

TOOL SOLUTIONS

03/2025



STARS OF TURNING

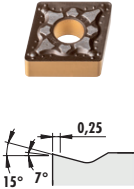
Offer valid until
31/07/2025

ISO indexable cutting inserts **CN.. ISO P**

ISO P

- 80° rhombic, negative 0°

Chip breaker **MP** negative

F finishing	M medium	R roughing	SARA® ISO designation	ISO P	ISO M	ISO K	ISO N	ISO S	ISO H	Quality	art.no.	€
○	●	-										
				●		○				SCP15T	10 367020 0115	5,20
				●		○				SCP25T	10 367020 0125	5,20
				●		○				SCP15T	10 367020 0215	5,20
				●		○				SCP25T	10 367020 0225	5,20
				●		○				SCP15T	10 367020 0315	5,20
				●		○				SCP25T	10 367020 0325	5,20

ISO	SCP15T	SCP25T
ISO P steel	Vc = 110 - 400	Vc = 100 - 345
ISO K cast iron	Vc = 110 - 400	Vc = 100 - 345
Vc = [m/min] f = [mm/U] ap = [mm]	f = 0.10 - 0.65 ap = 0.40 - 5.50	

Chip breaker **RP1** negative

F finishing	M medium	R roughing	ATORN ISO designation	ISO P	ISO M	ISO K	ISO N	ISO S	ISO H	Quality	art.no.	€
-	○	●										
 Medium finishing to roughing operation				●	○					ACP35T	10 366620 0335	10,80
				●	○					ACP35T	10 366620 0635	10,80
				●	○					ACP35T	10 366620 0935	14,80
				●	○					ACP35T	10 366620 1235	14,80

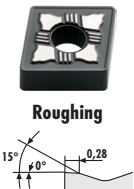
ISO	ACP35T
ISO P steel	Vc = 90 - 200
ISO M stainless steel	Vc = 55 - 200
Vc = [m/min] f = [mm/U] ap = [mm]	f = 0.2 - 0.7 ap = 0.5 - 7.5

Chip breaker **RP5** negative

F finishing	M medium	R roughing	ATORN ISO designation	ISO P	ISO M	ISO K	ISO N	ISO S	ISO H	Quality	art.no.	€
-	○	●										
 Roughing				●		○				HC7610	10 311520 1511	5,40
				●		○				HC7620	10 311520 1512	5,40
				●		○				HC7630	10 311520 1513	5,40
				●		○				HC7610	10 311520 1611	5,40
				●		○				HC7620	10 311520 1612	5,40
				●		○				HC7630	10 311520 1613	5,40

ISO	HC7610	HC7620	HC7630
ISO P steel	Vc = 160 - 320	Vc = 130 - 270	Vc = 110 - 230
ISO K cast iron	Vc = 160 - 520	Vc = 130 - 440	Vc = 110 - 390
Vc = [m/min] f = [mm/U] ap = [mm]	f = 0.20 - 0.40 ap = 1 - 6		

Chip breaker **RP2** negative

F finishing	M medium	R roughing	ATORN ISO designation	ISO P	ISO M	ISO K	ISO N	ISO S	ISO H	Quality	art.no.	€
-	○	●										
 Roughing				●		○				ACP15T	10 366618 0115	5,70
				●		○				ACP15T	10 366618 0215	5,70

ISO	ACP15T
ISO P steel	Vc = 180 - 400
ISO K cast iron	Vc = 140 - 520
Vc = [m/min] f = [mm/U] ap = [mm]	f = 0.2 - 0.5 ap = 0.5 - 6.0

ISO indexable cutting inserts **CN.. ISO M**

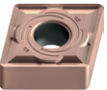
• 80° rhombic, negative 0°

ISO MChip breaker **FM5** negative

F finishing ●	M medium -	R roughing -	ATORN ISO designation	ISO P	ISO M	ISO K	ISO N	ISO S	ISO H	Quality	art.no.	€
 Smoothing			CNGP 120402-FM5		●	○	○	○		APM20T	10 366609 0120	10,30
			CNGP 120404-FM5		●	○	○	○		APM20T	10 366609 0220	10,30
			CNGP 120408-FM5		●	○	○	○		APM20T	10 366609 0320	10,30

