16320 | 16420

TETRAFEED

Double-sided high feed milling solution

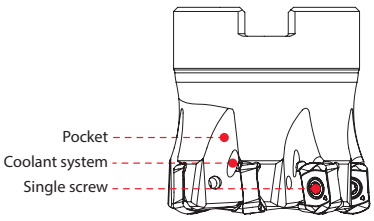
MILLING

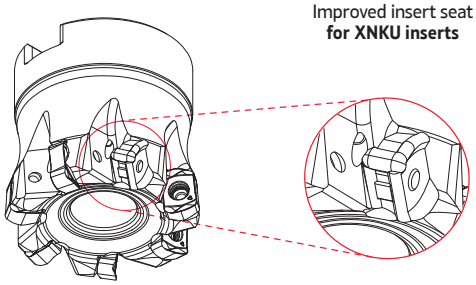
Facing | Profiling | Copying

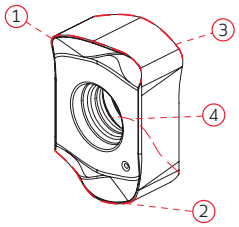
SINCE 1916

TETRAFEED 16320 | 16420

The Tetrafeed line is expanding! With XNKU 06 and XNKU 12, there are no limits for high feed machining of either small or large sized components. The 4 cutting edge negative insert enables you to achieve feeds of up to 1,5mm/t and depth of cut up to 1,5 mm, leading to higher productivity.



