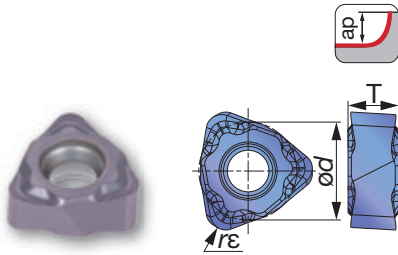


## INSERT

### WXHU-MJ



Designation	Max. ap	IC dia	T	rε	AH110	
WXHU040305R-MJ	0.5	6.35	3.18	0.5	●	●
WXHU040310R-MJ	1	6.35	3.18	1	●	●
					<b>P</b>	<b>H</b>

\* For plunging, depth up to 2 mm is possible.

● First choice

## STANDARD CUTTING CONDITIONS

ISO	Workpiece materials	Hardness (HB)	Grades	Cutting speed Vc (m/min)	Feed per tooth fz (mm/t)
<b>P</b>	High carbon steel (S45C / C45, S55C / C55, etc.)	200 - 300	AH110	100 - 300	0.1 - 0.3
	Alloy steel (SCM440 / 42CrMo4, SCr145, etc.)	150 - 300	AH110	100 - 300	0.1 - 0.3
	Prehardened steel (NAK80, PX5, etc.)	-	AH110	100 - 300	0.05 - 0.3
<b>H</b>	Hardened steel	(SKD61 / X40CrMoV5-1, etc.)	AH110	80 - 130	0.1 - 0.3
		(SKD11 / X153CrMoV12, etc.)	AH110	50 - 100	0.05 - 0.15