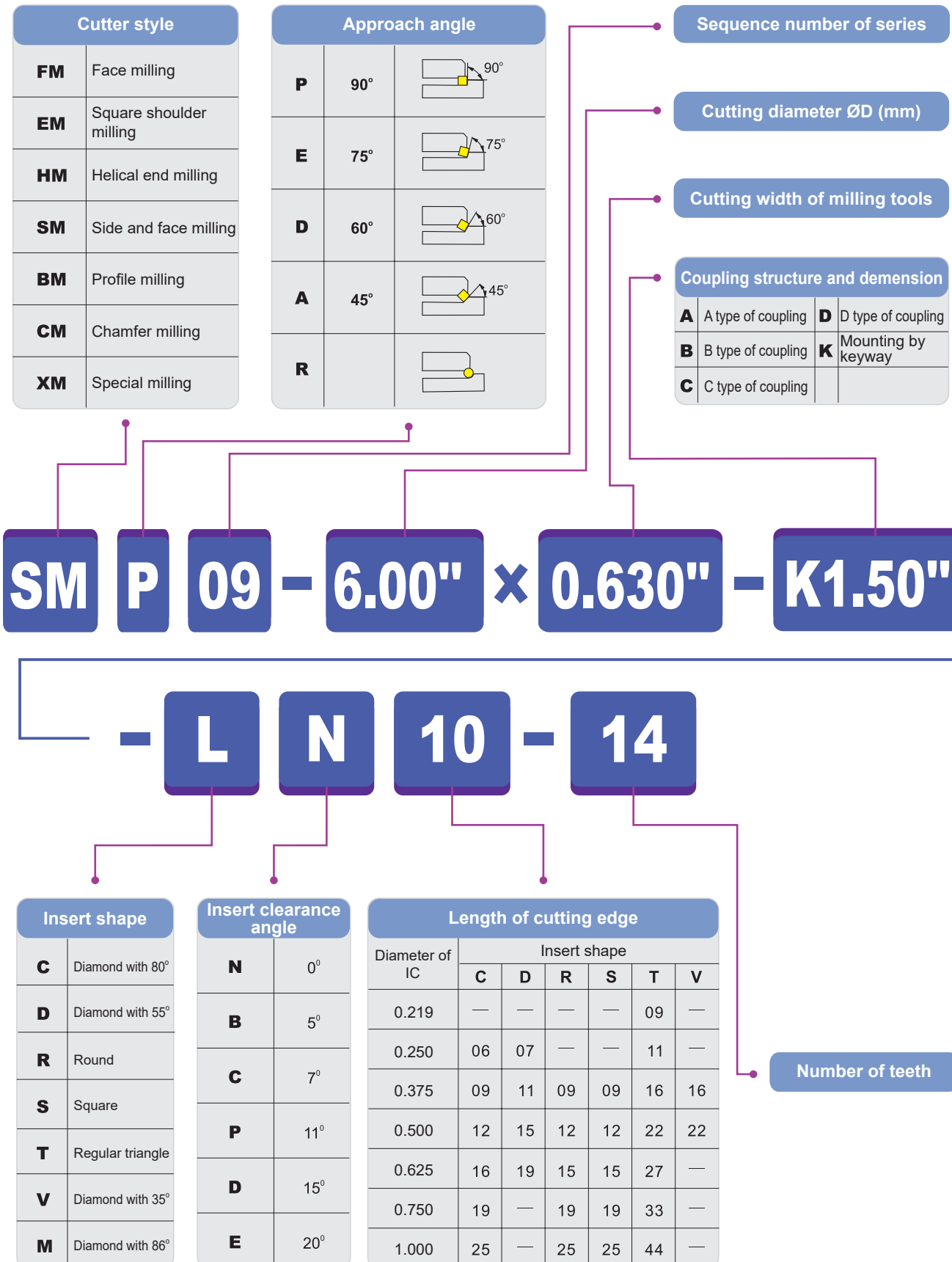
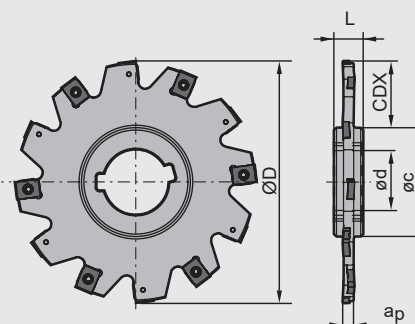




