

Inserts

Fig. 1
Used for both peripheral and center edges

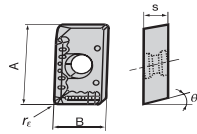
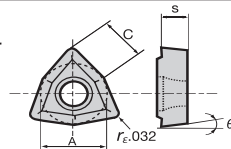


Fig. 2
Used for center cutting edge

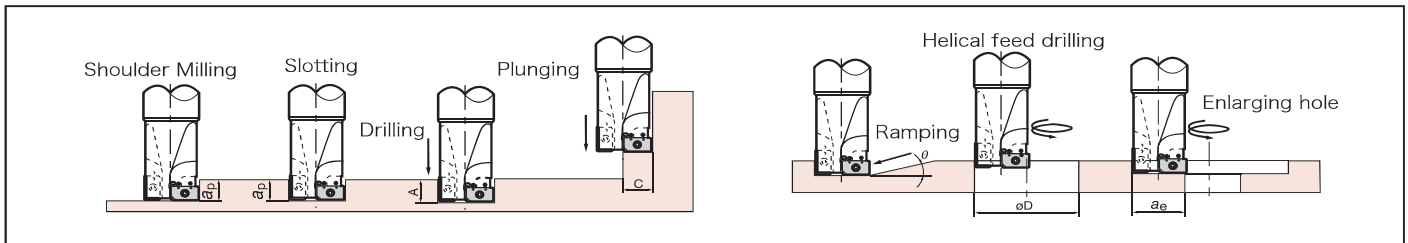


Cat. No.	Accuracy	Honing	Grades		Dimensions (in)						
			Coated		A	B	s	r _ε	θ	C	Figure
			AH120	AH140							
XXMU08T204PR-MJ	M	With	●	●	.323	.220	.109	.016	10°	-	Fig. 1
XXMU10H308PR-MJ			●	●	.417	.268	.138	.031	11°		
XXMU12X408PR-MJ			●	●	.520	.311	.165				
XXMU16X508PR-MJ			●	●	.661	.437	.197				
WCMT050308-D4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

Standard cutting conditions

Work material	Grades	øD: ø.625 ~ ø.750 in				øD: ø1.0 ~ ø1.25 in			
		Cutting speed Vc (SFM)	Feed per tooth fz (in/t)		Cutting speed Vc (SFM)	Feed per tooth fz (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 øD	Effective cutting edge length (ap)	Max. drilling depth (A)	Max. cutting width in plunging (C)	Max. ramping angle (D)	Min. machining hole dia. (øDmin)	Max. machining hole dia. (øDmax)	Max. cutting width in enlarging hole (ae)
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.