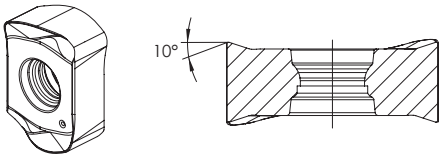




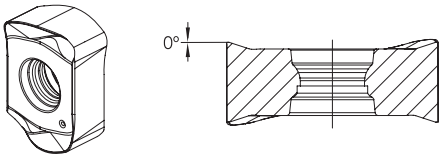
NEW XNKU 06T3 | 1205

P M K S

XNKU 06T310-MP



XNKU 06T310-MS



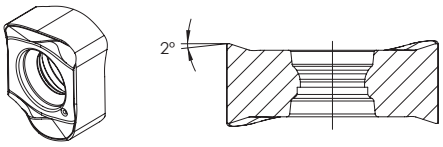
INSERT SIZE 06 | XNKU 06T3

XNKU-MP

NEW XNKU-MS

P M K S

XNKU 120516-MP

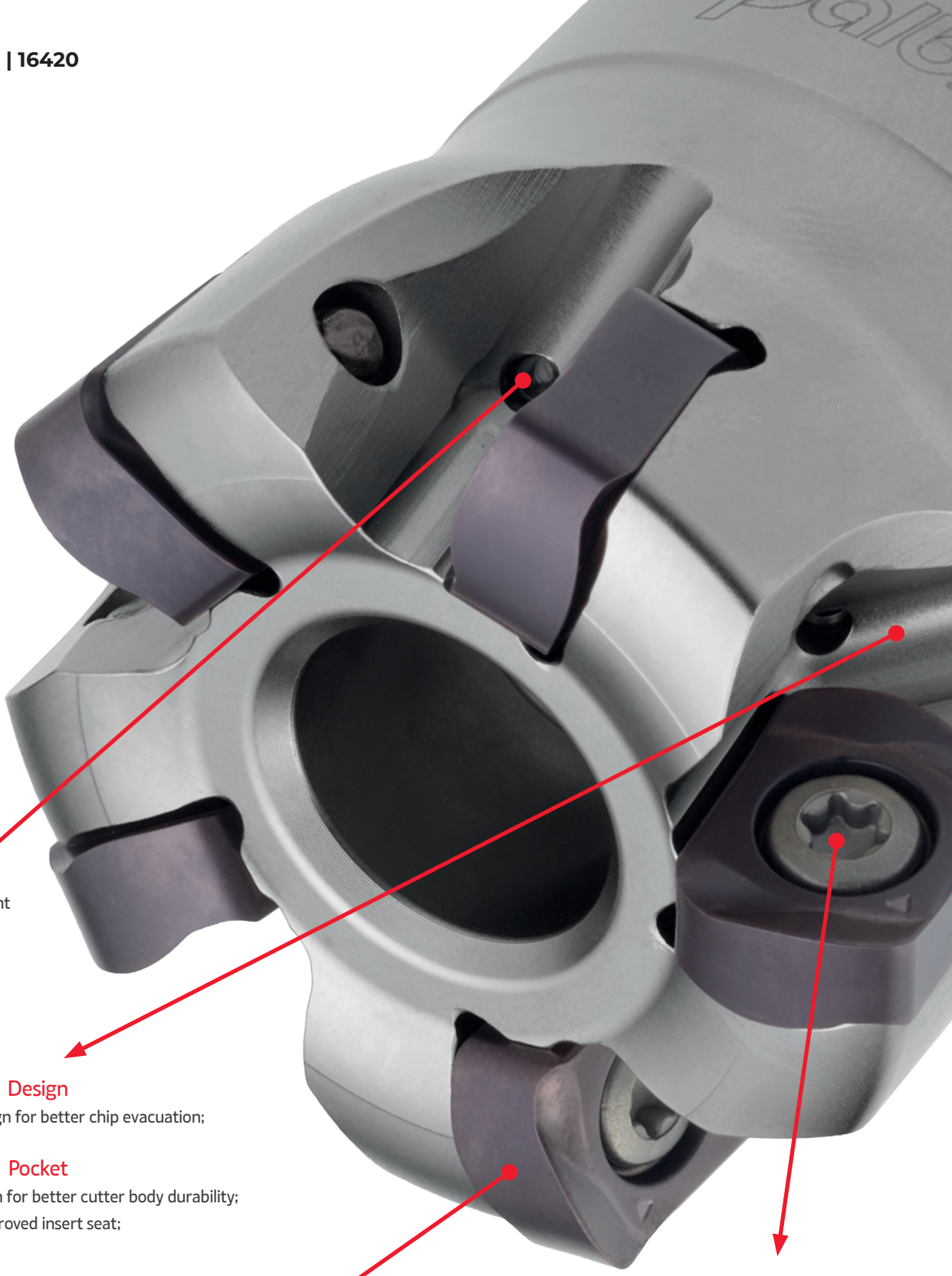


INSERT SIZE 12 | XNKU 1205

NEW XNKU-MP

GEOMETRY FEATURES Características geométricas | Características geométricas

Geometry	Features | Características | Características
Geometry MP General machining	Geometry with a reinforced cutting edge for general applications on different materials.
Geometry MS General machining	Geometry for stainless steel and HRSA. Suitable for alloy steel machining.



Internal coolant system

Design
- Optimized design for better chip evacuation;

Pocket
- Strong pocket design for better cutter body durability;
- Improved insert seat;

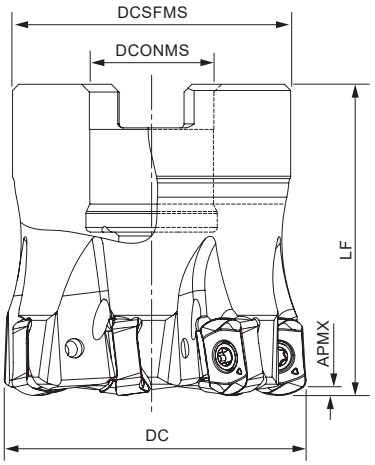
Insert Width
- Robust insert with large cross section;

Bigger screw size to whitstand loads of demanding operations

Cutting edge
- Improved cutting edge;
- Improved wear resistance;

Double-sided insert
- Double-sided insert with 4 cutting edges;

TETRAFEED 16320

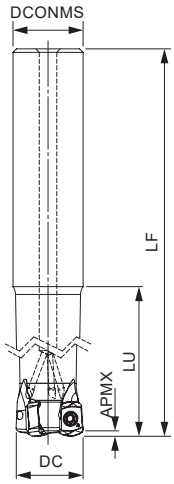


Arbor Mounting

KAPR=20° | GAMP=-7° | RP=1,8

Order code Código	Reference Referência Referencia	CICT	Dimensions | Dimensões | Dimensiones (mm)				WT	Specifications		Insert	Stock
			DC	DCONMS	DCSFMS	LF		Arbor Type	APMX (mm)		
181206300	032A16320-05-07-016040	5	32	16	30	40	0,14	A	1,00	XNKU 06...	◈
181218600	040A16320-05-07-016040	5	40	16	36	40	0,20	A	1,00	XNKU 06...	◈
181152300	040A16320-07-07-016040	7	40	16	36	40	0,20	A	1,00	XNKU 06...	◈
181157500	050A16320-06-07-022040	6	50	22	42	40	0,25	A	1,00	XNKU 06...	◈
181152400	050A16320-08-07-022040	8	50	22	42	40	0,29	A	1,00	XNKU 06...	◈
181152500	052A16320-08-07-022040	8	52	22	42	40	0,39	A	1,00	XNKU 06...	◈
181152600	063A16320-09-07-022040	9	63	22	48	40	0,50	A	1,00	XNKU 06...	◈
181177800	080A16320-10-07-027050	10	80	27	60	50	0,95	A	1,00	XNKU 06...	◈

◈ Stock item | Produto de stock | Itens de stock ◯ Available under request | Disponível sobre consulta | Disponible bajo consulta



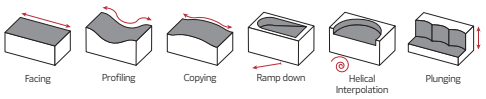
Cylindrical Shank

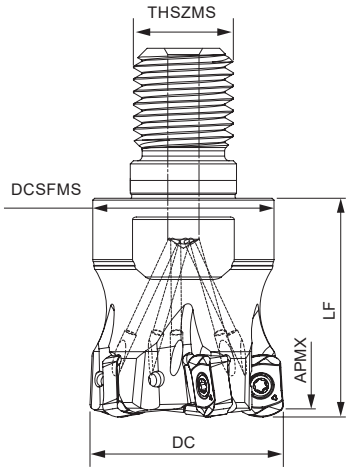
KAPR=20° | GAMP=-7° | RP=1,8

Order code Código	Reference Referência Referencia	CICT	Dimensions | Dimensões | Dimensiones (mm)				WT	Specifications	Insert	Stock
			DC	DCONMS	LF	LU		APMX (mm)		
181183700	016E16320-02-07-016100	2	16	16	100	30	0,19	1,00	XNKU 06...	◈
181171900	016E16320-02-07-016150	2	16	16	150	50	0,19	1,00	XNKU 06...	◇
181183800	020E16320-03-07-020130	3	20	20	130	50	0,30	1,00	XNKU 06...	◈
181183400	020E16320-03-07-020160	3	20	20	160	80	0,30	1,00	XNKU 06...	◇
181183900	025E16320-04-07-025140	4	25	25	140	60	0,54	1,00	XNKU 06...	◈
181183500	025E16320-04-07-025180	4	25	25	180	100	0,54	1,00	XNKU 06...	◇
181172200	032E16320-05-07-032150	5	32	32	150	60	1,00	1,00	XNKU 06...	◈
181183600	032E16320-05-07-032200	5	32	32	200	120	1,00	1,00	XNKU 06...	◇

