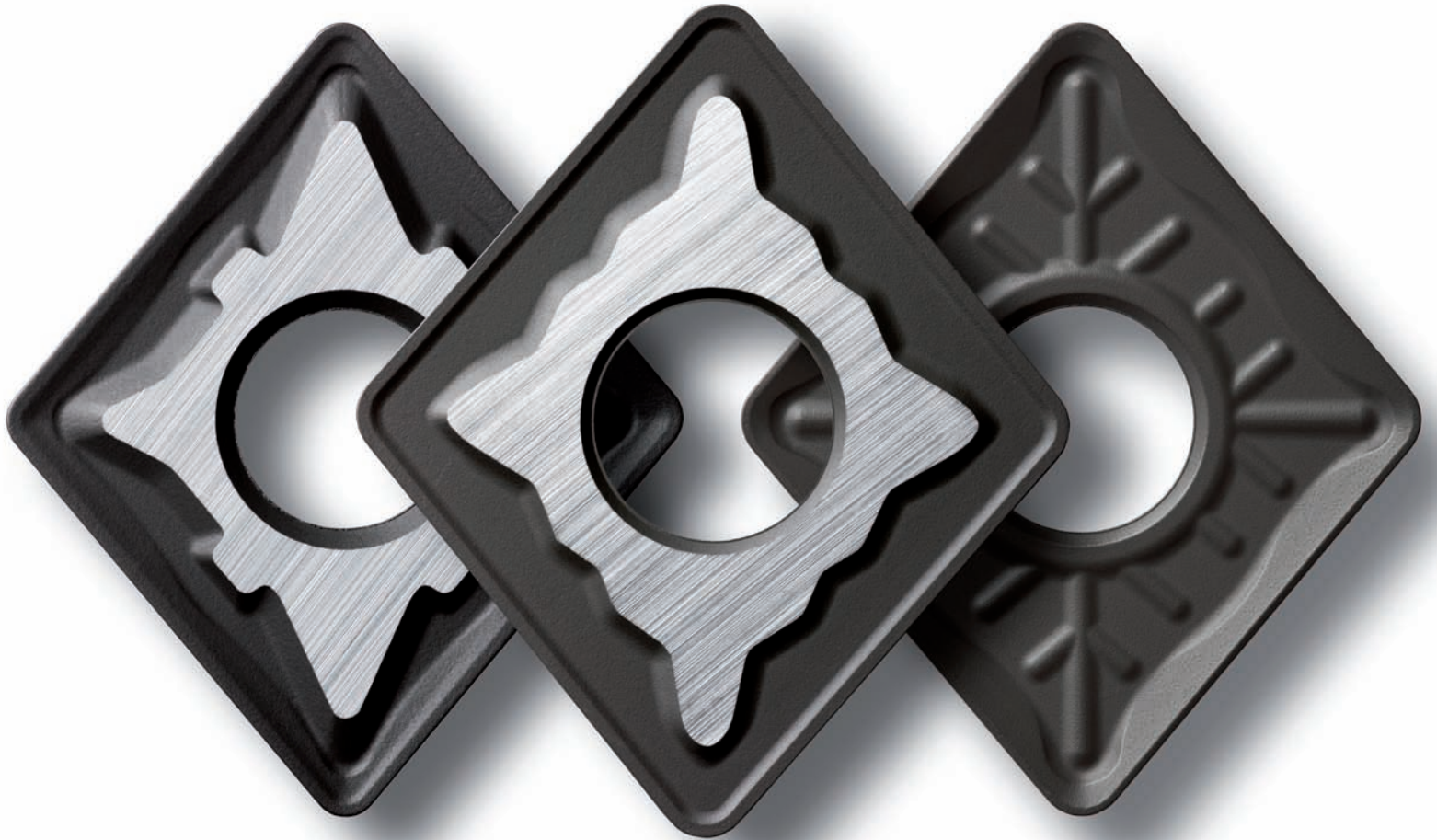


DURATOMIC®

**TECHNICAL GUIDE & INSERT PROGRAM
FOR STEEL & STAINLESS STEEL TURNING**

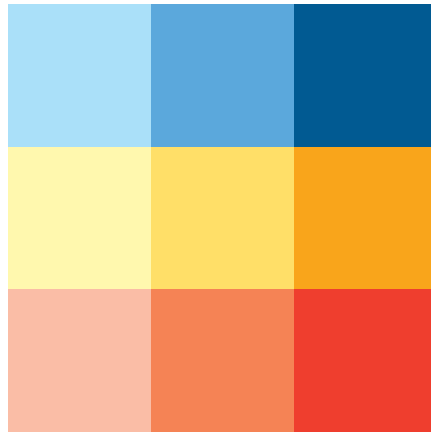


**NEW
TP0500**

TP1500 • TP2500 • TP3500 • TM2000 • TM4000

SECO 

A FULL RANGE SUPPLIER



SECO GRADES FOR MAXIMUM PRODUCTIVITY IN ALL ISO P AND M MATERIALS

Seco's family of grades provides excellent capability for the widest range of steel and stainless steel applications. TP0500 compliments TP1500, TP2500, and TP3500, all of which feature the unique Duratomic coating technology which provides an exceptional combination of wear resistance and edge toughness.

STEEL:

- TP0500: **DURATOMIC** Specifically developed for applications demanding heat resistance. It can also be used in situations where the time in cut is long or the work material is relatively hard. Offers long tool life when deformation and wear resistance is critical and the cutting set-up is stable and rigid.
- TP1500: **DURATOMIC** Specially designed to give long and reliable tool life, at high temperatures and speeds, during stable conditions.
- TP2500: **DURATOMIC** First choice for general purpose steel turning. Wide working window, capability to handle high speed as well as moderately interrupted cuts. Also performs well in ISO M and K applications.
- TP3500: **DURATOMIC** Offers long, predictable tool life in unstable conditions where high edge toughness is needed and harder more wear resistant grades show unpredictable behavior. Also offers the toughness required for ISO M applications

STAINLESS STEEL:

- TM2000: **DURATOMIC** First choice for the highest productivity in high temperature applications, like high speed machining.
- TM4000: **DURATOMIC** First choice for unstable conditions when high productivity and reliability is the most important requirement.

NEW TP0500

THE FASTEST PILE OF CHIPS POSSIBLE

TP0500 was developed specifically for applications requiring a very high degree of heat and wear resistance, especially where the cutting conditions are to be fine-tuned to maximum productivity. This grade's outstanding deformation and abrasion resistance make it ideal for users who typically work with stable set-ups, and can trade some toughness for added speed capability.

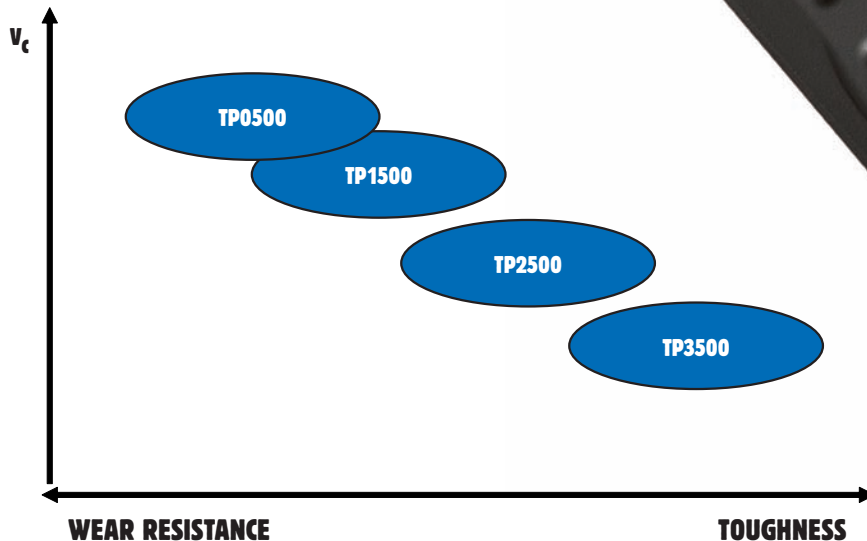
The increased heat resistance of TP0500 makes it an excellent complement to Seco's other steel cutting grades, TP1500, TP2500 and TP3500.

