



NEW GRADE FOR MILLING OF STEEL 8240

HIGH OPERATIONAL RELIABILITY
WIDE AREA OF APPLICATIONS



**COMPLETION
OF ASSORTMENT**
INSERTS CLAMPED BY SCREW
2008

PRAMET
STEEL AGE



880444



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New grade for milling of steel

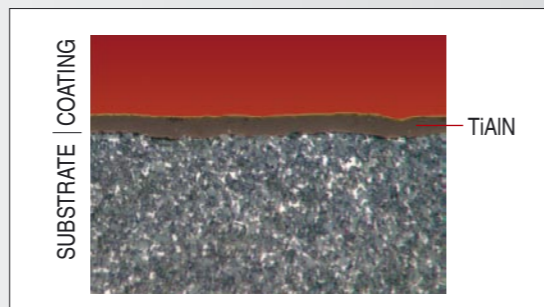
Grade 8240 - the toughest grade of series 8000

8240

High operational reliability and wide application field are predominant features of this grade.

It is suitable for milling of common, heat-resistant, creep-resistant steels and special alloys under adverse cutting conditions (machining of casting and forging skin).

- high operational reliability
- wide area of applications
- high strength of cutting edge
- low friction coefficient



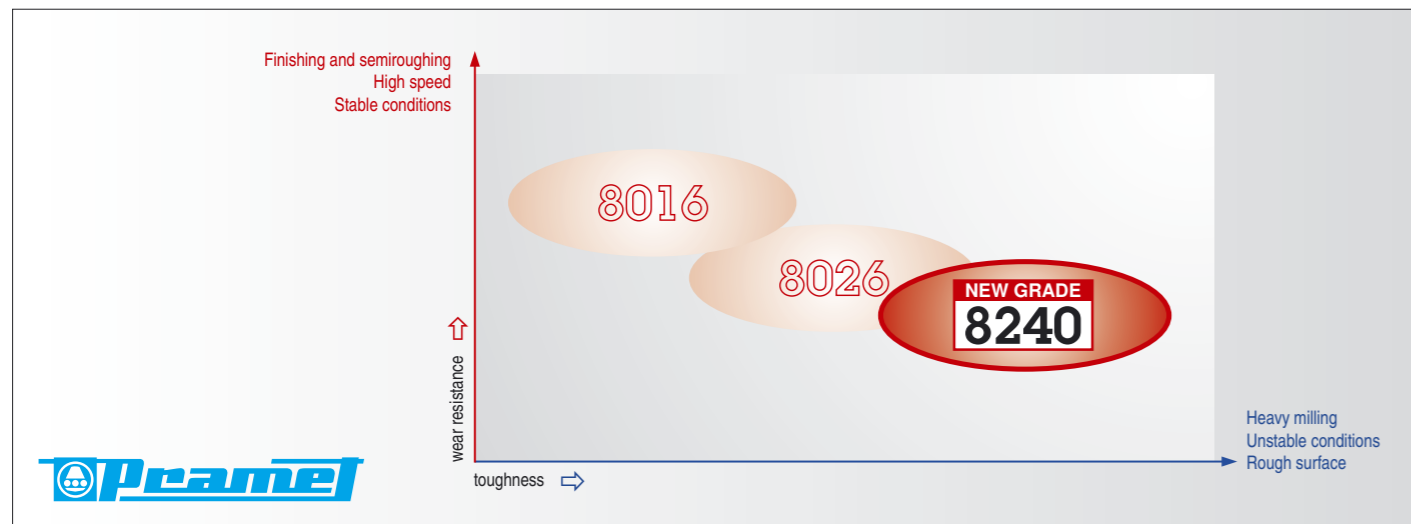
AREA OF APPLICATION:

ISO 513	Area of application 8240			
	20	30	40	50
P		P25 - P50		
M	M20 - M40			
K	K20 - K40			
N				
S	S20 - S30			
H				

Groups of machined materials					
P	M	K	N	S	H

main area
 other application

GRADES FOR MILLING WITH PVD COATING:



INITIAL CUTTING CONDITION:

