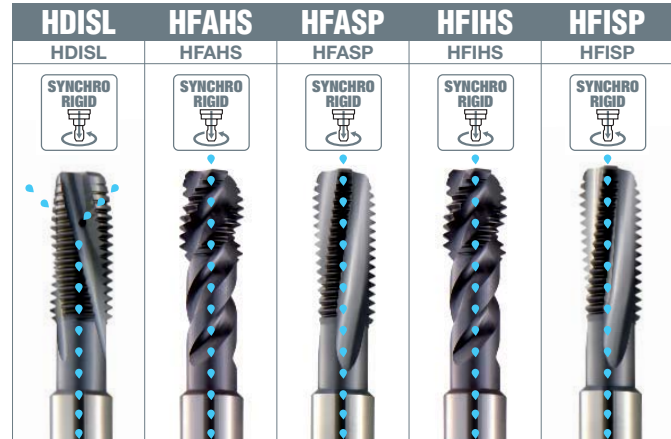


**M, MF**  
**YAMAWA**  
**NORM**

MATERIAL GROUP	Vc (m/min)	
	BR-OX-NX-NI	TiCN
1-5		40~80
6		30~50
9-10-11		25~45
13-14		40~80
15-20		50~100



MATERIAL GROUPS / GRUPPI MATERIALE WERKSTOFFEGRUPPE / GROUPES MATIÈRE									1-5 6 9-11 13 14 15-20	15-20	15-20	1-5 6 9-11 14	1-5 6 9-11 13 14
M6		L15°-OH	48°-OH	8°-OH	48°-OH	8°-OH	HSSE TiCN	HSSE TiCN	HSSE TiCN	HSSE TiCN	HSSE TiCN		
M8~		P CLASS	P CLASS	P CLASS	P CLASS	P CLASS	5 P	2,5 P	2,5 P	2,5 P	2,5 P		
D	p	$\varnothing$	L	l	*	l1	d	k	Stock	Stock	Stock	Stock	Stock
M 6	1	5.0	62	19	11	27	-	6	● (P4)	● (P4)	● (P4)	● (P4)	● (P4)
8	1.25	6.8	70	22	12		36	8	● (P4)	● (P4)	● (P4)	● (P4)	● (P4)
10	1.5	8.5	75	24	13		37	10	● (P4)	● (P4)	● (P4)	● (P4)	● (P4)
12	1.75	10.3	82	29	15		40	12	● (P4)	● (P4)	● (P4)	● (P4)	● (P4)
14	2	12	88	30			40	12	● (P4)				● (P4)
16	2	14	95	32			43	16	● (P4)				● (P4)
20	2.5	17.5	105	37			45	16	○ (P5)				● (P5)
MF10	1.25	8.8	75	24	12		37	10	● (P4)	○ (P4)	○ (P4)	○ (P4)	● (P4)
12	1.5	10.5	82	29	14		40	12	● (P4)	○ (P4)	○ (P4)	○ (P4)	● (P4)
12	1.25	10.8	82	29	14		40	12	● (P4)	○ (P4)	○ (P4)	○ (P4)	● (P4)
14	1.5	12.5	88	30	14		40	12	● (P4)	○ (P4)	○ (P4)	○ (P4)	● (P4)
16	1.5	14.5	95	32	14		43	16	● (P4)	○ (P4)	○ (P4)	○ (P4)	● (P4)
18	1.5	16.5	100	37	14		45	16	○ (P4)	○ (P4)	○ (P4)	○ (P4)	○ (P4)
20	1.5	18.5	105	37	14		45	16	○ (P5)	○ (P5)	○ (P5)	○ (P5)	○ (P5)

\*HDISL, HFISP, HFASP  
P CLASS page 50

● stock standard ○ non-standard stock △ on request EX stock exhaustion



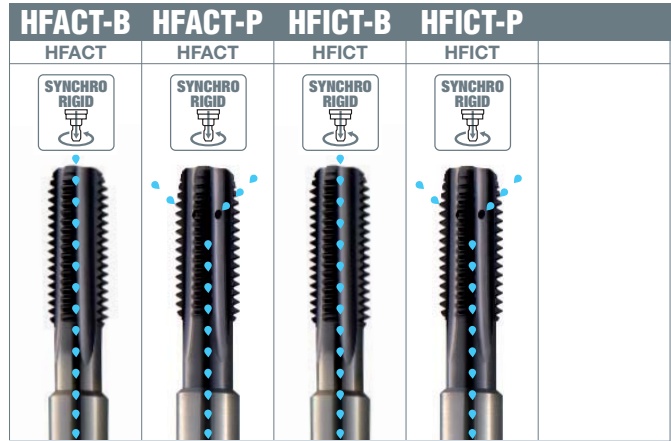
M 6 ~16	3	3	3	3	3
18 ~20	4	3	3	4	4

	●				
	●				
		●	○	●	○
		○	●	○	●

● Most suitable / scelta prioritaria / Geeignetest / le plus indiqué  
○ Alternative / scelta alternativa / Geeignet / indiqué

**M, MF**  
**YAMAWA NORM**

MATERIAL GROUP	Vc (m/min)	
	BR-OX-NX-NI	TiAIN
<b>13 - 14</b>		50~100
<b>16</b>		100~



MATERIAL GROUPS / GRUPPI MATERIALE WERKSTOFFEGRUPPE / GROUPES MATIÈRE													
									16	16	13 14	13 14	
M6									STR-OH-B	STR-OH-P	STR-OH-B	STR-OH-P	
M8~									CARBIDE	CARBIDE	CARBIDE	CARBIDE	
								TiAIN	TiAIN	TiAIN	TiAIN		
								P CLASS	P CLASS	P CLASS	P CLASS		
								2,5 P	4 P	2,5 P	4 P		
D	p	Ø	L	l	l1	l2	d	Stock	Stock	Stock	Stock		
<b>M 6</b>	1	5.0	62	19	27	-	6	○ (P3)	○ (P3)	○ (P3)	○ (P3)		
<b>8</b>	1.25	6.8	70	22		36	8	○ (P3)	○ (P3)	○ (P3)	○ (P3)		
<b>10</b>	1.5	8.5	75	24		37	10	○ (P3)	○ (P3)	○ (P3)	○ (P3)		
<b>12</b>	1.75	10.2	82	29		40	12	○ (P3)	○ (P3)	○ (P3)	○ (P3)		
<b>MF10</b>	1.25	8.8	75	24		37	10	○ (P3)	○ (P3)	○ (P3)	○ (P3)		
<b>12</b>	1.5	10.5	82	29		40	12	○ (P3)	○ (P3)	○ (P3)	○ (P3)		
<b>12</b>	1.25	10.8	82	29		40	12	○ (P3)	○ (P3)	○ (P3)	○ (P3)		

P CLASS page 50

● stock standard ○ non-standard stock △ on request EX stock exhaustion



M 6 ~ 12	3	3	4	4
	●		●	
		●		●

● Most suitable / scelta prioritaria / Geeignetest / le plus indiqué

○ Alternative / scelta alternativa / Geeignet / indiqué