Metallurgically, TP0500 consists of a hard substrate combined with a Duratomic coating. Practically, this means you get the most wear resistant coating for steel applications sitting on top of a hard, deformation resistant base layer. This arrangement withstands tremendous amounts of heat.

- Increased speed capability, even when the time in cut is long
- High metal removal rates, ideal for roughing and semi-roughing operations
- Fewer machine offsets
- Longer times between insert indexes
- Ability to machine harder parts
- Ability to hold tighter tolerances

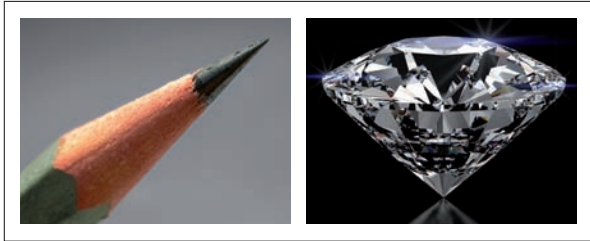
SECO'S DURATOMIC COATED GRADES FOR STEEL MACHINING

No matter what your steel turning need is, Seco has a grade that is well suited for your application.



WHAT IS DURATOMIC®?

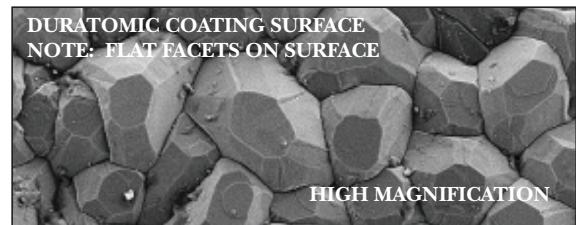
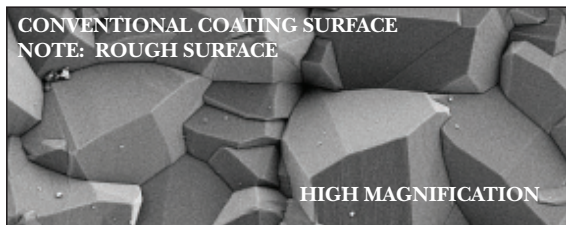
The Duratomic technology produces a durable coating by arranging the aluminum and oxygen atoms in a unique way to provide increased toughness and abrasion resistance. The importance of atomic arrangement can be understood by one extreme illustration. Both graphite and diamond are made from carbon atoms; but the properties of those two materials are dramatically different because of the way the atoms are arranged. In a somewhat similar way, the Duratomic coating is more valuable than traditional coatings because of its atomic structure.



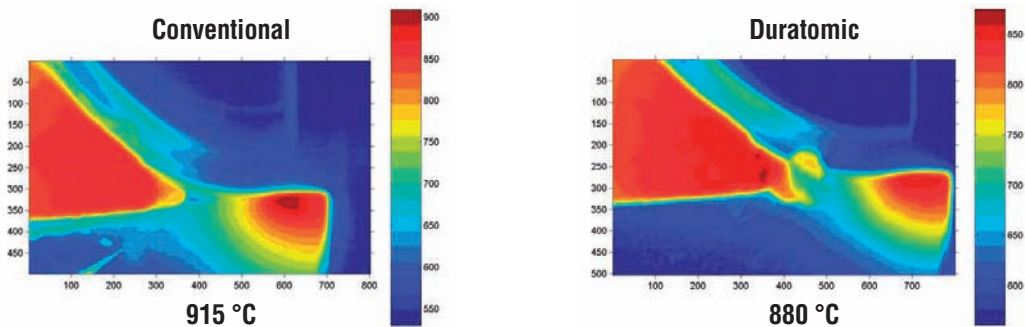
What a difference rearranging a few atoms makes! Above, two materials made from carbon.

Controlling the structure of the aluminum oxide coating leads to several benefits for the user. First, we bring a harder and tougher atomic structure into the cut. Just as wood can be easily split with the grain but not against the grain, aluminum oxide is more brittle in some atomic directions than others. We build the coating in a controlled way to make sure the best structure is engaged in the cut.

Secondly, controlling the structure produces a smoother surface, resulting in less friction and heat during the cut. This translates directly to less build-up, a better surface finish, less tool wear, greater tool life and speed capability.

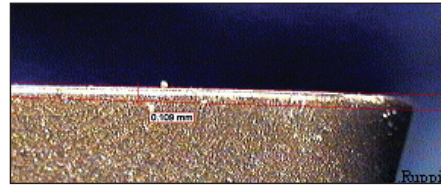
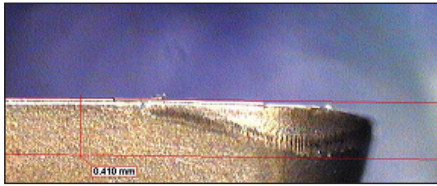


The flat facets on the Duratomic coating prevent built up edge and improve surface finish. These benefits are particularly important in stainless steel machining. The hardness and toughness of the Duratomic coating dramatically reduce insert wear.



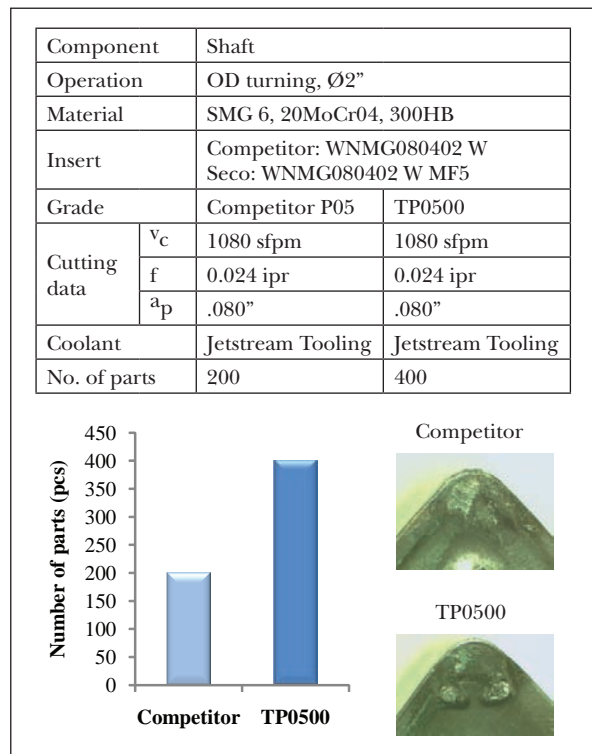
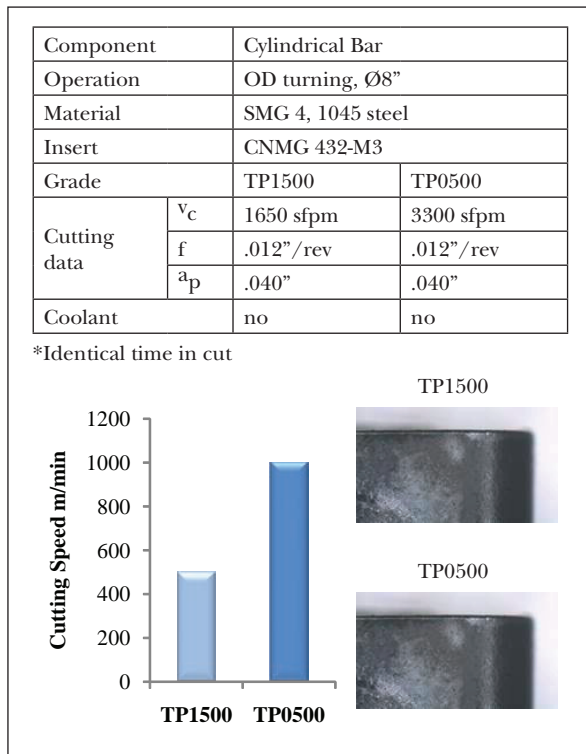
Another practical result of the unique Duratomic structure is illustrated in these thermal images. Under identical conditions, an insert coated with the Duratomic process runs cooler compared to an identical insert coated with a conventional aluminum oxide coating. This means less crater wear, less deformation of the cutting edge, and longer tool life.

