

# M8065HD

Heavy Duty Face Mill



New Versatile -MH Geometry  
for Face Milling in Steels, Alloy  
Steels, Stainless Steels, Cast Iron  
and Nodular Iron



Explore the depths of heavy-duty machining with the new M8065HD face milling inserts. Engineered with eight cutting edges, these inserts in -MH geometry are perfect for machining with high depths of cut, increased feed rates and improved metal removal rates across all materials.

## Industries



General Engineering



Automotive



Oil & Gas



Wind & Solar



Defense

## Materials

P

Steels

S

High-Temp Alloys

M

Stainless Steels

K

Cast Iron

## Applications



Face Milling

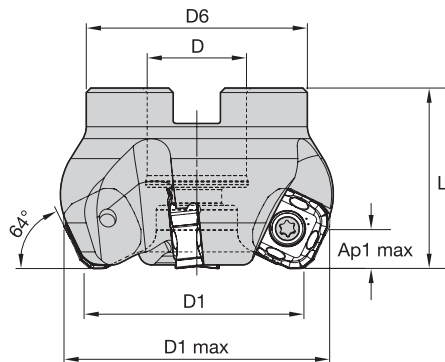


## **THE NEW -MH GEOMETRY IN M8065HD**

- ▽ Offers reliability in heavy-duty face milling applications in a variety of materials
- ▽ Provides smooth cutting action and low cutting forces resulting in increased tool life
- ▽ Features a specially designed chip breaker for smoother, vibration-free cutting action even at high cutting parameters and Material Removal Rates (MMR)
- ▽ Pressed and sintered to size with precision for high accuracy and economy

Increase reliability with the versatility and consistency demanded for heavy-duty face milling applications in variety of materials, like steels, cast iron, nodular iron and high-temp alloys.

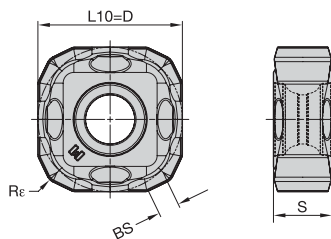




## M8065HD

64° • Shell Mills

| Order Number | Catalog Number       | D1  | D1 Max | D  | D6  | L  | Ap1 Max | Z  | Coolant | kg    |
|--------------|----------------------|-----|--------|----|-----|----|---------|----|---------|-------|
| 4124248      | M8065HD050Z04S22SN15 | 50  | 58,9   | 22 | 49  | 40 | 9,0     | 4  | No      | 0,38  |
| 4102270      | M8065HD063Z05S22SN15 | 63  | 71,9   | 22 | 49  | 40 | 9,0     | 5  | No      | 0,53  |
| 4073639      | M8065HD080Z06S27SN15 | 80  | 88,8   | 27 | 60  | 50 | 9,0     | 6  | No      | 1,15  |
| 4073640      | M8065HD100Z07S32SN15 | 100 | 108,8  | 32 | 78  | 50 | 9,0     | 7  | No      | 1,68  |
| 4039413      | M8065HD125Z09S40SN15 | 125 | 133,8  | 40 | 89  | 63 | 9,0     | 9  | No      | 3,24  |
| 4061110      | M8065HD160Z11S40SN15 | 160 | 168,8  | 40 | 90  | 63 | 9,0     | 11 | No      | 4,33  |
| 4113702      | M8065HD200Z14S60SN15 | 200 | 208,8  | 60 | 130 | 63 | 9,0     | 14 | No      | 7,13  |
| 4113753      | M8065HD250Z16S60SN15 | 250 | 258,8  | 60 | 130 | 63 | 9,0     | 16 | No      | 11,52 |
| 4113754      | M8065HD315Z20S60SN15 | 315 | 323,8  | 60 | 225 | 80 | 9,0     | 20 | No      | 27,90 |



