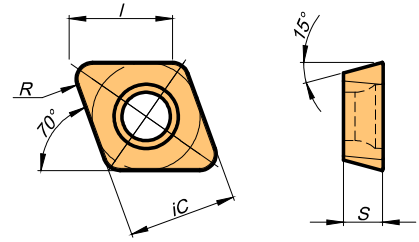
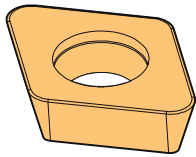


XD... Inserts | Pastilhas | Plaquetas



① Geometry Code	② Grade Code	Grades																Dimensions (mm)													
		P						M			K				N		S					H									
		M6	54	68	66	78	86	I5	68	66	I5	54	68	P3	66	D2	67	I5	P2	D6	P3	G6	I5	M6	D4	iC	S	I	R		
1110905	XDHW 040105	○	○	○		○												⊗								○		4,00	1,59	4,0	0,50
1110573	XDHW 040110	⊗	⊗	○		⊗												⊗								⊗		4,00	1,59	4,0	1,00
1110532	XDHW 060210	⊗	⊗	○		⊗	⊗											⊗								⊗		6,50	2,38	6,2	1,00
1110565	XDHW 10T310	⊗	⊗	○		⊗	⊗											⊗								⊗		10,00	3,97	9,9	1,00

⊗ First choice / 1ª escolha / 1ª opción ⊗ Stock items / Itens de stock ○ Available under request / Disponibilidade sob consulta / Disponible bajo consulta

Insert Order Code = (1) Geometry Code + (2) Grade Code

Rec. Cutting Conditions

ISO	PSM	Material	HB (Brinell)	V _C (m/min)					
				← Wear Resistance			Toughness →		
				PHD103	PH6103	PH6910	PH6920	PH6125	PH6135
P	1	Unalloyed steel	125-220	-	180-300	180-250	150-230	160-190	150-180
	2	Low-alloyed steel	220-280	-	180-250	170-210	140-220	140-180	140-170
	3	High-alloy steel	280-380	-	180-230	160-200	130-180	130-160	120-150
M	4	SS - Ferritic/martensitic	200-330	-	-	-	-	-	-
	5	SS - Austenitic	200-330	-	-	-	-	-	-
	6	SS - Austenitic-ferretic (Duplex)	230-260	-	-	-	-	-	-
K	7	Malleable cast iron	130-230	-	-	170-300	150-280	-	-
	8	Grey cast iron	180-245	-	-	150-250	130-230	-	-
	9	Nodular cast iron	160-250	-	-	90-210	80-190	-	-
N	10	Graphite	30-130	300-1000	-	-	-	-	-
H		Hardened Steels	40-55 HRC	-	120-260	-	-	-	-

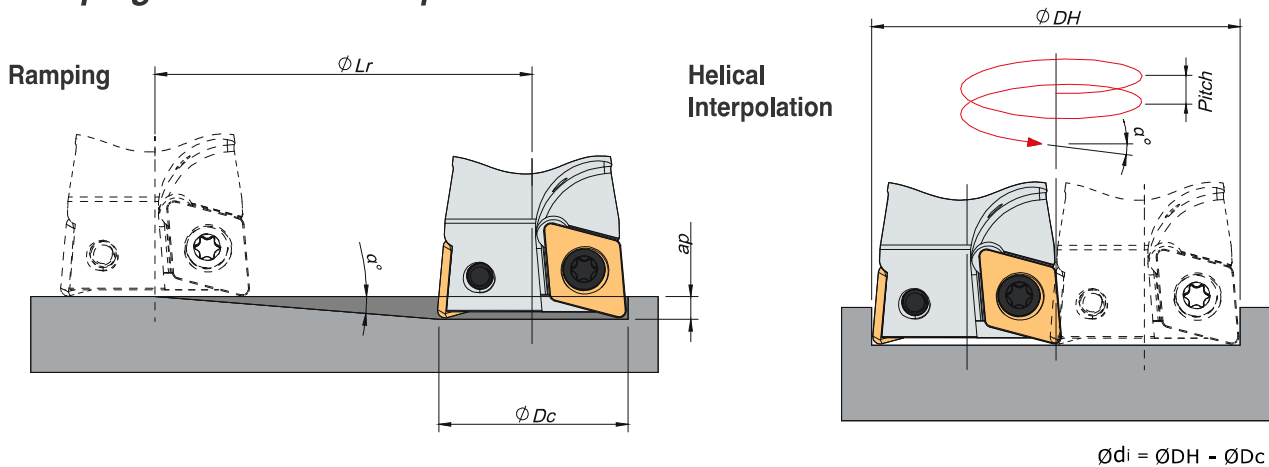
Insert	Feed f _Z (mm/t)		a _p Rec.
	Roughing	Finishing	
XD... 04	0.10-0.20	0.10-0.15	0.10-0.50
XD... 06	0.15-0.30	0.10-0.25	0.20-0.80
XD... 10	0.15-0.35	0.10-0.30	0.20-0.80

(Note 1) Cutting conditions should be adjusted according to the machine and work rigidity.

(Note 2) If chattering occurs, reduce a_p and V_C by 30% and keep the same f_Z per tooth.

LINEPro 40095 | 40595 41095 Milling Tool | Ferramenta | Herramienta

Ramping and Helical Interpolation



Insert	ϕD_c	Ramping			Helical Interpolation		
		Max Ramp α°	Max a_p	Min L_r	ϕD_{Hmin}	ϕD_{Hmax}	Max Pitch/Rev.
XDHW 04...	10	7,3	0,8	6,2	18,0	-	3,2
					-	20,0	4,0
	12	5,3	0,8	8,6	22,0	-	2,9
					-	24,0	3,5
XDHW 06...	16	8	1,0	7,1	30,0	-	6,2
					-	32,0	7,1
	20	5,7	1,0	10,0	38,0	-	5,6
					-	40,0	6,3
XDHW 10...	25	4	1,0	14,3	48,0	-	5,1
					-	50,0	5,5
	25	8,7	1,0	6,5	48,0	-	11,1
					-	50,0	12,0
XDHW 10...	35	5,2	1,0	11,0	68,0	-	9,4
					-	70,0	10,0
	42	4	1,0	14,3	82,0	-	8,8
					-	84,0	9,2
	52	3	1,0	19,1	102,0	-	8,2
					-	104,0	8,6
	66	2,3	1,0	24,9	130,0	-	8,1
					-	132,0	8,3
	80	1,8	1,0	31,8	158,0	-	7,7
					-	160,0	7,9

Note: During helical interpolation do not exceed max Pitch.