Side and face milling tools code key



Side and face milling tools


SMP08 **P** **M** **K**


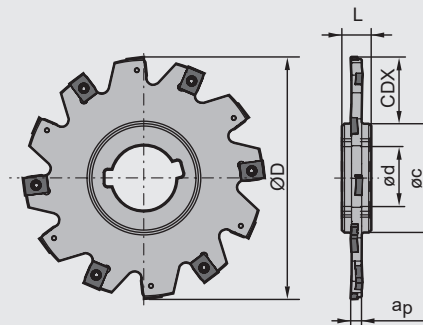
K type of mounting

Specification of tools

Type		Dimensions(inch)							Number of teeth Z	Type of coupling
		ØD	ød	øc	L	ap	CDX	Applicable inserts		
SMP08	-2.50"×0.158"-K0.75"-LN1023-08	2.50	0.75	1.25	0.315	0.158	0.50	LNET102304-GM	8	K
	-3.00"×0.158"-K0.75"-LN1023-10	3.00	0.75	1.25	0.315	0.158	0.75		10	K
	-4.00"×0.158"-K1.00"-LN1023-12	4.00	1.00	1.50	0.500	0.158	1.00		12	K
	-5.00"×0.158"-K1.50"-LN1023-14	5.00	1.50	2.00	0.500	0.158	1.25		14	K
	-6.00"×0.158"-K1.50"-LN1023-18	6.00	1.50	2.00	0.500	0.158	2.00		18	K
	-2.50"×0.197"-K0.75"-LN1028-08	2.50	0.75	1.25	0.315	0.197	0.50	LNET102804-GM	8	K
	-3.00"×0.197"-K0.75"-LN1028-10	3.00	0.75	1.25	0.315	0.197	0.75		10	K
	-4.00"×0.197"-K1.00"-LN1028-12	4.00	1.00	1.50	0.500	0.197	1.00		12	K
	-5.00"×0.197"-K1.50"-LN1028-14	5.00	1.50	2.00	0.500	0.197	1.25		14	K
	-6.00"×0.197"-K1.50"-LN1028-18	6.00	1.50	2.00	0.500	0.197	2.00		18	K
	-2.50"×0.236"-K0.75"-LN1033-08	2.50	0.75	1.25	0.315	0.236	0.50	LNET103304-GM	8	K
	-3.00"×0.236"-K0.75"-LN1033-10	3.00	0.75	1.25	0.315	0.236	0.75		10	K
	-4.00"×0.236"-K1.00"-LN1033-12	4.00	1.00	1.50	0.500	0.236	1.00		12	K
	-5.00"×0.236"-K1.50"-LN1033-14	5.00	1.50	2.00	0.500	0.236	1.25		14	K
	-6.00"×0.236"-K1.50"-LN1033-18	6.00	1.50	2.00	0.500	0.236	2.00		18	K
	-8.00"×0.236"-K2.00"-LN1033-20	8.00	2.00	2.50	0.500	0.236	2.50		20	K
	-10.00"×0.236"-K2.00"-LN1033-24	10.00	2.00	2.50	0.500	0.236	3.50		24	K
	-3.00"×0.275"-K0.75"-LN1238-08	3.00	0.75	1.25	0.500	0.275	0.75	LNET123804-GM	8	K
	-4.00"×0.275"-K1.00"-LN1238-10	4.00	1.00	1.50	0.500	0.275	1.00		10	K
	-5.00"×0.275"-K1.50"-LN1238-12	5.00	1.50	2.00	0.500	0.275	1.25		12	K
	-6.00"×0.275"-K1.50"-LN1238-16	6.00	1.50	2.00	0.500	0.275	2.00		16	K
	-8.00"×0.275"-K2.00"-LN1238-18	8.00	2.00	2.50	0.500	0.275	2.50		18	K
	-10.00"×0.275"-K2.00"-LN1238-24	10.00	2.00	2.50	0.500	0.275	3.50		24	K



