



**ULTIMATE TOUGHNESS. ULTIMATE WEAR RESISTANCE. ULTIMATE PERFORMANCE.**

**DURATOMIC™**

**SECO** 

# CUTTING DATA

## GENERAL CUTTING DATA

The recommended cutting speeds ( $v_c$  (m/min)) in the table are corresponding to 15 minutes tool life for Seco Material Groups 1-7 (steels) and 12-15 (cast irons). For the Seco Material Groups 8-11 (stainless steels) the cutting speeds are corresponding to 10 minutes tool life.

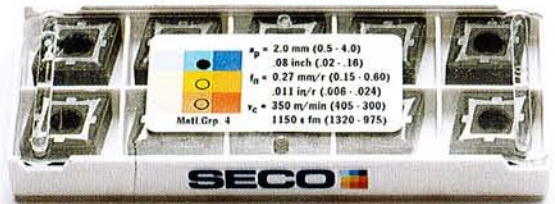
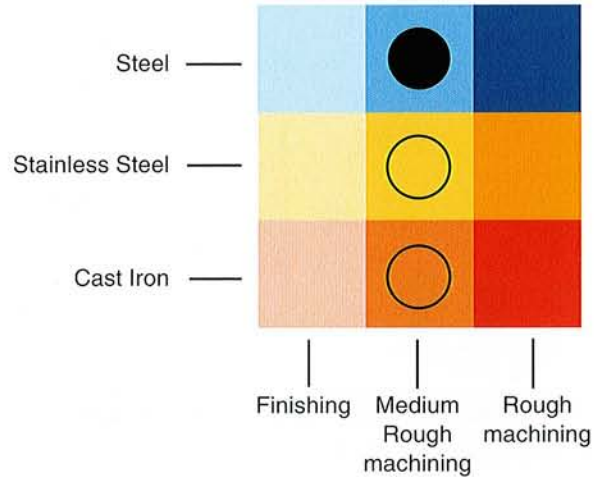
For the stainless steel materials the conditions are that coolant is used.

The classification of workpiece materials is found in our Machining Navigator.

Seco material group No.	TP2500		
	Feed, f (mm/rev)		
	0.2	0.4	0.6
1	640	495	415
2	545	420	350
3	465	355	300
4	385	295	245
5	325	250	210
6	295	225	190
7	130	100	85
8	325	230	130
9	255	185	100
10	210	150	85
11	155	110	60
12	370	280	225
13	330	245	200
14	280	210	170
15	230	175	140

## INDIVIDUAL CUTTING DATA ON THE INSERT BOX

The cutting data located on the cover of the box refer to the black dots in the Secolor matrix and the Seco Material Group stated. The cutting data includes depth of cut, feed rate and cutting speed recommendations in both metric and inch values. The values in bracket represent the total recommended working range. The cutting data is adapted for the specific insert style, chipbreaker, nose radius and the generally used entering angle.



## CUTTING DATA CALCULATOR

When machining workpiece materials corresponding to other material groups and with other depths of cut and/or feed rates, use the cutting data calculator on our website.

The calculator can also be used for changing the required tool life.

vc calculation
✕

Depth of cut:  mm TP1000 TK1000

Cutting edge angle:  Deg. TP2000 TK2000

Nose radius:  mm TP2500

Feed:  mm/r TP3000

Wanted tool life:  min. Calculated cutting speed:

m/min.

Seco Material Group:  ▼

# CHOICE IS EASY

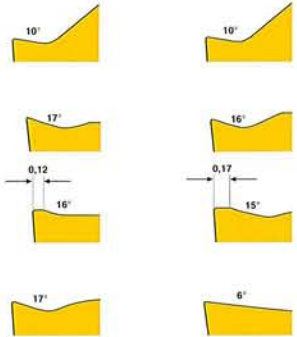
## Positive inserts



FF1	Extreme Finishing
F1	For Finishing.
F2	For General Turning.
W-F1	Seco Wiper For High Feed Finishing

## Corner

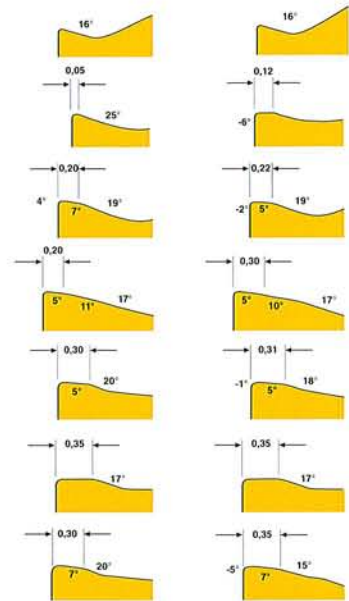
## Cutting Edge



## Negative double sided



FF1	Extreme Finishing
MF2	For Finishing.
M3	For General Turning.
MF5	For General And Near Net Shape Turning
M5	For Medium To Roughing
MR7	Strong Edge For Roughing And Interrupted Cut.
W-M3	Seco Wiper For High Feed General Turning.



## Negative single sided



R4	Medium Roughing
R5	Medium Roughing
RR6	Roughing Of Stainless Steels And Steel
R7	Strong Edge For Roughing And Intermittent Machining
W-R7	Seco Wiper For High Feed Roughing
57	Roughing At High Feed Rates