The result of these properties is dramatic. Inserts coated using the Duratomic process show less wear, less deformation and much greater tool life.



Identical inserts apart from the coating. The insert on the left has a conventional coating; the insert on the right features a Duratomic coating.

TP0500 TEST RESULTS



TP0500 TAKES THE HEAT!



Cutting Speed

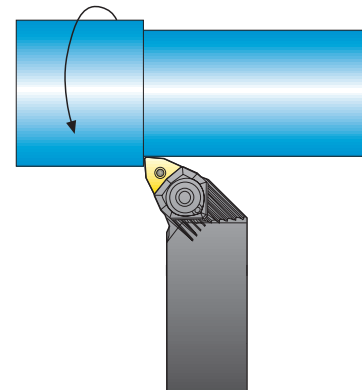
The recommended cutting speeds (sfpm) in the tables are estimated for 15 minutes tool life for Seco Material Groups 1-6 and 12-15, and 10 minutes tool life for Seco Material Group 8-11.

Tool life also depends on the depth of cut used and the insert nose radius. The cutting speeds in the tables are based on a cutting depth of 0.100 inch and nose radius of .031 inch.

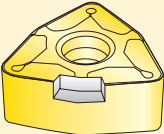

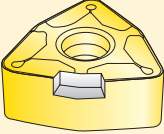

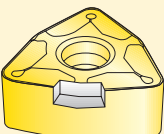

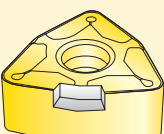

For more accurate recommendations with other combinations of cutting depths and nose radius and other feed rates than those used in the tables, use the Secolor Turning calculator, www.secotools.com.

Seco Material Group No.	CVD coated grades											
	TP0500			TP1500			TP2500			TP3500		
	Feed rate, f ipr											
	.008	.016	.024	.008	.016	.024	.008	.016	.024	.008	.016	.024
	Cutting speed, v _c sfpm											
1	3165	2245	1200	2755	2020	1640	1905	1460	1215	1575	1200	925
2	2690	1900	1015	2360	1740	1410	1610	1230	1035	1328	1000	770
3	2215	1575	835	2020	1475	1200	1360	1050	885	1100	835	640
4	1890	1345	720	1655	1215	985	1130	870	720	935	705	540
5	1575	1115	590	1395	1035	835	950	740	625	790	590	460
6	1375	985	525	1280	935	770	870	675	560	690	525	400
8	-	-	-	-	-	-	1065	755	425	1050	605	370
9	-	-	-	-	-	-	835	605	330	820	475	285
10	-	-	-	-	-	-	690	490	280	670	395	235
11	-	-	-	-	-	-	510	360	195	510	280	165
12	-	-	-	-	-	-	1100	820	675	-	-	-
13	-	-	-	-	-	-	970	720	590	-	-	-
14	-	-	-	-	-	-	835	625	510	-	-	-
15	-	-	-	-	-	-	690	510	410	-	-	-

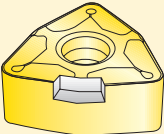

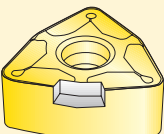

Seco Material Group No.	CVD coated grades					
	TM2000			TM4000		
	Feed rate, f ipr					
	.008	.016	.024	.008	.016	.024
	Cutting speed, v _c sfpm					
1	-	-	-	-	-	-
2	-	-	-	-	-	-
3	-	-	-	-	-	-
4	-	-	-	-	-	-
5	-	-	-	-	-	-
6	-	-	-	-	-	-
8	985	720	575	785	575	460
9	770	575	460	625	460	360
10	640	475	375	510	375	295
11	460	345	280	375	280	215
12	-	-	-	-	-	-
13	-	-	-	-	-	-
14	-	-	-	-	-	-
15	-	-	-	-	-	-



Steel grades - First choice

<p>TP0500</p> 		<p>First choice when maximum productivity under stable conditions is desired. Incorporates the Duratomic coating technology.</p>
<p>TP1500</p> 		<p>Intended for general turning of steel and alloyed steel. The high wear resistance offers high speed capability.</p>
<p>TP2500</p> 		<p>intended for a wide range of turning applications in both steels and stainless steels. Also a good choice for cast iron. The wear resistance and edge strength together with the high versatility make the grade the first choice in a large number of applications.</p>
<p>TP3500</p> 		<p>First choice for rough or intermittent turning in steels and stainless steels as well as general turning of stainless steels.</p>

Stainless Steel grades - First choice

<p>TM2000</p> 		<p>First choice for continuous cuts in stainless steels, particularly when extended time in cut is required. Utilizes the Duratomic coating process.</p>
<p>TM4000</p> 		<p>First choice for rough or intermittent turning in stainless steels. Utilizes a thin Duratomic coating process.</p>

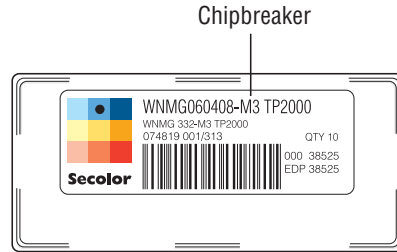


Chipbreaker overview

The chipbreakers are designed to control the chips when turning long chipping materials. The chipbreaker designations describe the application area as follows:

Letter: F = Finishing
M = Medium
R = Roughing

Digit: 1 = For low feed rates and easy conditions
9 = For high feed rates and rough conditions



Type of Operation	RR					RR6			RR9	
	R			R4	R5	R6	R7	R8		
	MR			MR3	MR4		MR6	MR7		
	M	M1		M3	M4	M5				
	MF	MF1	MF2	MF3	MF4	MF5				
	F	F1	F2							
	FF	FF1								
		1	2	3	4	5	6	7	8	9
		Edge strength/feed rate								

Chipbreaker Program

	-FF1	Chipbreaker for negative inserts. Used to achieve a very fine finish when turning steel and stainless steel. Machining range: $f = .003-.012$ ipr, $a_p = .008-.120$ "
	-MF1	Chipbreaker intended for machining stainless steel, superalloys and titanium alloys. Type ..GG insert has a sharp, precision ground edge. Type ..MG insert has a lightly honed cutting edge for increased strength.MF1 is intended for use in semi-finishing and finishing applications. Machining range: $f = .003-.012$ ipr, $a_p = .008-.140$ "
	-MF2	First choice for finishing with negative inserts. Suitable for chip control at depths of cut down to .010", provided that the feed rate is in excess of .010"/rev. Good capacity for medium-rough machining. Machining range: $f = .004-.016$ ipr, $a_p = .008-.120$ "

