

Inserts

Fig. 1
Used for both peripheral and center edges

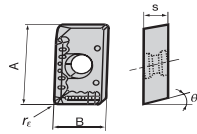
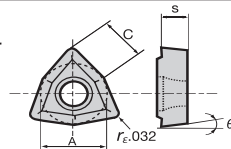


Fig. 2
Used for center cutting edge

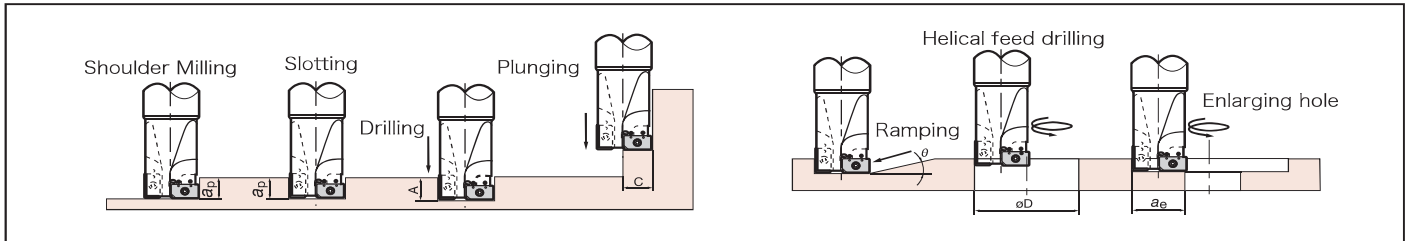


Cat. No.	Accuracy	Honing	Grades		Dimensions (in)						
			Coated		A	B	s	r_e	θ	C	Figure
			AH120	AH140							
XXMU08T204PR-MJ	M	With	●	●	.323	.220	.109	.016	10°	-	Fig. 1
XXMU10H308PR-MJ			●	●	.417	.268	.138	.031	11°		
XXMU12X408PR-MJ			●	●	.520	.311	.165				
XXMU16X508PR-MJ			●	●	.661	.437	.197				
WCMT050308-D4	M	With	●	●	.313	-	.125	-	7°	.197	Fig. 2
WCMT06T308-D4			●	●	.375	-	.156			.236	

Standard cutting conditions

Work material	Grades	$\phi D: \phi.625 \sim \phi.750$ in				$\phi D: \phi 1.0 \sim \phi 1.25$ in			
		Cutting speed V_c (SFM)	Feed per tooth f_z (in/t)		Cutting speed V_c (SFM)	Feed per tooth f_z (in/t)			
			Shouldering-Grooving	Drilling		Shouldering-Grooving	Drilling		
Carbon steels (1018,1055) < 300 HB	AH120	330 ~ 590	.002 ~ .008	.001 ~ .003	400 ~ 650	.003 ~ .010	.002 ~ .004		
Alloy steels (4140, 4340) < 300 HB	AH120	260 ~ 525	.002 ~ .006	.001 ~ .003	330 ~ 590	.003 ~ .008	.002 ~ .004		
Die steels (JIS SKD11 etc.) < 300 HB	AH120	200 ~ 400	.002 ~ .005	.001 ~ .002	260 ~ 500	.003 ~ .006	.001 ~ .003		
Stainless steels (JIS SUS304 etc.)	AH140	230 ~ 460	.002 ~ .006	.001 ~ .003	300 ~ 525	.003 ~ .008	.001 ~ .003		
Cast irons (JIS CLASS 25-40)	AH120	330 ~ 590	.002 ~ .010	.001 ~ .004	400 ~ 650	.003 ~ .010	.002 ~ .004		

Machining capability



	Cat. No.	Tool diameter ϕD	Effective cutting edge length (a_p)	Max. drilling depth (A)	Max. cutting width in plunging (C)	Max. ramping angle (D)	Min. machining hole dia. (ϕD_{min})	Max. machining hole dia. (ϕD_{max})	Max. cutting width in enlarging hole (a_e)
Standard type / Long type	EVX08062RSU/RLHU	.625	.276	.315	.315	3°	.756	1.25	.551
	EVX10020RSU/RLHU	.750	.354	.394	.394	3°	.945	1.50	.709
	EVX12100RSU/RLHU	1.00	.453	.492	.492	3°	1.25	1.89	.906
	EVX16125RSU/RLHU	1.25	.591	.630	.630	3°	1.51	2.44	1.25

● : Stocked items.

Most unmarked items are available on a RFQ basis, contact your sales rep for more information.