

PVD grade: AH725

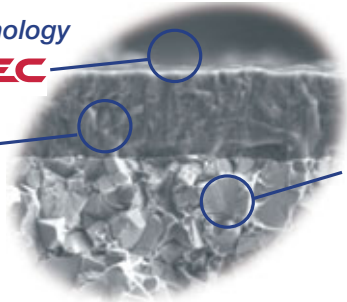
AH725 features a super tough substrate with a new PVD coating layer.

Special surface technology

PREMIUMTEC

Excellent adhesion strength of coating layer

PVD coating



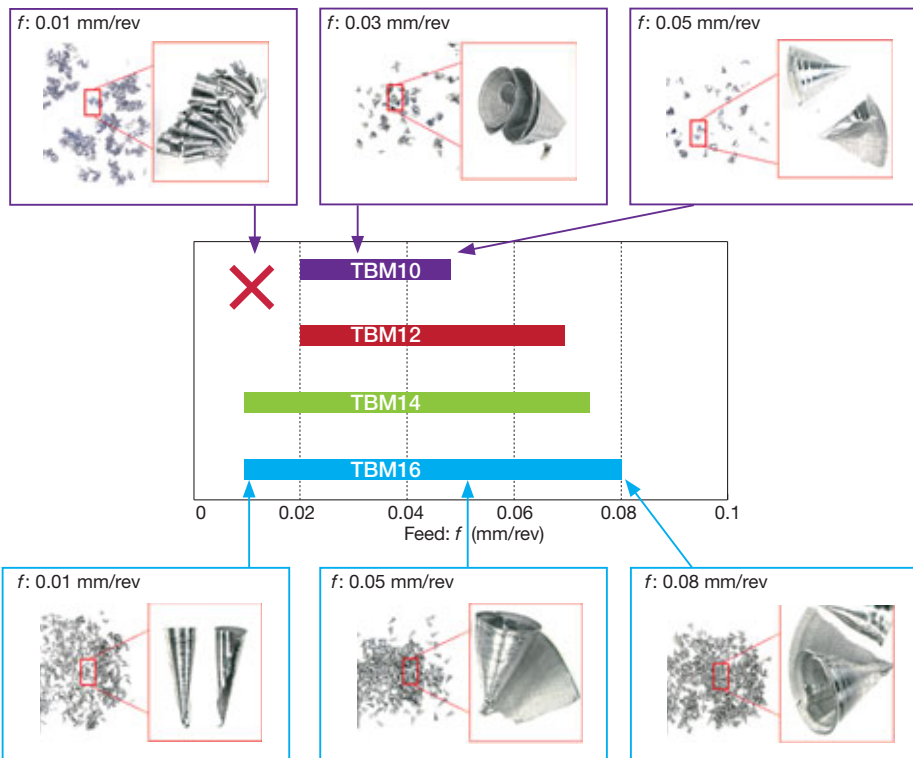
Remarkable toughness
Fine grain carbide

Standard cutting conditions and chip control for drilling

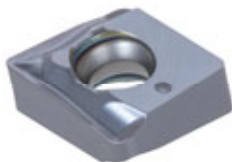
DMIN	Description		Feed: <i>f</i> (mm/rev)	Cutting speed: <i>V_c</i> (m/min)	
	Holder	Insert		Carbon steel, Alloy steel	Stainless steel
ø10	TBM10R/LF12-2.25	XOMU05X204-PS	0.02 - 0.050	50 - 180 m/min	50 - 160 m/min
ø12	TBM12R/LF16-2.25	XOMU06H204-PS	0.02 - 0.070		
ø14	TBM14R/LF16-2.25	XOMU07H304-PS	0.01 - 0.075		
ø16	TBM16R/LF20-2.25	XOMU08T304-PS	0.01 - 0.080		