Side and face milling tools

SMP08 **P** **M** **K**


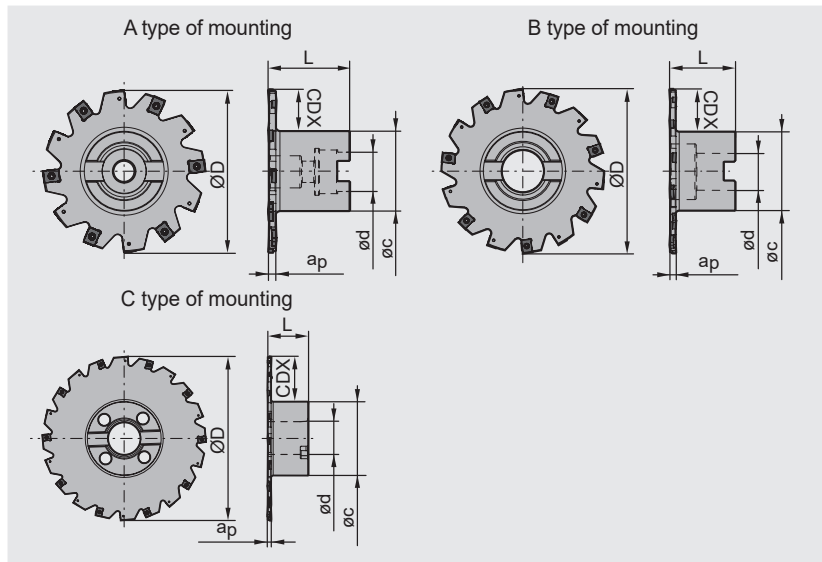
K type of mounting

Specification of tools

Type		Dimensions(inch)							Number of teeth Z	Type of coupling
		ØD	ød	øc	L	ap	CDX	Applicable inserts		
SMP08	-3.00"×0.315"-K0.75"-LN1243-08	3.00	0.75	1.25	0.500	0.315	0.75	LNET124304-GM	8	K
	-4.00"×0.315"-K1.00"-LN1243-10	4.00	1.00	1.50	0.500	0.315	1.00		10	K
	-5.00"×0.315"-K1.50"-LN1243-12	5.00	1.50	2.00	0.500	0.315	1.25		12	K
	-6.00"×0.315"-K1.50"-LN1243-16	6.00	1.50	2.00	0.500	0.315	2.00		16	K
	-8.00"×0.315"-K2.00"-LN1243-18	8.00	2.00	2.50	0.500	0.315	2.50		18	K
	-10.00"×0.315"-K2.00"-LN1243-24	10.00	2.00	2.50	0.500	0.315	3.50		24	K
	-4.00"×0.354"-K1.00"-LN1248-10	4.00	1.00	1.50	0.500	0.354	1.00	LNET124804-GM	10	K
	-5.00"×0.354"-K1.50"-LN1248-12	5.00	1.50	2.00	0.500	0.354	1.25		12	K
	-6.00"×0.354"-K1.50"-LN1248-16	6.00	1.50	2.00	0.500	0.354	2.00		16	K
	-8.00"×0.354"-K2.00"-LN1248-18	8.00	2.00	2.50	0.500	0.354	2.50		18	K
	-10.00"×0.354"-K2.00"-LN1248-24	10.00	2.00	2.50	0.500	0.354	3.50		24	K
	-4.00"×0.394"-K1.00"-LN1253-10	4.00	1.00	1.50	0.500	0.394	1.00	LNET125304-GM	10	K
	-5.00"×0.394"-K1.50"-LN1253-12	5.00	1.50	2.00	0.500	0.394	1.25		12	K
	-6.00"×0.394"-K1.50"-LN1253-16	6.00	1.50	2.00	0.500	0.394	2.00		16	K
	-8.00"×0.394"-K2.00"-LN1253-18	8.00	2.00	2.50	0.500	0.394	2.50		18	K
	-10.00"×0.394"-K2.00"-LN1253-24	10.00	2.00	2.50	0.500	0.394	3.50		24	K

