

Innovative Solutions
Indian Values



XMEGA FEED WOKX14

6 Corner Hi Feed Cutter

New standard for inserts in high-feed cutting

www.xcut.in



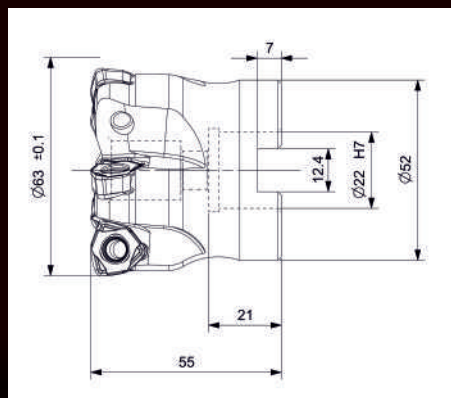
Features & Benefits:

- The unique R-shaped cutting edge enables milling with a constant cutting thickness. Therefore, it can work under constant machining conditions in various shapes and sections.
- The high-strength inserts design and high-toughness material control sudden tool breakage due to interrupted cutting, etc.
- Utilizing the features of a negative insert, and hence high cutting-edge strength.
- Neutral/High-Feed Geometry.
- Very low/neutral lead angle.
- Leads to smaller axial depth of cut but high feed per tooth.
- Allows high cutting speed with reduced cutting forces.
- Ideal for materials where you want to minimize deflection.

Tool Advantages

- Lower cutting force less vibration
- Higher productivity per pass
- Reduced spindle load
- Longer tool life in many applications

Cutter Specification:



Cutter Description	Dia (D)	Z (No. of Teeth)	Arbor Bore (d)	Body Length (L)	Overall Length (L1)	Keyway (mm)	Arbor Screw Size
XTFFC-D50-A22-Z4-WOKX14	Ø50	4	22	40 - 45 mm	50 - 55 mm	8 mm	M4/M5
XTFFC-D52-A22-Z5-WOKX14	Ø63	5	22	45 - 50 mm	55 - 60 mm	8 mm	M5
XTFFC-D63-A22-Z5-WOKX14	Ø63	5	22	45 - 50 mm	55 - 60 mm	8 mm	M5
XTFFC-D80-A27-Z6-WOKX14	Ø80	6	27	50 - 55 mm	60 - 65 mm	10 mm	M5/M6
XTFFC-D100-A32-Z7-WOKX14	Ø100	7	32	55 - 60 mm	65 - 75 mm	12 mm	M6
XTFFC-D125-A40-Z8-WOKX14	Ø125	8	40	55 - 65 mm	65 - 75 mm	14 mm	M6

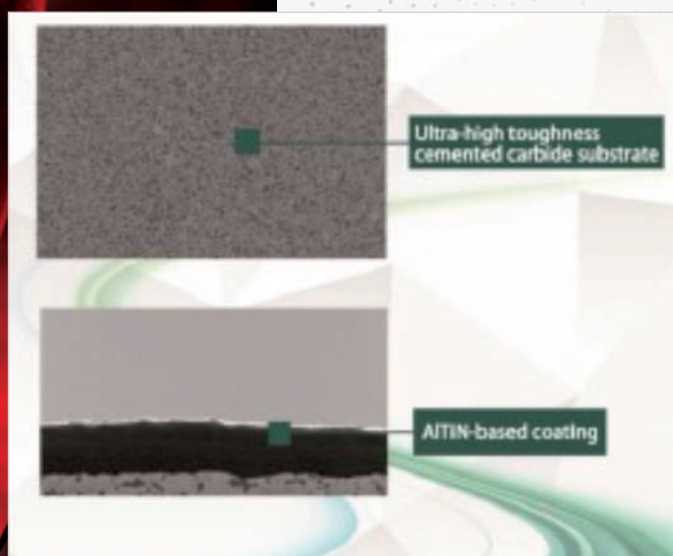
*Insert Screw - Screw M5x12



Insert Specification:

Insert Description	Insert Shape	Inscribed Circle (IC)	Thickness (S)	Corner Radius (R)	Rake Angle (α)	Relief Angle (α)	Hole Type
WOKX140630-GM-XT830	Trigon (80°)	14 mm	6.0 mm (+/- 0.13 typical)	3.0 mm	+10° to +18° (Hi-feed positive geometry)	7°	Screw mounting
WOKX140630-SM-XT960	Trigon (80°)	14 mm	6.0 mm (+/- 0.13 typical)	3.0 mm	+10° to +18° (Hi-feed positive geometry)	7°	Screw mounting

Insert Grade:



