ECO-TURN NEW

RECOMMENDED CUTTING CONDITIONS



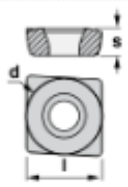
48..

Reference Referència	D5m	L1	L2	Insert size Mida plaqueta		Nm
PSC40-4824.16-2.25D	40	65	36,0	XCMT 0803..	1430 5508	0.8
PSC40-4834.20-2.25D	40	75	45,0	XCMT 10T3..	1235 5515	3.0
PSC40-4844.25-2.25D	40	90	56,5	XCMT 1304..	1250 5520	4.0
PSC50-4824.16-2.25D	50	65	36,0	XCMT 0803..	1430 5508	0.8
PSC50-4834.20-2.25D	50	75	45,0	XCMT 10T3..	1235 5515	3.0
PSC50-4844.25-2.25D	50	90	56,5	XCMT 1304..	1250 5520	4.0
PSC63-4824.16-2.25D	63	65	36,0	XCMT 0803..	1430 5508	0.8
PSC63-4834.20-2.25D	63	75	45,0	XCMT 10T3..	1235 5515	3.0
PSC63-4844.25-2.25D	63	90	56,5	XCMT 1304..	1250 5520	4.0

XCMT

Rhombic positive insert with 7° clearance.
Plaquetes ròmbiques positives amb 7° incidència.

Reference / Referència	l	s	d	r
XCMT 080304-MP EN	8,40	3,18	8,40	0,4
XCMT 10T308-MP EN	10,40	3,18	10,40	0,8
XCMT 130408-MP EN	13,34	4,70	13,34	0,8



XCMT



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Material P	HB	GRADES	
		TL20	ML30
Unalloyed Steel	125-170	110-220	-
Low-Alloyed Steel	180-350	100-210	-
High-Alloyed Steel	200-325	85-190	-

Material M	HB	GRADES	
		TL20	ML30
Stainless Steel (Ferritic / Martensitic)	200-330	95-210	70-230
Stainless Steel (Austensitic)	180-330	85-205	65-225
Stainless Steel (Austensitic / Ferritic (Duplex))	230-260	80-195	55-215

Material S	HB	GRADES	
		TL20	ML30
Heat Resistant Super Alloys	200-320	25-210	-

Reference	fn (mm/r)			ap (mm)	
	Face Turning	Int/Ext. Turning	Drilling	Face Turning	Int/Ext. Turning
XCMT 080304-MP EN	0,03-0,18	0,03-0,20	0,02-0,08	0,90-3,40	0,90-4,20
XCMT 10T308-MP EN	0,03-0,22	0,03-0,24	0,03-0,10	1,00-4,20	1,00-5,30
XCMT 130408-MP EN	0,03-0,24	0,03-0,26	0,04-0,12	1,00-5,00	1,00-6,50