

NEW ALL-IN-ONE **MULTICUT**



A multipurpose tool designed to enhance productivity and reduce setup times is capable of executing internal, external, and face turning, as well as drilling with either a stationary or rotating tool.

Uma ferramenta multifuncional projetada para aumentar a produtividade e reduzir os tempos de configuração. Capaz de executar torneamento interno, externo e facejamento, e até mesmo furação com uma ferramenta estacionária ou giratória.

Una herramienta multifuncional diseñada para aumentar la productividad y reducir los tiempos de configuración. Capaz de realizar torneado interno, externo y frontal, e incluso perforación con una herramienta estacionaria o giratoria.

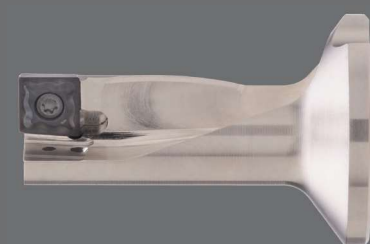
NEW XMS-R > page 484

- > From DC 8mm to 32mm
De DC 8mm a 32mm | Desde DC 8mm hasta 32mm
- > With length of 2,25xDC
Com comprimento de 2,25xDC | Con longitud de 2,25 x DC



NEW XMS-L > page 484

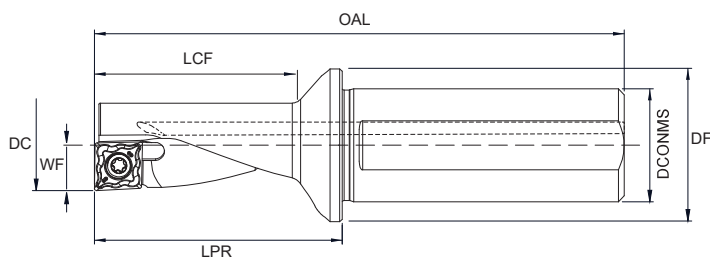
- > From DC 8mm to 32mm
De DC de 8mm a 32mm | Desde DC 8mm hasta 32mm
- > With length of 2,25xDC
Com comprimento de 2,25xDC | Con longitud de 2,25 x DC



NEW XCMT INSERTS > page 485

- > From sizes 04 to 17
De tamanhos de 04 a 17 | De tamaños de 04 a 17
- > Available in grades PH7920 and PHS225
Disponível nos graus PH7920 e PHS225 | Disponible en las calidades PH7920 y PHS225
- > Suitable for machining steels, stainless steels and HRSA
Adequado para maquinação de aços, aços inoxidáveis e HRSA | Adecuado para el mecanizado de aceros, aceros inoxidables y HRSA