◈ Stock item | Produto de stock | Itens de stock
◇ Stock available until sold out | Stock disponível até acabar o stock | Stock disponible hasta acabar el stock
◯ Available under request | Disponível sobre consulta | Disponible bajo consulta

TETRAFEED 16320
XNKU 06



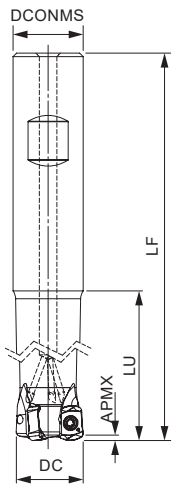


Threaded Coupling

KAPR=20° | GAMP=-7° | RP=1,8

Order code Código	Reference Referência Referencia	CICT	Dimensions | Dimensões | Dimensiones (mm)				WT	Specifications	Insert	Stock
			DC	THSZMS	DCSFMS	LF		APMX (mm)		
181151300	016R16320-02-07-M08025	2	16	M08	13	25	0,02	1,00	XNKU 06...	◈
181151400	020R16320-03-07-M10028	3	20	M10	18	28	0,05	1,00	XNKU 06...	◈
181151500	025R16320-04-07-M12035	4	25	M12	21	35	0,07	1,00	XNKU 06...	◈
181148000	032R16320-05-07-M16035	5	32	M16	29	35	0,16	1,00	XNKU 06...	◈
181178600	035R16320-05-07-M16035	5	35	M16	29	35	0,16	1,00	XNKU 06...	◈
181151600	035R16320-06-07-M16035	6	35	M16	29	35	0,17	1,00	XNKU 06...	◈
181151700	040R16320-05-07-M16045	5	40	M16	29	45	0,24	1,00	XNKU 06...	◈
181178500	040R16320-06-07-M16035	6	40	M16	29	35	0,23	1,00	XNKU 06...	◈
181151800	042R16320-07-07-M16035	7	42	M16	29	35	0,24	1,00	XNKU 06...	◈

◈ Stock item | Produto de stock | Itens de stock ◯ Available under request | Disponível sobre consulta | Disponible bajo consulta



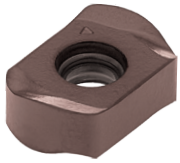
Weldon Shank

KAPR=20° | GAMP=-7° | RP=1,8

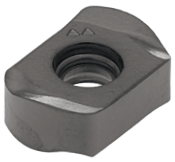
Order code Código	Reference Referência Referencia	CICT	Dimensions | Dimensões | Dimensiones (mm)				WT	Specifications	Insert	Stock
			DC	DCONMS	LF	LU		APMX (mm)		
181161000	016W16320-02-07-016150	2	16	16	150	50	0,19	1,00	XNKU 06...	◈
181151900	020W16320-03-07-020160	3	20	20	160	90	0,29	1,00	XNKU 06...	◈
181152000	025W16320-04-07-025180	4	25	25	180	100	0,40	1,00	XNKU 06...	◈
181152100	032W16320-05-07-032200	5	32	32	200	120	1,10	1,00	XNKU 06...	◈

◈ Stock item | Produto de stock | Itens de stock ◯ Available under request | Disponível sobre consulta | Disponible bajo consulta

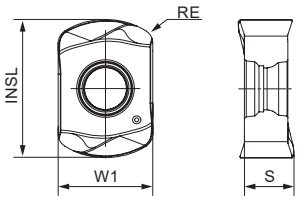
XNKU 06T3... Inserts | Pastilhas | Plaquitas



XNKU-MP



XNKU-MS



XNKU-MP | MS

		P					M				K		S			Dimensions Dimensões Dimensiones (mm)			
		CVD	PVD				CVD	PVD			CVD	PVD	CVD	PVD					
	(2) Grade code	T9	X5	T1	P4	Z2	T9	X9	Z2	Z3	T9	T1	T9	X9	Z3				
(1) Geometry code	ISO Reference	PHS740	PHP910	PHP920	PHP930	PHP530	PHS740	PHH930	PHP530	PHH530	PHS740	PHP920	PHS740	PHH930	PHH530	W1	S	INSL	RE
1112802	XNKU 06T310-MP	◎	◎	◉	◎		◎	◉			◎	◉	◎	◉		6,85	3,60	10,00	1,00
1113209	XNKU 06T310-MS					◉			◎	◉					◉	6,85	3,60	10,00	1,00

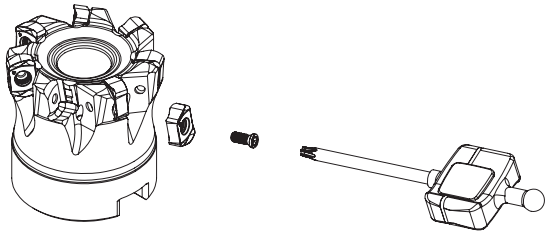
◉ First choice | Primeira opção | 1ª opción ◎ Stock item | Produto de stock | Itens de stock ○ Available under request | Disponível sobre consulta Disponible bajo consulta