D

Side and face milling tools

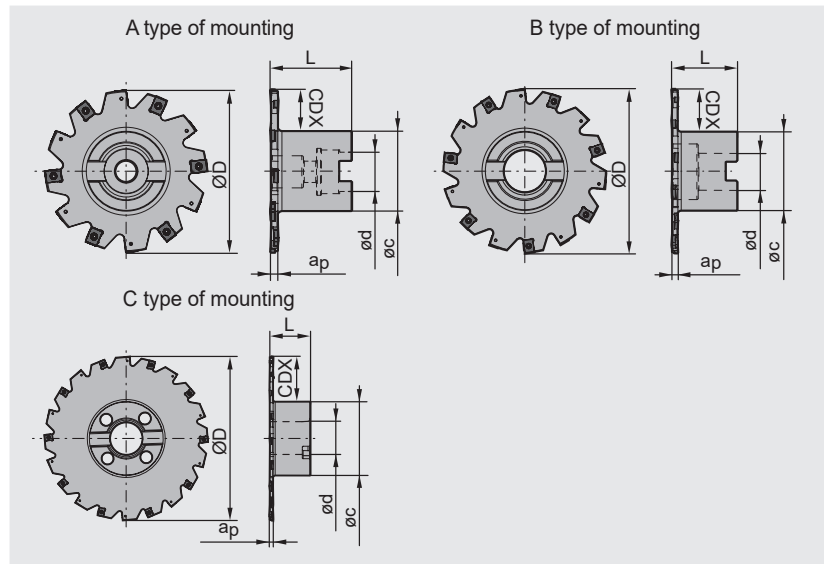

SMP08


Specification of tools

Type		Dimensions(inch)						Applicable inserts	Number of teeth Z	Type of coupling
		ØD	Ød	Øc	L	ap	CDX			
SMP08	-3.00"×0.158"-A0.75"-LN1023-10	3.00	0.75	1.50	2.00	0.158	0.75	LNET102304-GM	10	A
	-4.00"×0.158"-A1.00"-LN1023-12	4.00	1.00	2.00	2.00	0.158	1.00		12	A
	-5.00"×0.158"-B1.25"-LN1023-14	5.00	1.25	2.50	2.00	0.158	1.25		14	B
	-6.00"×0.158"-B1.50"-LN1023-18	6.00	1.50	3.00	2.00	0.158	1.50		18	B
	-3.00"×0.197"-A0.75"-LN1028-10	3.00	0.75	1.50	2.00	0.197	0.75	LNET102804-GM	10	A
	-4.00"×0.197"-A1.00"-LN1028-12	4.00	1.00	2.00	2.00	0.197	1.00		12	A
	-5.00"×0.197"-B1.25"-LN1028-14	5.00	1.25	2.50	2.00	0.197	1.25		14	B
	-6.00"×0.197"-B1.50"-LN1028-18	6.00	1.50	3.00	2.00	0.197	1.50		18	B
	-3.00"×0.236"-A0.75"-LN1033-10	3.00	0.75	1.50	2.00	0.236	0.75	LNET103304-GM	10	A
	-4.00"×0.236"-A1.00"-LN1033-12	4.00	1.00	2.00	2.00	0.236	1.00		12	A
	-5.00"×0.236"-B1.25"-LN1033-14	5.00	1.25	2.50	2.00	0.236	1.25		14	B
	-6.00"×0.236"-B1.50"-LN1033-18	6.00	1.50	3.00	2.00	0.236	1.50		18	B
	-8.00"×0.236"-C1.50"-LN1033-20	8.00	1.50	3.50	2.00	0.236	2.00		20	C
	-10.00"×0.236"-C2.50"-LN1033-24	10.00	2.50	5.00	2.00	0.236	2.25		24	C
	-3.00"×0.275"-A0.75"-LN1238-08	3.00	0.75	1.50	2.00	0.275	0.75	LNET123804-GM	8	A
	-4.00"×0.275"-A1.00"-LN1238-10	4.00	1.00	2.00	2.00	0.275	1.00		10	A
	-5.00"×0.275"-B1.25"-LN1238-12	5.00	1.25	2.50	2.00	0.275	1.25		12	B
	-6.00"×0.275"-B1.50"-LN1238-16	6.00	1.50	3.00	2.00	0.275	1.50		16	B
	-8.00"×0.275"-C1.50"-LN1238-18	8.00	1.50	3.50	2.00	0.275	2.00		18	C
	-10.00"×0.275"-C2.50"-LN1238-24	10.00	2.50	5.00	2.00	0.275	2.25		24	C
	-3.00"×0.315"-A0.75"-LN1243-08	3.00	0.75	1.50	2.00	0.315	0.75	LNET124304-GM	8	A
	-4.00"×0.315"-A1.00"-LN1243-10	4.00	1.00	2.00	2.00	0.315	1.00		10	A
	-5.00"×0.315"-B1.25"-LN1243-12	5.00	1.25	2.50	2.00	0.315	1.25		12	B
	-6.00"×0.315"-B1.50"-LN1243-16	6.00	1.50	3.00	2.00	0.315	1.50		16	B
	-8.00"×0.315"-C1.50"-LN1243-18	8.00	1.50	3.50	2.00	0.315	2.00		18	C
	-10.00"×0.315"-C2.50"-LN1243-24	10.00	2.50	5.00	2.00	0.315	2.25		24	C



Side and face milling tools

SMP08


Specification of tools

Type		Dimensions(inch)						Applicable inserts	Number of teeth Z	Type of coupling
		ØD	ød	øc	L	ap	CDX			
SMP08	-4.00"×0.354"-A1.00"-LN1248-10	4.00	1.00	2.00	2.00	0.354	1.00	LNET124804-GM	10	A
	-5.00"×0.354"-B1.25"-LN1248-12	5.00	1.25	2.50	2.00	0.354	1.25		12	B
	-6.00"×0.354"-B1.50"-LN1248-16	6.00	1.50	3.00	2.00	0.354	1.50		16	B
	-8.00"×0.354"-C1.50"-LN1248-18	8.00	1.50	3.50	2.00	0.354	2.00		18	C
	-10.00"×0.354"-C2.50"-LN1248-24	10.00	2.50	5.00	2.00	0.354	2.25		24	C
	-4.00"×0.394"-A1.00"-LN1253-10	4.00	1.00	2.00	2.00	0.394	1.00	LNET125304-GM	10	A
	-5.00"×0.394"-B1.25"-LN1253-12	5.00	1.25	2.50	2.00	0.394	1.25		12	B
	-6.00"×0.394"-B1.50"-LN1253-16	6.00	1.50	3.00	2.00	0.394	1.50		16	B
	-8.00"×0.394"-C1.50"-LN1253-18	8.00	1.50	3.50	2.00	0.394	2.00		18	C
	-10.00"×0.394"-C2.50"-LN1253-24	10.00	2.50	5.00	2.00	0.394	2.25		24	C