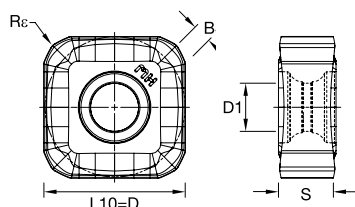
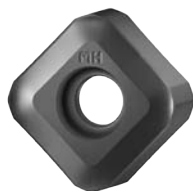
## M8065HD

SNMX-MM • Heavy Duty Face Milling

|   |        |       |
|---|--------|-------|
| P | Blue   | Black |
| M | Yellow | Black |
| K | Red    | Black |
| N | Green  | Black |
| S | Orange | Black |
| H | Grey   | Black |

● Primary  
○ Secondary

| ISO Catalog Number | Cutting Edges | D  | L10   | S    | BS   | Rε   | hm   | WK15CM  | WP35CM  | WU20PM  |
|--------------------|---------------|----|-------|------|------|------|------|---------|---------|---------|
| SNMX150612ZNSNMM   | 8             | 16 | 15,88 | 6,35 | 2,37 | 1,20 | 0,06 | 5649102 | 6852432 | 4137987 |



## NEW! M8065HD

SNMX-MH • Heavy Duty Face Milling

|   |        |       |
|---|--------|-------|
| P | Blue   | Black |
| M | Yellow | Black |
| K | Red    | Black |
| N | Green  | Black |
| S | Orange | Black |
| H | Grey   | Black |

● Primary  
○ Secondary

| ISO Catalog Number | Cutting Edges | D     | D1   | L10   | S    | BS   | Rε   | W       | W       | W       | W       | W       | W       |
|--------------------|---------------|-------|------|-------|------|------|------|---------|---------|---------|---------|---------|---------|
| SNMX150612ZNSNMH   | 8             | 15,88 | 5,40 | 15,88 | 6,35 | 1,72 | 1,20 | 7186173 | 7186218 | 7186129 | 7242744 | 7242743 | 7242720 |

## Recommended Starting Speeds • [m/min]

| Material Group |   | WP35CM |     |     | WK15CM |     |     | WU20PM |     |     | WP25PM |     |     | WS40PM |     |     | WU35PM |     |     |
|----------------|---|--------|-----|-----|--------|-----|-----|--------|-----|-----|--------|-----|-----|--------|-----|-----|--------|-----|-----|
| P              | 1 | 455    | 395 | 370 | —      | —   | —   | 330    | 290 | 270 | 330    | 285 | 270 | —      | —   | —   | 260    | 230 | 215 |
|                | 2 | 280    | 255 | 230 | —      | —   | —   | 275    | 250 | 200 | 275    | 240 | 200 | —      | —   | —   | 220    | 190 | 160 |
|                | 3 | 255    | 230 | 205 | —      | —   | —   | 255    | 220 | 175 | 255    | 215 | 175 | —      | —   | —   | 200    | 170 | 140 |
|                | 4 | 190    | 175 | 160 | —      | —   | —   | 225    | 190 | 150 | 225    | 185 | 150 | —      | —   | —   | 180    | 150 | 120 |
|                | 5 | 260    | 230 | 210 | —      | —   | —   | 185    | 175 | 150 | 185    | 170 | 150 | 170    | 145 | 120 | 150    | 135 | 120 |
| M              | 6 | 160    | 135 | 110 | —      | —   | —   | 165    | 130 | 100 | 165    | 125 | 100 | 150    | 110 | 80  | 130    | 100 | 80  |
|                | 1 | 205    | 185 | 155 | —      | —   | —   | 205    | 180 | 165 | 205    | 180 | 165 | 210    | 170 | 140 | 170    | 150 | 135 |
| K              | 2 | 185    | 160 | 140 | —      | —   | —   | 185    | 160 | 130 | 185    | 160 | 130 | 180    | 145 | 120 | 155    | 130 | 110 |
|                | 3 | 145    | 130 | 115 | —      | —   | —   | 140    | 120 | 95  | 140    | 120 | 95  | 145    | 110 | 85  | 115    | 100 | 80  |
| N              | 1 | 295    | 265 | 240 | 420    | 385 | 340 | 250    | 220 | 185 | 230    | 205 | 185 | —      | —   | —   | —      | —   | —   |
|                | 2 | 235    | 210 | 190 | 335    | 295 | 275 | 200    | 180 | 150 | 180    | 160 | 150 | —      | —   | —   | —      | —   | —   |
| S              | 3 | 195    | 175 | 160 | 280    | 250 | 230 | 180    | 150 | 120 | 150    | 135 | 120 | —      | —   | —   | —      | —   | —   |
|                | 1 | —      | —   | —   | —      | —   | —   | —      | —   | —   | —      | —   | —   | —      | —   | —   | —      | —   | —   |
| H              | 2 | —      | —   | —   | —      | —   | —   | —      | —   | —   | —      | —   | —   | —      | —   | —   | —      | —   | —   |
|                | 3 | —      | —   | —   | —      | —   | —   | —      | —   | —   | —      | —   | —   | —      | —   | —   | —      | —   | —   |
| H              | 1 | —      | —   | —   | —      | —   | —   | 40     | 35  | 25  | 40     | 35  | 25  | 40     | 35  | 25  | 35     | 30  | 25  |
|                | 2 | —      | —   | —   | —      | —   | —   | 40     | 35  | 25  | 40     | 35  | 25  | 40     | 35  | 25  | 35     | 30  | 25  |
| H              | 3 | —      | —   | —   | —      | —   | —   | 50     | 40  | 25  | 50     | 40  | 25  | 50     | 40  | 25  | 45     | 35  | 25  |
|                | 4 | —      | —   | —   | —      | —   | —   | 70     | 50  | 35  | 70     | 50  | 35  | 60     | 50  | 30  | 60     | 45  | 30  |
| H              | 1 | —      | —   | —   | —      | —   | —   | 110    | 80  | 70  | 120    | 90  | 70  | —      | —   | —   | —      | —   | —   |