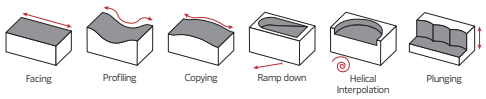
Insert order code = (1) Geometry Code + (2) Grade Code

SPARE PARTS Acessórios | Repuestos

Order separately

Cutter DC	Insert Screw	Key (Torx)	Key (Torx - Nm)	Torque Value
				Nm
A16320 - 32-80	P0250704	XT08	DT0812	1,20
R16320 - 20-42	P0250704	XT08	DT0812	1,20
W16320 - 20-32	P0250704	XT08	DT0812	1,20





RECOMMENDED CUTTING CONDITIONS Condições de corte recomendadas | Condiciones de corte recomendables

ISO	PSM	Material	HB (Brinell)	Vc (m/min) ← Wear Resistance Toughness →							Feed fz (mm/t)	
				PHP910	PHP920	PHP930	PHH930	PHS740	PHP530	PHH530	XNKU 06...-MP	XNKU 06...-MS
P	1	Unalloyed Steel	125-220	180-250	180-250	160-230	-	160-230	180-340	-	0,50-1,50	0,50-1,50
	2	Low-Alloyed Steel	220-280	160-240	170-210	150-190	-	150-190	180-340	-	0,50-1,50	0,50-1,50
	3	High-Alloyed Steel	280-380	140-230	160-200	140-180	-	140-180	180-330	-	0,50-1,50	0,50-1,50
M	4	SS - Ferritic / Martensitic	200-330	-	-	-	130-170	120-180	150-270	170-280	0,50-1,40	0,50-1,40
	5	SS - Austenitic	200-330	-	-	-	100-160	100-150	-	160-280	0,50-1,40	0,50-1,40
	6	SS - Austenitic-ferritic (Duplex)	230-260	-	-	-	80-140	70-130	-	150-260	0,50-1,40	0,50-1,40
K	7	Malleable Cast Iron	130-230	180-300	180-320	-	-	160-300	-	-	0,50-1,50	-
	8	Grey Cast Iron	180-245	160-250	170-280	-	-	150-260	-	-	0,50-1,50	-
	9	Nodular Cast iron	160-250	150-210	100-240	-	-	80-220	-	-	0,50-1,50	-
S	11	Heat Resistant Super Alloys	200-320	-	-	-	30-75	30-70	-	30-150	0,50-1,30	0,50-1,30

(Note 1) Cutting conditions $a_e/Dc=70\%$.
(Note 2) It's possible to occur vibrations in certain cases. Please reduce depth of cut and / or reduce cutting conditions in following cases:
- When using long shank;
- When using long tool overhang with arbor type;
- When application has poor clamping rigidity or when using a low rigidity machine.

(Note 3) When using DC=16mm apply 70% or less feed (fz) from the table.

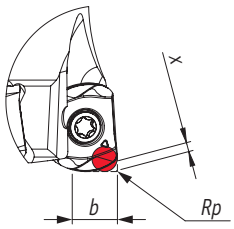
GRADES SELECTION GUIDE Guia para selecção de graus | Tabla para selección de calidades

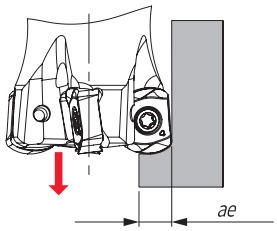
ISO	PSM	Material	HB (Brinell)	Grades ← Wear Resistance Toughness →						
				PHP910	PHP920	PHP930	PHH930	PHS740	PHP530	PHH530
P	1	Unalloyed Steel	125-220	✓	✓	✓		✓	✓	
	2	Low-Alloyed Steel	220-280	✓	✓	✓		✓	✓	
	3	High-Alloyed Steel	280-380	✓	✓	✓		✓	✓	
M	4	SS - Ferritic / Martensitic	200-330				✓	✓	✓	✓
	5	SS - Austenitic	200-330				✓	✓		✓
	6	SS - Austenitic-ferritic (Duplex)	230-260				✓	✓		✓
K	7	Malleable Cast Iron	130-230	✓	✓			✓		
	8	Grey Cast Iron	180-245	✓	✓			✓		
	9	Nodular Cast iron	160-250	✓	✓			✓		
S	11	Heat Resistant Super Alloys	200-320				✓	✓		✓

Good Conditions Average Conditions Difficult Conditions

PROGRAMMING DATA Dados para programação | Datos para la programación

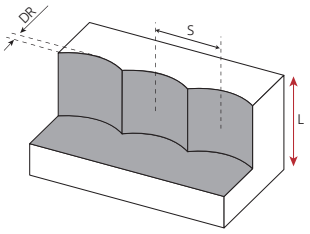
Insert	Programming Data			
	Rp	X	b	a_e
XNKU 06T3...	1,8	0,4	3,6	3,4





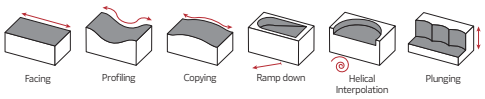
PLUNGING Mergulho | Plunge

L≤3DC	L>3DC	S max.
f_z (mm/t)		
0,08-0,15	0,05 - 0,10	$Smax = \sqrt{DC.Dr-Dr^2}$



S max and DR corresponding cutting diameter DC (mm)											
DR (mm)	DC (mm) XNKU 06...										
	16	20	25	32	35	40	42	50	52	60	80
1	3,9	4,4	4,9	5,6	5,8	6,2	6,4	7,0	7,1	7,9	8,9
2	5,3	6,0	6,8	7,7	8,1	8,7	8,9	9,8	10,0	11,0	12,5
3	6,2	7,1	8,1	9,3	9,8	10,5	10,8	11,9	12,1	13,4	15,2

