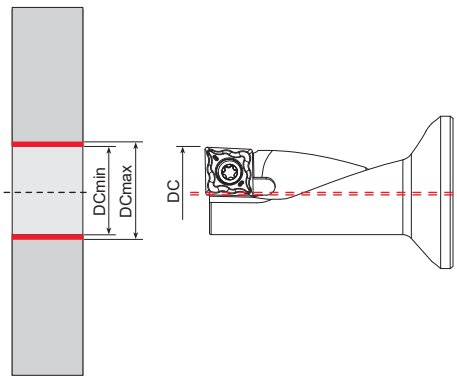
RECOMMENDED CUTTING CONDITIONS Condições de corte recomendadas | Condiciones de corte recomendables

ISO	PSM	Material	HB (Brinell)	Vc (m/min) ← Wear Resistance — Toughness →	
				PH7920	PHS225
P	1	Unalloyed Steel	125-170	110-220	-
	2	Low-Alloyed Steel	180-350	100-210	-
	3	High-Alloyed Steel	200-325	85-190	-
M	4	SS - Ferritic / Martensitic	200-330	95-210	70-230
	5	SS - Austenitic	180-330	85-205	65-225
	6	SS - Austenitic-ferritic (Duplex)	230-260	80-195	55-215
S	11	Heat Resistant Super Alloys	200-320	25-210	-

Reference	FN (mm/rev)			AP (mm)	
	Face Turning	Int/Ext Turning	Holemaking	Face Turning	Int/Ext Turning
XCMT 040104-MP ER/L	0,02-0,09	0,02-0,13	0,01-0,04	0,50-1,90	0,50-2,70
XCMT 050204-MP EN	0,02-0,12	0,02-0,15	0,01-0,05	0,50-2,20	0,50-3,20
XCMT 060204-MP EN	0,02-0,14	0,02-0,16	0,01-0,06	0,70-2,70	0,70-3,70
XCMT 070304-MP EN	0,02-0,16	0,02-0,18	0,01-0,08	0,80-3,00	0,80-4,00
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 09T304-MP EN	0,03-0,20	0,03-0,22	0,03-0,09	0,90-3,80	0,90-4,70
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
XCMT 170508-MP EN	0,03-0,27	0,03-0,30	0,04-0,15	1,00-6,00	1,00-7,00

Off-center drilling:

Thanks to MultiCut's unique geometry, it is possible to perform off-center drilling. Therefore, with slight deviations from the center of the workpiece, it is possible to make holes with diameters different from the nominal diameter, as shown in the table below.



Reference	Drilling (mm)		
	DC nominal	DCmin	DCmax
XMS-R/L 08010-2,25D	8	7,85	8,30
XMS-R/L 10012-2,25D	10	9,85	10,50
XMS-R/L 12016-2,25D	12	11,85	12,50
XMS-R/L 14016-2,25D	14	13,80	14,50
XMS-R/L 16020-2,25D	16	15,80	16,50
XMS-R/L 18025-2,25D	18	17,80	18,50
XMS-R/L 20025-2,25D	20	19,75	20,50
XMS-R/L 25032-2,25D	25	24,75	25,80
XMS-R/L 32040-2,25D	32	31,75	33,00