

# SNKX 09T3 HF LT30



**LAMINA**  
TECHNOLOGIES



# SNKX 09T3 HF LT30

Lamina Technologies, is pleased to announce the release of its revolutionary High feed SNKX 09T3 insert.

For the first time in the market you can have an 8 cutting edges square insert for high feed milling, with 09 size.



## APPLICATIONS

SNKX 09T3 HF insert is designed to excel in

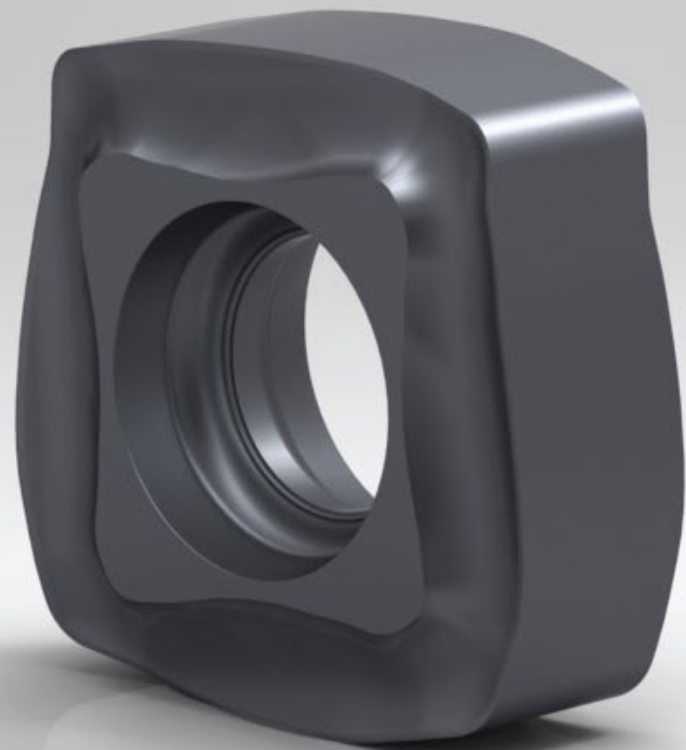
- Copying
- Plunge milling
- Roughing operations on pockets and 3D surfaces

## Key Advantages

- High productivity (more teeth per cutter)
- 8 cutting edges
- Long tool life
- Top Swiss quality with proprietary Sub-micron and PVD technologies
- Positive geometry for low cutting forces
- Excellent for dry machining of moulds and dies
- Superior toughness & wear resistances for consistent performance and tool life

## Ordering Information

- Catalog number M0002115
- Available from stock



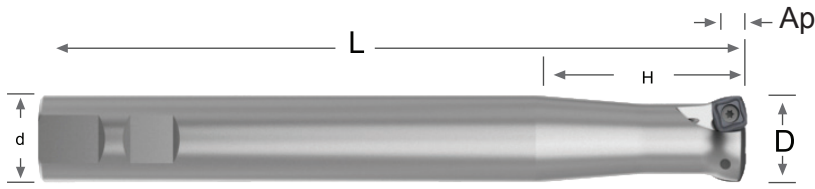
Insert Desig.	Grade	L	S	R	Direction
SNKX 09T3-HF	LT30	9.53mm	3.82mm	0.8mm	Right

# SNKX 09T3-HF LT 30

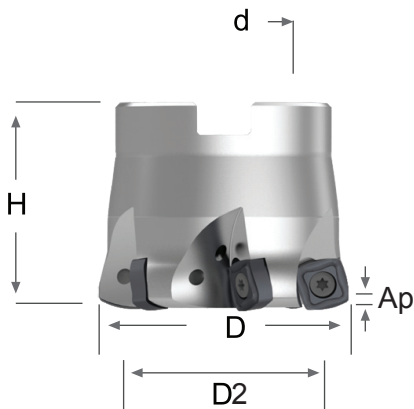
Corner radius for CNC programming: 4.2 mm

