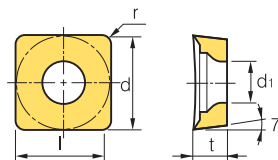


B Aluminum Insert (Positive)

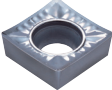
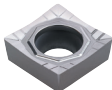
SC ○ ○

 Square **90° Positive**
Relief Angle: 7°



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

Workpiece	Steel							Machining types
	Stainless steel							
	Cast iron							● Continuous cutting ⚙ General cutting ⚙ Interrupted cutting
	Non-ferrous metal		⚙	●	⚙	⚙	⚙	
	Heat resistant alloy, Titanium alloy							
	Hardened steel							

Inserts	Designation	Coated			Uncoated		Cutting Condition	
		PC5040	PD1000	PD1010	H01	H05	f _n (mm/rev)	a _p (mm)
AK 	SCGT 09T302-AK	●				●	0.02~0.30	0.10~4.00
	09T304-AK	●			●	●	0.04~0.40	0.10~5.00
	09T308-AK				●	●	0.03~0.40	0.10~5.00
	120404-AK				●	●	0.03~0.50	0.10~5.00
	120408-AK				●	●	0.04~0.60	0.15~5.50
	120416-AK						0.04~0.60	0.15~5.50
AR 	SCGT 09T302-AR						0.03~0.40	0.50~5.00
	09T304-AR				●	●	0.04~0.50	0.50~6.00
	09T308-AR						0.04~0.50	0.50~6.50
	120404-AR				●	●	0.05~0.60	0.50~6.50
	120408-AR						0.05~0.60	0.50~7.00
	120416-AR						0.05~0.60	0.50~7.00

 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
SSDCN	B180	SSSCR/L	B181

