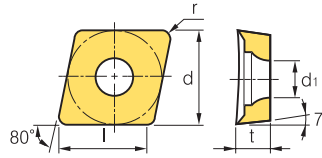




**Rhombic 80° Positive**  
Relief Angle: 7°



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

Workpiece	Steel	P					Machining types	
	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	Coated			Uncoated		Cutting Condition	
		PC5040	PD1000	PD1010	H01	H05	f <sub>n</sub> (mm/rev)	a <sub>p</sub> (mm)
<b>AK</b> 	<b>CCGT</b> 060202-AK	●			●	●	0.01~0.12	0.05~3.00
	060204-AK	●		●	●	●	0.02~0.15	0.10~3.00
	060208-AK				●	●	0.02~0.20	0.10~4.00
	09T302-AK	●		●	●	●	0.02~0.20	0.05~3.00
	09T304-AK	●		●	●	●	0.02~0.30	0.10~5.00
	09T308-AK	●			●	●	0.03~0.50	0.10~5.00
	120402-AK				●	●	0.02~0.30	0.05~4.00
	120404-AK	●		●	●	●	0.03~0.50	0.10~5.00
	120408-AK				●	●	0.04~0.80	0.10~5.50
<b>AR</b> 	<b>CCGT</b> 060202-AR				●	●	0.02~0.30	0.30~4.00
	060204-AR						0.03~0.35	0.50~4.50
	060208-AR						0.04~0.50	0.50~4.50
	09T302-AR				●	●	0.03~0.45	0.30~4.00
	09T304-AR				●	●	0.04~0.50	0.50~4.50
	09T308-AR				●	●	0.05~0.60	0.50~6.00
	120402-AR						0.04~0.50	0.30~5.00
	120404-AR				●	●	0.05~0.60	0.50~6.00
	120408-AR				●	●	0.06~0.65	0.50~6.00
	120412-AR						0.08~0.70	0.50~6.50

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

Available tool holders			
Designation	Page	Designation	Page
SCACR/L	B113, 178	SCLCR/L	B113, 178, 204