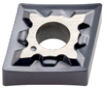
ISO	APM20T
ISO M stainless steel	Vc = 60 - 200
ISO K cast iron	Vc = 120 - 220
ISO N Al/non-ferrous	Vc = 100 - 600
ISO S superalloys	Vc = 20 - 50
Vc = [m/min] f = [mm/U] ap = [mm]	f = 0.08 - 0.25 ap = 0.2 - 2.5

Chip breaker **MM** negative

F finishing ○	M medium ●	R roughing -	SARA ISO designation	ISO P	ISO M	ISO K	ISO N	ISO S	ISO H	Quality	art.no.	€
 5°			CNMG 120404-MM		●			●		SPM10T	10 367023 0110	5,20
					●			●		SPM20T	10 367023 0120	5,20
			CNMG 120408-MM		●			●		SPM10T	10 367023 0210	5,20
					●			●		SPM20T	10 367023 0220	5,20
			CNMG 120412-MM		●			●		SPM10T	10 367023 0310	5,20
					●			●		SPM20T	10 367023 0320	5,20

ISO	SPM10T	SPM20T
ISO M stainless steel	Vc = 130 - 250	Vc = 110 - 220
ISO S superalloys	Vc = 25 - 70	Vc = 20 - 60
Vc = [m/min] f = [mm/U] ap = [mm]	f = 0.10 - 0.50 ap = 0.50 - 4.0	

Chip breaker **SM2** negative

F finishing -	M medium ●	R roughing ○	ATORN ISO designation	ISO P	ISO M	ISO K	ISO N	ISO S	ISO H	Quality	art.no.	€
 Medium finishing to roughing operation			CNMG 120404-SM2	○	●					ACM20T	10 311677 0112	5,95
			CNMG 120408-SM2	○	●					ACM20T	10 311677 0212	5,95

ISO	ACM20T
ISO P steel	Vc = 60 - 250
ISO M stainless steel	Vc = 120 - 250
Vc = [m/min] f = [mm/U] ap = [mm]	f = 0.14 - 0.4 ap = 1.0 - 4.2

Chip breaker **RM5** negative

F finishing -	M medium ○	R roughing ●	ATORN ISO designation	ISO P	ISO M	ISO K	ISO N	ISO S	ISO H	Quality	art.no.	€
 Roughing			CNMG 120408-RM5	○	●			○		APM25T	10 366616 0121	5,70
			CNMG 120412-RM5	○	●			○		APM25T	10 366616 0221	5,70
			CNMG 160612-RM5	○	●					APM25T	10 366616 0421	10,80

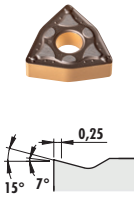
ISO	APM25T
ISO P steel	Vc = 80 - 250
ISO M stainless steel	Vc = 40 - 250
Vc = [m/min] f = [mm/U] ap = [mm]	f = 0.25 - 0.5 ap = 0.5 - 6.0

ISO indexable cutting inserts WN.. ISO P

ISO P

- 80° trigonometric, negative 0°

Chip breaker MP negative

F finishing ○	M medium ●	R roughing -	SARA® ISO designation	ISO P	ISO M	ISO K	ISO N	ISO S	ISO H	Quality	art.no.	€
			WNMG 060404-MP	●		○				SCP15T	10 367022 0115	4,95
				●		○				SCP25T	10 367022 0125	4,95
			WNMG 060408-MP	●		○				SCP15T	10 367022 0215	4,95
				●		○				SCP25T	10 367022 0225	4,95
			WNMG 080404-MP	●		○				SCP15T	10 367022 0315	5,95
				●		○				SCP25T	10 367022 0325	5,95
			WNMG 080408-MP	●		○				SCP15T	10 367022 0415	5,95
				●		○				SCP25T	10 367022 0425	5,95

ISO	SCP15T	SCP25T
ISO P steel	Vc = 110 - 400	Vc = 100 - 345
ISO K cast iron	Vc = 110 - 400	Vc = 100 - 345
Vc = [m/min] f = [mm/U] ap = [mm]	f = 0.10 - 0.30 ap = 0.50 - 4.50	

Chip breaker RP5 negative

F finishing			M medium	R roughing	ATORN	ISO P	ISO M	ISO K	ISO N	ISO S	ISO H	Quality	art.no.		€
-			○	●	ISO designation										
 Roughing					WNMG 080408-RP5	●		●				HC7610	10	311520 1911	6,40
						●		●				HC7620	10	311520 1912	6,40
						●		●				HC7630	10	311520 1913	6,40
					WNMG 080412-RP5	●		●				HC7620	10	311520 2012	6,40