Spare parts

Insert	Edge width a _p (mm)	Screw	Wrench			Sketch of installation
						
LNET10□□-GM	4	I60M2.5×3.2×B	WT06IP	WT06IS	--	
	5	I60M2.5×3.9×B				
	6	I60M2.5×4.8×B				
LNET12□□-GM	7	I60M4×5.1×B	WT10IP	WT10IS	--	
	8	I60M4×6.6×B				
	9	I60M4×7.6×B				
	10	I60M4×8.5×B				

Technical drawing of a cylindrical component. The front view (left) shows a cylinder with a central hole, labeled with length L and inner width $I.W.$. The side view (right) shows the cylinder's profile with outer diameter ϕd and a section line S indicating a cross-section at radius r .

[illegible]

Insert shape	Type	Dimensions(inch)					Coated grade								Cermet		Cemented carbide						
		I.W	L	S	ød	r	YBC302	YBM253	YBD152	YBD203	YBD252	YBG105	YBG202	YBG205	YBG205H	YB9320	YBG302	YBS203	YBS303	YNG151	YNG151C	YD101	YD201
	LNET102304-GM	0.295	0.394	0.091	0.114	0.0157	●	●							○				○				
	LNET102804-GM	0.295	0.394	0.110	0.114	0.0157	●	●							○				○				
	LNET103304-GM	0.295	0.394	0.130	0.114	0.0157	●	●							○				○				
	LNET123804-GM	0.394	0.512	0.150	0.173	0.0157	●	●							○				○				
	LNET124304-GM	0.394	0.512	0.169	0.173	0.0157	●	●							○				○				
	LNET124804-GM	0.394	0.512	0.189	0.173	0.0157	●	●							○				○				
	LNET125304-GM	0.394	0.512	0.209	0.173	0.0157	●	●							○				○				

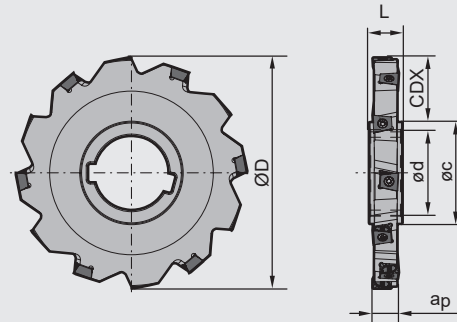
● Recommended grade ○ Produce according to order

Workpiece material		Hardness HB	Insert grade	Cutting parameters	
				V(SFPM)	f(IPT)
P	Low-carbon steel, Soft steel	≤ 180	YBG205H YBM253	492(328~656)	0.0047(0.0039~0.0118)
	High-carbon steel, Alloy steel	180-280	YBG205H YBM253	394(262~656)	0.0047(0.0039~0.0118)
	Alloy tool steel	280-350	YBG205H YBM253	328(262~656)	0.0047(0.0039~0.0118)
M	Stainless steel	≤ 270	YBG205H YBM253	328(262~656)	0.0031(0.0020~0.0059)
K	Cast iron, Ductile iron, High nickel cast iron	180-250	YBG205H	492(328~820)	0.0031(0.0020~0.0059)

Side and face milling tools



SMP09 P M K

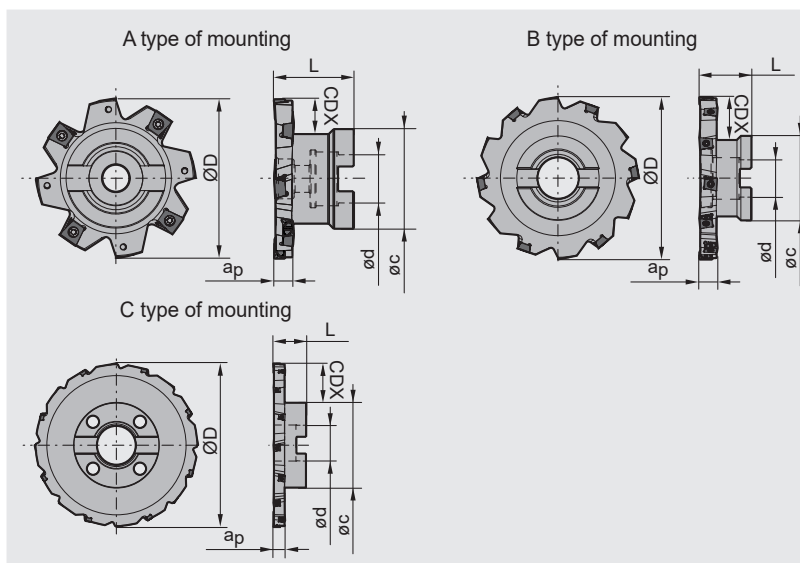
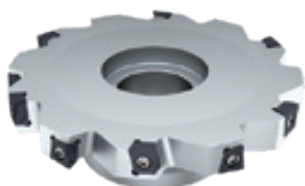


