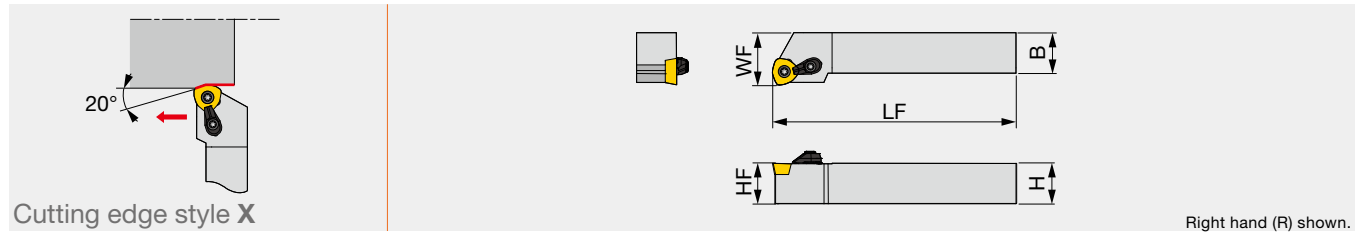


Double-clamp toolholder for roughing with 20° approach angle, for positive 80° trigon inserts



Inch	H	B	LF	HF	WF	Insert
XWXPR/L16-09	1.000	1.000	6.000	1.000	1.250	WPMT090725ZPR/L-ML
XWXPR/L20-09	1.250	1.250	7.000	1.250	1.500	WPMT090725ZPR/L-ML
XWXPR/L24-09	1.500	1.500	7.000	1.500	2.000	WPMT090725ZPR/L-ML

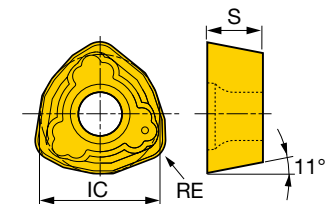
SPARE PARTS

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

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

INSERT

WPMT09-ML



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

★ : First choice
☆ : Second choice

Designation	Max. ap (in)	RE (in)	Coated						IC (in)	S (in)
			T9225	T9215	T9115	T9125	AH120			
WPMT090725ZPR-ML	0.118	0.098	●	●	●	●	●		0.059	0.276
WPMT090725ZPL-ML	0.118	0.098	●	●	●	●	●		0.059	0.276

● : Line up

STANDARD CUTTING CONDITIONS

ISO	Workpiece material	Grade	Chipbreaker	Cutting speed Vc (sfm)	Depth of cut ap (in)	Feed f (ipr)
P	Mild and low carbon steels 400SS, 1025, etc. < 180 HB	T9225	ML	330 - 990	0.025 - 0.100	0.025 - 0.100
	Carbon and alloy steels 1049, 4142, etc. < 300HB	T9215	ML	390 - 1150	0.025 - 0.100	0.025 - 0.100
M	Stainless steels 304, 316, etc. < 250 HB	T9225	ML	330 - 990	0.025 - 0.100	0.025 - 0.100
K	Gray and ductile cast irons No35B, 60-40-18, etc.	AH120	ML	330 - 820	0.025 - 0.100	0.025 - 0.100

When the side cutting edge is used for facing, the maximum feed is limited to within 0.040 ipr.