ISO	HC7610	HC7620	HC7630
ISO P steel	Vc = 160 - 270	Vc = 160 - 270	Vc = 160 - 270
ISO K cast iron	Vc = 140 - 390	Vc = 140 - 390	Vc = 140 - 390
Vc = [m/min] f = [mm/U] ap = [mm]	f = 0.2 - 0.4 ap = 0.8 - 6.0		

ISO indexable cutting inserts WN.. ISO M

ISO M

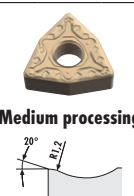
- 80° trigonometric, negative 0°

Chip breaker FM5 negative

F finishing ●	M medium -	R roughing -	ATORN ISO designation	ISO P	ISO M	ISO K	ISO N	ISO S	ISO H	Quality	art.no.	€
			WNGP 080404-FM5		●	○	○	○		APM20T	10 366692 0120	10,25
			WNGP 080408-FM5		●	○	○	○		APM20T	10 366692 0220	10,25

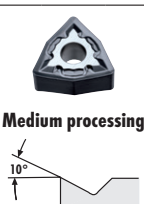
ISO	APM20T
ISO M stainless steel	Vc = 60 - 200
ISO K cast iron	Vc = 120 - 220
ISO N Al/non-ferrous	Vc = 100 - 600
ISO S superalloys	Vc = 20 - 50
Vc = [m/min] f = [mm/U] ap = [mm]	f = 0.2 - 0.08 ap = 0.14 - 2.5

Chip breaker MM (HC75..) negative

F finishing -	M medium ●	R roughing -	ATORN ISO designation	ISO P	ISO M	ISO K	ISO N	ISO S	ISO H	Quality	 art.no.	€
 Medium processing	WNMG 060404-MM				●			●		HC7520	10 310757 0325	5,95
					●			○		HC7530	10 310757 0326	5,95
	WNMG 060408-MM				●			○		HC7520	10 310757 0425	5,95
					●			○		HC7530	10 310757 0426	5,95
	WNMG 080404-MM				●			○		HC7520	10 310757 0625	6,40
	WNMG 080408-MM				●			○		HC7520	10 310757 0925	6,40
					●			○		HC7530	10 310757 0926	6,40

ISO	HC7520	HC7530
ISO M stainless steel	Vc = 110 - 260	Vc = 90 - 200
ISO S superalloys	Vc = 30 - 60	Vc = 30 - 60
Vc = [m/min] f = [mm/U] ap = [mm]	f = 0.18 - 0.4 ap = 1 - 6	

Chip breaker **MM5** negative

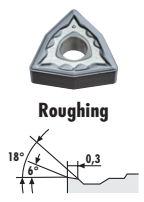
F finishing	M medium	R roughing	ATORN	ISO P	ISO M	ISO K	ISO N	ISO S	ISO H	Quality	art.no.	€
-	•	-	ISO designation									
 Medium processing			WNMG 060404-MM5	○	●					APM25T	10 366694 0121	6,30
			WNMG 060408-MM5	○	●					APM25T	10 366694 0221	6,30
			WNMG 080404-MM5	○	●					APM25T	10 366694 0321	6,75
			WNMG 080408-MM5	○	●					APM25T	10 366694 0421	6,75

Chip breaker **SM2-HP** negative

F finishing	M medium	R roughing	ATORN	ISO P	ISO M	ISO K	ISO N	ISO S	ISO H	Quality	art.no.	€
-	•	-	ISO designation									
 Medium finishing to roughing operation			WNMG 080404-SM2	○	●					ACM20T	10 311679 0112	6,95
			WNMG 080408-SM2	○	●					ACM20T	10 311679 0212	6,95

Highly wear-resistant

Chip breaker **RM5** negative

F finishing	M medium	R roughing	ATORN	ISO P	ISO M	ISO K	ISO N	ISO S	ISO H	Quality	art.no.	€
-	○	•	ISO designation									
 Roughing			WNMG 080408-RM5	○	●					APM25T	10 366699 0121	6,75
			WNMG 080412-RM5	○	●					APM25T	10 366699 0321	6,75

ISO	APM25T
ISO P steel	Vc = 60 - 250
ISO M stainless steel	Vc = 40 - 250
Vc = [m/min] f = [mm/U] ap = [mm]	f = 0.12 - 0.4 ap = 0.25 - 3.5