K type of mounting

Specification of tools

Type		Dimensions(inch)							Number of teeth Z	Type of coupling
		ØD	ød	øc	L	ap	CDX	Applicable inserts		
SMP09	-3.00"×0.394"-K1.00"-LN08-08	3.00	1.00	1.732	0.551	0.394	0.669	LNGX0804□□-GM	8	K
	-4.00"×0.394"-K1.25"-LN08-10	4.00	1.25	1.850	0.551	0.394	1.000		10	K
	-5.00"×0.394"-K1.50"-LN08-12	5.00	1.50	2.165	0.551	0.394	1.339		12	K
	-6.00"×0.394"-K1.50"-LN08-14	6.00	1.50	2.520	0.551	0.394	1.850		14	K
	-8.00"×0.394"-K2.00"-LN08-16	8.00	2.00	2.913	0.551	0.394	2.441	LNGX0804□□-GM	16	K
	-4.00"×0.472"-K1.25"-LN08-10	4.00	1.25	1.850	0.630	0.472	1.000		10	K
	-5.00"×0.472"-K1.50"-LN08-12	5.00	1.50	2.165	0.630	0.472	1.339		12	K
	-6.00"×0.472"-K1.50"-LN08-14	6.00	1.50	2.520	0.630	0.472	1.850		14	K
	-8.00"×0.472"-K2.00"-LN08-16	8.00	2.00	2.913	0.630	0.472	2.441	LNGX1005□□-GM	16	K
	-4.00"×0.551"-K1.25"-LN10-10	4.00	1.25	1.850	0.709	0.551	1.000		10	K
	-5.00"×0.551"-K1.50"-LN10-12	5.00	1.50	2.165	0.709	0.551	1.339		12	K
	-6.00"×0.551"-K1.50"-LN10-14	6.00	1.50	2.441	0.709	0.551	1.850		14	K
	-8.00"×0.551"-K2.00"-LN10-16	8.00	2.00	2.835	0.709	0.551	2.441		16	K
	-5.00"×0.630"-K1.50"-LN10-12	5.00	1.50	2.165	0.787	0.630	1.339	LNGX1005□□-GM	12	K
	-6.00"×0.630"-K1.50"-LN10-14	6.00	1.50	2.441	0.787	0.630	1.850		14	K
	-8.00"×0.630"-K2.00"-LN10-16	8.00	2.00	2.835	0.787	0.630	2.441		16	K
	-5.00"×0.709"-K1.50"-LN10-12	5.00	1.50	2.165	0.945	0.709	1.339	LNGX1005□□-GM	12	K
	-6.00"×0.709"-K1.50"-LN10-14	6.00	1.50	2.441	0.945	0.709	1.850		14	K
	-8.00"×0.709"-K2.00"-LN10-16	8.00	2.00	2.835	0.945	0.709	2.441		16	K
	-10.00"×0.709"-K2.00"-LN10-18	10.00	2.00	3.150	0.945	0.709	3.268	LNGX1407□□-GM	18	K
	-5.00"×0.787"-K1.50"-LN14-10	5.00	1.50	2.165	1.024	0.787	1.339		10	K
	-6.00"×0.787"-K1.50"-LN14-12	6.00	1.50	2.441	1.024	0.787	1.850		12	K
	-8.00"×0.787"-K2.00"-LN14-14	8.00	2.00	2.835	1.024	0.787	2.441		14	K
	-10.00"×0.787"-K2.00"-LN14-16	10.00	2.00	3.150	1.024	0.787	3.268		16	K
	-6.00"×0.984"-K1.50"-LN14-12	6.00	1.50	2.441	1.181	0.984	1.850	LNGX1407□□-GM	12	K
	-8.00"×0.984"-K2.00"-LN14-14	8.00	2.00	2.835	1.181	0.984	2.441		14	K
	-10.00"×0.984"-K2.00"-LN14-16	10.00	2.00	3.150	1.181	0.984	3.268		16	K

