45 YEARS OF LEGACY

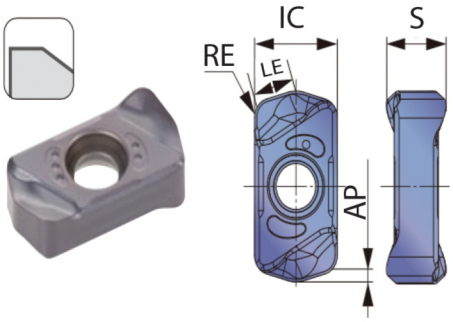
Innovative solutions
Indian values

XCUT® TECHNOLOGIES

FFC LINE

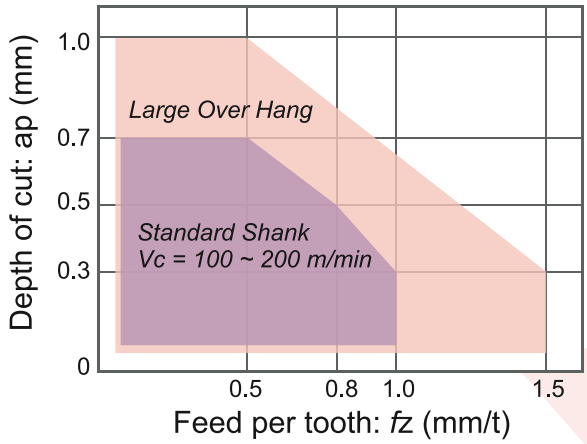
ZNMU1003

Overview



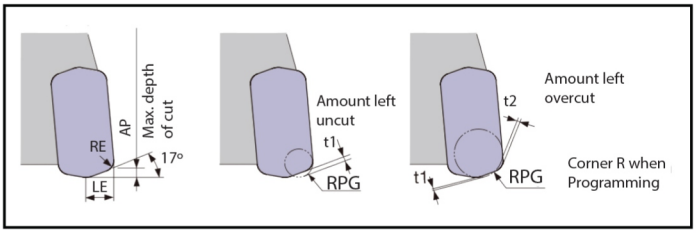
DESIGNATION	RE	APMX	LE	IC	S
ZNMU 100312-HF-XT830	1.2	1	3.2	6	4.3

Benefits:
- Effective for high feed milling
- Anti-chatter properties
- Excellent machine efficiency

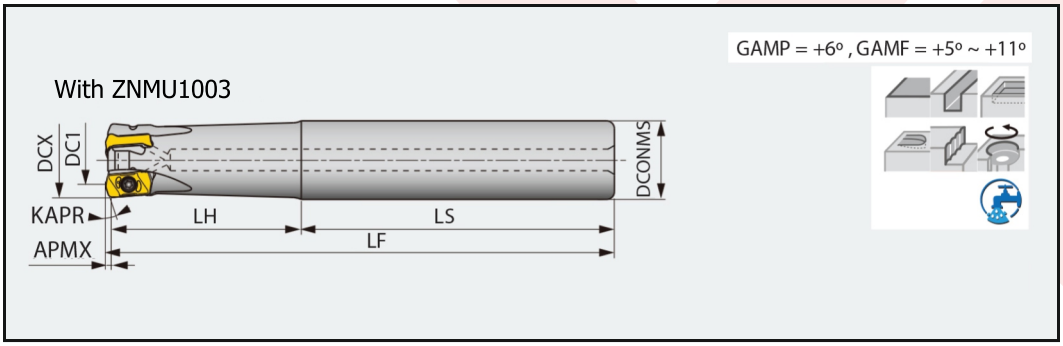


Tool geometry on programming:

The tool should be considered as a radius cutter, when programming for CAM. The corner radius should be set as R = 1.5mm. If larger radius is used, overcutting will occur. The following table shows the amount left uncut (t1) and overcut (t2).



