

Expansion with the latest grade **AH3225**,
high-feed geometry and cutter bodies





Cutter body lineup expansions for LNMX04 inserts

Now offering additional sizes of cylindrical, modular and shell mill cutter bodies for expanded application coverages



New high-feed geometry lineup with low cutting force

New

HL



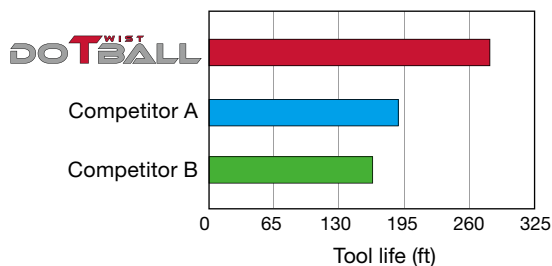
- Low cutting force (10% lower than HJ)
- Suitable for stainless steel and heat resistant alloys
- Suitable for long overhang

HJ



- Well-balanced geometry between sharpness and toughness
- Suitable for steel and cast iron
- Suitable for interrupted machining

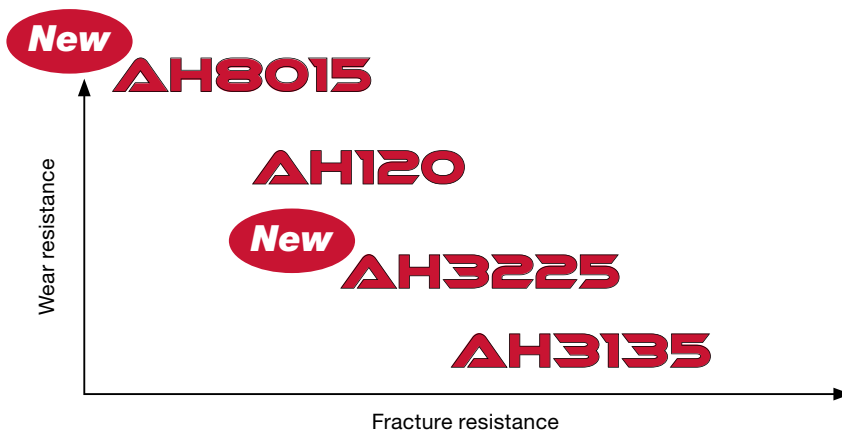
Tool life in stainless steel of HL geometry



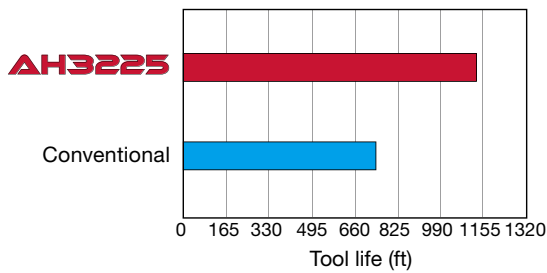
M

Cutter : EXLN04U1.00C1.00R03 ($\phi 1.000"$, $z = 1$)
 Insert : LNMX0405ZER-**HL** AH3135
 Workpiece material : 304SS (160HB)
 Cutting speed : $V_c = 490$ sfm
 Feed per tooth : $f_z = 0.031$ ipt
 Depth of cut : $a_p = 0.031"$
 Width of cut : $a_e = 0.394"$
 Coolant : Dry

New grades: AH3225 and AH8015



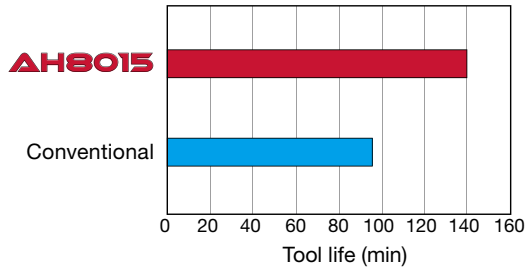
■ Tool life in alloy steel of AH3225



P

Cutter : EXLN04U1.00C1.00R03 ($\phi 1.000"$, $z = 1$)
 Insert : LNMX0405ZER-HJ **AH3225**
 Workpiece material : 304SS (300HB)
 Cutting speed : $V_c = 660$ sfm
 Feed per tooth : $f_z = 0.020$ ipt
 Depth of cut : $a_p = 0.039"$
 Width of cut : $a_e = 0.433"$
 Coolant : Dry

