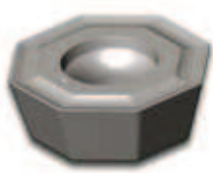


Milling

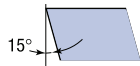


O



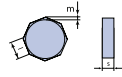
Shape
Octagonal

D



Clearance Angle
15°

M



Tolerance
l ± 0.05 m ± 0.013
s ± 0.025

T

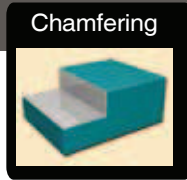


Insert Type
Screw down clamping
Chip breaker

Insert designation	Grade	l	s	P/r	D	Direction	Catalog Nr.	Page
ODMT 0504 ZZTR	LT 30	5	4,76	0,8		Right	M0000664	160
ODMT 060508 TN	LT 30	6	5,56	0,8		Right	M0001104	161

Surfacing Insert Lead angle 45°

Application Guide



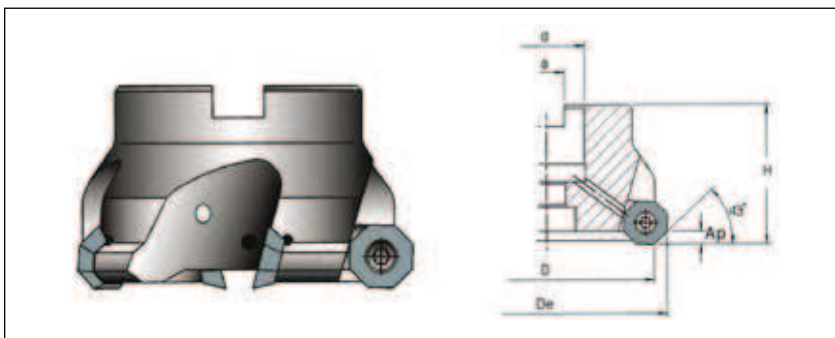
Multi purpose 45° milling inserts, with 8 cutting edges. Suitable for Roughing to Finishing - Face milling, Plunging and Ramping down operations.

Machining Recommendation Guide - Please see Pg. 8



Catalog Nr.	Description	D	De	L	Ap	H	z
M2000711	LT 820 M-D80	80	90	27	4	50	5
M2000712	LT 820 M-D100	100	110	32	4	50	6
M2000713	LT 820 M-D125	125	135	40	4	63	7
M2000714	LT 820 M-D160	160	170	40	4	63	9

Screw set: C O6710 Key set: CT 15



ODMT

Material Group	Group No	Material Examples*	Brinell hardness	d.o.c [mm]		feed [mm/tooth]		V _c [m/min]	
				min	max	min	max	min	max
Low Carbon Steel	1	Ck15, Ck45 1020, 1045	150	0.5	3.5	0.23	0.48	190	350
			180		3.5		0.48		300
			210		3.5		0.48		260
Alloy Steel	2	42 CrMo 4 St 50-2 Ck60 1060 4140	180	0.5	3.5	0.28	0.42	150	240
			230		3.5		0.42		210
			280	0.5	3.5	0.28	0.35	130	190
			320		3.5		0.35		170
High Alloy Steel	3	X40 CrMoV 5 1 H 13 40 NiCrMo 6 4340 S 2-10-1-8 HSS M42	220	0.5	3.5	0.15	0.32	90	150
			280		3.5		0.32		130
			320	0.5	3.5	0.15	0.28	60	110
			350		3.5		0.28		90
			400	0.5	3.0	0.14	0.25	40	80
			480		2.0		0.22		70
			550		1.0		0.20		60
Austenitic Stainless Steel	4	X5 CrNi 18 9 304	210 to 250	0.5	3.5	0.22	0.35	190	250
	5	X2 CrNiMo 17 2 2 316	230 to 270	0.5	3.5	0.18	0.32	160	210
	6	X6 CrNiMoTi 17 12 2 316 Ti Duplex / Nitronic	-----	0.5	3.5	0.15	0.28	70	150
Ferritic Stainless Steel	7	X8 Cr 7 430	Annealed	0.5	3.5	0.18	0.35	150	210
Martensitic Stainless Steel	8	X15 Cr 13 410	Annealed	0.5	3.5	0.18	0.35	150	230
			Treated	0.5	3.5	0.18	0.28	90	170
Grey Cast Iron	9	GG 20 GG 25 GG 30	140 to 230	0.5	3.5	0.20	0.50	170	300 250 210
Nodular Cast Iron	10	GGG 40	210	0.5	3.5	0.18	0.48	120	210
		GGG 50	260						170
		GGG 70	310	0.5	3.0	0.14	0.25	30	150
		G-X260NiCr42	450						60
Nickel Based Alloys	11	Inconel 625	-----	0.5	3.5	0.15	0.30	25	35
		Inconel 718						28	40
		Hastelloy C						40	60
Titanium Based Alloys	12	TiAl 6 V4	-----	0.5	3.5	0.15	0.35	35	60
		T40					0.28	28	40

Material Group	Group No	Material Examples*	Brinell hardness	d.o.c [mm]		feed [mm/tooth]		V _c [m/min]	
				min	max	min	max	min	max
Low Carbon Steel	1	Ck15, Ck45 1020, 1045	150	0.5	4.0	0.23	0.52	190	350
			180		4.0		0.52		300
			210		4.0		0.52		260
Alloy Steel	2	42 CrMo 4 St 50-2 Ck60 1060 4140	180	0.5	4.0	0.20	0.48	150	240
			230		4.0		0.48		210
			280	0.5	4.0	0.20	0.45	130	190
			320		4.0		0.45		170
High Alloy Steel	3	X40 CrMoV 5 1 H 13 40 NiCrMo 6 4340 S 2-10-1-8 HSS M42	220	0.5	4.0	0.15	0.42	90	150
			280		4.0		0.42		130
			320	0.5	4.0	0.15	0.38	60	110
			350		4.0		0.38		90
			400	0.5	3.0	0.14	0.25	40	80
			480		2.0		0.22		70
			550		1.0		0.20		60
Austenitic Stainless Steel	4	X5 CrNi 18 9 304	210 to 250	0.5	4.0	0.18	0.35	190	250
	5	X2 CrNiMo 17 2 2 316	230 to 270	0.5	4.0	0.18	0.32	160	210
	6	X6 CrNiMoTi 17 12 2 316 Ti Duplex / Nitronic	-----	0.5	4.0	0.15	0.28	70	150
Ferritic Stainless Steel	7	X8 Cr 7 430	Annealed	0.5	4.0	0.21	0.38	150	210
Martensitic Stainless Steel	8	X15 Cr 13 410	Annealed	0.5	4.0	0.21	0.38	150	230
			Treated	0.5	4.0	0.21	0.32	90	170
Grey Cast Iron	9	GG 20	140 to 230	0.5	4.0	0.22	0.50	170	300
		GG 25							250
		GG 30							210
Nodular Cast Iron	10	GGG 40	210	0.5	4.0	0.18	0.45	120	210
		GGG 50	260						170
		GGG 70	310						150
		G-X260NiCr42	450						0.5
Nickel Based Alloys	11	Inconel 625	-----	0.5	4.0	0.16	0.32	25	35
		Inconel 718						28	40
		Hastelloy C						40	60
Titanium Based Alloys	12	TiAl 6 V4	-----	0.5	4.0	0.18	0.32	35	60
		T40					0.28	28	40

ODMT

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