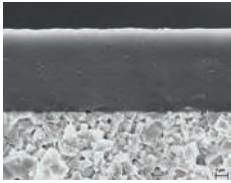


XTGP



XP7125

HC-P45 | HC-M40 | HC-S40



Specification:

Composition: Co 12.5 %; mixed carbides 2.0 %; WC balance | Grain size: 1-1.5 μm |
Hardness: HV₃₀ 1380 | Coating specification: CVD TiAlN

Recommended application:

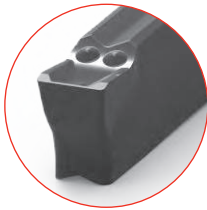
The reliable solution for steel and austenitic steels under unstable conditions.

- Ideal for steel
- Excellent toughness
- Good wear resistance
- High application security

Chipbreaker Overview

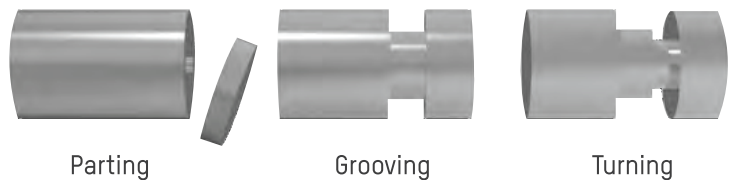
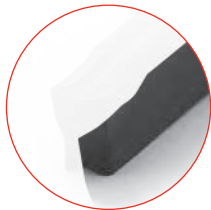
■ ■ P – Medium cutting chipbreaker

- Insert with narrow negative chamfer
- Suitable for all steel materials with high strength
- Suitable for all applications
- For steel and grey cast iron



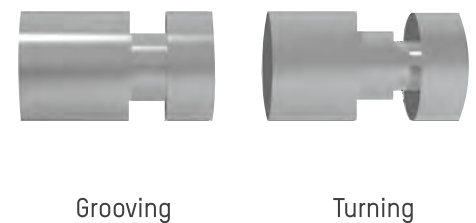
■ ■ GT – Grooving and Turning

- For grooving and turning
- Suitable for all steel and stainless steel materials
- Very good chip control



■ ■ R – Radius grooves

- Insert for radius grooves
- For copy turning
- Suitable for all steel and cast iron materials



DESIGNATION	INSERT width	Insert Length	Corner Radius	XT830	XT930	XP7125
XTGP2002-P	2	24	0.2	●	○	○
XTGP2002-GT	2	24	0.2	●	●	○
XTGP2010-R	2	24	1.0	●	●	○
XTGP3002-P	3	24	0.2	●	○	○
XTGP3003-GT	3	24	0.3	●	○	○
XTGP3015-R	3	24	1.5	●	●	○
XTGP4003-P	4	24	0.3	●	○	○
XTGP4004-GT	4	24	0.4	●	●	○
XTGP4020-R	4	24	2.0	●	●	○
XTGP5004-P	5	24	0.4	●	○	○
XTGP5004-GT	5	24	0.4	●	○	○
XTGP5025-R	5	24	2.5	●	○	○
XTGP6004-P	6	24	0.4	●	○	○
XTGP6004-GT	6	24	0.4	●	●	○
XTGP6030-R	6	24	3.0	●	●	○