Chipbreaker Program

	-MF3	Chipbreaker with positive cutting rake angle intended for moderately difficult stainless steel. The MF3 is also intended for light roughing in relatively soft, “tacky” steel and difficult to machine stainless steel if the depth of cut is limited. MF3 can also be used for finishing of cast iron. Machining range: $f = .006-.016$ ipr, $a_p = .040-.200$ ”
	-MF4	Chipbreaker intended for medium/finishing of stainless steel, very open and highly positive geometry. Machining range: $f = .006-.020$ ipr, $a_p = .020-.160$ ”
	-MF5	Chipbreaker intended for medium finishing of steel and stainless steel at high feeds. Very easy cutting and open geometry. Machining range: $f = .008-.031$ ipr, $a_p = .008-.100$ ”
	-M3	First choice for medium-rough machining and also the most versatile Seco chipbreaker. In most cases, it is the only chipbreaker needed. Offers the best useful life and best chipbreaking in a wide range of cutting data and workpiece materials. Suitable for precision forged and cast workpieces (Near Net Shape workpieces or NNS) as regards both chip control and edge strength. Machining range: $f = .006-.020$ ipr, $a_p = .020-.200$ ”
	-M5	First choice for roughing by means of double-sided inserts. Intended for demanding operations at high feed rates in steel, stainless steel and cast iron. Combines high edge strength with comparatively low cutting forces. Machining range: $f = .010-.028$ ipr, $a_p = .060-.275$ ”
	-MR4	The MR4 has a negative T-land, which gives extremely high edge strength. The chipbreaker is intended for more difficult machining applications on superalloys and titanium alloys, such as intermittent cuts and the machining of parts with raw surface. Machining range: $f = .006-.022$ ipr, $a_p = .060-.275$ ”
	-MR7	The strongest chipbreaker for double-sided inserts. The MR7 is suitable for high feed rates and depths of cut that normally require a single-sided insert. The chipbreaker has a wide negative T land, which gives high edge strength. Machining range: $f = .010-.032$ ipr, $a_p = .060-.275$ ”
	-R4	Chipbreaker for single-sided inserts. It has a positive cutting edge which gives low cutting forces. Machining range: $f = .008-.024$, $a_p = .080-.400$ ”
	-R5	Chipbreaker for single-sided inserts. Recommended for medium-roughing of steel. Machining range: $f = .012-.040$ ipr, $a_p = .080-.480$ ”
	-R6	Chipbreaker for single-sided inserts. Recommended for medium-roughing of stainless steel. Machining range: $f = .010-.025$ ipr, $a_p = .080-.400$ ”
	-RR6	A very easy-cutting chipbreaker for single-sided inserts. Recommended for roughing of stainless steel and steel. Machining range: $f = .012-.040$, $a_p = .080-.480$ ”
	-R7	A strong but easy-cutting chipbreaker for single sided inserts. The R7 is well suited for intermittent machining of both stainless and ordinary carbon steel. Machining range: $f = .016-.040$, $a_p = .070-.500$ ”

Chipbreaker Program



	-FF1	Chipbreaker for positive inserts. Used to achieve a very fine finish when turning steel and stainless steel. Machining range: $f = .002-.012$ ipr, $a_p = .008-.080$ "
	-F1	A versatile chipbreaker for positive inserts. Positive geometry with sharp cutting edge gives easy-cutting properties. Suitable for high feed rates at fine depths of cut on precision forgings and castings. Machining range: $f = .004-.012$, $a_p = .020-.100$ " Machining in bar automatics, for instance: $f = .003-.010$ ipr, $a_p = .040-.120$ "
	-F2	Chipbreaker for positive inserts. Ensures safe chip flow on finishing and medium roughing in steel and stainless steel. Machining range: $f = .006-.016$ ipr, $a_p = .030-.200$ "




Supplementary Chipbreaker Program

	-R8	A very strong chipbreaker for single-sided inserts. The R8 is intended for high feed rates when machining castings and forgings of austenitic stainless steel. Machining range: $f = .014-.031$ ipr, $a_p = .070-.500$ "
	-RR9	Extremely strong chipbreaker for single-sided negative inserts, for use at high feed rates. Suitable for difficult castings and forgings and for austenitic stainless steel. Machining range: $f = .020-.048$ ipr, $a_p = .100-.600$ "
	-UX	Chipbreaker for negative inserts. Positive cutting rake with sharp edge. Low cutting force. Suitable for slim components. Machining range: $f = .008-.016$ ipr, $a_p = .040-.240$ "

Chipbreaker Program, High Feed inserts (with wiper radius)








































































	W-F1	A versatile chipbreaker for positive inserts. For finishing machining of steel, stainless steel and cast iron giving good surface finish. Suitable for high feed rates at small depth of cut. Machining range: $f = .002-.020$, $a_p = .010-.120$ "
	W-MF2	First choice for finishing with negative inserts. Chipbreaker suitable for finishing machining of steel, stainless steel and cast iron at high feed rates giving good surface finish. Machining range: $f = .002-.024$ ipr, $a_p = .010-.160$ "
	W-MF5	Chipbreaker intended for medium finishing of steel at high feed. The geometry is very open and highly positive. Machining range: $f = .008-.031$ ipr, $a_p = .008-.105$ "
	W-M3	Versatile chipbreaker for high feed finishing and medium-roughing machining of steel, stainless steel and cast iron. Operates in a wide application area. Gives a good surface finish even at high feeds. Machining range: $f = .008-.035$ ipr, $a_p = .020-.240$ "
	W-R7	A strong easy cutting chipbreaker for single sided inserts. Intended for the highest feeds when medium-roughing and roughing machining of steel, stainless steel and cast iron. Gives a good surface finish even at the higher feeds. Machining range: $f = .016-.048$ ipr, $a_p = .080-.375$ "





































































Part No.	Grade					
	TP0500	TP1500	TP2500	TP3500	TW2000	TW4000
	CCMT 21.52-F1		36260	27778	50451	31413
	CCMT 21.52-F2		36261	27779	50452	31414
	CCMT 32.50.5-F1		36262	27780	50453	31416
	CCMT 32.50.5-F2		36263	27781		
	CCMT 32.51-F1		36264	27505	50454	31513 31417
	CCMT 32.51-F2		36265	27506	50455	31418
	CCMT 32.51-FF1			27507		
	CCMT 32.51W-F1		36266	27878		
	CCMT 32.52-F1		36267	27508	50456	31419
	CCMT 32.52-F2		36270	27510	50457	31516 31420
	CCMT 32.52W-F1		36271	27879		
	CCMT 32.52W-F2		36272			
	CCMT 32.53-F2		36273	14032		
	CCMT 321-F2			27875		
	CCMT 431-F1			27881	50458	
	CCMT 431-F2		36274	27883	50462	
	CCMT 432-F1		36276	27511	50463	
	CCMT 432-F2		36277	27512	50464	31517 31421
	CCMT 432W-F1			43347		
	CCMT 433-F1			27885		
	CCMT 433-F2				50465	
	CCMT 433-F2		36278	27888		
	CCMT 53.52-F2			27889		31422
	CCMT 53.53-F2					31423
	CCMT431W-F1			50639		
	CNMG 321-M3		36242			
	CNMG 322-M3		36279	27890		
	CNMG 431-FF1			27782		
	CNMG 431-M3		36280	27783	49977	
	CNMG 431-M5		36281	27784	49820	
	CNMG 431-MF2		36282	27785	49973	
	CNMG 431-MF3				49978	
	CNMG 431-MF4					31519 31425
	CNMG 431W-MF2		36283	52239		
	CNMG 432-FF1		36284	33660		
	CNMG 432-M3	57903	36285	27513	49981	
	CNMG 432-M5	57771	36286	27514	49997	31520 31426
	CNMG 432-MF2		36287	27515	49979	
	CNMG 432-MF3				49998	
	CNMG 432-MF4			32559	50000	31522 31428
	CNMG 432-MF5	58632	36289	28690	49980	
	CNMG 432-MR6		39433	39510	50001	
	CNMG 432-MR7		36290	27516	50002	35164
	CNMG 432W-M3	57789	36291	27891		
	CNMG 432W-MF2		36292	27892		
	CNMG 432W-MF5		36293	32892		
	CNMG 433-M3	57913	36294	27542	50003	
	CNMG 433-M5	57914	36295	27546	50004	31523 31429
	CNMG 433-MF2		36296	27547		
	CNMG 433-MF3				50019	
	CNMG 433-MF4			32560		31524 31430
	CNMG 433-MF5	58633	36297	28697	50020	
	CNMG 433-MR6		39468	39511	50018	
	CNMG 433-MR7		36298	27548	50021	35166
	CNMG 433W-M3		36299	27893		
	CNMG 434-M3		36301	35206		
	CNMG 434-M5		36302	27894	50050	
	CNMG 434-MF4					31525 31431
	CNMG 434-MF5		36303	28705		
	CNMG 434-MR6		39470	39513	50057	
	CNMG 434-MR7		36304	27895	50058	
	CNMG 442-MR6					
	CNMG 443-MR6				50060	
	CNMG 444-MR6		39471	39514	50061	
	CNMG 542-M3			27786	50063	
	CNMG 542-M3		36307			
	CNMG 542-M5		36308	27787	50069	
	CNMG 542-MF4					31526 31432
	CNMG 542-MR7				50062	
	CNMG 543-M3		36309	27571	50071	
	CNMG 543-M5	57916	36310	27572	50072	31527 31433