Drilling



Please adjust the center height of the tool post before use



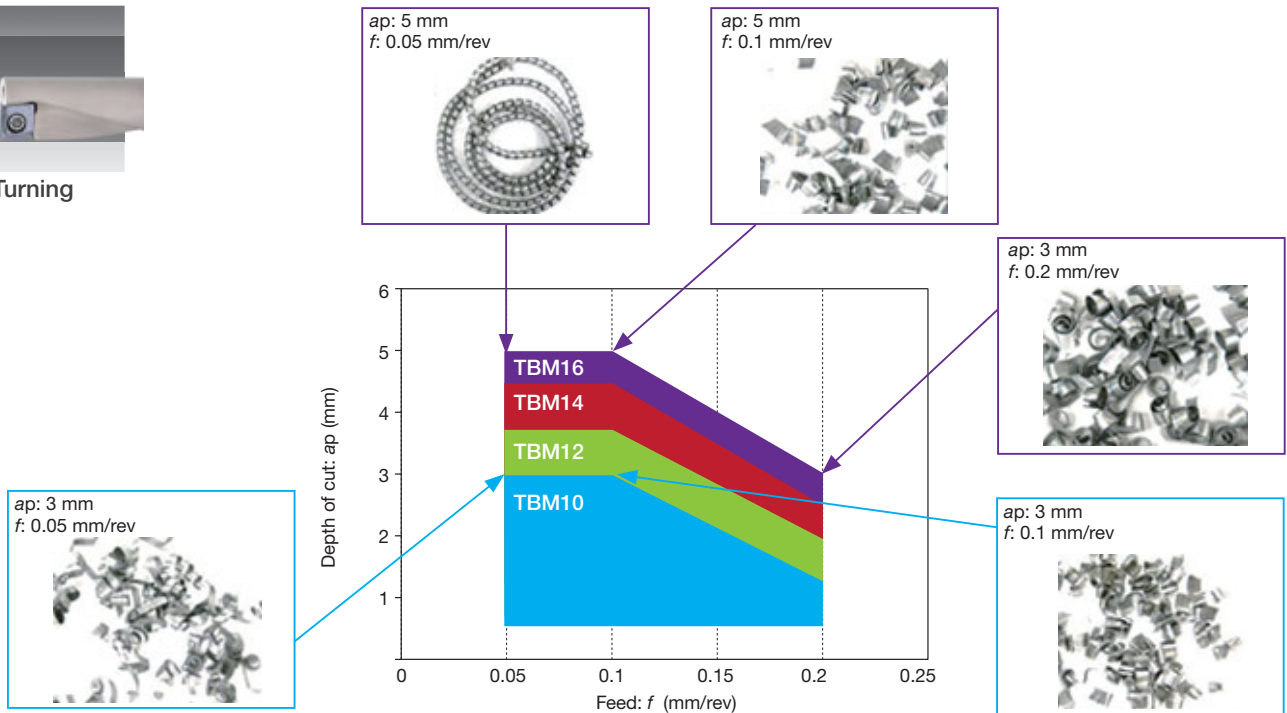
Improved chip evacuation during drilling by optimizing rake angle and breaker width. (2 corner)

Standard cutting conditions and chip control for turning

DMIN	Description		Depth of cut: a_p (mm)	Feed: f (mm/rev)	Cutting speed: V_c (m/min)	
	Holder	Insert			Carbon steel, Alloy steel	Stainless steel
ø10	TBM10R/LF12-2.25	XOMU05X204-PS	0.5 - 3.0	0.05 - 0.2	50 - 180 m/min	50 - 160 m/min
ø12	TBM12R/LF16-2.25	XOMU06H204-PS	0.5 - 3.5			
ø14	TBM14R/LF16-2.25	XOMU07H304-PS	0.5 - 4.5			
ø16	TBM16R/LF20-2.25	XOMU08T304-PS	0.5 - 5.0			



Turning



The first protrusion is effective for improving chip control at low feed rate machining.

