

ALLOY WHEEL GROOVING

Double-Ended Precision Inserts with a
Polished Top Rake for Aluminum Machining



Feature & Benefits

- Insert Available in R3 and R4 (6mm and 8mm)
- 6 mm inserts 2 sided for better rigidity
- Precision ground double ended insert.
- Polished to avoid Built up edge.
- Used for external machining of Aluminum at medium-to-high Feed.
- Insert Grade available XA330

Machining of Alloy Wheel

- In aluminium wheel machining, the greatest time-saving potential lies in hub machining, which demands extremely high cutting speeds and hard cutting materials; we provide optimal tools for every stage of the process—from inside and outside profile machining to valve and screw hole drilling.



Hub machining



Internal machining of mating surface





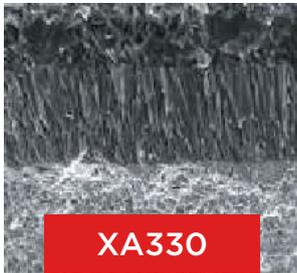
Internal machining




Undercut



Grade Information



XA330

N10-N20 (Si<13%)

Polished rake surface for smoother flow of chips.
Positive & sharp cutting edge for enhanced tooling performance.
excellent machining & chip flow, reduced built-up edge

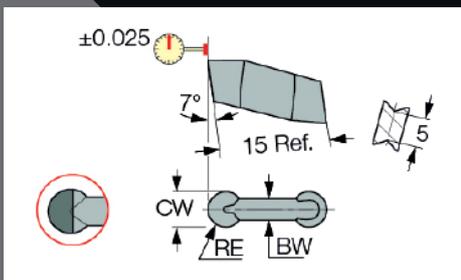
Cutting Speed Recommendation

Material Group	Relative Materials (DIN)	XA330	XPD330
		N1	Wrought Aluminium
N2	Low Silicon, Aluminium and Mn Alloys	120-280	140-310
N3	High Silicon, Aluminium and Mn Alloys	120-250	120-250
N4	Copper Brass Zinc Based Aluminium	90-220	110-250

Grooving Insert

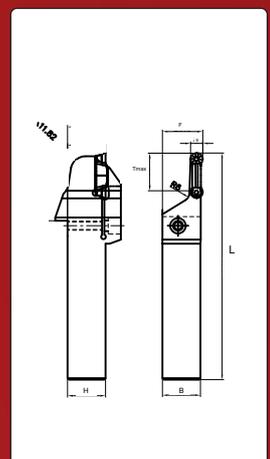
Designation	CW	RE	CWTOL	RETOL	BW	DAXN	ap (min)	ap (max)	ft (min)	ft (min)	fg (min)	fg (min)
GIPA060-030R-XA330	6	3	0.02	0.05	4.8	160	0.8	3	0.21	0.58	0.11	0.29
GXA080-040R-XA330	8	4	0.02	0.05	5.6	25	1	4	0.24	0.67	0.14	0.38

Profiling Insert	IC	S	RE	ap (min)	ap (max)	Stock
VCGT220516-XA300	12.7	5.56	1.6	1	3	○
VCGT220530-XA300	12.7	5.56	3	1.5	4.5	●



Holder table

Designation	Insert Size	H	B	H	F	Tmax	Availability
GH-LH-2525-T25-GIPA08-XCD	8	25	25	150	26.5	25	●
GH-RH-2525-T25-GIPA08-XCD	8	25	25	150	26.5	25	●
GH-LH-3232-T25-GIPA08-XCD	8	32	32	170	33.5	25	●
GH-RH-3232-T25-GIPA08-XCD	8	32	32	170	33.5	25	●
GH-LH-2525-T19-GIPA06-XCD	6	25	25	150	26.5	19	●
GH-RH-2525-T19-GIPA06-XCD	6	25	25	150	26.5	19	●

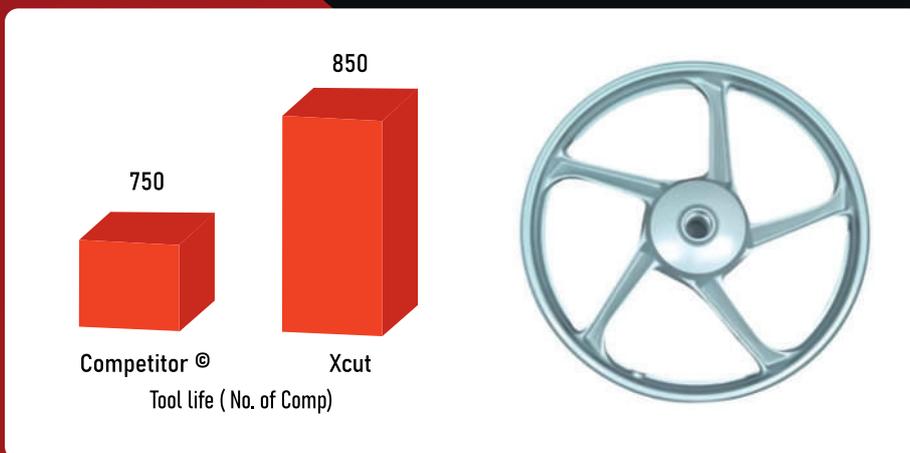


● STOCKABLE ○ NON STOCKABLE

Case Study

Product Description	GIPA060-030R-XA330	
Material & Hardness	Aluminium	
Parameters	Competitor (K)	XCUT
Depth of Cut	1 mm	1 mm
Vc: m/min	2180	2320
Fz: mm/tooth	0.33 / 0.4	0.33 / 0.38

Tool Life Increased By 31.9 %





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