Part No.	Grade					
	TP0500	TP1500	TP2500	TP3500	TW2000	TW4000
	CNMG 543-MF4					31528 31434
	CNMG 543-MR6		39472	39515	50073	
	CNMG 543-MR7	57917	36311	27573	50070	35167
	CNMG 544-M3		36313			
	CNMG 544-M5	57918	36314	27896	50080	31529 31436
	CNMG 544-MR6		39475	39517	50082	
	CNMG 544-MR7	57920	36316	27897	50074	35168
	CNMG 546-MR6		39477	39519	50083	
	CNMG 546-MR7		36317			
	CNMG 642-M3		36318	27898	50260	
	CNMG 642-M5		36320	27899	50261	
	CNMG 642-MR7				50262	
	CNMG 643-M3		36321	27603	50263	
	CNMG 643-M5	57921	36322	27605	50264	
	CNMG 643-MF4					31530 31437
	CNMG 643-MR6		39479	39521	50267	
	CNMG 643-MR7	57922	36323	27606	50270	35169
	CNMG 644-M3			27900	50273	
	CNMG 644-M5	57924	36324	27901	50274	31438
	CNMG 644-MR6		39481	39523		
	CNMG 644-MR7	57926	36325	27902	50279	35170
	CNMG 646-MR6		39483	39526		
	CNMG 646-MR7		36326	14035		
	CNMG 866-MR4				50557	
	CNMG 866-MR7		36243	27584	50558	
	CNMM 432-R4		36327	27788	50086	
	CNMM 432-R6			27789	50087	
	CNMM 432-RR6			27790	50560	
	CNMM 432W-R4		36328			
	CNMM 433-R4	57927	36329	27791	50088	
	CNMM 433-R6				50089	
	CNMM 433-RR6			35209	50564	
	CNMM 433W-R4		36332			
	CNMM 434-R4	57928	43672	27792		
	CNMM 543-MR6		39474	39516	50090	
	CNMM 543-R4	57947	36333	27903	50094	
	CNMM 543-R6				50097	
	CNMM 543-R7		36334		50099	
	CNMM 543-RR6			27904		32501
	CNMM 544-MR6		39476	39518	50101	
	CNMM 544-R4	57948	36337	27905	50103	
	CNMM 544-R5	57958	36338	27906		
	CNMM 544-R7		36339	35213	50102	
	CNMM 544-RR6		36340	27915		32502
	CNMM 546-MR6		39478	39520	50104	
	CNMM 546-R7		36341	14037		
	CNMM 643-57		36343			
	CNMM 643-MR6		39480	39522	50280	
	CNMM 643-R4	58001	36344	27918	50283	
	CNMM 643-R6				50284	
	CNMM 643-R7		36347	27919	50288	
	CNMM 643-RR6			27610		32503
	CNMM 644-57			52254		
	CNMM 644-MR6		39482	39525		
	CNMM 644-R4	58002	36348	27611	50290	
	CNMM 644-R5	58003	36351	27613	50292	
	CNMM 644-R7		36352	27614	50293	
	CNMM 644-R8				50295	
	CNMM 644-RR6		36353	27617	50300	32504
	CNMM 644W-R7		36354	27920		
	CNMM 646-57		36355			
	CNMM 646-MR6		39484	39527		
	CNMM 646-R4	58004	36356	27921	50304	
	CNMM 646-R5	58007	36357	27922		
	CNMM 646-R7		36358	37572	50306	
	CNMM 646-RR6			35218	50307	32500
	CNMM 646W-R7			27923		
	CNMP 431-MF1					31518 31424
	CNMP 432-MF1					31521 31427

	Part No.	Grade					
		TP0500	TP1500	TP2500	TP3500	TM2000	TM4000
	DCMT 21.50.5-F1			27924	50466		
	DCMT 21.50.5-F2		36359	27925			31439
	DCMT 21.51-F1		36362	27620	50470	31531	31440
	DCMT 21.51-F2		36364	27628	50471	31532	31441
	DCMT 21.52-F1		36365		50472		
	DCMT 21.52-F2		36366	27632	50473	31533	31442
	DCMT 32.50.5-F1			27926	50474		
	DCMT 32.50.5-F2		36367	27927			
	DCMT 32.50.5-FF1			27928			
	DCMT 32.51-F1		36368	27633	50482	31534	31443
	DCMT 32.51-F2		36369	27634	50483	31535	31444
	DCMT 32.51-FF1			27636			
	DCMT 32.52-F1		36370	27641	50485		39787
	DCMT 32.52-F2		36371	27642	50486	31536	31446
	DCMT 32.52-FF1			37016			
DCMT 32.53-F1		36372	27929				
DCMT 431-F2		36373	27643	49822			
DCMT 432-F2		36374	27644	50488			
DCMT 433-F2		36375	27930	50489			
	DCMX 32.51W-F1		36376	27933			
	DCMX 32.52W-F1		36377	27645			
	DNMG 431-M3		36387	27936	50330		
	DNMG 431-M5				50332		
	DNMG 431-MF2		36388	27937	50340		
	DNMG 431-MF3				50344		
	DNMG 431-MF4						31451
	DNMG 432-M3		36389	27650	50346		
	DNMG 432-M5		36392	27651	50347	42649	
	DNMG 432-MF2		36393	27667	50348		
	DNMG 432-MF3				50349		
	DNMG 432-MF4					37665	31452
	DNMG 432-MF5		36395	28754			
	DNMG 432-MR6		39501	39547			
	DNMG 433-M3		36396	27941	50350		
	DNMG 433-M5		36397	32585	50351	42756	
	DNMG 433-MF2		36400	27942			
	DNMG 433-MF5		36401	28761			
	DNMG 433-MR6		39503	39549			
	DNMG 434-MF5			28772			
	DNMG 441L-UX			27977			
	DNMG 441-M3		36402	27795	50353		
	DNMG 441-M5			27797	50354		
	DNMG 441-MF2		36403	27798	50355		
	DNMG 441-MF3				50356		
	DNMG 441-MF4					31542	31454
	DNMG 441R-UX			27978			
	DNMG 442L-UX			27979			
	DNMG 442-M3		36404	27673	50357		
	DNMG 442-M5	58095	36407	27675	50360		44008
	DNMG 442-MF2		36408	27677	50361		
	DNMG 442-MF3				50362		
	DNMG 442-MF4			32561		31544	31456
	DNMG 442-MF5	58649	36409	28781			
	DNMG 442-MR6		39502	39548	50364		
	DNMG 442-MR7		36412				
	DNMG 442R-UX			27980			
	DNMG 443-M3		36413	27679	50365		
	DNMG 443-M5	58096	36414	27680	50366		44009
	DNMG 443-MF2		36417	27682			
	DNMG 443-MF4					31545	31457
	DNMG 443-MF5	58650	36418	28787			
	DNMG 443-MR6		39504	39550	50367		
	DNMG 443-MR7	58097	36419		50368		
	DNMG 444-M3		36421	27801			
	DNMG 444-M5	58098	36423	27803	50372		
	DNMG 444-MF5			28793			
DNMG 444-MR6		39505	39551				
	DNMM 442-R4		36424	27943	50373		
	DNMM 443-R4		36425	27944	50374		
	DNMM 444-R4		36426	32586			

