

Processing Example

Data Example 1

[Insert life test]

- Body : EC12-8XX-M4
- Insert : XX21MNX-M4 NK2020

- Material..... SKD11
- Cutting Conditions..... S3000 F100
- Water-soluble coolant
- 0.5 step sends

Result

1760 places / 1 Corner

Good surface finish and a stable cutting result is obtained

Data Example 2

[Insert life test]

- Body : EC16-14XS-M8
- Insert : XS22MNX-M8 NK6060

- Material..... SUS304
- Cutting Conditions..... S1600 F70
- Water-soluble coolant
- 0.5 step sends

Result

510 places / 1 Corner

Good surface finish and a stable cutting result is obtained

Insert

Figure	Model.No.	Material	Coating	Usable corners	Quantity per box																																																												
<p>● Eaglecut(M4~M6)</p> <p style="text-align: center;">(XX21MNX) (XX31MNX)</p> <table border="1" style="width: 100%; border-collapse: collapse; margin-top: 10px;"> <thead> <tr style="background-color: #f8bbd0;"> <th>型番</th> <th>A</th> <th>B</th> <th>T</th> <th>R</th> <th>φd</th> </tr> </thead> <tbody> <tr> <td>XX21MNX-M4</td> <td>8mm</td> <td>6.548mm</td> <td>1.59mm</td> <td>R0.2</td> <td>2.3mm</td> </tr> <tr> <td>XX21MNX-M5</td> <td>8mm</td> <td>6.841mm</td> <td>1.59mm</td> <td>R0.2</td> <td>2.3mm</td> </tr> <tr> <td>XX31MNX-M6</td> <td>9mm</td> <td>8.084mm</td> <td>1.59mm</td> <td>R0.2</td> <td>2.5mm</td> </tr> </tbody> </table>	型番	A	B	T	R	φd	XX21MNX-M4	8mm	6.548mm	1.59mm	R0.2	2.3mm	XX21MNX-M5	8mm	6.841mm	1.59mm	R0.2	2.3mm	XX31MNX-M6	9mm	8.084mm	1.59mm	R0.2	2.5mm	XX21MNX-M4 NK2020	Carbide M20	None	1	12																																				
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