Basic shape of insert	Cutting condition		Initial cutting conditions			
			P	M	K	S
ADKT 1505PDER-M; 8240	cutting speed	[m.min ⁻¹]	165 ÷ 235	95 ÷ 140	155 ÷ 220	30 ÷ 70
	feed	[mm.tooth ⁻¹]	0,15 ÷ 0,30	0,15 ÷ 0,23	0,15 ÷ 0,30	0,15 ÷ 0,18
	depth of cut	[mm]	1,0 ÷ 13,0	1,0 ÷ 9,8	1,0 ÷ 13,0	1,0 ÷ 7,8
APET 150412SN; 8240	cutting speed	[m.min ⁻¹]	175 ÷ 230	105 ÷ 135	165 ÷ 215	35 ÷ 65
	feed	[mm.tooth ⁻¹]	0,20 ÷ 0,35	0,20 ÷ 0,26	0,20 ÷ 0,35	0,20 ÷ 0,21
	depth of cut	[mm]	1,5 ÷ 12,0	1,5 ÷ 9,0	1,5 ÷ 12,0	1,5 ÷ 7,2
APKT 1003PDER-M; 8240	cutting speed	[m.min ⁻¹]	185 ÷ 255	110 ÷ 150	165 ÷ 215	35 ÷ 75
	feed	[mm.tooth ⁻¹]	0,10 ÷ 0,25	0,10 ÷ 0,19	0,20 ÷ 0,35	0,10 ÷ 0,15
	depth of cut	[mm]	1,0 ÷ 9,0	1,0 ÷ 6,8	1,5 ÷ 12,0	1,0 ÷ 5,4
APKT 160404-HM; 8240	cutting speed	[m.min ⁻¹]	140 ÷ 195	80 ÷ 115	130 ÷ 185	25 ÷ 55
	feed	[mm.tooth ⁻¹]	0,20 ÷ 0,35	0,20 ÷ 0,26	0,20 ÷ 0,35	0,20 ÷ 0,21
	depth of cut	[mm]	1,0 ÷ 13,0	1,0 ÷ 9,8	1,0 ÷ 13,0	1,0 ÷ 7,8
APKT 160416-HM; 8240	cutting speed	[m.min ⁻¹]	185 ÷ 255	110 ÷ 150	175 ÷ 240	35 ÷ 75
	feed	[mm.tooth ⁻¹]	0,20 ÷ 0,35	0,20 ÷ 0,26	0,20 ÷ 0,35	0,20 ÷ 0,21
	depth of cut	[mm]	1,0 ÷ 13,0	1,0 ÷ 9,8	1,0 ÷ 13,0	1,0 ÷ 7,8
APKT 160431-HM; 8240	cutting speed	[m.min ⁻¹]	195 ÷ 270	115 ÷ 160	185 ÷ 255	35 ÷ 80
	feed	[mm.tooth ⁻¹]	0,20 ÷ 0,35	0,20 ÷ 0,26	0,20 ÷ 0,35	0,20 ÷ 0,21
	depth of cut	[mm]	1,0 ÷ 13,0	1,0 ÷ 9,8	1,0 ÷ 13,0	1,0 ÷ 7,8
APKT 1604PDR-GM; 8240	cutting speed	[m.min ⁻¹]	175 ÷ 250	105 ÷ 150	165 ÷ 235	35 ÷ 75
	feed	[mm.tooth ⁻¹]	0,15 ÷ 0,30	0,15 ÷ 0,23	0,15 ÷ 0,30	0,15 ÷ 0,18
	depth of cut	[mm]	1,0 ÷ 13,0	1,0 ÷ 9,8	1,0 ÷ 13,0	1,0 ÷ 7,8