	Part No.	Grade					
		TP0500	TP1500	TP2500	TP3500	TM2000	TM4000
	DNMP 441-MF1					31541	31453
	DNMP 442-MF1					31543	31455
	DNMU 331-M3				50309		
	DNMU 331-MF2				50310		
	DNMU 332-M3				50319		
	DNMU 332-MF2				50320		
	DNMU 333-M3	58094					
	DNMU 333-MF2			52563		52201	
	DNMU330.5-M3			39811			
	DNMU331-M3		39814	43356			
DNMU331-MF1					39815	39816	
DNMU331-MF2		39817	43863				
DNMU331-MF4					39818	39819	
DNMU331-MF5			29570				
DNMU332-M3		39821	43868				
DNMU332-M5		39822					
DNMU332-MF1					39823	39824	
DNMU332-MF2		39825	43873				
DNMU332-MF4					39826	39827	
DNMU332-MF5			29576				
DNMU333-M3		39829					
DNMU333-M5		39830					
DNMU333-MF5			29582				
	DNMX 331W-MF2		36427	27945			
	DNMX 332W-MF2		36428	27946			
	DNMX 442W-M3		36429				
	DNMX 443W-M3	58099	36433				
	LNMX 191940-MF		36434	35154			
	LNMX 191940-MR		36435	35146			
	LNMX 301940-MF		36436	35158			
	LNMX 301940-MR		36437	35150			
	RCMT 0602M0-F1			27683			
	RCMT 0602M0-F2		36438	27684			
	RCMT 0803M0-F1			27685			
	RCMT 0803M0-F2		36439	27686			
	RCMT 10T3M0-F1			27687	50515		
	RCMT 10T3M0-F2		36444	27688	50516		
	RCMT 1204M0-F1		50637	27804	50517		
	RCMT 1204M0-F2		36454	27806	50519		
	RCMT 1606M0-F1		36455				
	RCMT 1606M0-F2		36456	27947	50521		
	RCMX 100300			27981	50522		
	RCMX 120400		36457	27807	50523		
	RCMX 160600		36458				
	RCMX 200600	57906	36459	27982	49849		
	RCMX 250700	58120	36460	25787	50553		
	RCMX 320900	58133	36461	27592	50554		
	RCMX160600			39810			
	RNMG 43-M3		36462	27948	50614		
	SCMT 070308-F2				50525		
	SCMT 09T312-F1				50538		
	SCMT 2.522-F2			27983			
	SCMT 21.51-F2			27809			
	SCMT 32.51-F1		44719	27949	50528		
	SCMT 32.51-F2			27950	50533	31546	
	SCMT 32.52-F1		36464	27689	50534		
	SCMT 32.52-F2		36465	27690	50535	31547	
	SCMT 432-F1			27691	50542		
	SCMT 432-F2		36466	27692	50544	31548	
SCMT 433-F1		36468			31460		
SCMT 866T-F2			27593				
	SNMG 321-MF2			27810			
	SNMG 322-M5			14571	50105		
	SNMG 322-MF2		36469				

Part No.	Grade					
	TP0500	TP1500	TP2500	TP3500	TM2000	TM4000
 SNMG 431-M3		36471	27813	50106		
 SNMG 432-M3		36473	27693	50107		
 SNMG 432-M5		36479	27694	50109	31549	31461
 SNMG 432-MF2		36480	27695	50111		
 SNMG 432-MF4					31551	31463
 SNMG 432-MR6		39490	39534	50110		
 SNMG 432-MR7		36481	32589	50112		35171
 SNMG 433-M3		36482	27815	50113		
 SNMG 433-M5		36483	27816	50114	31552	31464
 SNMG 433-MF2		36484	27818			
 SNMG 433-MF4					31553	31466
 SNMG 433-MR6		39491	39535	50115		
 SNMG 433-MR7			27819	50116		35172
 SNMG 434-M3		36486	27822			
 SNMG 434-M5		36489	27827	50117	42791	
 SNMG 434-MR6		39493	39537			
 SNMG 434-MR7			35223			
 SNMG 442-MR6						
 SNMG 443-MR6				50376		
 SNMG 444-MR6		39494	39538			
 SNMG 542-M5			14582			
 SNMG 543-M3		36490	27828			
 SNMG 543-M5		36491	27829	50377		43673
 SNMG 543-MR6		39495	39539	50379		
 SNMG 543-MR7			27830	50380		
 SNMG 544-M5	58139	36497	27951	50384		
 SNMG 544-MR6		39497	39541			
 SNMG 544-MR7			35225	50383		
 SNMG 546-MR6		39499	39545	50385		
 SNMG 643-M3			27831	50375		
 SNMG 643-M5	58173	36501	27832	50387	31554	31467
 SNMG 643-MR7			27833	50388		35173
 SNMG 644-M3			27952			
 SNMG 644-M5	58187	36503	27953	50390	31555	31468
 SNMG 644-MR7	58199	36504	27955	50391		35174
 SNMG 646-MR7			14583			
 SNMG 866-MR7			27574	49853		
 SNMM 432-R4	58274			50392		
 SNMM 432-RR6						54124
 SNMM 433-R4			27957	50393		
 SNMM 543-MR6		39496	39540	50397		
 SNMM 543-R4			27958	50398		
 SNMM 544-MR6		39498	39544			
 SNMM 544-R4	58286					
 SNMM 546-MR6		39500	39599	50399		
 SNMM 546-R7			14592			
 SNMM 643-R4			27959	50400		
 SNMM 643-R6				50401		
 SNMM 643-R7			27960			
 SNMM 643-RR6				50405		32506
 SNMM 644-56				50407		
 SNMM 644-57		36505	27834			
 SNMM 644-R4	58301	36506	27835	50408		
 SNMM 644-R5			27836			
 SNMM 644-R6				50409		
 SNMM 644-R7			27837	50410		
 SNMM 644-R8				50411		
 SNMM 644-RR6			27838	50412		32507
 SNMM 646-57	58315	36507		50413		
 SNMM 646-R4	58310		27839	50414		
 SNMM 646-R5			27840			
 SNMM 646-R7			27841	50415		
 SNMM 646-RR6			44784			
 SNMM 646W-R7			27961			
 SNMM 856-56				50565		
 SNMM 856-57		36508	27575	50567		
 SNMM 856-R7			27576	50569		
 SNMM 856-RR6			43348	50570		
 SNMM 856-RR9				50571		
 SNMM 866-R7			27577	50572		
 SNMP 432-MF1					31550	31462