HOLDER DESIGNATION	HOLDER TYPE -ORIENTATION	SHANK DIA	OAL	TMAX	APPLICABLE INSERT	AVAILABILITY
XTGMEL-16-J-02T13	EXTERNAL-LEFT HAND	16	110	13	XTGP20...	●
XTGMEL-20-K-02T13	EXTERNAL-LEFT HAND	20	125	13	XTGP20...	●
XTGMEL-25-K-02T13	EXTERNAL-LEFT HAND	25	125	13	XTGP20...	●
XTGMEL-25-K-02T20	EXTERNAL-LEFT HAND	25	125	20	XTGP20...	●
XTGMEL-20-K-03T13	EXTERNAL-LEFT HAND	20	125	13	XTGP30...	●
XTGMEL-20-K-03T25	EXTERNAL-LEFT HAND	20	125	25	XTGP30...	○
XTGMEL-25-K-03T13	EXTERNAL-LEFT HAND	25	125	13	XTGP30...	●
XTGMEL-25-K-03T25	EXTERNAL-LEFT HAND	25	125	25	XTGP30...	●
XTGMEL-20-K-04T15	EXTERNAL-LEFT HAND	20	125	15	XTGP40...	○
XTGMEL-20-K-04T25	EXTERNAL-LEFT HAND	20	125	25	XTGP40...	○
XTGMEL-25-K-04T15	EXTERNAL-LEFT HAND	25	125	15	XTGP40...	●
XTGMEL-25-K-04T25	EXTERNAL-LEFT HAND	25	125	25	XTGP40...	●
XTGMEL-25-M-05T25	EXTERNAL-LEFT HAND	25	150	25	XTGP50...	●
XTGMEL-25-M-06T25	EXTERNAL-LEFT HAND	25	150	25	XTGP60...	●
XTGMEL-32-M-06T32	EXTERNAL-LEFT HAND	32	150	32	XTGP60...	○
XTGMER-16-J-02T13	EXTERNAL-RIGHT HAND	16	110	13	XTGP20...	○
XTGMER-20-K-02T13	EXTERNAL-RIGHT HAND	20	125	13	XTGP20...	●
XTGMER-25-K-02T13	EXTERNAL-RIGHT HAND	25	125	13	XTGP20...	●
XTGMER-25-K-02T20	EXTERNAL-RIGHT HAND	25	125	20	XTGP20...	○
XTGMER-20-K-03T13	EXTERNAL-RIGHT HAND	20	125	13	XTGP30...	●
XTGMER-20-K-03T25	EXTERNAL-RIGHT HAND	20	125	25	XTGP30...	○
XTGMER-25-K-03T13	EXTERNAL-RIGHT HAND	25	125	13	XTGP30...	●
XTGMER-25-K-03T25	EXTERNAL-RIGHT HAND	25	125	25	XTGP30...	●
XTGMER-20-K-04T15	EXTERNAL-RIGHT HAND	20	125	15	XTGP40...	○
XTGMER-20-K-04T25	EXTERNAL-RIGHT HAND	20	125	25	XTGP40...	○
XTGMER-25-K-04T15	EXTERNAL-RIGHT HAND	25	125	15	XTGP40...	●
XTGMER-25-K-04T25	EXTERNAL-RIGHT HAND	25	125	25	XTGP40...	●
XTGMER-25-M-05T25	EXTERNAL-RIGHT HAND	25	150	25	XTGP50...	●
XTGMER-25-M-06T25	EXTERNAL-RIGHT HAND	25	150	25	XTGP60...	●
XTGMER-32-M-06T32	EXTERNAL-RIGHT HAND	32	150	32	XTGP60...	○

Cutting parameters overview

INSERT WIDTH	CHIPBREAKER	FEED RATE
2	P	0.05 - 0.16
	GT	0.05 - 0.12
	R	0.08 - 0.25
3	P	0.11 - 0.20
	GT	0.06 - 0.16
	R	0.11 - 0.30
4	P	0.13 - 0.22
	GT	0.11 - 0.21
	R	0.15 - 0.36
5	P	0.16 - 0.31
	GT	0.11 - 0.23
	R	0.17 - 0.30
6	P	0.16 - 0.35
	GT	0.13 - 0.25
	R	0.14 - 0.40

Cutting speed recommendation

P/GT/R

Work piece material	Type of treatment/alloy	Hardness HB	Coated carbide		
			XT830 v _c [m/min]	XT930 v _c [m/min]	XP7125 v _c [m/min]
P Steel	non alloyed steel 0.15% - 0.45% C	150 - 250	80 - 180	110 - 190	80 - 150
	low alloyed steel tempered	250 - 300	60 - 150	110 - 180	70 - 120
	high alloyed steel tempered	350	50 - 120	70 - 160	60 - 100
	corrosion resistant steel annealed	200	50 - 200	120 - 200	90 - 160
M Stainless steel	annealed pearlitic	200	50 - 200	120 - 200	100 - 180
	quenched austenitic	180	50 - 180	100 - 170	80 - 150
	quenched duplex	230 - 260	50 - 100	70 - 110	70 - 110
	hardened martensitic	330	50 - 80	60 - 90	60 - 90
K Cast iron	grey cast iron	180	100 - 200	90 - 180	100 - 180
	spheroidal	160	100 - 180	100 - 160	80 - 150
	malleable pearlitic	130	80 - 160	80 - 150	70 - 110