■ Tool life in heat resistant alloy of AH8015

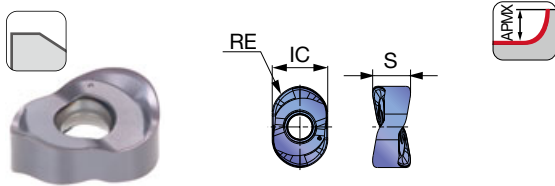


S

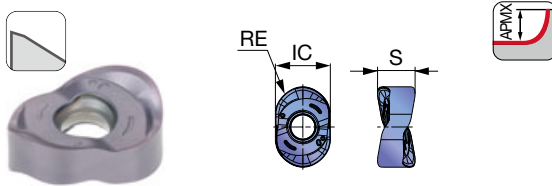
Cutter : EXLN04U1.00C1.00R03 ($\phi 1.000"$, $z = 1$)
 Insert : LNMX0405ZER-HJ **AH8015**
 Workpiece material : Inconel718 (40HRC)
 Cutting speed : $V_c = 98$ sfm
 Feed per tooth : $f_z = 0.008$ ipt
 Depth of cut : $a_p = 0.020"$
 Width of cut : $a_e = 0.512"$
 Coolant : Wet

INSERT

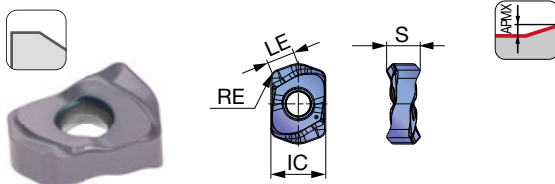
LNMX-MJ (Radius)



LNMX-ML (Radius)

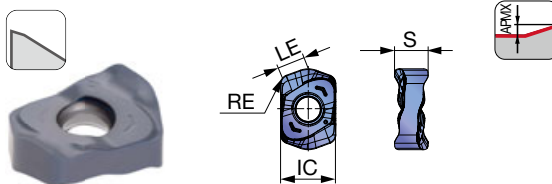


LNMX-HJ (High-feed)



New

LNMX-HL (High-feed)



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

★ : First choice
 ☆ : Second choice

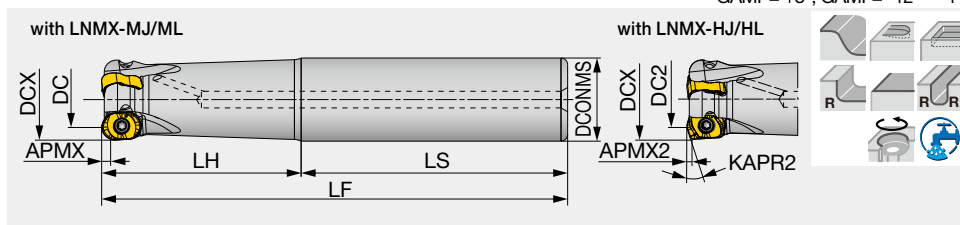
Designation	RE	APMX	Coated				LE	IC	S
			AH8015	AH3225	AH120	AH3135			
LNMX0405R4-MJ	0.157	0.157	●	●	●	●	-	0.323	0.220
LNMX0405R4-ML	0.157	0.157			●	●	-	0.323	0.220
LNMX0405ZER-HJ	0.051	0.051	●	●	●	●	0.172	0.323	0.197
New LNMX0405ZER-HL	0.051	0.051	●	●		●	0.172	0.323	0.197
LNMX0506R5-MJ	0.197	0.197	●	●	●	●	-	0.409	0.240
LNMX0607R6-MJ	0.236	0.236	●	●	●	●	-	0.496	0.291
LNMX0607ZER-HJ	0.079	0.079	●	●	●	●	0.264	0.500	0.283