ISO	ACM20T
ISO P steel	Vc = 60 - 250
ISO M stainless steel	Vc = 120 - 250
Vc = [m/min] f = [mm/U] ap = [mm]	f = 0.2 - 0.4 ap = 1.0 - 4.2

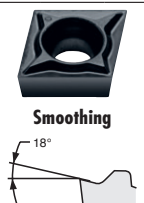
ISO	APM25T
ISO P steel	Vc = 60 - 250
ISO M stainless steel	Vc = 40 - 250
Vc = [m/min] f = [mm/U] ap = [mm]	f = 0.2 - 0.5 ap = 0.5 - 6

ISO indexable cutting inserts **CC.. ISO P**

- 80° rhombic, positive 7°

ISO P

Chip breaker **FU1** positive

F finishing	M medium	R roughing	ATORN	ISO P	ISO M	ISO K	ISO N	ISO S	ISO H	Quality	art.no.	€
•	-	-	ISO designation									
 Smoothing			CCGT 060201-FU1	●	●			●		HC7820	10 311530 1312	7,40
			CCGT 060202-FU1	●	●			●		HC7810	10 311530 1411	7,40
				●	●			●		HC7820	10 311530 1412	7,40
			CCGT 060204-FU1	●	●			●		HC7810	10 311530 1511	7,40
				●	●			●		HC7820	10 311530 1512	7,40
			CCGT 09T301-FU1	●	●			●		HC7820	10 311530 1612	8,50
			CCGT 09T302-FU1	●	●			●		HC7810	10 311530 1711	8,50
				●	●			●		HC7820	10 311530 1712	8,50
			CCGT 09T304-FU1	●	●			●		HC7810	10 311530 1811	8,50
				●	●			●		HC7820	10 311530 1812	8,50
			CCGT 09T308-FU1	●	●			●		HC7810	10 311530 1911	8,50
				●	●			●		HC7820	10 311530 1912	8,50
			CCGT 120404-FU1	●	●			●		HC7820	10 311530 3212	9,70
			CCGT 120408-FU1	●	●			●		HC7820	10 311530 3312	9,70

ISO	HC7810	HC7820
ISO P steel	Vc = 80 - 160	Vc = 30 - 120
ISO M stainless steel	Vc = 130 - 220	Vc = 100 - 220
ISO S superalloys	Vc = 40 - 60	Vc = 40 - 60
Vc = [m/min] f = [mm/U] ap = [mm]	f = 0.05 - 0.30 ap = 0.3 - 3.0	f = 0.08 - 0.25 ap = 0.3 - 3.0

Excellent chip control

ISO indexable cutting inserts **DC.. ISO P****ISO P**

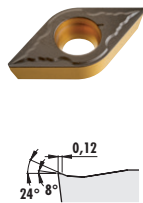
- 55° rhombic, positive 7°

Chip breaker **FU1**

F finishing	M medium	R roughing	ATORN	ISO P	ISO M	ISO K	ISO N	ISO S	ISO H	Quality	art.no.	€
●	-	-	ISO designation									
				●	●			●		HC7820	10 311530 2012	7,10
				●	●			●		HC7810	10 311530 2111	7,10
				●	●			●		HC7820	10 311530 2112	7,10
				●	●			●		HC7810	10 311530 2211	7,10
				●	●			●		HC7820	10 311530 2212	7,10
				●	●			●		HC7820	10 311530 2312	8,30
				●	●			●		HC7810	10 311530 2411	8,30
				●	●			●		HC7820	10 311530 2412	8,30
				●	●			●		HC7810	10 311530 2511	8,30
				●	●			●		HC7820	10 311530 2512	8,30
				●	●			●		HC7810	10 311530 2611	8,30
				●	●			●		HC7820	10 311530 2612	8,30

ISO	HC7810	HC7820
ISO P steel	Vc = 80 - 160	Vc = 80 - 130
ISO M stainless steel	Vc = 130 - 220	Vc = 100 - 210
ISO S superalloys	Vc = 40 - 70	Vc = 40 - 60
Vc = [m/min] f = [mm/U] ap = [mm]	f = 0.05 - 0.30 ap = 0.3 - 3.0	f = 0.05 - 0.12 ap = 0.3 - 3.0