Side and face milling tools

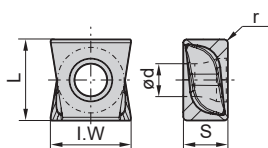

SMP09


Specification of tools

Type		Dimensions(inch)						Applicable inserts	Number of teeth Z	Type of coupling
		ØD	ød	øc	L	ap	CDX			
SMP09	-3.00"×0.394"-A0.75"-LN08-08	3.00	0.75	1.732	0.551	0.394	0.669	LNGX0804□□-GM	8	A
	-4.00"×0.394"-B1.00"-LN08-10	4.00	1.00	1.850	0.551	0.394	1.000		10	B
	-5.00"×0.394"-B1.25"-LN08-12	5.00	1.25	2.165	0.551	0.394	1.339		12	B
	-6.00"×0.394"-B1.50"-LN08-14	6.00	1.50	2.520	0.551	0.394	1.850		14	B
	-8.00"×0.394"-C1.50"-LN08-16	8.00	1.50	2.913	0.551	0.394	2.441		16	C
	-4.00"×0.472"-B1.00"-LN08-10	4.00	1.00	1.850	0.630	0.472	1.000	LNGX0804□□-GM	10	B
	-5.00"×0.472"-B1.25"-LN08-12	5.00	1.25	2.165	0.630	0.472	1.339		12	B
	-6.00"×0.472"-B1.50"-LN08-14	6.00	1.50	2.520	0.630	0.472	1.850		14	B
	-8.00"×0.472"-C1.50"-LN08-16	8.00	1.50	2.913	0.630	0.472	2.441		16	C
	-4.00"×0.551"-B1.00"-LN10-10	4.00	1.00	1.850	0.709	0.551	1.000	LNGX1005□□-G	10	B
	-5.00"×0.551"-B1.25"-LN10-12	5.00	1.25	2.165	0.709	0.551	1.339		12	B
	-6.00"×0.551"-B1.50"-LN10-14	6.00	1.50	2.441	0.709	0.551	1.850		14	B
	-8.00"×0.551"-C1.50"-LN10-16	8.00	1.50	2.835	0.709	0.551	2.441		16	C
	-5.00"×0.630"-B1.25"-LN10-12	5.00	1.25	2.165	0.787	0.630	1.339	LNGX1005□□-GM	12	B
	-6.00"×0.630"-B1.50"-LN10-14	6.00	1.50	2.441	0.787	0.630	1.850		14	B
	-8.00"×0.630"-C1.50"-LN10-16	8.00	1.50	2.835	0.787	0.630	2.441		16	C
	-5.00"×0.709"-B1.25"-LN10-12	5.00	1.25	2.165	0.945	0.709	1.339	LNGX1005□□-GM	12	B
	-6.00"×0.709"-B1.50"-LN10-14	6.00	1.50	2.441	0.945	0.709	1.850		14	B
	-8.00"×0.709"-C1.50"-LN10-16	8.00	1.50	2.835	0.945	0.709	2.441		16	C
	-10.00"×0.709"-C2.50"-LN10-18	10.00	2.50	3.150	0.945	0.709	3.268		18	C
	-5.00"×0.787"-B1.25"-LN14-10	5.00	1.25	2.165	1.024	0.787	1.339	LNGX1407□□-GM	10	B
	-6.00"×0.787"-B1.50"-LN14-12	6.00	1.50	2.441	1.024	0.787	1.850		12	B
	-8.00"×0.787"-C1.50"-LN14-14	8.00	1.50	2.835	1.024	0.787	2.441		14	C
	-10.00"×0.787"-C2.50"-LN14-16	10.00	2.50	3.150	1.024	0.787	3.268		16	C
	-6.00"×0.984"-B1.50"-LN14-12	6.00	1.50	2.441	1.181	0.984	1.850	LNGX1407□□-GM	12	B
	-8.00"×0.984"-C1.50"-LN14-14	8.00	1.50	2.835	1.181	0.984	2.441		14	C
	-10.00"×0.984"-C2.50"-LN14-16	10.00	2.50	3.150	1.181	0.984	3.268		16	C
	-12.00"×0.984"-C2.50"-LN14-20	12.00	2.50	3.150	1.181	0.984	3.543		20	C

Insert	Edge width a _p (inch)	Screw	Wrench		Sketch of installation
LNGX0804□□-GM	0.394	I60M3.5×8TT	--	WP10IS	
LNGX0804□□-GM	0.472	I60M4×10	--	WP15IS	
LNGX1005□□-GM	0.551~0.709	I60M3.5×8TT	--	WP10IS	
LNGX1407□□-GM	0.787~0.984	I60M4×12	--	WP15IS	