APKT 1604PDR-HM; 8240	cutting speed	[m.min ⁻¹]	175 ÷ 245	105 ÷ 145	165 ÷ 230	35 ÷ 70
	feed	[mm.tooth ⁻¹]	0,20 ÷ 0,35	0,20 ÷ 0,26	0,20 ÷ 0,35	0,20 ÷ 0,21
	depth of cut	[mm]	1,0 ÷ 13,0	1,0 ÷ 9,8	1,0 ÷ 13,0	1,0 ÷ 7,8
ODMT 0504ZZN; 8240	cutting speed	[m.min ⁻¹]	170 ÷ 230	100 ÷ 135	160 ÷ 215	30 ÷ 65
	feed	[mm.tooth ⁻¹]	0,12 ÷ 0,40	0,12 ÷ 0,30	0,12 ÷ 0,40	0,12 ÷ 0,24
	depth of cut	[mm]	1,0 ÷ 7,3	1,0 ÷ 5,5	1,0 ÷ 7,3	1,0 ÷ 4,4
ODMT 0605ZZN; 8240	cutting speed	[m.min ⁻¹]	170 ÷ 230	100 ÷ 135	160 ÷ 215	30 ÷ 65
	feed	[mm.tooth ⁻¹]	0,15 ÷ 0,45	0,15 ÷ 0,34	0,15 ÷ 0,45	0,15 ÷ 0,27
	depth of cut	[mm]	1,0 ÷ 8,6	1,0 ÷ 6,5	1,0 ÷ 8,6	1,0 ÷ 5,2
SDEW 090308EN; 8240	cutting speed	[m.min ⁻¹]	160 ÷ 205	95 ÷ 120	150 ÷ 190	-
	feed	[mm.tooth ⁻¹]	0,10 ÷ 0,30	0,10 ÷ 0,23	0,10 ÷ 0,30	-
	depth of cut	[mm]	1,0 ÷ 4,5	1,0 ÷ 3,4	1,0 ÷ 4,5	-
SDEW 090308SN; 8240	cutting speed	[m.min ⁻¹]	160 ÷ 200	95 ÷ 120	150 ÷ 190	-
	feed	[mm.tooth ⁻¹]	0,15 ÷ 0,30	0,15 ÷ 0,23	0,15 ÷ 0,30	-
	depth of cut	[mm]	1,0 ÷ 4,5	1,0 ÷ 3,4	1,0 ÷ 4,5	-
SDMT 120508SR-M; 8240	cutting speed	[m.min ⁻¹]	165 ÷ 225	95 ÷ 135	155 ÷ 210	30 ÷ 65
	feed	[mm.tooth ⁻¹]	0,10 ÷ 0,25	0,10 ÷ 0,19	0,10 ÷ 0,25	0,10 ÷ 0,15
	depth of cut	[mm]	1,0 ÷ 10,0	1,0 ÷ 7,5	1,0 ÷ 10,0	1,0 ÷ 6,0
SEET 1204AFSN; 8240	cutting speed	[m.min ⁻¹]	200 ÷ 255	120 ÷ 150	190 ÷ 240	40 ÷ 75
	feed	[mm.tooth ⁻¹]	0,20 ÷ 0,40	0,20 ÷ 0,30	0,20 ÷ 0,40	0,20 ÷ 0,24
	depth of cut	[mm]	1,0 ÷ 6,5	1,0 ÷ 4,9	1,0 ÷ 6,5	1,0 ÷ 3,9
SEET 12T3M-PM; 8240	cutting speed	[m.min ⁻¹]	180 ÷ 230	105 ÷ 135	170 ÷ 215	35 ÷ 65
	feed	[mm.tooth ⁻¹]	0,20 ÷ 0,40	0,20 ÷ 0,30	0,20 ÷ 0,40	0,20 ÷ 0,24
	depth of cut	[mm]	1,0 ÷ 6,5	1,0 ÷ 4,9	1,0 ÷ 6,5	1,0 ÷ 3,9

