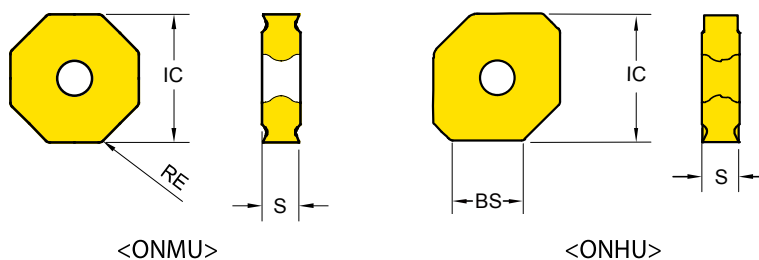


Milling - Face Milling - Inserts

**ONMU / ONHU** - Face Milling Negative (16 Corners)

Series	IC	S
ON*U 0806	20.2	5.8



EDP 1200..

●: Stock item ○: Order made item

P25	P30	P20	P30	P40	K15	K15
M30	K30			M35	S30	H15
S20						

ONMU ONHU	Designation	RE (mm)	Fz (mm/tooth)	BS (mm)	YG602	YG622	YG712	YG713	YG603	YG501	YG5020
	ONMU 080608	0.8	0.22 ~ 0.50		● 0233						● 0414
<b>ONMU</b> General											
	ONHU 080612	1.2	0.08 ~ 0.25	10.6							● 0482
<b>ONHU</b> Wiper Insert											

Cutting Speed			Vc (m/min.)													
ISO	VDI	Sub Group	YG602		YG622		YG712		YG713		YG603		YG501		YG5020	
			Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max
P	1~5	Non-Alloyed Steel	140	380	140	400	170	300	150	280	90	230	-	-	-	-
	6~9	Low-Alloyed Steel	120	300	120	320	180	250	130	235	70	210	-	-	-	-
	10~11	High-Alloyed Steel	70	150	70	170	100	140	90	130	60	100	-	-	-	-
M	12~13	Ferritic & Martensitic	120	200	-	-	-	-	-	-	80	180	-	-	-	-
	14	Austenitic Stainless Steel	130	250	-	-	-	-	-	-	100	200	-	-	-	-
K	15~16	Grey Cast Iron	120	250	120	270	-	-	-	-	-	-	180	350	200	350
	17~18	Nodular Cast Iron	130	220	130	240	-	-	-	-	-	-	120	270	150	300
N	21~30	Non-Ferrous Metals (Al)	-	-	-	-	-	-	-	-	-	-	-	-	-	-
S	31~37	Superalloys & Titanium	25	45	-	-	-	-	-	-	20	40	-	-	-	-
H	38~41	Hard Materials	40	80	40	100	-	-	50	100	-	-	50	90	-	-