Selection of inserts



	Good working conditions	General working conditions	Adverse working conditions
P Steel	😊😊		😞😞😞😞😞😞😞😞
M Stainless steel	😞😞		😞😞😞😞😞😞😞😞😞😞😞😞
K Cast iron		😞😞😞😞	
N Ferrite materials			😞😞
S Heat-resistant steel		😊😞😞😞😞😞😞😞😞	

Insert shape	Type	Dimensions(inch)					Coated grade													Cermets		Cemented carbide		
		I.W	L	S	ød	r	YBC302	YBM253	YBD152	YBD203	YBD252	YBG105	YBG202	YBG205	YBG205H	YBG320	YBG302	YBS203	YBS303	YNG151	YNG151C	YD101	YD201	
	LNGX080404-GM	0.331	0.305	0.157	0.136	0.0315	●	○		○				○	○	○			○					
	LNGX080408-GM	0.331	0.305	0.157	0.136	0.0315	●	○		○				○	○	○			○					
	LNGX080410-GM	0.331	0.305	0.157	0.136	0.0394	●	○		○				○	○	○			○					
	LNGX080412-GM	0.331	0.305	0.157	0.136	0.0472	●	○		○				○	○	○			○					
	LNGX080416-GM	0.331	0.305	0.157	0.136	0.0630	●	○		○				○	○	○			○					
	LNGX080420-GM	0.331	0.305	0.157	0.136	0.0787	●	○		○				○	○	○			○					
	LNGX080424-GM	0.331	0.305	0.157	0.136	0.0945	●	○		○				○	○	○			○					
	LNGX080430-GM	0.331	0.305	0.157	0.136	0.1181	●	○		○				○	○	○			○					
	LNGX100504-GM	0.390	0.394	0.217	0.161	0.0157	●	○		○				○	○	○			○					
	LNGX100508-GM	0.390	0.394	0.217	0.161	0.0315	●	○		○				○	○	○			○					
	LNGX100512-GM	0.390	0.394	0.217	0.161	0.0472	●	○		○				○	○	○			○					
	LNGX100516-GM	0.390	0.394	0.217	0.161	0.0630	●	○		○				○	○	○			○					
	LNGX100520-GM	0.390	0.394	0.217	0.161	0.0787	●	○		○				○	○	○			○					
	LNGX100524-GM	0.390	0.394	0.217	0.161	0.0945	●	○		○				○	○	○			○					
	LNGX100530-GM	0.390	0.394	0.217	0.161	0.1181	●	○		○				○	○	○			○					
	LNGX100540-GM	0.390	0.394	0.217	0.161	0.1575	●	○		○				○	○	○			○					
	LNGX140704-GM	0.528	0.551	0.295	0.173	0.0157	●	○		○				○	○	○			○					
	LNGX140708-GM	0.528	0.551	0.295	0.173	0.0315	●	○		○				○	○	○			○					
	LNGX140712-GM	0.528	0.551	0.295	0.173	0.0472	●	○		○				○	○	○			○					
	LNGX140716-GM	0.528	0.551	0.295	0.173	0.0630	●	○		○				○	○	○			○					
	LNGX140720-GM	0.528	0.551	0.295	0.173	0.0787	●	○		○				○	○	○			○					
	LNGX140724-GM	0.528	0.551	0.295	0.173	0.0945	●	○		○				○	○	○			○					
	LNGX140730-GM	0.528	0.551	0.295	0.173	0.1181	●	○		○				○	○	○			○					
	LNGX140740-GM	0.528	0.551	0.295	0.173	0.1575	●	○		○				○	○	○			○					
	LNGX140750-GM	0.528	0.551	0.295	0.173	0.1969	●	○		○				○	○	○			○					

● Recommended grade ○ Produce according to order



Recommended cutting parameters

	Workpiece material	Hardness HB	Insert grade	Cutting parameters	
				V(SFPM)	f(IPT)
P	Low-carbon steel, Soft steel	≤ 180	YBG205H YBM253	492 (328-656)	0.0047 (0.0039-0.0118)
	High-carbon steel, Alloy steel	180-280	YBG205H YBM253	394 (262-656)	0.0047 (0.0039-0.0118)
	Alloy tool steel	280-350	YBG205H YBM253	328 (262-656)	0.0047 (0.0039-0.0118)
M	Stainless steel	≤ 270	YBG205H YBM253	328 (262-656)	0.0031 (0.0020-0.0059)
K	Cast iron, Ductile iron, High nickel cast iron	180-250	YBG205H	492 (328-820)	0.0031 (0.0020-0.0059)