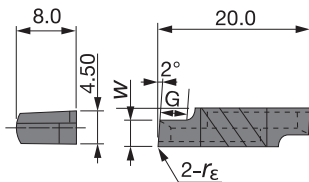




## INSERT

### XGR/L



Right hand (R) shown.

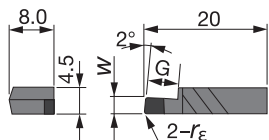
Designation	W±0.05 (mm)	W±0.002 (in)	r <sub>c</sub> (mm)	Cermet		Uncoated			G (mm)	
				NS9530		TH10		UX30		
				R	L	R	L	R		L
XGR/L6310-02	1	0.039	0.2	●	●	●	●	●	1.5	
XGR/L6315-02	1.5	0.059	0.2	●	●	●	●	●	2.3	
XGR/L6320-02	2	0.079	0.2	●	●	●	●	●	3	
XGR/L6325-02	2.5	0.098	0.2	●	●	●	●	●	3.8	
XGR/L6330-02	3	0.118	0.2	●	●	●	●	●	4.5	
XGR/L6335-02	3.5	0.138	0.2	●	●	●	●	●	5.3	
XGR/L6340-02	4	0.157	0.2	●	●	●	●	●	6	
XGR/L6345-02	4.5	0.177	0.2	●	●	●	●	●	6	

Note;

For internal machining, use right-hand toolholder (GX-\*\*\*\*R) with left-hand insert (XGL\*\*\*\*), and use left-hand toolholder (GX-\*\*\*\*L) with right-hand insert (XGR\*\*\*\*).  
For external machining, use right-hand toolholder (GX-\*\*\*\*RE) with right-hand insert (XGR\*\*\*\*), and use left-hand toolholder (GX-\*\*\*\*LE) with left-hand insert (XGL\*\*\*\*).

● : Line up

### XGR/L-QBN



Right hand (R) shown.

Designation	W±0.05 (mm)	W±0.002 (in)	r <sub>c</sub> (mm)	T-CBN		G (mm)
				BX360		
				R	L	
XGL6310S-QBN	1	0.039	0.2		●	2.3
XGR/L6315S-QBN	1.5	0.059	0.2	●	●	2.3
XGR/L6320S-QBN	2	0.079	0.2	●	●	3
XGR/L6325S-QBN	2.5	0.098	0.2	●	●	3.8
XGR/L6330S-QBN	3	0.118	0.2	●	●	4.5
XGR/L6335S-QBN	3.5	0.138	0.2	●	●	5.3
XGR/L6340S-QBN	4	0.157	0.2	●	●	6
XGR/L6345S-QBN	4.5	0.177	0.2	●	●	6

Note;

For internal machining, use right-hand toolholder (GX-\*\*\*\*R) with left-hand insert (XGL\*\*\*\*), and use left-hand toolholder (GX-\*\*\*\*L) with right-hand insert (XGR\*\*\*\*).  
For external machining, use right-hand toolholder (GX-\*\*\*\*RE) with right-hand insert (XGR\*\*\*\*), and use left-hand toolholder (GX-\*\*\*\*LE) with left-hand insert (XGL\*\*\*\*).

● : Line up

## STANDARD CUTTING CONDITIONS

ISO	Workpiece material	Grade	Cutting speed v <sub>c</sub> (sfm)	Feed f (ipr)		
				W < 0.078"	W = 0.078" - 0.157"	W > 0.157"
<b>P</b>	Carbon steels	NS9530	260 - 650	0.001 - 0.004	0.003 - 0.008	0.003 - 0.010
		TX10S	200 - 500	0.001 - 0.004	0.003 - 0.008	0.003 - 0.010
		UX30	200 - 500	0.001 - 0.004	0.003 - 0.008	0.003 - 0.010
<b>K</b>	Cast irons , Light alloys	TH10	200 - 500	0.001 - 0.004	0.003 - 0.008	0.003 - 0.010
<b>H</b>	Hardened steels	BX360	60 - 500	0.001 - 0.15	0.001 - 0.15	0.001 - 0.006