● : New lineup

EXLN

Radius endmill, shank type, for 4-corner double sided inserts

GAMP= +3°, GAMF= -12° ~ -14°



	Inch	APMX	APMX2	DCX	CICT	DC	DC2	KAPR2	DCONMS	LS	LH	LF	WT(lb)	Air hole	Insert
	EXLN04U1.00C1.00R03	0.157	0.051	1.000	3	0.693	0.669	20°	1.000	3.000	2.500	5.500	1.00	With	LNMX04...
New	EXLN04U1.00C1.00R03L	0.157	0.051	1.000	3	0.693	0.669	20°	1.000	3.000	4.000	7.000	1.32	With	LNMX04...
	EXLN04U1.25C1.25R04	0.157	0.051	1.250	4	0.941	0.917	20°	1.250	3.000	3.000	6.000	1.80	With	LNMX04...
	EXLN04U1.25C1.25R05	0.157	0.051	1.250	5	0.941	0.917	20°	1.250	3.000	3.000	6.000	1.80	With	LNMX04...
New	EXLN04U1.25C1.25R05L	0.157	0.051	1.250	5	0.941	0.917	20°	1.250	3.000	5.000	8.000	2.38	With	LNMX04...
	EXLN06U1.25C1.25R02	0.236	0.079	1.250	2	0.758	0.746	25°	1.250	3.000	3.000	6.000	1.90	With	LNMX06...
	EXLN06U1.50C1.25R03	0.236	0.079	1.500	3	1.012	1.000	25°	1.250	4.000	2.000	6.000	2.06	With	LNMX06...
	Metric	APMX	APMX2	DCX	CICT	DC	DC2	KAPR2	DCONMS	LS	LH	LF	WT(kg)	Air hole	Insert
	EXLN04M020C20.0R02	4	1.3	20	2	12.2	11.6	20°	20	80	50	130	0.28	With	LNMX04...
New	EXLN04M020C20.0R02L	4	1.3	20	2	12.2	11.6	20°	20	80	80	160	0.34	With	LNMX04...
	EXLN04M025C25.0R03	4	1.3	25	3	17.2	16.6	20°	25	80	60	140	0.46	With	LNMX04...
New	EXLN04M025C25.0R03L	4	1.3	25	3	17.2	16.6	20°	25	80	100	180	0.6	With	LNMX04...
	EXLN04M032C32.0R04	4	1.3	32	4	24.2	23.6	20°	32	80	70	150	0.83	With	LNMX04...
	EXLN04M032C32.0R05	4	1.3	32	5	24.2	23.6	20°	32	80	70	150	0.83	With	LNMX04...
New	EXLN04M032C32.0R05L	4	1.3	32	5	24.2	23.6	20°	32	80	120	200	1.09	With	LNMX04...
	EXLN05M025C25.0R02	5	-	25	2	15	-	-	25	90	60	150	0.54	With	LNMX05...
	EXLN05M032C32.0R04	5	-	32	4	21.9	-	-	32	80	70	150	0.87	With	LNMX05...
	EXLN06M032C32.0R02	6	2	32	2	19.6	19.3	25°	32	80	70	150	0.9	With	LNMX06...
	EXLN06M040C32.0R04	6	2	40	4	27.6	27.3	25°	32	100	50	150	0.95	With	LNMX06...

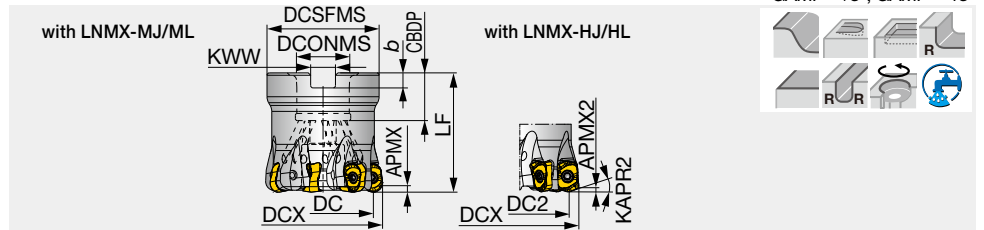
SPARE PARTS

Designation	Clamping screw	Mono block wrench	Torx bit	Grip
EXLN04...	CSPD-3	IP-10D	-	-
EXLN05...	CSPB-4S	-	BLDIP15/S7	H-TB2W
EXLN06...	CSPB-5	-	BLDIP20/S7	H-TB2W

*Recommended clamping torque: CSPD-3 = 1.84 lbs·ft, 2.5 N·m, CSPB-5 = 3.69 lbs·ft, 5 N·m

