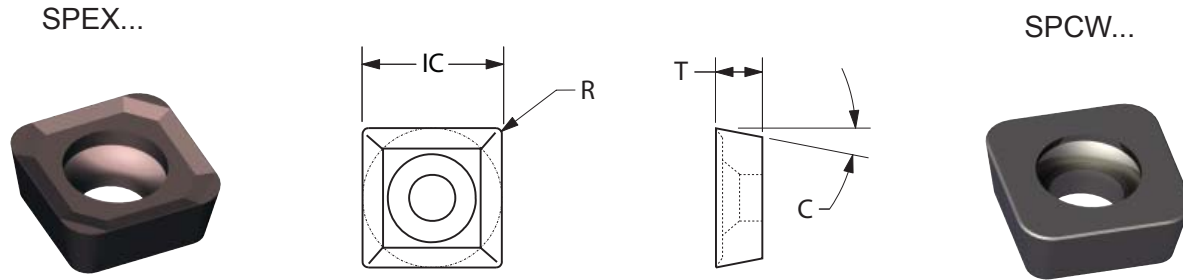


250 Series



| Insert Dimensional & Grade Specifications | | | | | | | | |
|---|-------|-------|-------|-----|----------|----------|--------|----------|
| Insert Number | IC | T | R | C | LT-4073B | LT-2373B | 908XRm | LTC-1200 |
| SPEX-436 | 0.500 | 0.188 | 0.094 | 11° | ● | ● | ● | ● |
| SPCW-436W820 | 0.500 | 0.188 | 0.094 | 11° | | | | ▼ |

| 250 Series High Feed Cutter - Speeds and Feeds Machining Parameters | | | |
|---|-------------|--------------|------------|
| Material | SFM | Feed / Tooth | Max. Depth |
| Low Carbon Steel | 650 - 750 | .020 - .060 | 0.040 |
| Alloy Steel | 500 - 600 | .020 - .060 | 0.040 |
| Austenitic Stainless | 550 - 650 | .020 - .060 | 0.040 |
| Martensitic Stainless | 500 - 550 | .020 - .060 | 0.040 |
| Aluminum | 1000 + | .020 - .060 | 0.040 |
| ▼ Gray Iron | 2500 - 2800 | .020 - .060 | 0.040 |
| ■ Gray & Ductile Iron | 750 - 850 | .020 - .060 | 0.040 |
| Titanium / Supper Alloys | 80 - 150 | .020 - .060 | 0.040 |

P = Steel
 M = Stainless
 K = Cast Iron
 N = Non-Ferrous
 S = High Temp Alloy