

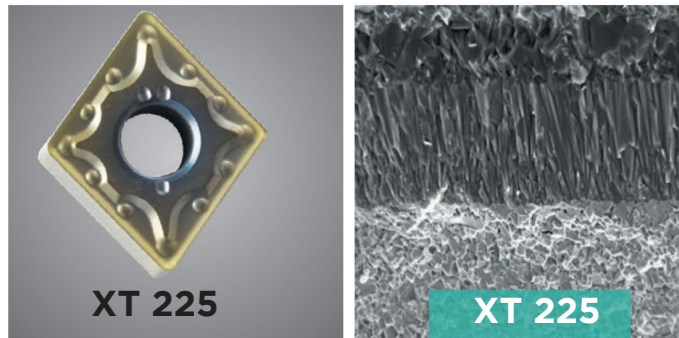
XT225

Exotic Material Machining

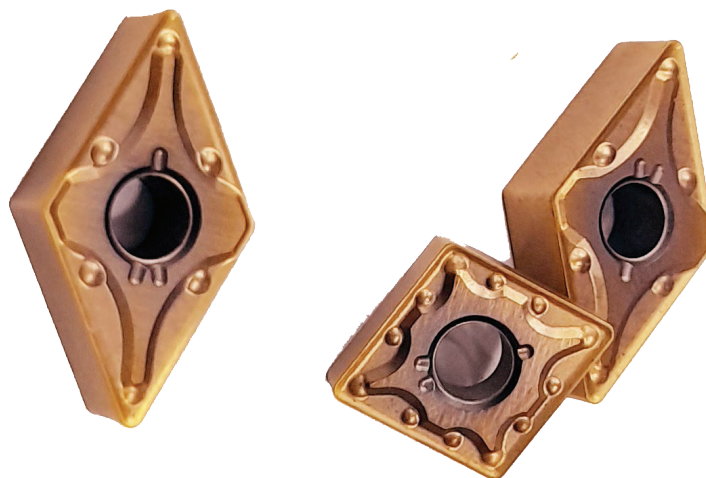


Product Features

- Improved version of XT125.
- New, reliable and tough grade for tough steels, stainless steels & difficult-to-cut materials.
- Strong Geometries like GM/GR reduce sudden fracture from interrupted machining.
- Allows for stable operation and longer tool life.



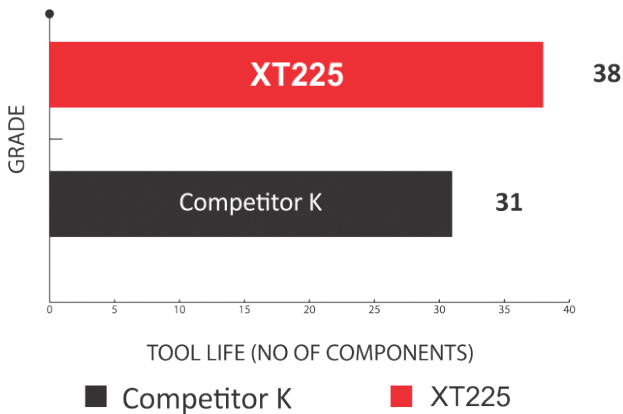
- 2-4 μ ALCrN+ALCrSIN PVD Coated, Combining with ultra fine particles' substrates with High-Toughness.
- Suitable for all materials in light & medium load turning.
- Suitable stainless steel & High-Temperature high hardness alloy in finishing, semi finishing.



PERFORMANCE COMPARISON

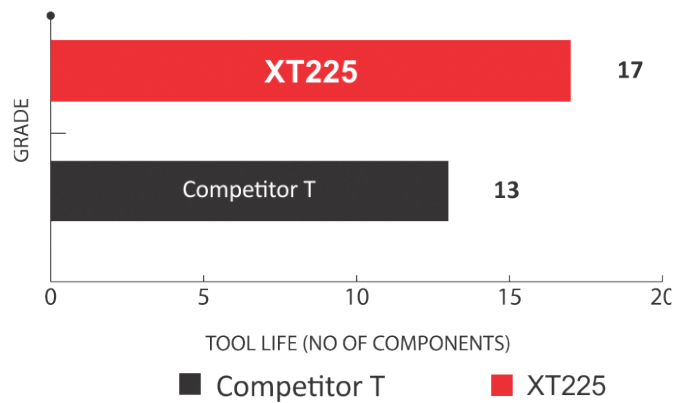
Performance of **WNMG080412BM-XT225**

Material:
INCONEL718=130m/min
Feed=0.22-0.25mm/rev
Ap=0.8-1mm



Performance of **TNMG160408CR-XT225**

Material:
SS316Vc=120-180m/min
Feed=0.15-0.18mm/rev
Ap=1-1.2mm



PARAMETER		
MATERIAL	GRADE	RECOMMENDED CUTTING SPEED (m/min)
STEEL	XT225	90-200
STAINLESS STEEL	XT225	90-200
SUPPERALLOYS	XT225	30-90

CHIPBREAKER'S CHART		
Geometry	ap = (mm)	fn = (mm/rev)
HF	0.1 - 2	0.05 - 0.3
HM	1 - 4	0.1 - 0.3
CR	0.9 - 4	0.1 - 0.5
BM	0.5 - 1.5	0.1 - 0.3
GM	1 - 4	0.12 - 0.35
GR	2 - 6	0.15 - 0.5
BF	0.5 - 1.5	0.1 - 0.3

INSERT	GRADE	HF	HM	CR	BM	BF	GM	GR
CCMT	060204	•						
	060208		•					
	09T304		•					
	09T308		•					
CNMG	120404			•				
	120408			•	•		•	•
	120412				•		•	
	160612						•	
	160616						•	
	190608						•	•
	190612							•
	190616							•
DCMT	070204		•					
	070208		•					
	11T304	•	•					
	11T308		•					
DNMG	150604			•				
	150608			•				
SNMG	120408					•		
	190612							•
TNMG	160404			•		•		
	160408			•	•		•	•
	160412			•	•			
VNMG	160404						•	
	160408						•	
WNMG	060404						•	
	060408						•	
	080408			•	•			
	080412			•	•		•	•

Authorized Dealer