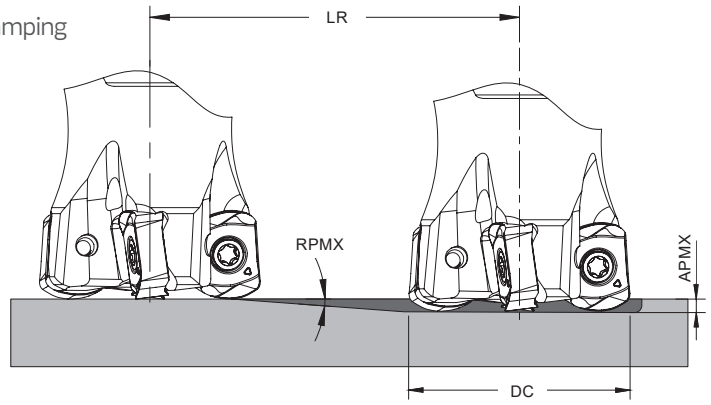
Note: Recommended for L ≤ 4 Dc for extra long tool this step and side cut must be reduced.



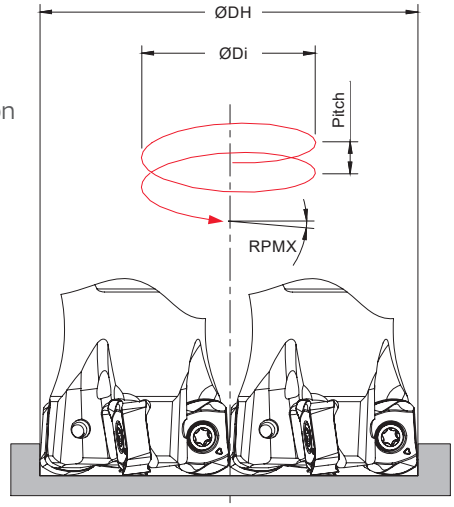
RAMPING AND HELICAL INTERPOLATION

Descida em rampa e interpolação helicoidal | Bajada en rampa e interpolación circular

Ramping



Helical Interpolation



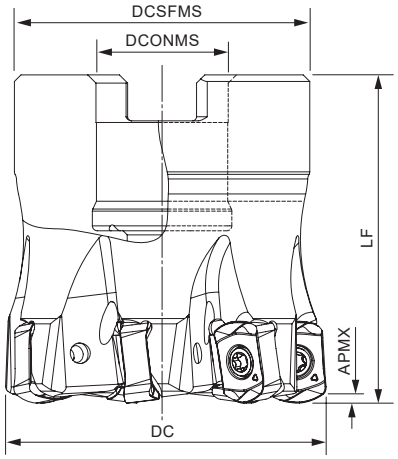
Blind hole
Flat bottom

ØDi = ØDH - DC

DC	Ramping			Helical Interpolation		
	RPMX	APMX	Min LR	ØDHmin	ØDHmax	Max Pitch/Rev.
16	2,00	1	28,6	24,8 -	- 28,4	0,96 1,00
20	1,30	1	44,1	32,8 -	- 36,4	0,91 1,00
25	0,90	1	63,7	42,8 -	- 46,4	0,87 1,00
32	0,65	1	88,1	56,8 -	- 60,4	0,88 1,00
35	0,55	1	104,2	62,8 -	- 66,4	0,83 0,94
40	0,50	1	114,6	72,8 -	- 76,4	0,89 0,99
42	0,45	1	127,3	76,8 -	- 80,4	0,85 0,94
50	0,35	1	163,7	92,8 -	- 96,4	0,82 0,89
52	0,35	1	163,7	96,8 -	- 100,4	0,85 0,92
63	0,30	1	191,0	118,8 -	- 122,4	0,91 0,97
80	0,20	1	286,5	152,8 -	- 156,4	0,79 0,83

Note: During helical interpolation do not exceed APMX.
(*) Down cutting is recommended, tool pass rotation should be counter-clockwise.
(*) In case of ramping and helical interpolation, apply 70% or less feed (fz) from recommended cutting conditions table.

