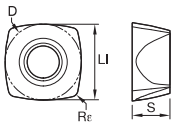

XDLW09-D



XDLW09-D

● first choice
○ alternate choice

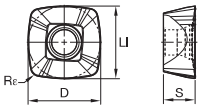
		GH2	KC510M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM40	SC3025	SC6525	SP6519	X400	X500
P			○	○	●		●	●	○		●	○	●	○
M					●	●		○	○	●			●		●
K		○	●	○		●	○				●	●	○		
N		●	○												
S					●	●				●			●		●
H														○	

XDLW09-D • First choice for roughing alloyed steel and cast iron

catalog number	D	LI	S	Rε	hm	RT	GH2	KC510M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM40	SC3025	SC6525	SP6519	X400	X500
XDLW090408SRD	.375	.375	.187	.031	.004	.079	–	–	–	–	–	–	–	–	●	●	–	●	●

NOTE: RT is the theoretical radius to be used for CAD/CAM programming.


XDPT09-GP



XDPT09-GP

XDPT09-GP • Precision pressed. General use on alloyed steels. Good balance across all machining situations.

catalog number	D	LI	S	Rε	hm	RT	GH2	KC510M	KC522M	KC725M	KCK15	KCPK30	KCPM40	KCSM40	SC3025	SC6525	SP6519	X400	X500
XDPT090412SRGP	.375	.375	.187	.047	.009	.026	–	–	●	●	–	●	●	–	–	–	–	–	–

NOTE: RT is the theoretical radius to be used for CAD/CAM programming.

Recommended Starting Feeds • High-Feed and Plunging Applications • fz [in/tooth]

Recommended Starting Feeds [IPT] • High-Feed

Light Machining	General Purpose	Heavy Machining

At .060 Axial Depth of Cut (ap)

Insert Geometry	Recommended Starting Feed per Tooth (Fz) in Relation to % of Radial Engagement (ae)															Insert Geometry
	5%			10%			20%			30%			40–100%			
.E..D721	.012	**.038**	.067	.009	**.027**	.047	.006	**.020**	.034	.006	**.018**	.030	.005	**.016**	.027	.E..D721
.E..D41	.015	**.044**	.067	.011	**.031**	.047	.008	**.023**	.034	.007	**.020**	.030	.006	**.018**	.027	.E..D41
.E..D411	.015	**.044**	.067	.011	**.031**	.047	.008	**.023**	.034	.007	**.020**	.030	.006	**.018**	.027	.E..D411
.S..D	.021	**.048**	.079	.015	**.034**	.055	.011	**.025**	.040	.010	**.022**	.035	.009	**.020**	.032	.S..D
.S..GP	.021	**.048**	.079	.015	**.034**	.054	.011	**.025**	.040	.010	**.022**	.035	.009	**.020**	.032	.S..GP

At .040 Axial Depth of Cut (ap)

Insert Geometry	Recommended Starting Feed per Tooth (Fz) in Relation to % of Radial Engagement (ae)															Insert Geometry
	5%			10%			20%			30%			40–100%			
.E..D721	.015	**.047**	.083	.010	**.033**	.057	.008	**.024**	.042	.007	**.021**	.036	.006	**.019**	.033	.E..D721
.E..D41	.018	**.053**	.083	.013	**.038**	.057	.010	**.028**	.042	.009	**.024**	.036	.008	**.022**	.033	.E..D41
.E..D411	.018	**.053**	.083	.013	**.038**	.057	.010	**.028**	.042	.009	**.024**	.036	.008	**.022**	.033	.E..D411
.S..D	.026	**.059**	.098	.019	**.041**	.067	.014	**.031**	.049	.012	**.027**	.042	.011	**.024**	.039	.S..D
.S..GP	.026	**.058**	.097	.019	**.041**	.067	.014	**.030**	.049	.012	**.026**	.042	.011	**.024**	.038	.S..GP

At .030 Axial Depth of Cut (ap)

Insert Geometry	Recommended Starting Feed per Tooth (Fz) in Relation to % of Radial Engagement (ae)															Insert Geometry
	5%			10%			20%			30%			40–100%			
.E..D721	.017	**.054**	.097	.012	**.038**	.066	.009	**.028**	.048	.008	**.024**	.042	.007	**.022**	.038	.E..D721
.E..D41	.021	**.062**	.097	.015	**.043**	.066	.011	**.032**	.048	.010	**.028**	.042	.009	**.025**	.038	.E..D41
.E..D411	.021	**.062**	.097	.015	**.043**	.066	.011	**.032**	.048	.010	**.028**	.042	.009	**.025**	.038	.E..D411
.S..D	.030	**.069**	.115	.021	**.048**	.078	.016	**.035**	.056	.014	**.031**	.049	.013	**.028**	.044	.S..D
.S..GP	.030	**.068**	.114	.021	**.047**	.077	.016	**.035**	.056	.014	**.030**	.048	.013	**.028**	.044	.S..GP

Feed Rate Guide • Plunging • IC 09 • fz [in/tooth]

Insert Geometry	Programmed Feed per Tooth (fz) Max .236" insert engagement (ae radial engagement)			Insert Geometry
.E..D721	.002	**.007**	.012	.E..D721
.E..D41	.003	**.008**	.012	.E..D41
.E..D411	.003	**.008**	.012	.E..D411
.S..D	.004	**.009**	.014	.S..D
.S..GP	.004	**.009**	.014	.S..GP

NOTE: For further details about using the 7792VX series in plunging operations, please see page V30.
Use "Light Machining" values as starting feed rate
Please see pages X22–X37 for recommended starting speeds.

Copy Milling