TXLN

Radius mill, for 4-corner double sided inserts



Inch	APMX	APMX2	DCX	CICT	DC	DC2	KAPR2	DCSFMS	LF	DCONMS	CBDF	KWW	b	WT(kg)	Air hole	Insert
TXLN04U1.50B0.50R06	0.157	0.051	1.500	6	1.193	1.169	20°	1.378	1.574	0.500	0.610	0.258	0.157	0.84	With	LNMX04...
TXLN04U2.00B0.75R07	0.157	0.051	2.000	7	1.693	1.669	20°	1.850	1.969	0.750	0.750	0.315	0.197	1.10	With	LNMX04...
TXLN06U2.00B0.75R05	0.236	0.079	2.000	5	1.511	1.499	25°	1.850	1.969	0.750	0.750	0.315	0.197	1.17	With	LNMX06...
TXLN06U2.50B0.75R06	0.236	0.079	2.500	6	2.009	1.997	25°	2.323	1.969	0.750	0.750	0.315	0.197	1.90	With	LNMX06...
TXLN06U3.00B1.00R07	0.236	0.079	3.000	7	2.510	2.498	25°	2.835	2.480	1.000	1.024	0.374	0.236	3.47	With	LNMX06...

Metric	APMX	APMX2	DCX	CICT	DC	DC2	KAPR2	DCSFMS	LF	DCONMS	CBDF	KWW	b	WT(kg)	Air hole	Insert
TXLN04M040B16.0R06	4	1.3	40	6	32.2	31.6	20	35	40	16	18	8.4	5.6	0.21	With	LNMX04...
New TXLN04M042B16.0R06	4	1.3	42	6	34.2	33.6	20	35	40	16	18	8.4	5.6	0.21	With	LNMX04...
TXLN04M050B22.0R07	4	1.3	50	7	42.2	41.6	20	47	50	22	20	10.4	6.3	0.45	With	LNMX04...
New TXLN04M052B22.0R07	4	1.3	52	7	44.2	43.6	20	47	50	22	20	10.4	6.3	0.47	With	LNMX04...
New TXLN04M063B22.0R07	4	1.3	63	7	55.2	54.6	20	59	50	22	20	10.4	6.3	0.76	With	LNMX04...
TXLN05M040B16.0R05	5	-	40	5	29.8	-	-	35	40	16	18	8.4	5.6	0.26	With	LNMX05...
TXLN05M050B22.0R06	5	-	50	6	39.8	-	-	47	50	22	20	10.4	6.3	0.5	With	LNMX05...
TXLN06M050B22.0R05	6	2	50	5	37.6	37.3	25	47	50	22	20	10.4	6.3	0.5	With	LNMX06...
TXLN06M052B22.0R05	6	2	52	5	39.6	39.3	25	49	50	22	20	10.4	6.3	0.55	With	LNMX06...
TXLN06M063B22.0R06	6	2	63	6	50.6	50.3	25	59	50	22	20	10.4	6.3	0.82	With	LNMX06...

SPARE PARTS



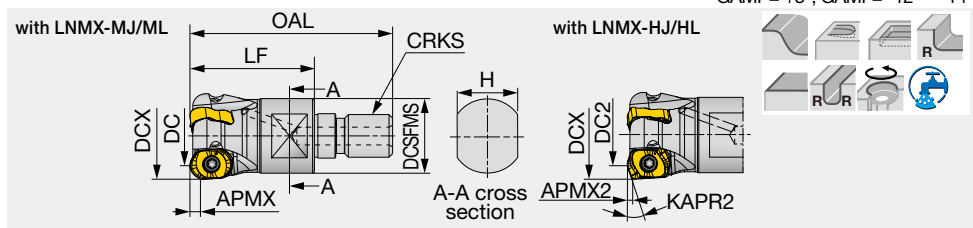
Designation	Clamping screw	Torx bit	Grip	Shell locking bolt (Optional parts)
TXLN04U1.50B0.50R06	CSPD-3	BLD IP10/S7	SW6-SD	(SR UNF 1/4X3/4 B18.3)
TXLN04U2.00B0.75R07	CSPD-3	BLD IP10/S7	SW6-SD	(C0.375X1.125H)
TXLN06U2.00B..., TXLN06U2.50B...	CSPB-5	BLDIP20/S7	H-TB2W	(C0.375X1.125H)
TXLN06U3.00B1.00R07	CSPB-5	BLDIP20/S7	H-TB2W	(C0.500X1.375H)
TXLN04M04*B16.0R06	CSPD-3	BLD IP10/S7	SW6-SD	FSHM8-30H
TXLN04M05*B22.0R07	CSPD-3	BLD IP10/S7	SW6-SD	CM10X30H
TXLN04M063B22.0R07	CSPD-3	BLD IP10/S7	SW6-SD	CM10X30H
TXLN05M040B16.0R05	CSPB-4S	BLDIP15/S7	H-TB2W	FSHM8-30H
TXLN05M050B22.0R06	CSPB-4S	BLDIP15/S7	H-TB2W	CM10X30H
TXLN06M050B22.0R05	CSPB-5	BLDIP20/S7	H-TB2W	FSHM10-40H
TXLN06M052B22.0R05	CSPB-5	BLDIP20/S7	H-TB2W	CM10X30H
TXLN06M063B22.0R06	CSPB-5	BLDIP20/S7	H-TB2W	CM10X30H