*Right hand style show

Order code Código	Reference Referência Referencia	Hand		Dimensions Dimensões Dimensiones (mm)							WT	Insert	Stock
				DC	DCONMS	DF	WF	OAL	LCF	LPR			
182021200	XMS-R 08010-2,25D	Right	1	8	10	12	4	60,0	18,0	22,0	0,027	XCMT 0401.. ER	
182021300	XMS-R 10012-2,25D	Right	1	10	12	16	5	69,5	22,5	27,5	0,046	XCMT 0502..	
182021400	XMS-R 12016-2,25D	Right	1	12	16	20	6	78,0	27,0	33,0	0,089	XCMT 0602..	
182021500	XMS-R 14016-2,25D	Right	1	14	16	20	7	83,5	31,5	38,5	0,094	XCMT 0703..	
182021600	XMS-R 16020-2,25D	Right	1	16	20	25	8	94,0	36,0	44,0	0,154	XCMT 0803..	
182021700	XMS-R 18025-2,25D	Right	1	18	25	32	9	109,5	40,5	53,5	0,293	XCMT 09T3..	
182021800	XMS-R 20025-2,25D	Right	1	20	25	32	10	111,0	45,0	55,0	0,311	XCMT 10T3..	
182021900	XMS-R 25032-2,25D	Right	1	25	32	40	12,5	129,0	56,5	69,0	0,563	XCMT 1304..	
182022000	XMS-R 32040-2,25D	Right	1	32	40	50	16	158,0	72,0	88,0	1,117	XCMT 1705..	
182022100	XMS-L 08010-2,25D	Left	1	8	10	12	4	60,0	18,0	22,0	0,027	XCMT 0401.. EL	
182022200	XMS-L 10012-2,25D	Left	1	10	12	16	5	69,5	22,5	27,5	0,046	XCMT 0502..	
182022300	XMS-L 12016-2,25D	Left	1	12	16	20	6	78,0	27,0	33,0	0,089	XCMT 0602..	
182022400	XMS-L 14016-2,25D	Left	1	14	16	20	7	83,5	31,5	38,5	0,094	XCMT 0703..	
182022500	XMS-L 16020-2,25D	Left	1	16	20	25	8	94,0	36,0	44,0	0,154	XCMT 0803..	
182022600	XMS-L 18025-2,25D	Left	1	18	25	32	9	109,5	40,5	53,5	0,293	XCMT 09T3..	
182022700	XMS-L 20025-2,25D	Left	1	20	25	32	10	111,0	45,0	55,0	0,311	XCMT 10T3..	
182022800	XMS-L 25032-2,25D	Left	1	25	32	40	12,5	129,0	56,5	69,0	0,563	XCMT 1304..	
182022900	XMS-L 32040-2,25D	Left	1	32	40	50	16	158,0	72,0	88,0	1,117	XCMT 1705..	

 Stock item | Produto de stock | Itens de stock

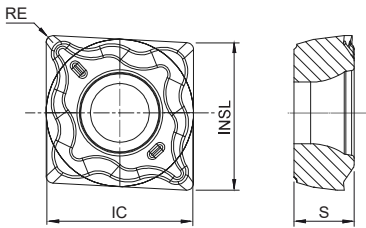
 Available under request | Disponível sobre consulta | Disponible bajo consulta



XCMT-MP
(PH7 grade)



XCMT-MP
(PHS grade)



XCMT-MP

		P	M		S	Dimensions Dimensões Dimensiones (mm)				Hand
		PVD	CVD	PVD	PVD					
		⁽²⁾ Grade code	G4	U5	G4					
⁽¹⁾ Geometry code	ISO Reference	PH7920	PHS225	PH7920	PH7920	IC	S	INSL	RE	
1124790	XCMT 040104-MP ER					4,40	1,89	4,00	0,40	Right
1124791	XCMT 040104-MP EL					4,40	1,89	4,00	0,40	Left
1124792	XCMT 050204-MP EN					5,65	2,14	5,00	0,40	Neutral
1123788	XCMT 060204-MP EN					6,40	2,47	6,00	0,40	Neutral
1124784	XCMT 070304-MP EN					7,50	3,25	7,00	0,40	Neutral
1124785	XCMT 080304-MP EN					8,40	3,26	8,00	0,40	Neutral
1124786	XCMT 09T304-MP EN					9,45	4,00	9,00	0,40	Neutral
1124787	XCMT 10T308-MP EN					10,40	4,00	10,00	0,80	Neutral
1124788	XCMT 130408-MP EN					13,35	4,85	12,50	0,80	Neutral
1124789	XCMT 170508-MP EN					17,30	5,58	16,00	0,80	Neutral

Ⓐ First choice | Primeira opção | 1ª opción

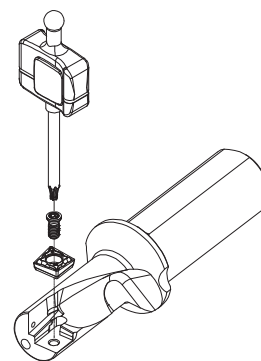
Ⓐ Stock item | Produto de stock | Itens de stock