Material Group	Group N°	Material Examples*	Brinell hardness	d.o.c [mm]		feed [mm/tooth]		V <sub>c</sub> [m/min]		
				min	max	min	max	min	max	
Low Carbon Steel	1	Ck15, Ck45 1020, 1045	150	0.1	1.0	0.27	2.10	190	350	
			180		1.0		1.95		300	
			210		1.0		1.50		260	
Alloy Steel	2	42 CrMo 4 St 50-2 Ck60 1060 4140	180	0.1	1.0	0.25	1.95	150	240	
			230		1.0		1.71		210	
			280	0.1	1.0	0.23	1.56	130	190	
			320		1.0		1.50		170	
High Alloy Steel	3	X40 CrMoV 5 1 40 NiCrMo 6 S 2-10-1-8 H 13 D2 HSS M42	220	0.1	1.0	0.20	1.71	90	150	
			280		1.0		1.56		130	
			320	0.1	1.0	0.20	1.50	60	110	
			350		0.8		1.41		90	
			400	0.1	0.6	0.18	1.14	40	80	
			480		0.5		1.02		70	
			550		0.4		0.90		60	
Austenitic Stainless Steel	4	X5 CrNi 18 9 304	210 to 250	0.1	1.0	0.20	1.35	190	250	
	5	X2 CrNiMo 17 2 2 316	230 to 270	0.1	1.0	0.17	1.20	160	210	
	6	X6 CrNiMoTi 17 12 2 316 Ti Duplex/Nitronic	-----	0.1	1.0	0.15	1.11	70	150	
Ferritic Stainless Steel	7	X8 Cr 7 430	Annealed	0.1	1.0	0.17	1.20	150	210	
Martensitic Stainless Steel	8	X15 Cr 13 410	Annealed	0.1	1.0	0.17	1.20	150	230	
			Treated	0.1	1.0	0.17	1.20	90	170	
Grey Cast Iron	9	GG 20	140 to 230	0.1	1.0	0.20	2.40	170	300	
		GG 25							250	
		GG 30							210	
Nodular Cast Iron	10	GGG 40	210	0.1	1.0	0.20	1.80	120	210	
		GGG 50	260						170	
		GGG 70	310						150	
White Cast Iron		G-X260NiCr42	400	0.1	1.0	0.16	0.90	30	60	
Nickel Based Alloys	11	Inconel 625	-----	0.1	1.0	0.17	1.05	25	35	
		Inconel 718							28	40
		Hastelloy C							40	60
Titanium Based Alloys	12	TiAl 6 V4	-----	0.1	1.0	0.20	1.14	35	60	
		T40							0.90	28

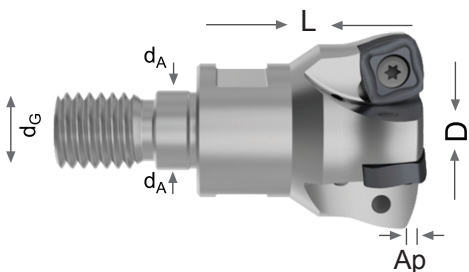
# Cutters Range



Catalog Nr.	Description	D	d	H	L	Ap	Z
<b>M2002118</b>	LT 900 W-W-D25/3	25	25	60	110	1	3
<b>M2002117</b>	LT 900 W-WL-D25/2	25	25	100	200	1	2
<b>M2002119</b>	LT 900 W-W-D32/4	32	32	60	110	1	4
<b>M2002120</b>	LT 900 W-WL-D32/3	32	32	100	200	1	3



Catalog Nr.	Description	D1	D2	d	H	Ap	Z
<b>M2002121</b>	LT 900 M-W-D40/4	40	28.5	16	40	1	4
<b>M2002122</b>	LT 900 M-W-D42/4	42	30.5	16	40	1	4
<b>M2002123</b>	LT 900 M-W-D50/6	50	38.5	22	40	1	6
<b>M2002124</b>	LT 900 M-W-D52/6	52	40.5	22	40	1	6
<b>M2002125</b>	LT 900 M-W-D63/6	63	51.5	22	40	1	6
<b>M2002127</b>	LT 900 M-W-D66/6	66	54.5	22	40	1	6



Catalog Nr.	Description	D	L	dG	dA	Ap	Z
<b>M2002128</b>	LT 900 S-W-D25/3	25	35	M 12	12.5	1	3
<b>M2002129</b>	LT 900 S-W-D32/4	32	35	M 16	12.5	1	4
<b>M2002130</b>	LT 900 S-W-D35/4	35	35	M 16	17	1	4