*Recommended clamping torque: CSPD-3 = 1.84 lbs·ft, 2.5 N·m, CSPB-4S = 2.58 lbs·ft, 3.5 N·m, CSPB-5 = 3.69 lbs·ft, 5 N·m

TUNGFLEX

HXLN04-M

Radius endmill, modular type, for 4-corner double sided inserts (TungFlex)



Metric	APMX	APMX2	DCX	CICT	DC	DC2	KAPR2	OAL	LF	H	DCSFMS	CRKS	WT(kg)	Air hole	Insert
HXLN04M020M10R02	4	1.3	20	2	12.2	11.6	20°	49	30	15	18	M10	0.07	With	LNMJ04...
HXLN04M025M12R03	4	1.3	25	3	17.2	16.6	20°	57	35	17	21	M12	0.16	With	LNMJ04...
HXLN04M032M16R04	4	1.3	32	4	24.2	23.6	20°	63	40	22	29	M16	0.2	With	LNMJ04...
New HXLN04M032M16R05	4	1.3	32	5	24.2	23.6	20°	63	40	22	29	M16	0.2	With	LNMJ04...
New HXLN04M040M16R06	4	1.3	40	6	32.2	31.6	20°	63	40	22	29	M16	0.24	With	LNMJ04...
HXLN05M025M12R02	5	-	25	2	15	-	-	57	35	17	21	M12	0.1	With	LNMJ05...
HXLN05M032M16R04	5	-	32	4	21.9	-	-	63	40	22	28.8	M16	0.2	With	LNMJ05...
HXLN06M032M16R02	6	2	32	2	19.6	19.3	25°	63	40	22	28.8	M16	0.24	With	LNMJ06...

SPARE PARTS

Designation	Clamping screw	Mono block wrench	Torx bit	Grip
HXLN04...	CSPD-3	IP-10D	-	-
HXLN05...	CSPB-4S	-	BLDIP15/S7	H-TB2W
HXLN06...	CSPB-5	-	BLDIP20/S7	H-TB2W

· Recommended clamping torque (N·m): CSPD-3=2.5, CSPB-4S=3.5, CSPB-5=5

STANDARD CUTTING CONDITIONS FOR RADIUS (MJ, ML)

ISO	Workpiece material	Hardness	Priority	Grade	Chip-breaker	Cutting speed Vc (sfm)	Feed per tooth fz (ipt)
P	Low carbon steel 1015, 1020, etc.	- 200 HB	First choice	AH3225	MJ	328 - 984	0.008 - 0.024
		- 200 HB	Low cutting force	AH3135	ML	328 - 984	0.008 - 0.024
	Carbon steel, Alloy steel 1055, 4140, etc.	- 300 HB	First choice	AH3225	MJ	328 - 820	0.008 - 0.024
		- 300 HB	Low cutting force	AH3135	ML	328 - 820	0.008 - 0.024
M	Prehardened steel NAK80, PX5, etc.	30 - 40 HRC	First choice	AH3225	MJ	328 - 656	0.006 - 0.016
		30 - 40 HRC	Low cutting force	AH3135	ML	328 - 656	0.006 - 0.016
	Austenitic Stainless steel 304SS, 316SS, etc.	- 200 HB	First choice	AH3135	MJ	328 - 656	0.008 - 0.024
		- 200 HB	Low cutting force	AH3135	ML	328 - 656	0.008 - 0.024
K	Martensitic Stainless steel 420SS etc.	- 200 HB	First choice	AH3135	ML	328 - 984	0.008 - 0.024
		- 200 HB	Fracture resistance	AH3135	MJ	328 - 984	0.008 - 0.024
	Gray cast iron Class 25, Class 30, etc.	150 - 250 HB	First choice	AH120	MJ	328 - 984	0.008 - 0.024
		150 - 250 HB	Fracture resistance	AH3225	MJ	328 - 984	0.008 - 0.024
S	Ductile cast iron 60-40-18, 80-55-06, etc.	150 - 250 HB	First choice	AH120	MJ	262 - 820	0.008 - 0.024
		150 - 250 HB	Fracture resistance	AH3225	MJ	262 - 820	0.008 - 0.024
	Titanium alloy Ti-6Al-4V, etc.	-	First choice	AH3135	ML	98 - 197	0.006 - 0.024
		-	Fracture resistance	AH3135	MJ	98 - 197	0.006 - 0.024
H	Superalloys Inconel718, etc.	-	First choice	AH8015	MJ	66 - 164	0.002 - 0.012
		-	Low cutting force	AH120	ML	66 - 164	0.002 - 0.012
	Hardened steel	H13, etc.	First choice	AH3225	MJ	164 - 492	0.004 - 0.012
		D2, etc.	Wear resistance	AH8015	MJ	164 - 492	0.004 - 0.012
		50 - 60 HRC	First choice	AH8015	MJ	164 - 230	0.002 - 0.006