Basic shape of insert	Cutting condition		Initial cutting conditions			
			P	M	K	S
SEEW 1204AFEN; 8240	cutting speed	[m.min ⁻¹]	180 ÷ 255	105 ÷ 150	170 ÷ 240	-
	feed	[mm.tooth ⁻¹]	0,10 ÷ 0,40	0,10 ÷ 0,30	0,10 ÷ 0,40	-
	depth of cut	[mm]	0,5 ÷ 6,5	0,5 ÷ 4,9	0,5 ÷ 6,5	-
SEEW 1204AFSN; 8240	cutting speed	[m.min ⁻¹]	200 ÷ 260	120 ÷ 155	190 ÷ 245	40 ÷ 75
	feed	[mm.tooth ⁻¹]	0,15 ÷ 0,40	0,15 ÷ 0,30	0,15 ÷ 0,40	0,15 ÷ 0,24
	depth of cut	[mm]	1,0 ÷ 6,5	1,0 ÷ 4,9	1,0 ÷ 6,5	1,0 ÷ 3,9
SEMT 09T3AFSN; 8240	cutting speed	[m.min ⁻¹]	185 ÷ 250	110 ÷ 150	175 ÷ 235	35 ÷ 75
	feed	[mm.tooth ⁻¹]	0,12 ÷ 0,35	0,12 ÷ 0,26	0,12 ÷ 0,35	0,12 ÷ 0,21
	depth of cut	[mm]	0,5 ÷ 4,5	0,5 ÷ 3,4	0,5 ÷ 4,5	0,5 ÷ 2,7
SNHQ 1203AZTN; 8240	cutting speed	[m.min ⁻¹]	261 ÷ 295	153 ÷ 175	248 ÷ 280	50 ÷ 85
	feed	[mm.tooth ⁻¹]	0,20 ÷ 0,40	0,20 ÷ 0,30	0,20 ÷ 0,40	0,20 ÷ 0,24
	depth of cut	[mm]	-	-	-	-
SNHQ 1204AZTN; 8240	cutting speed	[m.min ⁻¹]	248 ÷ 290	149 ÷ 170	234 ÷ 275	50 ÷ 85
	feed	[mm.tooth ⁻¹]	0,20 ÷ 0,40	0,20 ÷ 0,30	0,20 ÷ 0,40	0,20 ÷ 0,24
	depth of cut	[mm]	-	-	-	-
SNHQ 1205AZTN; 8240	cutting speed	[m.min ⁻¹]	243 ÷ 285	144 ÷ 170	230 ÷ 270	45 ÷ 85
	feed	[mm.tooth ⁻¹]	0,20 ÷ 0,50	0,20 ÷ 0,38	0,20 ÷ 0,50	0,20 ÷ 0,30
	depth of cut	[mm]	-	-	-	-
SNHQ 1207AZTN; 8240	cutting speed	[m.min ⁻¹]	239 ÷ 275	140 ÷ 165	225 ÷ 260	45 ÷ 80
	feed	[mm.tooth ⁻¹]	0,20 ÷ 0,50	0,20 ÷ 0,38	0,20 ÷ 0,50	0,20 ÷ 0,30
	depth of cut	[mm]	-	-	-	-
SNMT 1205AZSR-M; 8240	cutting speed	[m.min ⁻¹]	230 ÷ 305	135 ÷ 180	215 ÷ 285	45 ÷ 90
	feed	[mm.tooth ⁻¹]	0,15 ÷ 0,50	0,15 ÷ 0,38	0,15 ÷ 0,50	0,15 ÷ 0,30
	depth of cut	[mm]	1,0 ÷ 6,5	1,0 ÷ 4,9	1,0 ÷ 6,5	1,0 ÷ 3,9
SNMT 1205AZSR-R; 8240	cutting speed	[m.min ⁻¹]	230 ÷ 300	135 ÷ 180	215 ÷ 285	45 ÷ 90
	feed	[mm.tooth ⁻¹]	0,18 ÷ 0,50	0,18 ÷ 0,38	0,18 ÷ 0,50	0,18 ÷ 0,30
	depth of cut	[mm]	1,0 ÷ 6,5	1,0 ÷ 4,9	1,0 ÷ 6,5	1,0 ÷ 3,9
SOMT 09T304-MI; 8240	cutting speed	[m.min ⁻¹]	135 ÷ 200	80 ÷ 120	125 ÷ 190	25 ÷ 60
	feed	[mm.tooth ⁻¹]	0,08 ÷ 0,35	0,08 ÷ 0,26	0,08 ÷ 0,35	0,08 ÷ 0,21
	depth of cut	[mm]	0,5 ÷ 8,0	0,5 ÷ 6,0	0,5 ÷ 8,0	0,5 ÷ 4,8
SOMT 09T304-P; 8240	cutting speed	[m.min ⁻¹]	135 ÷ 200	80 ÷ 120	125 ÷ 190	25 ÷ 60
	feed	[mm.tooth ⁻¹]	0,08 ÷ 0,35	0,08 ÷ 0,26	0,08 ÷ 0,35	0,08 ÷ 0,21
	depth of cut	[mm]	0,5 ÷ 8,0	0,5 ÷ 6,0	0,5 ÷ 8,0	0,5 ÷ 4,8
SPET 120408S; 8240	cutting speed	[m.min ⁻¹]	170 ÷ 230	100 ÷ 135	160 ÷ 215	30 ÷ 65
	feed	[mm.tooth ⁻¹]	0,17 ÷ 0,40	0,17 ÷ 0,30	0,17 ÷ 0,40	0,17 ÷ 0,24
	depth of cut	[mm]	1,0 ÷ 12,0	1,0 ÷ 9,0	1,0 ÷ 12,0	1,0 ÷ 7,2
SPET 1204ADEN; 8240	cutting speed	[m.min ⁻¹]	195 ÷ 275	115 ÷ 165	185 ÷ 260	35 ÷ 80
	feed	[mm.tooth ⁻¹]	0,12 ÷ 0,40	0,12 ÷ 0,30	0,12 ÷ 0,40	0,12 ÷ 0,24
	depth of cut	[mm]	1,0 ÷ 12,0	1,0 ÷ 9,0	1,0 ÷ 12,0	1,0 ÷ 7,2
SPET 1204ADSN; 8240	cutting speed	[m.min ⁻¹]	195 ÷ 275	115 ÷ 165	185 ÷ 260	35 ÷ 80
	feed	[mm.tooth ⁻¹]	0,12 ÷ 0,40	0,12 ÷ 0,30	0,12 ÷ 0,40	0,12 ÷ 0,24
	depth of cut	[mm]	1,0 ÷ 12,0	1,0 ÷ 9,0	1,0 ÷ 12,0	1,0 ÷ 7,2
XPHT 160412S; 8240	cutting speed	[m.min ⁻¹]	150 ÷ 215	90 ÷ 125	140 ÷ 200	30 ÷ 60
	feed	[mm.tooth ⁻¹]	0,05 ÷ 0,30	0,05 ÷ 0,23	0,05 ÷ 0,30	0,05 ÷ 0,18
	depth of cut	[mm]	1,2 ÷ 15,0	1,2 ÷ 11,3	1,2 ÷ 15,0	1,2 ÷ 9,0