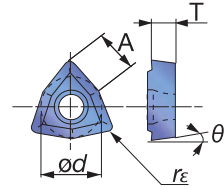
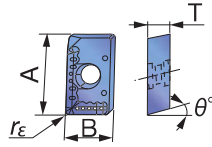


INSERT

XXMU-MJ

WCMT-D4



P	Steel	★							
M	Stainless		★						
K	Cast iron	★							
N	Non-ferrous								
S	Superalloys								
H	Hard materials								

★ : First choice
☆ : Second choice

Designation	rε	Coating		A	ød	T	θ°	B
		AH120	AH140					
XXMU08T204PR-MJ	0.4	●	●	8.2	-	2.78	10	5.6
XXMU10H308PR-MJ	0.8	●	●	10.6	-	3.5	11	6.8
XXMU12X408PR-MJ	0.8	●	●	13.2	-	4.2	11	7.9
XXMU16X508PR-MJ	0.8	●	●	16.8	-	5	11	11.1
WCMT050308-D4	0.8	●	●	5.4	7.94	3.18	7	-
WCMT06T308-D4	0.8	●	●	6.5	9.525	3.97	7	-

● : Line-up



Multi Function

STANDARD CUTTING CONDITIONS

ISO	Workpiece material	Grade	øD: ø16 ~ ø20 mm			øD: ø25 ~ ø63 mm		
			Cutting speed Vc (m/min)	Feed per tooth fz (mm/t)		Cutting speed Vc (m/min)	Feed per tooth fz (mm/t)	
				Shouldering-Grooving	Drilling		Shouldering-Grooving	Drilling
P	Carbon steels C55, etc. < 300 HB	AH120	100 ~ 180	0.05 ~ 0.2	0.03 ~ 0.08	120 ~ 200	0.08 ~ 0.25	0.05 ~ 0.1
	Alloy steels 42CrMo4, etc. < 300 HB	AH120	80 ~ 160	0.05 ~ 0.15	0.03 ~ 0.08	100 ~ 180	0.08 ~ 0.2	0.05 ~ 0.1
	Die steels X96CrMoV12, etc. < 300 HB	AH120	60 ~ 120	0.05 ~ 0.13	0.03 ~ 0.06	80 ~ 150	0.08 ~ 0.15	0.03 ~ 0.08
M	Stainless steels X5CrNi18 9, etc.	AH140	70 ~ 140	0.05 ~ 0.15	0.03 ~ 0.08	90 ~ 160	0.08 ~ 0.2	0.03 ~ 0.08
K	Cast irons 250, etc.	AH120	100 ~ 180	0.05 ~ 0.25	0.03 ~ 0.1	120 ~ 200	0.08 ~ 0.25	0.05 ~ 0.1