Excellent chip controlChip breaker **MP negative**

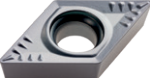
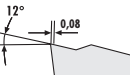
F finishing	M medium	R roughing	SARA®	ISO P	ISO M	ISO K	ISO N	ISO S	ISO H	Quality	art.no.	€
○	●	-	ISO designation									
				●		●				SCP15T	10 367027 0115	4,85
				●		●				SCP25T	10 367027 0125	4,85
				●		●				SCP15T	10 367027 0215	4,85
				●		●				SCP25T	10 367027 0225	4,85
				●		●				SCP15T	10 367027 0315	4,85
				●		●				SCP25T	10 367027 0325	4,85
				●		●				SCP15T	10 367027 0415	4,85
				●		●				SCP25T	10 367027 0425	4,85

ISO	SCP15T	SCP25T
ISO P steel	Vc = 110 - 400	Vc = 100 - 345
ISO K cast iron	Vc = 110 - 400	Vc = 100 - 345
Vc = [m/min] f = [mm/U] ap = [mm]	f = 0.06 - 0.60 ap = 0.20 - 3.00	

ISO indexable cutting inserts **DC.. ISO M**

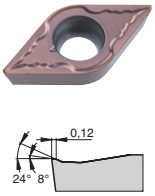
• 55° rhombic, positive 7°

ISO MChip breaker **MM3**

F finishing			M medium	R roughing	ATORN					Quality	 art.no.	€		
○	●	-	ISO designation											
 Medium finishing 					DCMT 070204-MM3							APM35T	10 366629 0121	5,30
					DCMT 070208-MM3							APM35T	10 366629 0221	5,30
					DCMT 11T304-MM3							APM25T	10 366629 0321	6,10
					DCMT 11T308-MM3							APM25T	10 366629 0521	6,10

ISO	APM25T	APM35T
ISO P steel	Vc = 60 - 250	Vc = 60 - 250
ISO M stainless steel	Vc = 40 - 250	Vc = 40 - 250
Vc = [m/min] f = [mm/U] ap = [mm]		
f = 0.12 - 0.3 ap = 0.25 - 3.5		

Chip breaker **MM negative**

F finishing	M medium	R roughing	SARA®	ISO P	ISO M	ISO K	ISO N	ISO S	ISO H	Quality	art.no.	€
○	●	-	ISO designation									
					●			●		SPM10T	10 367030 0110	4,20
					●			●		SPM20T	10 367030 0120	4,20
					●			●		SPM10T	10 367030 0210	4,20
					●			●		SPM20T	10 367030 0220	4,20
					●			●		SPM10T	10 367030 0310	4,20
					●			●		SPM20T	10 367030 0320	4,20
					●			●		SPM10T	10 367030 0410	4,20
					●			●		SPM20T	10 367030 0420	4,20

ISO	SPM10T	SPM20T
ISO M stainless steel	Vc = 100 - 230	Vc = 90 - 220
ISO S superalloys	Vc = 40 - 150	Vc = 35 - 145
Vc = [m/min] f = [mm/U] ap = [mm]		
f = 0.06 - 0.60 ap = 0.19 - 3.00		

ISO indexable cutting inserts **VC.. ISO P**

• 35° rhombic, positive 7°

ISO PChip breaker **FU1**

F finishing	M medium	R roughing	ATORN	ISO P	ISO M	ISO K	ISO N	ISO S	ISO H	Quality	art.no.	€
●	-	-	ISO designation									
 Smoothing				●	●			●		HC7820	10 311530 2712	9,80
					●			●		HC7810	10 311530 2811	9,80
				●	●			●		HC7820	10 311530 2812	9,80
					●			●		HC7810	10 311530 2911	9,80
				●	●			●		HC7820	10 311530 2912	9,80
					●			●		HC7810	10 311530 3011	11,20
				●	●			●		HC7820	10 311530 3012	11,20
					●			●		HC7810	10 311530 3111	11,20
				●	●			●		HC7820	10 311530 3112	11,20

ISO	HC7810	HC7820
ISO P steel	Vc = 80 - 160	Vc = 60 - 130
ISO M stainless steel	Vc = 130 - 220	Vc = 110 - 210
ISO S superalloys	Vc = 40 - 70	Vc = 40 - 60
Vc = [m/min] f = [mm/U] ap = [mm]		
f = 0.05 - 0.12 ap = 0.2 - 2.5		

Excellent chip control

SARATools.com

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