Part No.	Grade					
	TP0500	TP1500	TP2500	TP3500	TM2000	TM4000
 SPMR 321-F1						27984
 SPMR 322-F1						27986
 SPMR 322-FF1						27987
 SPMR 421-F1						27988
 SPMR 422-F1						27989
 SPMR 422-F2						27990
 SPMR 423-F1						27991
 SPU 421						27992
 SPU 422						27993
 SPU 633						27594
 SPU 634T						27595
 TCMT 21.50.5-F1						50503
 TCMT 21.51-F1		36510	27842	50505	31556	31470
 TCMT 21.52-F1		36559	27843	50506	31557	31471
 TCMT 32.50.5-F1				50507		31472
 TCMT 32.51-F1		36560	27696	50508	31558	31473
 TCMT 32.51-F2		36561	27698	50509		
 TCMT 32.52-F1		36562	27699	50510	31559	31474
 TCMT 32.52-F2		36563	27700	50511	31560	31476
 TCMT 32.53-F1				50512		31477
 TCMT 432-F2		36565	27701	50513		
 TCMX 32.52W-F1		36566	14595			
 TNMG 221-MF2				27962		
 TNMG 322-M5					50118	
 TNMG 322-MF3					50119	
 TNMG 331L-UX				27994		
 TNMG 331-M3		36567	27702	50121		
 TNMG 331-M5			27708	50122		
 TNMG 331-MF2		36569	27709	50123		
 TNMG 331-MF3				50127		
 TNMG 331-MF4					31562	31479
 TNMG 331R-UX				27996		
 TNMG 332-FF1		36570	32587			
 TNMG 332L-UX			27997			
 TNMG 332-M3	58318	36571	27710	50128		
 TNMG 332-M5	58329	36572	27711	50130	31563	31480
 TNMG 332-MF2		36573	27712	50131		
 TNMG 332-MF3				50134		
 TNMG 332-MF4				32562	50135	31565
 TNMG 332-MF5		36574	28845			
 TNMG 332-MR6		39506	39552	50132		
 TNMG 332-MR7				50133		
 TNMG 332R-UX				27998		
 TNMG 333-M3		36575	27844	50136		
 TNMG 333-M5	58337	36576	27846	50139		
 TNMG 333-MF2		36577	27847			
 TNMG 333-MF4					31566	31483
 TNMG 333-MF5		36578	28855			
 TNMG 333-MR6		39507	39553			
 TNMG 333-MR7				50140		
 TNMG 431-M5			27848	50142		
 TNMG 431-MF2			27849			
 TNMG 431-MF3				50151		
 TNMG 432-M3		36579	27713	50153		
 TNMG 432-M5	58342	36580	27714	50154	42607	39633
 TNMG 432-MF2		36581	27715			
 TNMG 432-MF3				50152		
 TNMG 432-MF4					31567	31484
 TNMG 432-MR6		39508	39554	50157		
 TNMG 432-MR7		36582		50164		
 TNMG 433-M3		36583	27850	50183		
 TNMG 433-M5	58346	36584	27851	50194		39634
 TNMG 433-MF4					31568	31485
 TNMG 433-MR6		39509	39555			
 TNMG 433-MR7				50172		
 TNMG 434-M5	58347	36585	27965	50196		
 TNMG 542-M5				50574		
 TNMG 543-M3			27578	50575		

	Part No.	Grade						
		TP0500	TP1500	TP2500	TP3500	TM2000	TM4000	
	TNMG 543-M5		36587	27579	50576			
	TNMG 543-MR7			27599	50577			
	TNMG 544-M5		36588	27581	50578			
	TNMG 544-MR7			27600	50579			
	TNMG 666-MR7			27582	50580			
	TNMM 331-R6				50210			
	TNMM 332-R4			27857	50222			
	TNMM 333-R4		36589	27966				
	TNMM 432-R4			27858	50223			
	TNMM 433-R4		36590	27859	50233			
	TNMM 434-R4		36591	27716	50235			
	TNMM 434-R6				50236			
	TNMP 331-MF1					31561	31478	
TNMP 332-MF1					31564	31481		
	TNMX 332W-M3		36592	27967				
	TNMX 333W-M3		36593					
	TPMR 221-F1		36594	27999			31486	
	TPMR 222-F1			28000			31487	
	TPMR 321-F1		36595	28001			31488	
	TPMR 321-F2			28003				
	TPMR 322-F1		36244	28004			31489	
	TPMR 322-F2			28005				
	TPMR 323-F1			28006				
	TPMR 432-F2			28007				
	TPMR 433-F2			28008				
		TPU 321			28009	49823		
TPU 322				28010				
TPU 431				28011				
TPU 432				28012				
TPU 433				28013				
	TPUN 322				50550			
	TPUN 432				50551			
	VBMT 21.50.5-F1			27968	50490			
	VBMT 21.51-F1			27717	50491			
	VBMT 21.52-F1			27860				
	VBMT 220.5-F1			39636	54122			
	VBMT 221-F1			39639	54123			
	VBMT 222-F1			39642				
	VBMT 330.5-F1			39786	50493			
	VBMT 331-F1		36597	27718	50494		43669	
	VBMT 331-F2		36598	27719	50495	31569	31491	
	VBMT 332-F1		36599	27725	50497		43670	
	VBMT 332-F2		36600	27740	50496	31570	31492	
	VBMT 333-F1		36601	37573	50499			
	VBMT 333-F2		36603	27861	50501		31493	
		VNMG 331-FF1		36636				
VNMG 331-M3			36637	27863	50438			
VNMG 331-MF2				27865				
VNMG 331-MF3					50437			
VNMG 331-MF4						31571	31494	
VNMG 332-M3			36638	27746	50439			
VNMG 332-MF2			43671	31054				
VNMG 332-MF3					50440			
VNMG 332-MF4						31572	31496	
VNMG 333-MF2				14968				
		VNMM 2.531-M3		51466	39831	50441		
		VNMM 2.532-M3		51467	39832	50442		
	WCMT 32.52-F1			40783				
	WNMG 330.5-M3			27866				
	WNMG 331-M3		36604	27751	50416			
	WNMG 331-MF2		36605	27757	50417			
	WNMG 331-MF4					31577	31498	

	Part No.	Grade					
		TP0500	TP1500	TP2500	TP3500	TM2000	TM4000
	WNMG 331-MF5			28876			
	WNMG 331W-MF2			27867			
	WNMG 332-M3	58348	36606	27760	50418		
	WNMG 332-M5	58349	36607	27764	50419		
	WNMG 332-MF2		36608	27765	50420		
	WNMG 332-MF3				50421		
	WNMG 332-MF4			32556		31581	31500
	WNMG 332-MF5		36609	28711	50422		
	WNMG 332W-M3		36610	27868			
	WNMG 332W-MF2		36611	27771			
	WNMG 333-M3	58353	36612	27970	50423		
	WNMG 333-M5	58364		27971	50425		
	WNMG 333-MF2			27972			
	WNMG 333-MF4					31583	31501
	WNMG 333-MF5		36613	28717			
	WNMG 333W-M3		36614	14969			
	WNMG 431-M3		36615	27869	50237		
	WNMG 431-MF2		36616	27870			
	WNMG 431-MF4					31586	31503
	WNMG 431W-MF2			27973			
	WNMG 432-M3	58372	36617	27767	50242		
	WNMG 432-M5	58375	36618	27768	50243	31587	31504
	WNMG 432-MF2		36619	27769			
	WNMG 432-MF3				50238		
	WNMG 432-MF4			32557	50240	31589	31506
	WNMG 432-MF5	58647	36620	28722	50241		
	WNMG 432-MR6		39485	39528	50244		
	WNMG 432-MR7			27770	50246		
WNMG 432W-M3	58376	36621	27871				
WNMG 432W-MF2		36622	27974				
WNMG 432W-MF5		36623	32897				
WNMG 433-M3	58377	36624	27772	50247			
WNMG 433-M5	58378	36625	27773	50248	31590	31507	
WNMG 433-MF2		50638					
WNMG 433-MF4			32558		31591	31508	
WNMG 433-MF5	58647	36626	28729	50250			
WNMG 433-MR6		39486	39529	50249			
WNMG 433-MR7		36627	35227	50251		44720	
WNMG 433W-M3	58380	36628	27976				
WNMG 434-M3	58384	36629	32588				
WNMG 434-M5	58385	36630	31055	50255			
WNMG 434-MF5		36631	28734				
WNMG 434-MR6		39488	39532				
WNMG 434-MR7		36632	31056	50252			
WNMG 442-M5				50426			
WNMG 443-M5	58386		27872	50428			
WNMG 443-MR6		39487	39531	50429			
WNMG 444-M5	58387		27873	50434			
WNMG 444-MR6		39489	39533				
	WNMM 432-R6			50245			
	WNMP 331-MF1					31573	31497
	WNMP 332-MF1					31579	31499
	WNMP 431-MF1					31585	31502
	WNMP 432-MF1					31588	31505

