

MULTICUT

NEW ALL-IN-ONE



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.

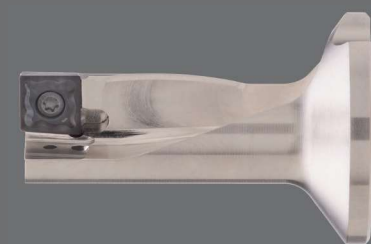
NEW XMS-R > page 374

- > From DC 8mm to 32mm
De DC 8mm a 32mm | Desde DC 8mm hasta 32mm
- > Available in 2,25D
Disponível em 2,25D | Disponible en 2,25D



NEW XMS-L > page 374

- > From DC 8mm to 32mm
De DC de 8mm a 32mm | Desde DC 8mm hasta 32mm
- > Available in 2,25D
Disponível em 2,25D | Disponible en 2,25D



NEW XCMT INSERTS > page 375

- > 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



B NEW MULTICUT

HOLEMAKING

Multicut

Jet Drills

Integrex Drills

Vortex Drills

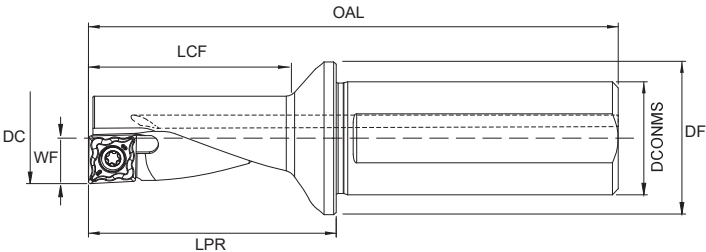
Trepanning Drills

Inserts

Spare Parts

Technical Data

Solid Carbide Drills



*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	8,0	10	12	4	60,0	18,0	22,0	0,027	XCMT 0401.. ER	
182021300	XMS-R 10012-2,25D	Right	1	10,0	12	16	5	69,5	22,5	27,5	0,046	XCMT 0502..	
182021400	XMS-R 12016-2,25D	Right	1	12,0	16	20	6	78,0	27,0	33,0	0,089	XCMT 0602..	
182021500	XMS-R 14016-2,25D	Right	1	14,0	16	20	7	83,5	31,5	38,5	0,094	XCMT 0703..	
182021600	XMS-R 16020-2,25D	Right	1	16,0	20	25	8	94,0	36,0	44,0	0,154	XCMT 0803..	
182021700	XMS-R 18025-2,25D	Right	1	18,0	25	32	9	109,5	40,5	53,5	0,293	XCMT 09T3..	
182021800	XMS-R 20025-2,25D	Right	1	20,0	25	32	10	111,0	45,0	55,0	0,311	XCMT 10T3..	
182021900	XMS-R 25032-2,25D	Right	1	25,0	32	40	12,5	129,0	56,5	69,0	0,563	XCMT 1304..	
182022000	XMS-R 32040-2,25D	Right	1	32,0	40	50	16	158,0	72,0	88,0	1,117	XCMT 1705..	
182022100	XMS-L 08010-2,25D	Left	1	8,0	10	12	4	60,0	18,0	22,0	0,027	XCMT 0401.. EL	
182022200	XMS-L 10012-2,25D	Left	1	10,0	12	16	5	69,5	22,5	27,5	0,046	XCMT 0502..	
182022300	XMS-L 12016-2,25D	Left	1	12,0	16	20	6	78,0	27,0	33,0	0,089	XCMT 0602..	
182022400	XMS-L 14016-2,25D	Left	1	14,0	16	20	7	83,5	31,5	38,5	0,094	XCMT 0703..	
182022500	XMS-L 16020-2,25D	Left	1	16,0	20	25	8	94,0	36,0	44,0	0,154	XCMT 0803..	
182022600	XMS-L 18025-2,25D	Left	1	18,0	25	32	9	109,5	40,5	53,5	0,293	XCMT 09T3..	
182022700	XMS-L 20025-2,25D	Left	1	20,0	25	32	10	111,0	45,0	55,0	0,311	XCMT 10T3..	
182022800	XMS-L 25032-2,25D	Left	1	25,0	32	40	12,5	129,0	56,5	69,0	0,563	XCMT 1304..	
182022900	XMS-L 32040-2,25D	Left	1	32,0	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

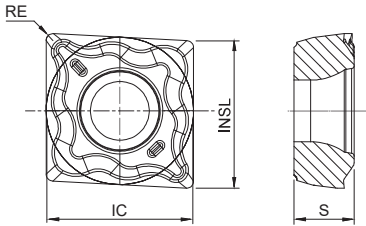
XCMT Inserts | Pastilhas | Plaquitas



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

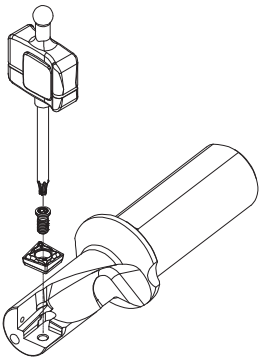
Ⓢ Stock item | Produto de stock | Itens de stock

○ 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

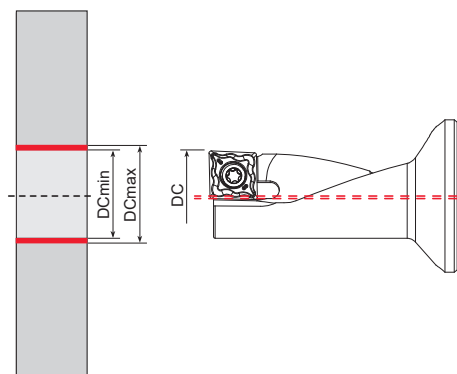
RECOMMENDED CUTTING CONDITIONS Condições de corte recomendadas | Condiciones de corte recomendables

ISO	PSM	Material	HB (Brinell)	Vc (m/min)	
				← Wear Resistance PH7920	Toughness → 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

Off-center drilling:

Thanks to MultiCut's unique geometry, it is possible to perform off-center drilling. Therefore, with slight deviations from the center of the workpiece, it is possible to make holes with diameters different from the nominal diameter, as shown in the table below.



Reference	Drilling (mm)		
	DC nominal	DC _{min}	DC _{max}
XMS-R/L 08010-2,25D	8	7,85	8,30
XMS-R/L 10012-2,25D	10	9,85	10,50
XMS-R/L 12016-2,25D	12	11,85	12,50
XMS-R/L 14016-2,25D	14	13,80	14,50
XMS-R/L 16020-2,25D	16	15,80	16,50
XMS-R/L 18025-2,25D	18	17,80	18,50
XMS-R/L 20025-2,25D	20	19,75	20,50
XMS-R/L 25032-2,25D	25	24,75	25,80
XMS-R/L 32040-2,25D	32	31,75	33,00