· When using a long shank or modular head with long overhang, please lower the cutting conditions (Vc, fz, ap) to 70% of the maximum conditions for the standard shank.

STANDARD CUTTING CONDITIONS FOR HIGH-FEED (HJ, HL)

LNMX04-HJ/HL

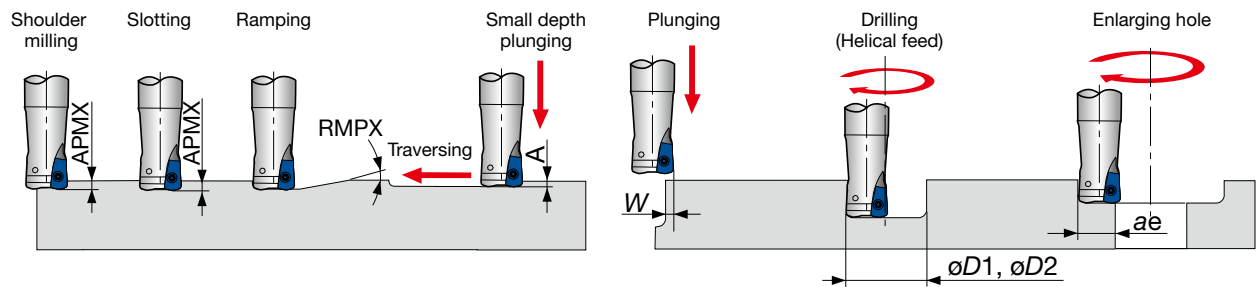
ISO	Workpiece material	Hardness	Priority	Grade	Chip-breaker	Cutting speed Vc (sfm)	Feed per tooth fz (ipt)
P	Low carbon steel 1015, 1020, etc.	- 300HB	First choice	AH3225	HJ	328 - 984	0.020 - 0.051
			Wear resistance	AH8015	HJ		0.016 - 0.039
			Low cutting force	AH3225	HL		
	Carbon steel, Alloy steel 1055, 4140, etc.	- 300HB	First choice	AH3225	HJ	328 - 820	0.020 - 0.051
			Wear resistance	AH8015	HJ		0.016 - 0.039
			Low cutting force	AH3225	HL		
M	Prehardened steel NAK80, PX5, etc.	30 - 40HRC	First choice	AH3225	HJ	328 - 656	0.016 - 0.039
			Wear resistance	AH8015	HJ		0.008 - 0.031
			Low cutting force	AH3225	HL		
	Austenitic Stainless steel 304SS, 316SS, etc.	- 200HB	First choice	AH3135	HL	328 - 656	0.012 - 0.035
			Fracture resistance	AH3135	HJ		0.012 - 0.035
			First choice	AH3135	HL		
K	Martensitic Stainless steel 420SS, etc.	- 200HB	First choice	AH3135	HL	328 - 984	0.012 - 0.035
			Fracture resistance	AH3135	HJ		0.012 - 0.035
			First choice	AH3135	HL		
	Gray cast iron Class 25, Class 30, etc.	150 - 250HB	First choice	AH120	HJ	328 - 984	0.020 - 0.051
			Fracture resistance	AH3225	HJ		0.020 - 0.051
			First choice	AH120	HJ		
S	Ductile cast iron 60-40-18, 80-55-06, etc.	150 - 250HB	First choice	AH120	HJ	262 - 820	0.020 - 0.051
			Fracture resistance	AH3225	HJ		0.020 - 0.051
			First choice	AH120	HJ		
	Titanium alloy Ti-6Al-4V, etc.	150 - 250HB	First choice	AH3135	HL	98 - 197	0.012 - 0.028
			Fracture resistance	AH3135	HJ		0.012 - 0.028
			First choice	AH3135	HL		
H	Superalloys Inconel718, etc.	150 - 250HB	First choice	AH8015	HL	66 - 164	0.004 - 0.012
			Fracture resistance	AH8015	HJ		0.004 - 0.012
			First choice	AH8015	HJ		
	Hardened steel H13, etc.	40 - 50HRC	First choice	AH3225	HJ	164 - 492	0.004 - 0.020
			Wear resistance	AH8015	HJ		0.004 - 0.020
			First choice	AH8015	HJ		
H	D2, etc.	50 - 60HRC	First choice	AH8015	HJ	164 - 230	0.002 - 0.008
			First choice	AH8015	HJ		0.002 - 0.008
			First choice	AH8015	HJ		