NEW TETRAFEED 16420



Arbor Mounting

KAPR=20° | GAMP=-7° | RP=3,2

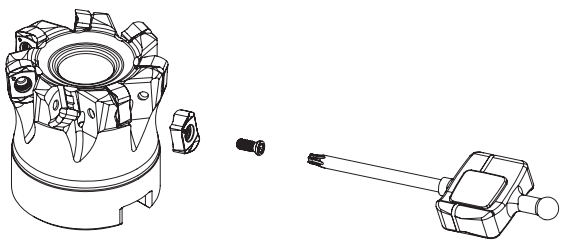
Order code Código	Reference Referência Referencia	CICT	Dimensions | Dimensões | Dimensiones (mm)				WT	Specifications		Insert	Stock
			DC	DCONMS	DCSFMS	LF		Arbor Type	APMX (mm)		
181169300	050A16420-04-07-022045	4	50	22	42	45	0,28	A	1,50	XNKU 12...	◈
181180100	050A16420-05-07-022045	5	50	22	42	45	0,31	A	1,50	XNKU 12...	◈
181178400	052A16420-04-07-022045	4	52	22	42	45	0,33	A	1,50	XNKU 12...	◈
181180200	052A16420-05-07-022045	5	52	22	42	45	0,33	A	1,50	XNKU 12...	◈
181180300	063A16420-05-07-027050	5	63	27	48	50	0,51	A	1,50	XNKU 12...	◈
181180400	063A16420-06-07-027050	6	63	27	48	50	0,52	A	1,50	XNKU 12...	◈
181180500	066A16420-05-07-027050	5	66	27	48	50	0,54	A	1,50	XNKU 12...	◈
181180600	066A16420-06-07-027050	6	66	27	48	50	0,55	A	1,50	XNKU 12...	◈
181177900	080A16420-06-07-027050	6	80	27	60	50	0,94	A	1,50	XNKU 12...	◈
181180700	080A16420-08-07-027050	8	80	27	60	50	0,95	A	1,50	XNKU 12...	◈
181180800	100A16420-06-07-032050	6	100	32	80	50	1,21	A	1,50	XNKU 12...	○
181180900	100A16420-08-07-032050	8	100	32	80	50	1,24	A	1,50	XNKU 12...	◈

◈ Stock item | Produto de stock | Itens de stock ○ Available under request | Disponível sobre consulta | Disponible bajo consulta

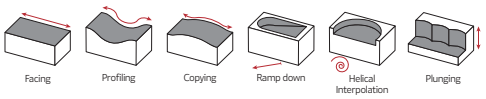
SPARE PARTS Acessórios | Repuestos

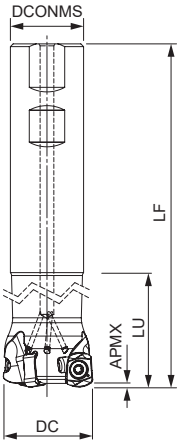
Order separately

Cutter DC	Insert Screw	Key (Torx)	Key (Torx - Nm)	Torque Value
			Nm	Nm
A16420 - 50-80	P0451400	XT20	DT2050	5,0
A16420 - 100	P0451400	PT20	DT2050	5,0
W16420 - 32-40	P0451400	XT20	DT2050	5,0



TETRAFEED 16420
XNKU 12





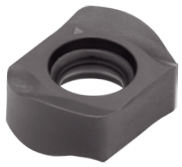
Weldon Shank

KAPR=20° | GAMP=-7° | RP=3,2

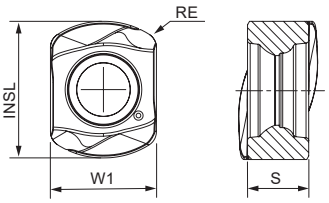
Order code Código	Reference Referência Referencia	CICT	Dimensions | Dimensões | Dimensiones (mm)				WT	Specifications	Insert	Stock
			DC	DCONMS	LF	LU		APMX (mm)		
181181000	032W16420-02-07-032150	2	32	32	150	70	0,80	1,50	XNKU 12...	◈
181181100	032W16420-02-07-032200	2	32	32	200	120	1,10	1,50	XNKU 12...	○
181181200	035W16420-02-07-032150	2	35	32	150	45	0,90	1,50	XNKU 12...	○
181181300	035W16420-02-07-032200	2	35	32	200	45	1,20	1,50	XNKU 12...	○
181181400	040W16420-03-07-032150	3	40	32	150	45	1,10	1,50	XNKU 12...	○
181181500	040W16420-03-07-032220	3	40	32	220	45	1,40	1,50	XNKU 12...	◈

◈ Stock item | Produto de stock | Itens de stock ○ Available under request | Disponível sobre consulta | Disponible bajo consulta

XNKU 1205... Inserts | Pastilhas | Plaquitas



XNKU-MP



XNKU-MP | MS

		P					M				K		S			Dimensions Dimensões Dimensiones (mm)			
		CVD	PVD				CVD	PVD			CVD	PVD	CVD	PVD					
	(2) Grade code	T9	X5	T1	P4	Z2	T9	X9	Z2	Z3	T9	T1	T9	X9	Z3				
(1) Geometry code	ISO Reference	PHS740	PHP910	PHP920	PHP930	PHP530	PHS740	PHH930	PHP530	PHH530	PHS740	PHP920	PHS740	PHH930	PHH530	W1	S	INSL	RE
1113071	XNKU 120516-MP	◈	◈	◈	○		◈	◈			◈	◈	◈	◈		11,70	5,90	15,00	1,60

◈ First choice | Primeira opção | 1ª opción ◈ Stock item | Produto de stock | Itens de stock ○ Available under request | Disponível sobre consulta Disponible bajo consulta

Insert order code = (1) Geometry Code + (2) Grade Code

RECOMMENDED CUTTING CONDITIONS Condições de corte recomendadas | Condiciones de corte recomendables