○ Available under request | Disponível sobre consulta | Disponible bajo consulta

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

SPARE PARTS Acessórios | Repuestos

Cutter ØDc	Insert Screw	Key (Torx)	Order separately Key (Torx - Nm)	Torque Value
				
XMS-R/L 08010-2,25D	P0180400	XT06IP	DT0606IP	0,60
XMS-R/L 10012-2,25D	P0200500	XT06	DT0606	0,60
XMS-R/L 12016-2,25D	P0220500	XT07	DT0709	0,90
XMS-R/L 14016-2,25D	P0250704	XT08	DT0812	1,20
XMS-R/L 16020-2,25D	P0300701	XT08	DT0812	1,20
XMS-R/L 18025-2,25D	P0300701	XT08	DT0812	1,20
XMS-R/L 20025-2,25D	P0350800	PT15	DT1530	3,00
XMS-R/L 25032-2,25D	P0500900	PT20	DT2050	4,00
XMS-R/L 32040-2,25D	P0501302	PT20	DT2050	4,00

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

ISO	PSM	Material	HB (Brinell)	Grades	
				← Wear Resistance PH7920 	Toughness → PHS225 
P	1	Unalloyed Steel	125-170	✓	
	2	Low-Alloyed Steel	180-350	✓	
	3	High-Alloyed Steel	200-325	✓	
M	4	SS - Ferritic / Martensitic	200-330	✓	✓
	5	SS - Austenitic	180-330	✓	✓
	6	SS - Austenitic-ferritic (Duplex)	230-260	✓	✓
S	11	Heat Resistant Super Alloys	200-320	✓	



Good Conditions



Average Conditions



Difficult Conditions

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

ISO	PSM	Material	HB (Brinell)	Vc (m/min)	
				← Wear Resistance	Toughness →
				PH7920	PHS225
P	1	Unalloyed Steel	125-170	110-220	-
	2	Low-Alloyed Steel	180-350	100-210	-
	3	High-Alloyed Steel	200-325	85-190	-
M	4	SS - Ferritic / Martensitic	200-330	95-210	70-230
	5	SS - Austenitic	180-330	85-205	65-225
	6	SS - Austenitic-ferritic (Duplex)	230-260	80-195	55-215
S	11	Heat Resistant Super Alloys	200-320	25-210	-

Reference	FN (mm/rev)			AP (mm)	
	Face Turning	Int/Ext Turning	Holemaking	Face Turning	Int/Ext Turning
XCMT 040104-MP ER/L	0,02-0,09	0,02-0,13	0,01-0,04	0,50-1,90	0,50-2,70
XCMT 050204-MP EN	0,02-0,12	0,02-0,15	0,01-0,05	0,50-2,20	0,50-3,20
XCMT 060204-MP EN	0,02-0,14	0,02-0,16	0,01-0,06	0,70-2,70	0,70-3,70
XCMT 070304-MP EN	0,02-0,16	0,02-0,18	0,01-0,08	0,80-3,00	0,80-4,00
XCMT 080304-MP EN	0,03-0,18	0,03-0,20	0,02-0,08	0,90-3,40	0,90-4,20
XCMT 09T304-MP EN	0,03-0,20	0,03-0,22	0,03-0,09	0,90-3,80	0,90-4,70
XCMT 10T308-MP EN	0,03-0,22	0,03-0,24	0,03-0,10	1,00-4,20	1,00-5,30
XCMT 130408-MP EN	0,03-0,24	0,03-0,26	0,04-0,12	1,00-5,00	1,00-6,50
XCMT 170508-MP EN	0,03-0,27	0,03-0,30	0,04-0,15	1,00-6,00	1,00-7,00

Note: For additional details on drilling operations check the page B-377.

TURNING

Negative inserts

Positive inserts

PCBN & PCD inserts

Heavy turning

External Toolholders

Internal Toolholders

Automatic Lathes

Spare Parts

Technical Data