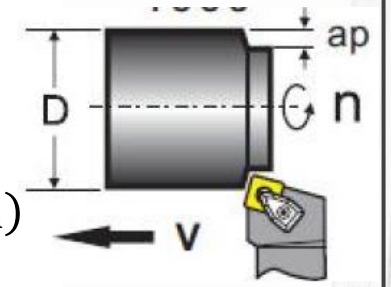
Application & Accessory Guide

Product No.: 2387-2006

Cutting Parameters



Cutting Speed

$$V = \frac{\pi \times D \times n}{1000} (in/min)$$

- *V: Cutting Speed
- *D: Cutting Diameter
- *n: Number of Revolutions

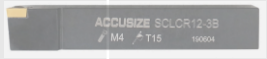
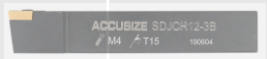
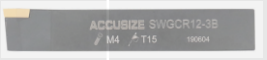
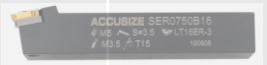
Feed Speed

$$f = \frac{F}{n}$$

- f: Quantity per revolution
- F: Quantity per Min
- n: Number of Revolutions

Cutting depth Ap: 0.012~0.08	Material	Feed speed 0.003~0.012 in
SCLCR12-3B SCLCL12-3B SDJCR12-3B SDNCN12-3B SWGCR12-3B	Low-Carbon steel	459~590 ft/min
	Medium-Carbon steel	328~426 ft/min
	Alloy Steel	262~360 ft/min
	Tool Steel	295~393 ft/min
SER0750B16	Low-Carbon steel	328~590 ft/min
	Medium-Carbon steel	262~524 ft/min
	High-Carbon Steel	196~459 ft/min
	Alloy Steel	229~524 ft/min
MGEHR12-3B Width 0.118”	Alloy Steel	196~360 ft/min
	Low-Carbon steel	262~492 ft/min
	Carbon steel≤HB200	328~656 ft/min
	Carbon steel≥HB200	328~492 ft/min

Accessories

Code of Cutter	Shank	Insert Code	Item No. of Inserts (Cutting Steel)		Item No of Inserts (Cutting Aluminum)
SCLCR12-3B	3/4 × 3/4	CCMT32.5	2200-1014		2000-1008
SCLCL12-3B	3/4 × 3/4	CCMT32.5	2200-1014		2000-1008
SDJCR12-3B	3/4 × 3/4	DCMT32.5	2104-1014		2004-1010
SDNCN12-3B	3/4 × 3/4	DCMT32.5	2104-1014		2004-1010
SWGCR12-3B	3/4 × 3/4	WCMT32.5	2139-1024		2039-1020
SER0750B16	3/4 × 3/4	16ER AG60	2652-0025		2600-0015
MGEHR12-3B	3/4 × 3/4	MGMN300	2403-4026		2403-4023