LNMX06-HJ

ISO	Workpiece material	Hardness	Priority	Grade	Chip-breaker	Cutting speed Vc (sfm)	Feed per tooth fz (ipt)
P	Low carbon steel 1015, 1020, etc.	- 300HB	First choice	AH3225	HJ	328 - 984	0.012 - 0.043
			Wear resistance	AH8015	HJ		0.012 - 0.043
			First choice	AH3225	HJ		
	Carbon steel, Alloy steel 1055, 4140, etc.	- 300HB	Wear resistance	AH8015	HJ	328 - 820	0.012 - 0.043
			First choice	AH3225	HJ		0.008 - 0.028
			Wear resistance	AH8015	HJ		
M	Prehardened steel NAK80, PX5, etc.	30 - 40HRC	First choice	AH3225	HJ	328 - 656	0.008 - 0.028
			Wear resistance	AH8015	HJ		0.008 - 0.028
			First choice	AH3225	HJ		
	Austenitic Stainless steel 304SS, 316SS, etc.	- 200HB	First choice	AH3135	HJ	328 - 656	0.008 - 0.028
			First choice	AH3135	HJ		0.008 - 0.028
			First choice	AH3135	HJ		
K	Martensitic Stainless steel 420SS, etc.	- 200HB	First choice	AH3135	HJ	328 - 984	0.008 - 0.028
			First choice	AH3135	HJ		0.008 - 0.028
			First choice	AH3135	HJ		
	Gray cast iron Class 25, Class 30, etc.	150 - 250HB	First choice	AH120	HJ	328 - 984	0.012 - 0.043
			Fracture resistance	AH3225	HJ		0.012 - 0.043
			First choice	AH120	HJ		
S	Ductile cast iron 60-40-18, 80-55-06, etc.	150 - 250HB	Fracture resistance	AH3225	HJ	262 - 820	0.012 - 0.043
			First choice	AH3225	HJ		0.012 - 0.043
			First choice	AH3225	HJ		
	Titanium alloy Ti-6Al-4V, etc.	150 - 250HB	First choice	AH3135	HJ	98 - 197	0.006 - 0.024
			First choice	AH3135	HJ		0.006 - 0.024
			First choice	AH3135	HJ		
H	Superalloys Inconel718, etc.	150 - 250HB	First choice	AH8015	HJ	66 - 164	0.002 - 0.012
			First choice	AH8015	HJ		0.002 - 0.012
			First choice	AH8015	HJ		
	Hardened steel H13, etc.	40 - 50HRC	First choice	AH3225	HJ	164 - 492	0.004 - 0.012
			Wear resistance	AH8015	HJ		0.004 - 0.012
			First choice	AH8015	HJ		
H	D2, etc.	50 - 60HRC	First choice	AH8015	HJ	164 - 230	0.002 - 0.006
			First choice	AH8015	HJ		0.002 - 0.006
			First choice	AH8015	HJ		

· When using a long shank or modular head with long overhang, lower the cutting conditions (Vc, fz, ap) to 70% of the maximum conditions for the standard shank.

