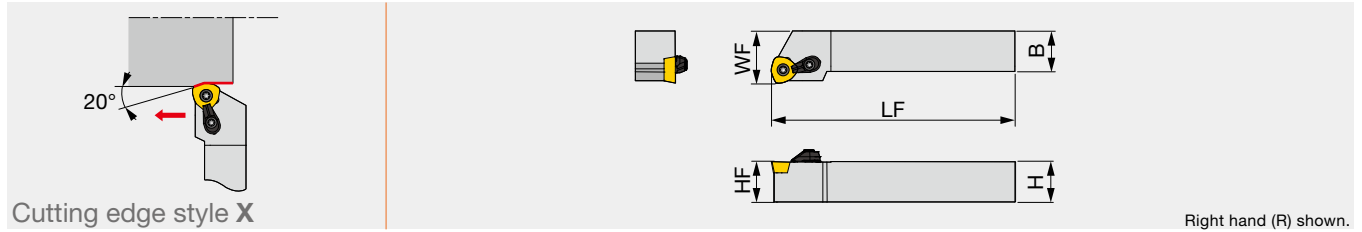


Double-clamp toolholder for roughing with 20° approach angle, for positive 80° trigon inserts



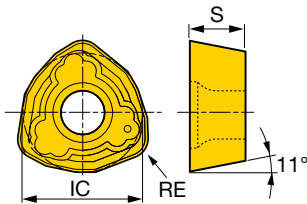
Designation	H	B	LF	HF	WF	Insert
XWXPR/L2525M09	25	25	150	25	32	WPMT090725ZPR/L-ML
XWXPR/L3232P09	32	32	170	32	40	WPMT090725ZPR/L-ML
XWXPR/L4040S09	40	40	250	40	50	WPMT090725ZPR/L-ML

SPARE PARTS			
Designation	Clamp set	Clamping screw	Wrench
XWXPR/L...	CSY-20	CSPB-5	IP-20T

Note: Each insert is either right- or left-handed. Please be sure not to use a wrong insert.

INSERT

WPMT09-ML



	P	M	K	N	S	H
Steel	★	★	★	★	★	
Stainless					☆	
Cast iron	☆	☆	☆	☆	☆	
Non-ferrous						
Superalloys						
Hard materials						

★ : First choice
☆ : Second choice

Designation	RE	Coated					IC	S
		T9225	T9215	T9115	T9125	AH120		
WPMT090725ZPR-ML	2.5	●	●	●	●	●	1.5	7
WPMT090725ZPL-ML	2.5	●	●	●	●	●	1.5	7

● : Line up

STANDARD CUTTING CONDITIONS

ISO	Workpiece material	Grade	Chipbreaker	Cutting Speed Vc (m/min)	Depth of cut ap (mm)	Feed f (mm/rev)
P	Mild and low carbon steels SS400, SM490, etc. E275A, C15E4, etc. < 180 HB	T9225	ML	100 - 300	0.5 - 2.5	0.5 - 2.5
	Carbon and alloy steels S55C, SCM440, etc. C55, 42CrMo4, etc. < 300HB	T9215	ML	120 - 350	0.5 - 2.5	0.5 - 2.5
M	Stainless steels SUS304, SUS316, etc. X5CrNi18-9, X5CrNiMo17-12-3, etc. < 250 HB	T9225	ML	100 - 300	0.5 - 2.5	0.5 - 2.5
K	Grey and ductile cast irons FC250, FCD400, etc. 250, 400-15S, etc.	AH120	ML	100 - 250	0.5 - 2.5	0.5 - 2.5

Note: When the side cutting edge is used for facing, the maximum feed is limited to within 1.0 mm/rev.