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Coromant

## CoroMill® MH20

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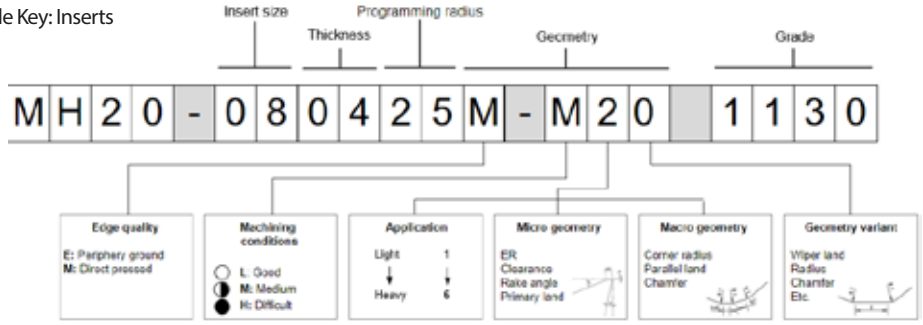
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# The CoroMill® MH20 is primarily designed for pocketing applications with optimized geometries for ISO S, M and P.

Code Key: Inserts



Cutting data, feed recommendations:

ISO area	Grade	Insert Size	Geometry	fz start value (min-max)	
				mm/z	in/z
ISO S	S30T, S40T, GC2040	IC06	E-L30	0.3 (0.1-0.6)	0.012 (0.004-0.024)
		IC08	E-L30	0.45 (0.1-0.6)	0.018 (0.004-0.024)
ISO M	GC1040, GC2040, S30T, S40T	IC06	E-L30	0.3 (0.2-0.8)	0.012 (0.008-0.031)
		IC08	E-L30	0.45 (0.2-0.8)	0.018 (0.008-0.031)
ISO P	GC1130, GC4340	IC06	M-M20	0.6 (0.2-0.8)	0.024 (0.008-0.031)
		IC08	M-M20	0.7 (0.2-1.0)	0.028 (0.008-0.039)
		IC06	M-M50	0.8 (0.45-1.0)	0.031 (0.018-0.039)
		IC08	M-M50	1.0 (0.45-1.3)	0.039 (0.018-0.051)
ISO H	GC1010, GC1130	IC06	M-M20	0.45 (0.15-0.6)	0.018 (0.006-0.024)
		IC08	M-M20	0.55 (0.1-0.8)	0.022 (0.039-0.031)

Cutting data, cutting speed recommendations:

ISO area	Grade	vc (min-max)	
		m/min	ft/m
ISO S	S30T	75-115	246-377
	S40T	75-100	246-328
	GC2040	31-40	102-131
ISO M	GC1040	115-180	377-591
	GC2040	160-225	525-738
	S30T	155-250	509-820
	S40T	165-235	541-771
ISO P	GC1130	150-265	492-869
	GC4340	150-265	492-869
ISO H	GC1010	75-115	246-377

Helical ramping

Metric cutters (DCX)	Inch cutters (DCX)	IC06 inserts				IC08 inserts			
		Max ap 0.8 mm				Max ap 1.3 mm			
		Max ramping angle (RMPX)	Max D <sub>m</sub>	Flat min D <sub>m</sub>	Min D <sub>m</sub>	Max ramping angle (RMPX)	Max D <sub>m</sub>	Flat min D <sub>m</sub>	Min D <sub>m</sub>
16	5/8	10.1°	31.8	23.4	22.4				
		9.5°	32.0	23.6	22.6				
20	3/4	6.5°	38.2	29.8	28.8	38.2	27.6	26.1	
		5.8°	40.0	31.6	30.6	40.0	29.4	27.9	
25		3.7°	50.0	41.6	40.6	50.0	39.4	37.9	
	1	3.6°	50.8	42.4	41.4	50.8	40.2	38.7	
32	1 1/4					63.6	53.0	51.5	
						64.0	53.4	51.9	
40						76.2	65.6	64.1	
	1 1/2					80.0	69.4	67.9	
50						100.0	89.4	87.9	
	2					101.6	91.0	89.5	