ISO	PSM	Material	HB (Brinell)	Vc (m/min) ← Wear Resistance				Toughness →	Feed fz (mm/t)
				PHP910	PHP920	PHP930	PHH930	PHS740	XNKU 12...-MP
P	1	Unalloyed Steel	125-220	180-250	180-250	160-230	-	160-230	0,50-1,50
	2	Low-Alloyed Steel	220-280	160-240	170-210	150-190	-	150-190	0,50-1,50
	3	High-Alloyed Steel	280-380	140-230	160-200	140-180	-	140-180	0,50-1,50
M	4	SS - Ferritic / Martensitic	200-330	-	-	-	130-170	120-180	0,50-1,40
	5	SS - Austenitic	200-330	-	-	-	100-160	100-150	0,50-1,40
	6	SS - Austenitic-ferritic (Duplex)	230-260	-	-	-	80-140	70-130	0,50-1,40
K	7	Malleable Cast Iron	130-230	180-300	180-320	-	-	160-300	0,50-1,50
	8	Grey Cast Iron	180-245	160-250	170-280	-	-	150-260	0,50-1,50
	9	Nodular Cast iron	160-250	150-210	100-240	-	-	80-220	0,50-1,50
S	11	Heat Resistant Super Alloys	200-320	-	-	-	30-75	30-70	0,50-1,30

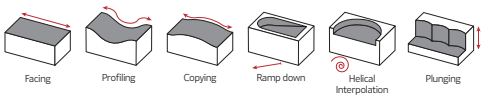
(Note 1) Cutting conditions $a_e/Dc=70\%$.
(Note 2) It's possible to occur vibrations in certain cases. Please reduce depth of cut and / or reduce cutting conditions in following cases:
- When using long shank;
- When using long tool overhang with arbor type;
- When application has poor clamping rigidity or when using a low rigidity machine.

(Note 3) When using DC=16mm apply 70% or less feed (fz) from the table.

GRADES SELECTION GUIDE Guia para selecção de graus | Tabla para selección de calidades

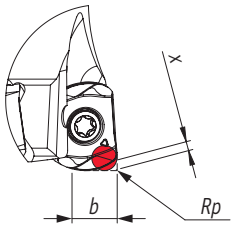
ISO	PSM	Material	HB (Brinell)	Grades ← Wear Resistance				Toughness →
				PHP910	PHP920	PHP930	PHH930	PHS740
P	1	Unalloyed Steel	125-220	✓	✓	✓		✓
	2	Low-Alloyed Steel	220-280	✓	✓	✓		✓
	3	High-Alloyed Steel	280-380	✓	✓	✓		✓
M	4	SS - Ferritic / Martensitic	200-330				✓	✓
	5	SS - Austenitic	200-330				✓	✓
	6	SS - Austenitic-ferritic (Duplex)	230-260				✓	✓
K	7	Malleable Cast Iron	130-230	✓	✓			✓
	8	Grey Cast Iron	180-245	✓	✓			✓
	9	Nodular Cast iron	160-250	✓	✓			✓
S	11	Heat Resistant Super Alloys	200-320				✓	✓

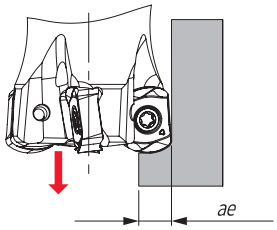
Good Conditions Average Conditions Difficult Conditions



PROGRAMMING DATA Dados para programação | Datos para la programación

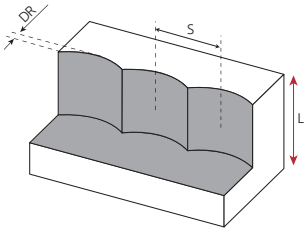
Insert	Programming Data			
	Rp	X	b	a_e
XNKU 1206...	3,2	0,65	7,5	7,1





PLUNGING Mergulho | Plunge

L≤3DC	L>3DC	S max.
f_z (mm/t)		
0,10-0,15	0,05 - 0,10	$Smax = \sqrt{DC.Dr-Dr^2}$



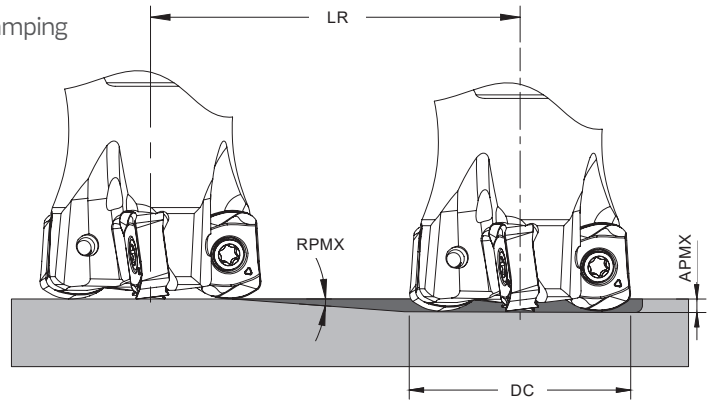
S max and DR corresponding cutting diameter DC (mm)									
DR (mm)	DC (mm)								
	32	35	40	50	52	63	66	80	100
1	5,6	5,8	6,2	7,0	7,1	7,9	8,1	8,9	9,9
2	7,7	8,1	8,7	9,8	10,0	11,0	11,3	12,5	14,0
3	9,3	9,8	10,5	11,9	12,1	13,4	13,7	15,2	17,1
4	10,6	11,1	12,0	13,6	13,9	15,4	15,7	17,4	19,6
5	11,6	12,2	13,2	15,0	15,3	17,0	17,5	19,4	21,8
6	12,5	13,2	14,3	16,2	16,6	18,5	19,0	21,1	23,7
7	13,2	14,0	15,2	17,3	17,7	19,8	20,3	22,6	25,5

Note: Recommended for L ≤ 4 Dc for extra long tool this step and side cut must be reduced.

