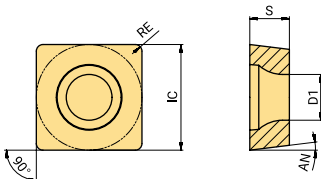
Turning Inserts Positive 90° (S)

(mm)

Product code	IC	S	D1	AN
SC_09T3_	9.525	3.97	4.40	7°
SC_1204_	12.70	4.76	5.50	7°
SC_3809_	38.10	9.525	9.80	7°



● Good Conditions ◐ General Conditions ✱ Bad Conditions

Inserts		Product code	RE (mm)	Recommanded parameters		P						M				K			N	S
				f (mm/rev)	ap (mm)	AT202	AT210A	AC052P	AC152P	AC252P	AC350P	AC100M	AC200M	AP200U	AP301M	AC100K	AC102K	AC202K	AW100K	AP100S
Semi-finishing		**SCGT 09T308F-NC2**	0.80	0.10-0.40	0.64-4.30														●	
Finishing		**SCMT 09T304E-PB1**	0.40	0.04-0.14	0.30-2.40	●	●		○	●		●	●	●						
		09T308E-PB1	0.80	0.09-0.28	0.60-2.40	●	●		●	○		●	●	●	●					
		120404E-PB1	0.40	0.04-0.14	0.30-3.20				○	○		●	●	●						
Semi-finishing		**SCMT 09T304E-PC2**	0.40	0.05-0.16	0.35-2.90	●	●		○	●		●	●	●	●					●
		09T308E-PC2	0.80	0.10-0.32	0.70-2.90	●	●		○	●		●	●	●	●					●
		120404E-PC2	0.40	0.05-0.16	0.35-3.80	●	●		●	○		●	●	●	●					●
		120408E-PC2	0.80	0.10-0.32	0.70-3.80	●	●	○	●	○		●	●	●	●					●
		120412E-PC2	1.20	0.16-0.48	1.05-3.80			○	○	●		●	●	●						●
		SCMT 09T304-M2T	0.40	0.10-0.25	0.70-3.50	●	●													
		09T308-M2T	0.80	0.10-0.25	0.70-3.50	●	●													
Medium		**SCMT 09T304E-KC2**	0.40	0.06-0.18	0.40-3.10	●	●		○	○							●	●		
		09T308E-KC2	0.80	0.12-0.36	0.80-3.10	●	●		●	○					●		●	●		
		120404E-KC2	0.40	0.06-0.18	0.40-4.20	●	●		●	○							●	●		
		120408E-KC2	0.80	0.12-0.36	0.80-4.20	●	●		●	○							●	●		
		120412E-KC2	1.20	0.18-0.54	1.20-4.20				●	●							●	●		
		SCMW 09T304E-KD5	0.40	0.10-0.22	0.40-4.80												●	●		
		09T308E-KD5	0.80	0.20-0.44	0.80-4.80											●	●	●		
		120404E-KD5	0.40	0.10-0.22	0.40-6.40												●	●		
		120408E-KD5	0.80	0.20-0.44	0.80-6.40												●	●		
		120412E-KD5	1.20	0.30-0.66	1.20-6.40											●	●	●		
Roughing		**SCMT 380932S-HT**	3.20	0.70-1.40	4.00-18.00						●									

● : Standard stock ○ : Made-to-Order