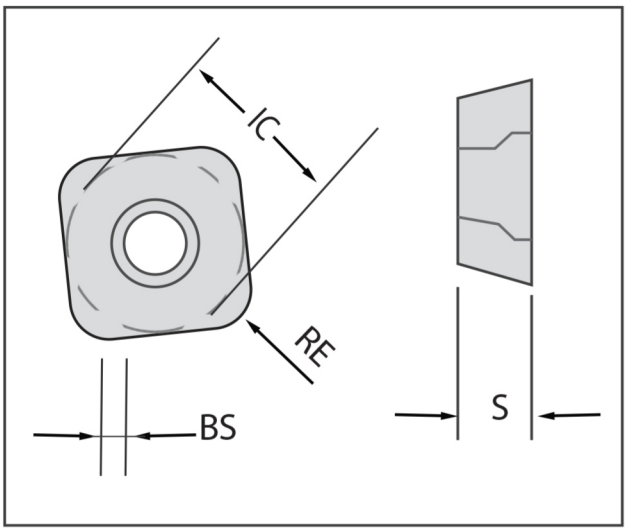
Max.Dept of cut APMX (mm)	Corner radius RE (mm)	LE (mm)	Corner R when programming RPG	Amount left uncut t1 (mm)	Amount left uncut t2 (mm)
1.0	1.2	3.0	1.0	0.6	-
1.0	1.2	3.0	1.5	0.5	-
1.0	1.2	3.0	2.0	0.25	0.08
1.0	1.2	3.0	2.5	0.14	0.26



DESIGNATION	D	d	L1	L	Z
XTFFC-1616-30FL-T2-ZNMU100	16	16	60	200	2
XTFFC-2020-45FL-T3-ZNMU100	20	20	60	200	3
XTFFC-2525-40FL-T4-ZNMU100	25	25	60	200	4

SDKW13

Overview



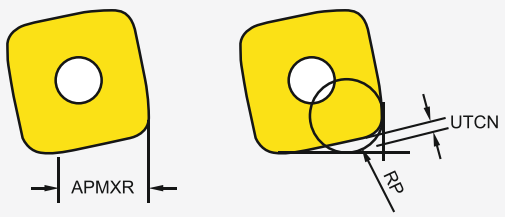
Benefits:

- Decreased cost with 4 cutting edges.
- It can cut dept upto max 2mm.
- High feed cutter for high Metal Removal Rate
- Reduces tool pressure and rake angles for smoother cutting.
- Cutting force is reduced due to positive rake angle.

DESIGNATION	GRADE	RE	BS	IC	S	Fz
SDKW 130420-HF	XT830	1.9	1.45	12.7	4.7	0.60~1.20
SDKT 130420-HF	XT830	1.9	1.45	12.7	4.7	0.60~1.40

DESIGNATION	D	DE	d	L	Z
XTFFC-D50-Z4-SDKW1304	50	38	22	40	4
XTFFC-D63-Z5-SDKW1304	63	76	22	40	5
XTFFC-D80-Z6-SDKW1304	80	93	27	50	6
XTFFC-D100-Z7-SDKW1304	100	113	32	63	7
XTFFC-D125-Z10-SDKW1304	125	138	40	63	10
XTFFC-3232-50FL-T2-SDKW1304	32		32	200	3

Technical Information



APMXR Radial AP Max	RP Programmed Corner R	UTCN Uncut Thickness
8.6	R3.5	0.94

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XT830

Cutting Conditions

ISO	Material Group	Relative Materials (DIN)	Hardness HB	VC (m/min.) Min	Max
P	Non-alloy steel	9 SMN 28, C35c50, C40E, C45E 49 CrMo 4	125 - 250	140	380
	Low alloy steel	13 CrMo 44, 40NICrMo22, 58 CrV4	200 - 350	120	300
	High alloy steel	X 40 CrMoV 5 1, X100 CrMov % 1, S6-5-5	200 - 320	70	150
M	Ferritic/martensitic Stainless steel	X6Cr13, X10CrA118, X20CrNI175	200 - 240	120	200
	Auestenitic Stainless steel	X5 CrNI 18 9, X5 CrNIMo 17 13 3 X6 CrNITI 18 9	180	130	250
K	Grey cast iron	GG15, GG20, GGG40 GG-35	180 - 260	120	250
	Malleable Cast iron	GTS-35-10 GTS-35, GTS70-20, 20mNS	130 - 230	130	220
S	Fe, Ni or Co based	X12NICrAITI 31 20, TIAI5Sn2	200 - 350	25	45
	Titanium and Ti - alloy based	TICu2, TIAI6V4, TIAI6V4ELI		25	45
H	Hardended Steel	C 105 W1, 75 CrMoNIW 6 7	55 - 66 HRc	40	80
	Chilled cast iron	G-X 260 NICr 4 2, X15 CrNISI 25 20	400	40	80
	Cast iron	G-X 300 CRMo 15 3	55 HRc	40	80

Authorised Channel Partner

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