MACHINING APPLICATIONS



MJ, ML

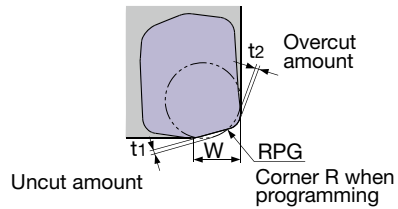
	Inch	DCX	Max. depth of cut APMX	Max. ramping angle RMPX	Max. plunging A	Max. cutting width in plunging W	Min. machining dia. øD1	Max. machining dia. øD2	Max. cutting width in enlarging ae
New	EXLN04U1.00...	1.000	0.157	3°	0.031	0.157	1.535	1.929	0.803
New	EXLN04U1.25...	1.250	0.157	1.9°	0.031	0.157	2.047	2.402	1.053
	EXLN04U1.25C1.25R05	1.250	0.157	1.9°	0.031	0.157	2.047	2.402	1.053
	TXLN04U1.50B0.50R06	1.500	0.157	1.2°	0.024	0.157	2.511	2.905	1.342
	TXLN04U2.00B0.75R07	2.000	0.157	1°	0.027	0.157	3.496	3.889	1.842
	HXLN04M020M10R02	0.787	0.157	4.7°	0.031	0.157	1.102	1.496	0.591
	HXLN04M025M12R03	0.984	0.157	3°	0.031	0.157	1.496	1.890	0.787
	HXLN04M032M16R04	1.260	0.157	2°	0.031	0.157	2.047	2.441	1.063
	EXLN06U1.25C01.25R02	1.250	0.236	3.7°	0.039	0.394	1.732	2.421	0.827
	EXLN06U1.50C01.25R03	1.500	0.236	4°	0.067	0.394	2.165	2.921	1.063
	TXLN06U2.00B0.75R05	2.000	0.236	2.7°	0.067	0.394	3.150	3.921	1.575
	TXLN06U2.50B0.75R06	2.500	0.236	2.3°	0.079	0.394	4.134	4.921	2.047
	TXLN06U3.00B1.00R07	3.000	0.236	1.6°	0.071	0.394	5.157	5.921	2.559

HJ, HL

	Inch	DCX	Max. depth of cut APMX	Max. ramping angle RMPX	Max. plunging A	Max. cutting width in plunging W	Min. machining øD1	Max. machining øD2	Max. cutting width in enlarging ae
	EXLN04U1.00C1.00R03	1.000	0.051	3°	0.030	0.161	1.496	1.929	0.803
	EXLN04U1.25C1.25R04	1.250	0.051	2°	0.030	0.161	2.008	2.441	1.053
	EXLN04U1.25C1.25R05	1.250	0.051	2°	0.030	0.161	2.008	2.441	1.053
	TXLN04U1.50B0.50R06	1.500	0.157	1.3°	0.024	0.161	2.456	2.905	1.342
	TXLN04U2.00B0.75R07	2.000	0.157	1°	0.027	0.161	3.456	3.889	1.842
	HXLN04M020M10R02	0.787	0.051	4.9°	0.030	0.161	1.063	1.496	0.610
	HXLN04M025M12R03	0.984	0.051	3°	0.030	0.161	1.457	1.890	0.807
	HXLN04M032M16R04	1.260	0.051	2°	0.030	0.161	2.008	2.441	1.083
	EXLN06U1.25C01.25R02	1.250	0.079	5.7°	0.055	0.433	1.614	2.421	0.787
	EXLN06U1.50C01.25R03	1.500	0.079	4.3°	0.059	0.433	2.087	2.921	1.024
	TXLN06U2.00B0.75R05	2.000	0.079	2.7°	0.063	0.433	3.110	4.000	1.535
	TXLN06U2.50B0.75R06	2.500	0.079	2°	0.067	0.433	4.094	4.921	2.008
	TXLN06U3.00B1.00R07	3.000	0.079	1.4°	0.067	0.433	5.079	5.921	2.520

■ TOOL GEOMETRY ON PROGRAMMING FOR HIGH-FEED (HJ, HL)

The following table shows the amount left uncut (t1) and overcut (t2).



	Max. depth of cut APMX (in)	W (in)	Programmed corner R (in)	Amount left uncut t1 (in)	Amount left overcut t2 (in)
LNMX04-HJ LNMX04-HL	0.051	0.161	R0.059	0.031	-
	0.051	0.161	R0.079	0.026	-
	0.051	0.161	R0.098	0.020	0.002
LNMX06-HJ	0.051	0.161	R0.118	0.014	0.008
	0.079	0.236	R0.079	0.055	-
	0.079	0.236	R0.118	0.043	-
	0.079	0.236	R0.138	0.036	-
	0.079	0.236	R0.157	0.029	0.002
	0.079	0.236	R0.197	0.016	0.014

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