

 DJ (general application)	XPMT040104R	4,3	4,5	1,59	0,4
	XPMT050204R	5,2	5,4	2,38	0,4
	XPMT06X308R	6	7	3,15	0,8
	XPMT07H308R	7	8,2	3,6	0,8
	XPMT08T308R	8,5	9,9	3,97	0,8
	XPMT110412R	11,2	12,5	4,76	1,2
	XPMT150512	15	16,1	5,56	1,2

 DS (low cutting force)	XPMT040104R	4,3	4,5	1,59	0,4
	XPMT050204R	5,2	5,4	2,38	0,4
	XPMT06X308R	6	7	3,15	0,8
	XPMT07H308R	7	8,2	3,6	0,8
	XPMT08T308R	8,5	9,9	3,97	0,8
	XPMT110412R	11,2	12,5	4,76	1,2
	XPMT150512	15	16,1	5,56	1,2

			Description	Grade	Tech. Code	P			M		K		N	S	H
						<500 N/mm²	<800 N/mm²	<1200 N/mm²	<600 N/mm²	<850 N/mm²	<240 HB	<300 HB	Alu	HTA	<60 HRC
GENERAL APPLICATIONS	DJ		XPMT040104R-DJ	AH6030	B8A2504XPDJ01	○	●	●	○		●	●		○	●
			XPMT050204R-DJ		B8A2505XPDJ02	○	●	●	○		●	●		○	●
			XPMT06X308R-DJ		B8A2506XPDJ03	○	●	●	○		●	●		○	●
			XPMT07H308R-DJ		B8A2507XPDJ04	○	●	●	○		●	●		○	●
			XPMT08T308R-DJ		B8A2508XPDJ05	○	●	●	○		●	●		○	●
			XPMT110412R-DJ		B8A2511XPDJ06	○	●	●	○		●	●		○	●
			XPMT150512R-DJ		B8A2515XPDJ07	○	●	●	○		●	●		○	●
			XPMT040104R-DJ	AH725	B8A2504XPDJ08	○	●	●	○		●	●		○	●
			XPMT050204R-DJ		B8A2505XPDJ09	○	●	●	○		●	●		○	●
			XPMT06X308R-DJ		B8A2506XPDJ10	○	●	●	○		●	●		○	●
			XPMT07H308R-DJ		B8A2507XPDJ11	○	●	●	○		●	●		○	●
			XPMT08T308R-DJ		B8A2508XPDJ12	○	●	●	○		●	●		○	●
			XPMT110412R-DJ		B8A2511XPDJ13	○	●	●	○		●	●		○	●
			XPMT150512R-DJ		B8A2515XPDJ14	○	●	●	○		●	●		○	●
FINE CUTTING	DS		XPMT040104R-DS	AH6030	B8A2604XPDS01	●	○	○	●	●			●	●	
			XPMT050204R-DS		B8A2605XPDS02	●	○	○	●	●			●	●	
			XPMT06X308R-DS		B8A2606XPDS03	●	○	○	●	●			●	●	
			XPMT07H308R-DS		B8A2607XPDS04	●	○	○	●	●			●	●	
			XPMT08T308R-DS		B8A2608XPDS05	●	○	○	●	●			●	●	
			XPMT110412R-DS		B8A2611XPDS06	●	○	○	●	●			●	●	
			XPMT150512R-DS		B8A2615XPDS07	●	○	○	●	●			●	●	
			XPMT040104R-DS	AH725	B8A2604XPDS08	●	○	○	●	●			●	●	
			XPMT050204R-DS		B8A2605XPDS09	●	○	○	●	●			●	●	
			XPMT06X308R-DS		B8A2606XPDS10	●	○	○	●	●			●	●	
			XPMT07H308R-DS		B8A2607XPDS11	●	○	○	●	●			●	●	
			XPMT08T308R-DS		B8A2608XPDS12	●	○	○	●	●			●	●	
			XPMT110412R-DS		B8A2611XPDS13	●	○	○	●	●			●	●	
			XPMT150512R-DS		B8A2615XPDS14	●	○	○	●	●			●	●	

● RECOMMENDED FOR... ○ USABLE FOR...

SPARE PARTS

Tech. Code	Description	Description	Insert	Tech. Code	Description	Description	Insert
BRICA188	Up to Ø 14,5	Clamping insert screw	CSPB-2H	BRICA241	From Ø 27 to Ø 32	Clamping insert screw	CSTB-3
BRICA107	From Ø 15 to Ø 17		CSPB-2L043	BRICA242	From Ø 33 to Ø 41		CSTB-4
BRICA240	From Ø 17,5 to Ø 21,5		CSPB-2.2	BRICA243	From Ø 42 to Ø 50		CSTB-5
BRICA109	From Ø 22 to Ø 26		CSPB-2.5				

RECOMMENDED CUTTING DATA

Material	Priority	Recommended Grades	Geometria	Cutting speed m/min.	Feed Ø 12,5 - 17 (mm/turn)	Feed Ø 17,5 - 32 (mm/turn)	Feed Ø 33 - 50 (mm/turn)
Carbon steels (C45, C55, etc.)	First choice	AH6030	DJ	80 - 250	0,04 - 0,10	0,06 - 0,13	0,08 - 0,18
Low alloy steels (18CrMo4, etc.)	First choice	AH6030	DS	160 - 250	0,04 - 0,08	0,06 - 0,12	0,06 - 0,14
	Wear resistance	AH725	DS	160 - 250	0,04 - 0,08	0,06 - 0,12	0,06 - 0,14
High alloy steels (42CrMo4, 20Cr4, etc.)	First choice	AH6030	DJ	80 - 200	0,04 - 0,10	0,06 - 0,13	0,08 - 0,18
Stainless steels (X5CrNi 18-9, etc.)	Wear resistance	AH6030	DS	100 - 200	0,02 - 0,08	0,04 - 0,10	0,04 - 0,12
	First choice	AH6030	DS	100 - 200	0,02 - 0,08	0,04 - 0,10	0,04 - 0,12
Hardened stainless steels	Wear resistance	AH6030	DS	80 - 180	0,04 - 0,08	0,04 - 0,10	0,06 - 0,10
	First choice	AH6030	DS	80 - 180	0,04 - 0,08	0,04 - 0,10	0,06 - 0,10
Grey cast irons (GG25, GG30, etc.)	First choice	AH725	DJ	80 - 250	0,06 - 0,12	0,06 - 0,15	0,08 - 0,20
Spheroidal cast iron (GGG40, etc.)	First choice	AH725	DJ	80 - 200	0,06 - 0,12	0,06 - 0,15	0,08 - 0,20
Aluminum alloys	High speed	AH725	DS	200 - 400	0,10 - 0,15	0,15 - 0,20	0,15 - 0,25
Titanium alloys (Ti-6Al-4V, etc.)	First choice	AH6030	DS	40 - 110	0,04 - 0,08	0,04 - 0,10	0,04 - 0,10
	Wear resistance	AH725	DS	40 - 110	0,04 - 0,08	0,04 - 0,10	0,04 - 0,10
Hardened steels (≥40 HRC)	First choice	AH725	DJ	40 - 100	0,04 - 0,08	0,04 - 0,08	0,04 - 0,10