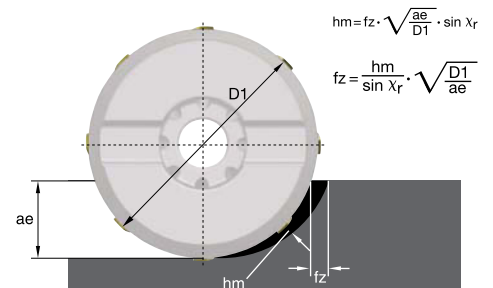
NOTE: First choice starting feed (fz) is in bold type.  
As the average chip thickness increases, the speed should be decreased.

## Recommended Starting Feeds • [mm]

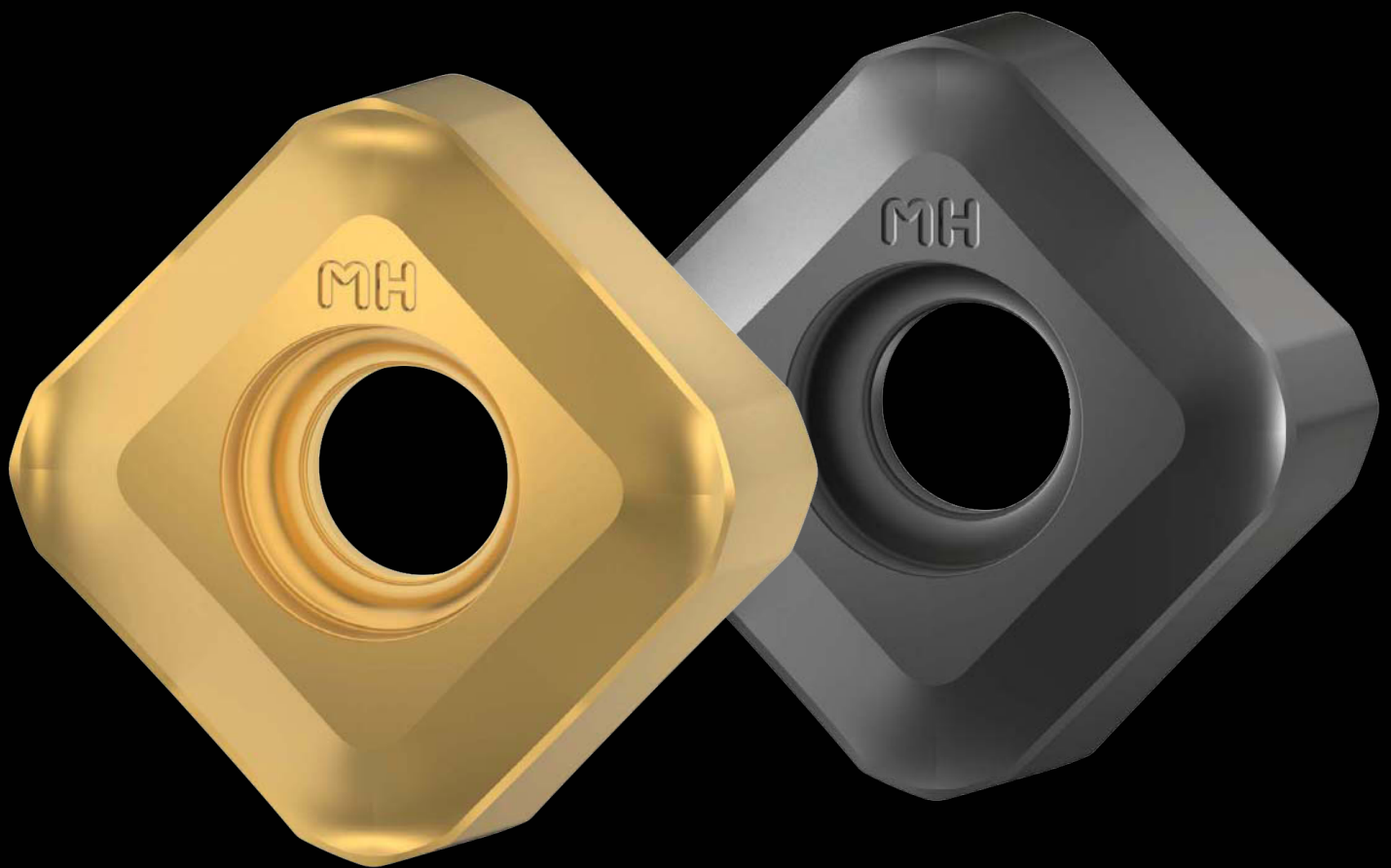
| Light Machining | General Purpose | Heavy Machining |
|-----------------|-----------------|-----------------|
|-----------------|-----------------|-----------------|

| Insert Geometry | Programmed Feed per Tooth (fz)<br>as a % of Radial Depth of Cut (ae) |      |      |      |      |      |      |      |      |      |      |      |         |      |      | Insert Geometry |
|-----------------|----------------------------------------------------------------------|------|------|------|------|------|------|------|------|------|------|------|---------|------|------|-----------------|
|                 | 5%                                                                   |      |      | 10%  |      |      | 20%  |      |      | 30%  |      |      | 40–100% |      |      |                 |
| .S..MM          | 0,22                                                                 | 0,65 | 1,07 | 0,16 | 0,47 | 0,77 | 0,12 | 0,35 | 0,58 | 0,10 | 0,31 | 0,50 | 0,10    | 0,28 | 0,46 | .S..MM          |
| .S..MH          | 0,24                                                                 | 0,71 | 1,17 | 0,17 | 0,51 | 0,84 | 0,13 | 0,38 | 0,63 | 0,11 | 0,34 | 0,55 | 0,11    | 0,3  | 0,5  | .S..MH          |

NOTE: First choice starting feed (fz) is in bold type.  
Use corresponding speed (vc).  
fz and vc are valid for ae ≥ 0,4 D1.  
For smaller ae, fz and vc should be multiplied by the factor given below:



**RELIABILITY**  
**COST SAVINGS**  
**PRODUCTIVITY**  
**HEAVY DUTY**



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FOR EVERY MACHINE SHOP**

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