WOKX140630-GM-XT830 P15-P30/M15-M25/S10-S20

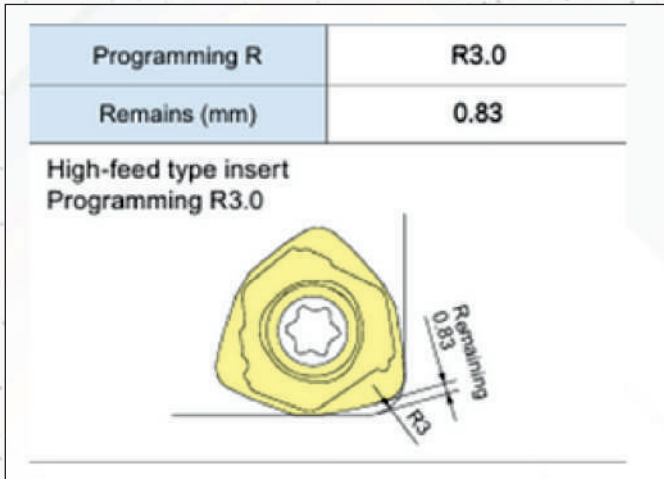
1. Suitable for heavy interrupted machining and rough machining of stainless steel and steel.
2. Suitable for low-speed and heavy interrupted machining of heat-resistant alloy as well.



WOKX140630-SM-XT960 M25-M35 / S15-S25

1. Higher fracture-resistant cemented carbide substrate, which reduces chipping and cracking when subjected to high impact loads. Suitable for machining high-strength materials (Ti alloys and high-temp alloys) or performing intermittent cuttings.
2. Nanostructured AlTiN Based on a coating with a fine-grained cemented carbide substrate, it provides excellent wear resistance and can resist thermal cracks and edge chipping.

Programming Radius:



HI FEED CUTTER - CUTTING PARAMETERS

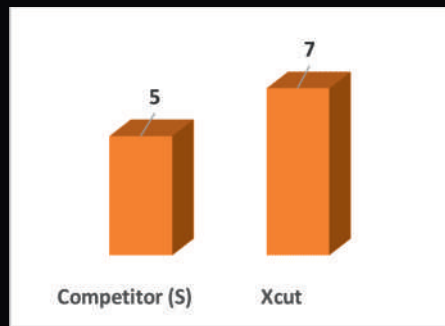
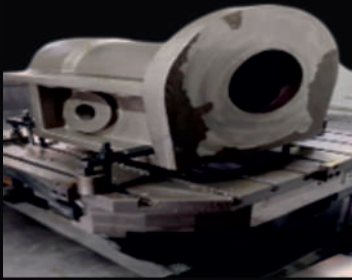
Insert: WOKX140630-GM-XT830 | WOKX140630-SM-XT960ap max 1.0mm |
Flood coolant (reduce Vc 15-20% for dry/MQL)

			XT830 (WOKX140630-GM-XT830)			Xt960 (WOKX140630-SM-XT960)		
Group	Sub	Material Description	Vc (m/min)	fz (mm/tooth)	Status	Vc (m/min)	fz (mm/tooth)	Status
P	P1	Low carbon / unalloyed steel (0.25% C)	200 - 320	1.0 - 2.0	Primary	—	—	—
P	P2	Alloy / medium carbon steel (900-1100 Mpa)	150 - 250	0.8 - 1.6	Primary	—	—	—
P	P3	High alloy / tool steel (1100-1400 Mpa)	100 - 180	0.6 - 1.2	Primary	—	—	—
M	M1	Ferritic / martensitic stainless steel	120 - 200	0.6 - 1.2	Secondary	120 - 200	0.6 - 1.2	Primary
M	M2	Austenitic stainless steel (304 / 316 type)	80 - 150	0.5 - 1.0	Secondary	100 -170	0.6 - 1.2	Primary
M	M3	Duplex / super duplex stainless steel	—	—	—	80 - 140	0.5 - 1.0	Primary
K	K1	Grey cast iron (GCI / HB 220)	180 - 300	0.8 - 1.8	Primary	—	—	—
K	K2	Nodular / ductile iron (SGI / HB 280)	120 - 220	0.8 - 1.5	Primary	—	—	—
N	N1	Aluminium alloys (Si 13%)	300 - 500	1.0 - 2.5	Primary	—	—	—
N	N2	Copper / brass / bronze alloys	200 - 400	0.8 - 2.0	Primary	—	—	—
H	H1	Hardened steel 45 - 55 HRC	—	—	—	80 - 150	0.3 - 0.8	Primary
H	H2	Hardened steel 55 - 65 HRC	—	—	—	60 - 110	0.2 - 0.6	Primary
S	S1	Titanium alloys (Ti-6Al-4V type)	—	—	—	40 - 80	0.3 - 0.8	Primary
S	S2	Nickel-based superalloys (Inconel / Hastelloy)	—	—	—	20 - 50	0.2 - 0.6	Primary
S	S3	Cobalt-based superalloys	—	—	—	20 - 45	0.2 - 0.5	Primary

WOKX Case Study :

Product Description	WOKX140630-SM-XT960	
Material & Hardness	CF8M & 32 HRC	
Parameters	Competitor (S)	X CUT
Depth of Cut	Total Stock = 8mm Width of cut = 80mm Ap = 1mm No.of Pass =8	Total Stock = 8mm Width of cut = 80mm Ap = 1mm No.of Pass =8
Vc: m/min	135	130
Fz: mm/tooth	0.7(2200)	0.8(2500)

Tool Life Increased By 40%



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