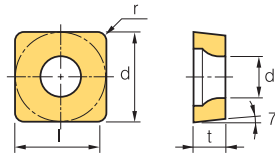


SC ○ ○

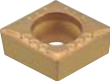
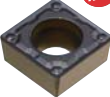


Square 90° Positive
Relief Angle: 7°



Dimensions (mm)			
Size	d	t	d ₁
06	6.35	2.38	2.8
09	9.525	3.97	4.4
12	12.7	4.76	5.5

Workpiece																			Machining types
	Steel	P	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	
Stainless steel	M	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	● Continuous cutting ● General cutting ● Interrupted cutting
Cast iron	K	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	
Non-ferrous metal	N	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	
Heat resistant alloy, Titanium alloy	S	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	
Hardened steel	H	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	

Inserts		Designation	Cermet			Coated		Coated												Uncoated		Cutting Condition					
			CN1500	CN2000	CN2500	CC1500	CC2500	NC3215	NC3120	NC3225	NC3030	NC5330	NC6310	NC6315	NC9115	NC9125	NC9135	PC5300	PC5400	PC8105	PC8110	PC8115	PC9030	H01	H05	fn (mm/rev)	ap (mm)
Finishing	VL 	SCMT 09T304-VL	●		●	●	●	●		●					●	●	●	●	●	●	●	●				0.05~0.10	0.10~1.00
		09T308-VL	●		●	●	●	●		●					●	●	●	●	●	●	●	●				0.08~0.15	0.10~1.00
Medium to finishing	HMP 	SCMT 09T304-HMP							●		●						●					●				0.08~0.23	0.30~3.00
		09T308-HMP							●		●						●					●				0.10~0.30	0.50~3.00
		120404-HMP																								0.09~0.27	0.30~3.60
		120408-HMP									●						●					●				0.12~0.36	0.60~3.60
Medium to finishing	MP 	SCMT 09T304-MP						●		●			●	●	●	●	●		●	●						0.05~0.25	0.30~2.80
		09T308-MP						●		●		●	●	●	●	●	●		●	●						0.10~0.30	0.50~2.80
		120404-MP						●		●				●	●	●	●									0.10~0.30	0.50~2.80
		120408-MP						●		●			●	●	●	●	●		●	●						0.15~0.35	0.80~3.50
		120412-MP																								0.25~0.40	1.00~3.50
Medium cutting	C25 	SCMT 060204-C25									●															0.08~0.25	0.40~2.50
		09T304-C25	●	●	●	●	●	●		●	●	●		●				●	●		●					0.08~0.25	0.60~3.00
		09T308-C25	●		●	●	●	●	●	●	●	●	●					●	●		●					0.10~0.30	1.00~3.00
		120404-C25	●		●	●	●	●	●		●		●					●	●		●		●			0.10~0.30	0.80~3.80
		120408-C25	●		●	●	●	●	●	●	●	●	●					●	●		●		●			0.12~0.38	1.20~3.80

Cutting edge geometry **A52~A61**
 Recommended chip breaker **B04~B11**
 Code system **B26~B27**
● : Stock item

Available tool holders			
Designation	Page	Designation	Page
SSBCR/L	B180	SSKCR/L	B181, 208
SSDCN	B180	SSSCR/L	B181, 234