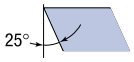
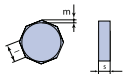
O F M T

Shape
Octagonal



Clearance Angle
15°



Tolerance
l ± 0.05 m ± 0.013
s ± 0.025

Insert Type
Screw down clamping
Chip breaker

Insert designation	Grade	l	s	P/r	D	Direction	Catalog Nr.	Page
OFMT 05T305 TN	LT 30	5	3,97	0,8		Right	M0000591	170
OFMT 050405 TR	LT 30	5	4,76	0,8		Right	M0000034	170
OFMT 070405 TN	LT 30	7	4,76	0,8		Right	M0000592	171

Surfacing Insert Lead angle 43°

Application Guide

Surfacing

Chamfering

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

Machining Recommendation Guide - Please see Pg. 8

LAMINA TECHNOLOGIES

OFMT 05T305 TN

Catalog Nr.	Description	D	De	d	H	Ap	z
M2000501	LT 800 M-W-D32	32	39	16	40	3,5	3
M2000502	LT 800 M-W-D40	40	47	16	40	3,5	3
M2000503	LT 800 M-W-D50	50	57	22	40	3,5	4
M2000504	LT 800 M-W-D63	63	70	22	40	3,5	5
M2000505	LT 800 M-W-D80	80	87	27	50	3,5	6
M2000506	LT 800 M-W-D100	100	107	32	50	3,5	7
M2000507	LT 800 M-W-D125	125	132	40	63	3,5	8

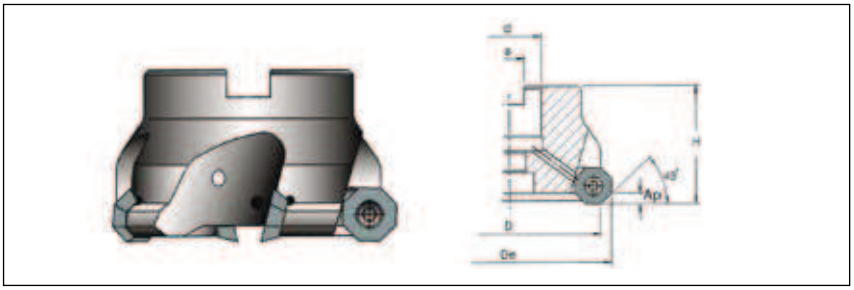
OFMT 050405 TR

Catalog Nr.	Description	D	De	d	H	Ap	z
M2001602	LT 805 M-W-D32	32	39	16	40	3,5	3
M2001603	LT 805 M-W-D40	40	47	16	40	3,5	3
M2001604	LT 805 M-W-D50	50	57	22	40	3,5	4
M2001605	LT 805 M-W-D63	63	70	22	40	3,5	5
M2001607	LT 805 M-W-D80	80	87	27	50	3,5	6
M2001608	LT 805 M-W-D100	100	107	32	50	3,5	7
M2001609	LT 805 M-W-D125	125	132	40	63	3,5	8

OFMT 070405 TN

Catalog Nr.	Description	D	De	d	H	Ap	z
M2000707	LT 810 M-D80	80	92	27	50	5	6
M2000708	LT 810 M-D100	100	112	32	50	5	7
M2000709	LT 810 M-D125	125	137	40	63	5	8

W = With coolant Screw set: C O6710 Key set: CT 15



OFMT 05T305 TN & OFMT 050405 TR

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	140 to 230	0.5	3.5	0.20	0.50	170	300
		GG 25							250
		GG 30							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						150
		G-X260NiCr42	450	0.5	3.0	0.14	0.25	30	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	4.5	0.23	0.48	190	350
			180		4.5		0.48		300
			210		4.5		0.48		260
Alloy Steel	2	42 CrMo 4 St 50-2 Ck60 1060 4140	180	0.5	4.5	0.28	0.42	150	240
			230		4.5		0.42		210
			280	0.5	4.5	0.28	0.35	130	190
			320		4.5		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	4.0	0.15	0.32	90	150
			280		4.0		0.32		130
			320	0.5	4.0	0.15	0.28	60	110
			350		4.0		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	4.5	0.22	0.35	190	250
	5	X2 CrNiMo 17 2 2 316	230 to 270	0.5	4.5	0.18	0.32	160	210
	6	X6 CrNiMoTi 17 12 2 316 Ti Duplex / Nitronic	--------	0.5	4.5	0.15	0.28	70	150
Ferritic Stainless Steel	7	X8 Cr 7 430	Annealed	0.5	4.5	0.18	0.35	150	210
Martensitic Stainless Steel	8	X15 Cr 13 410	Annealed	0.5	4.5	0.18	0.35	150	230
			Treated	0.5	4.5	0.18	0.28	90	170
Grey Cast Iron	9	GG 20	140 to 230	0.5	4.5	0.20	0.50	170	300
		GG 25							250
		GG 30							210
Nodular Cast Iron	10	GGG 40	210	0.5	4.0	0.18	0.48	120	210
		GGG 50	260						170
		GGG 70	310						150
		G-X260NiCr42	450	0.5	3.0	0.14	0.25	30	60
Nickel Based Alloys	11	Inconel 625	--------	0.5	4.0	0.15	0.30	25	35
		Inconel 718						28	40
		Hastelloy C						40	60
Titanium Based Alloys	12	TiAl 6 V4	--------	0.5	4.0	0.15	0.35	35	60
		T40					0.28	28	40

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