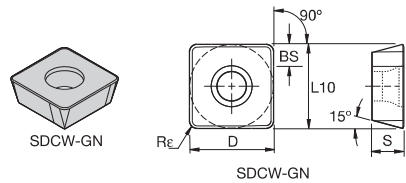


- Heavy machining.
- Precision ground.
- 0° rake face flat top.
- Four cutting edges.



SDCW-GN

catalog number	D	S	L10	BS	Rε	hm	cutting edges	KC410M	KC520M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM30	KCSM40	KY3500
SDCW43EDSR8GN	.500	.188	.500	.132	.031	.006	4	-	-	-	-	-	-	-	-	-	•
SDCW43PDSR8GN	.500	.188	.500	.099	.031	.006	4	-	-	-	-	-	-	-	-	-	•
SDCW433PDSR8GN	.500	.188	.500	.120	.047	.006	4	-	-	-	-	-	-	-	-	-	•

beyond

P	M	K	N	S	H
•	•	•	•	•	•
•	•	•	•	•	•
•	•	•	•	•	•
•	•	•	•	•	•
•	•	•	•	•	•

- first choice
- alternate choice

Recommended Starting Feeds

Recommended Starting Feeds [IPT]

Recommended Starting Feeds [IPT]																Light Machining			General Purpose			Heavy Machining		
Insert Geometry	Recommended Starting Feed per Tooth (Fz) in Relation to % of Radial Engagement (ae)															Insert Geometry								
	5%			10%			20%			30%			40–100%											
.F..LE	.005	.017	.030	.003	.012	.021	.003	.009	.016	.002	.008	.014	.002	.007	.013	.F..LE								
.E..LD	.007	.019	.032	.005	.013	.023	.004	.010	.017	.003	.009	.015	.003	.008	.014	.E..LD								
.E..LD2	.005	.018	.032	.004	.013	.023	.003	.010	.017	.002	.009	.015	.002	.008	.014	.E..LD2								
.E..GB	.009	.021	.035	.007	.015	.025	.005	.011	.019	.004	.010	.016	.004	.009	.015	.E..GB								
.E..GB2	.009	.021	.035	.007	.015	.025	.005	.011	.019	.004	.010	.016	.004	.009	.015	.E..GB2								
.S..GB	.009	.023	.037	.007	.017	.027	.005	.013	.020	.004	.011	.017	.004	.010	.016	.S..GB								
.S..GB2	.009	.023	.037	.007	.017	.027	.005	.013	.020	.004	.011	.017	.004	.010	.016	.S..GB2								
.S..GN	.009	.023	.037	.007	.017	.027	.005	.013	.020	.004	.011	.017	.004	.010	.016	.S..GN								

NOTE: Use "Light Machining" values as starting feed rate.
Please see pages X22-X37 for recommended starting speeds.