ARGENTINA Seco Tools Argentina S.A. Tel: +54 11 48 92 00 60 Fax: +54 11 47 23 86 00.
AUSTRALIA Seco Tools Australia Pty. Ltd. Tel: +61 2 96 76 22 79 (local tel: 1300 55 7326) Fax: +61 2 96 76 61 58 (local fax: 1300 65 7326). **AUSTRIA** Seco Tools Ges.m.b.H Tel: +43 2253 210 40 Fax: +43 2253 210 4011. **BELGIUM** Seco Tools Benelux N.V./S.A. Tel: +32 2 389 09 60 Fax: +32 2 389 09 89. **BOSNIA** See Slovenia. **BRAZIL** Seco Tools Ind. e Com. Ltda. Tel: +55 15 2101 86 00 Fax: +55 15 2101 8606. **BULGARIA** See Sweden. **CANADA** Seco Tools Canada Inc. Tel: +1 905 693 1780 Fax: +1 905 693 1788. **CHINA** Seco Tools (Shanghai) Co., Ltd. Tel: +86 21 54 26 55 00 Fax: +86 21 64 85 56 85. **COLOMBIA** Rexco Tools Tel: +57 1 660 6030 Fax: +57 1 311 0026. **CROATIA** See Slovenia. **CZECH REPUBLIC** Seco Tools CZ s.r.o. Tel: +420 530 500 811 Fax: +420 530 500 810. **DENMARK** Seco Tools A/S Tel: +45 43 44 7600 Fax: +45 43 44 5030. **FINLAND** Seco Tools OY Tel: +358 09 2511 7200 Fax: +358 09 2511 7201. **FRANCE** Seco Tools France S.A. Tel: +33 2 48 67 27 27 Fax: +33 2 48 67 27 05, Seco EPB Tel: +33 3 88 71 38 89 Fax: +33 3 88 70 98 98, Seco Ets. Planche S.A. Tel: +33 4 74 83 26 54 Fax: +33 4 74 83 26 59. **GERMANY** Seco Tools GmbH Tel: +49 211 240 10 Fax: +49 211 240 12 75. **GREECE** Athens Mechanica Tel: +30 210 523 1284/5 Fax: +30 210 523 1286. **HUNGARY** Seco Tools KFT. Tel: +36 1 267 6720 Fax: +36 1 267 6721. **INDIA** Seco Tools India (P) Ltd. Tel: +91 21 3766 7300 Fax: +91 21 3766 7410. **INDONESIA** Seco Tools (SEA) Pte Ltd. Tel: +62 21 7918 6441/6442 Fax: +62 21 7918 6440. **ITALY** Seco Tools Italia S.p.A. Tel: +39 031 97 81 11 Fax: +39 031 97 85 91 (local fax: 840 000938). **JAPAN** Seco Tools Japan K.K. Tel: +81 3 37 33 81 11 Fax: +81 3 37 33 81 25. **MACEDONIA** See Slovenia. **MALAYSIA** Seco Tools Malaysia SDN. BHD Tel: +60 3 9059 1833 Fax: +60 3 9059 4833. **MEXICO** Seco Tools de Mexico Tel/Fax: +52 818 350 6311. **MONTENEGRO** See Slovenia. **NETHERLANDS** Seco Tools Benelux N.V. Tel: +31 183 63 66 00 Fax: +31 183 66 06 01, Seco Jabro Tools b.v. Tel: +31 77 463 24 44 Fax: +31 77 463 14 54. **NEW ZEALAND** Seco Tools New Zealand Ltd. Tel: +64 9 415 8441 Fax: +64 9 415 8442. **NORWAY** Seco Tools A/S Tel: +47 67 92 73 00 Fax: +47 67 92 73 02. **PHILIPPINES** See Singapore. **POLAND** Seco Tools (Poland) Sp. z.o.o. Tel: +48 22 637 5383 Fax: +48 22 637 5384. **PORTUGAL** Seco Tools Portugal, Lda. Tel: +351 256 371 650 Fax: +351 256 371 659. **ROMANIA** Seco Tools Romania S.R.L. Tel: +40 268 414 723 Fax: +40 268 476 772. **RUSSIA** Seco Tools Russia Tel: +7 495 680 1322 Fax: +7 495 680 6241. **SERBIA** Seco Tools SRB d.o.o Tel: +381 21 527 087 Fax: +381 21 527 093. **SINGAPORE** Seco Tools (SEA) Pte. Ltd. Tel: +65 68 41 28 02 Fax: +65 68 41 28 01. **SLOVAKIA** Seco Tools SK s.r.o. Tel: +421 33 551 3537 Fax: +421 33 551 3538. **SLOVENIA** Seco Tools SI d.o.o. Tel: +386 2 450 2340 Fax: +386 2 450 2341. **SOUTH AFRICA** Seco Tools South Africa (Pty.) Ltd. Tel: +27 11 362 2660 Fax: +27 11 362 1893. **SOUTH KOREA** Seco Tools Korea Ltd. Tel: +82 41 622 9785 Fax: +82 41 622 0985. **SPAIN** Seco Tools España S.A. Tel: +34 93 474 5533 Fax: +34 93 474 5550. **SWEDEN** Seco Tools AB Tel: +46 223 400 00 Fax: +46 223 718 60. **SWITZERLAND** Seco Tools AG Tel: +41 32 332 78 78 Fax: +41 32 332 78 79. **TAIWAN** Seco Tools (SEA) Taiwan Tel: +886 2 26 57 79 18 Fax: +886 2 26 57 94 61. **THAILAND** Seco Tools (Thailand) Co. Ltd. Tel: +66 2 74 67 801 Fax: +66 2 74 67 802. **TURKEY** Seco Tools A.S. Tel: +90 216 569 74 00 Fax: +90 216 575 73 83. **UKRAINE** Seco Tools Ukraine Tel: +38 056 790 05 44 Fax: +38 056 790 05 43. **UNITED KINGDOM** Seco Tools (U.K.) Ltd. Tel: +44 1789 76 43 41 Fax: +44 1789 76 11 70. **USA** Seco Tools Inc. Tel: +1 248 528 5200 Fax: +1 248 528 5250. **VIETNAM** Seco Tools (SEA) Pte. Ltd. Tel: +84 8 91 44 393/91 43 164 Fax: +84 8 91 43 164.

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