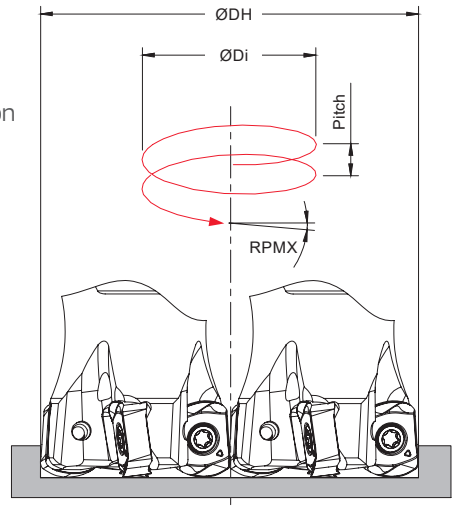
RAMPING AND HELICAL INTERPOLATION

Descida em rampa e interpolação helicoidal | Bajada en rampa e interpolación circular

Ramping



Helical Interpolation



Blind hole
Flat bottom

ØDi = ØDH - DC

DC	Ramping			Helical Interpolation		
	RPMX	APMX	Min LR	ØDHmin	ØDHmax	Max Pitch/Rev.
32	1,25	1,5	68,7	49 -	- 57,6	1,16 1,50
35	1,1	1,5	78,1	55 -	- 63,6	1,20 1,50
40	0,85	1,5	101,1	65 -	- 73,6	1,16 1,50
50	0,6	1,5	143,2	85 -	- 93,6	1,15 1,43
52	0,55	1,5	156,3	89 -	- 97,6	1,11 1,37
63	0,45	1,5	191,0	111 -	- 119,6	1,18 1,39
66	0,4	1,5	214,9	117 -	- 125,6	1,11 1,30
80	0,3	1,5	286,5	145 -	- 153,6	1,06 1,21
100	0,25	1,5	343,8	185 -	- 193,6	1,16 1,28

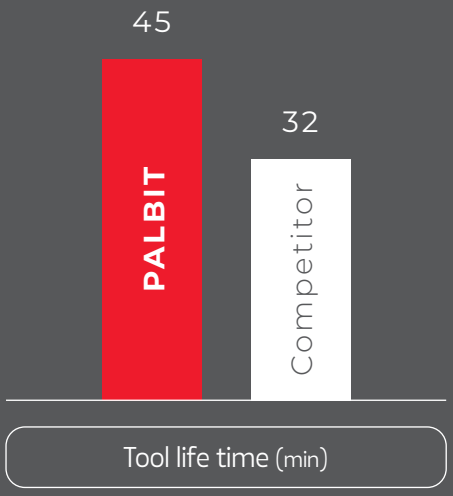
Note: During helical interpolation do not exceed APMX.
(*) Down cutting is recommended, tool pass rotation should be counter-clockwise.
(*) In case of ramping and helical interpolation, apply 70% or less feed (fz) from recommended cutting conditions table.

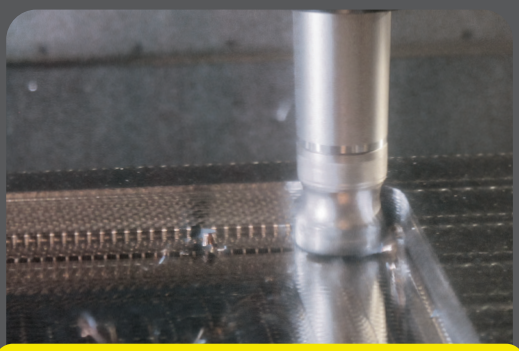
TEST REPORTS

TETRAFEED 16320

Toolholder 032R16320-05-07-M16035
Insert XNKU 06T310-MP
Grade PHH930

+40% Tool Life Time





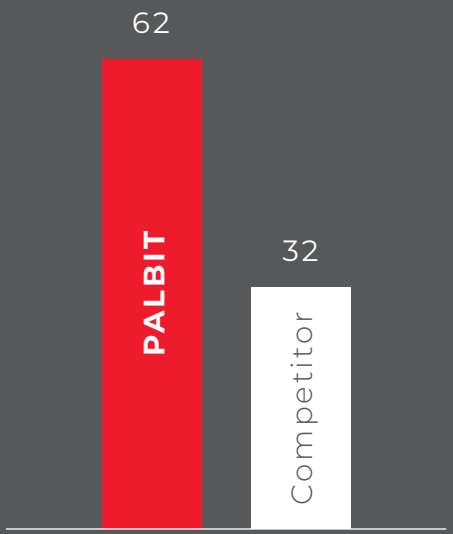
Workpiece Material Stainless steel, AISI 316

Cutting speed: Vc	120 m/min
Feed per tooth: fz	1,0 mm/t
Depth of cut: ap	0,5 mm
Width of cut: ae	24 mm
Method of machining	Ramping and Helical Interpolation
Coolant	Dry

TETRAFEED 16420

Toolholder 050A16420-05-07-022045
Insert XNKU 120516-MP
Grade PHP920

+94% Tool Life Time



Workpiece Material 1.2738 | 34-36 HRC, Mould Steel

Cutting speed: Vc	200 m/min
Feed per tooth: fz	1,2 mm/t
Depth of cut: ap	1,0 mm
Width of cut: ae	60%
Method of machining	Facing
Coolant	Air

16320 | 16420

TETRAFEED

Double-sided high feed milling solution

Check the QrCode for more information

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