

XNMX 90° Shoulder Milling

- ◆ Double sided design, total 6 cutting edges.
- ◆ Suitable for different materials by optimized geometries.
- ◆ True 90° square shoulder angle, one milling operation without mismatch on machining walls.

XNMX04 \$10.74_{each}

XNMX08 \$12.21_{each}



*The above prices are valid through 12/31/17

Specification

Inserts	Designation	Grade					Dimensions (mm)						Drawing
		OT42NS	OT62NA	OT62NS	OT82NS	OT82NA	A	B	S	r	d1	t1	
	XNMX 040308-OM	●	●	●	○	○	6.7	-	3.285	0.8	3.15	-	
	XNMX 040308-OG	○	○	○	●	●	6.7	-	3.285	0.8	3.15	-	
	XNMX 080608-OM	○	○	○	○	○	12.53	-	6.5	0.8	4.5	-	

OG: Negative cutting edge protection. General purpose chip breaker for steels and cast iron.

OM: Positive edge with radius, low cutting force and chatter reduction.

Recommended Cutting Conditions

for XNMX0403

Working Material	Vc (Speed)		fz (Feed)		ap (Axial DOC)	
	m/min	SFM	FPT mm	FPT in	mm	in
Carbon Steel (HB85-225)	80 ~ 220	260 ~ 720	0.10 ~ 0.16	0.004" ~ 0.006"	~ 3.0	~ .118"
Stainless 300 Series	50 ~ 130	165 ~ 425	0.08 ~ 0.12	0.003" ~ 0.005"	~ 1.6	~ .063"
Cast Iron (HB140-220)	80 ~ 200	260 ~ 720	0.10 ~ 0.16	0.004" ~ 0.006"	~ 3.0	~ .118"

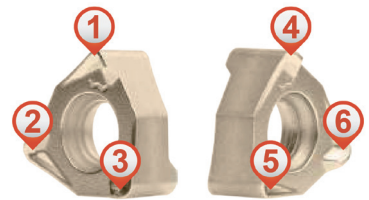
for XNMX0806

Working Material	Vc (Speed)		fz (Feed)		ap (Axial DOC)	
	m/min	SFM	FPT mm	FPT in	mm	in
Carbon Steel (HB85-225)	80 ~ 220	260 ~ 720	0.13 ~ 0.25	0.005" ~ 0.010"	~ 7.0	~ .2756"
Stainless 300 Series	50 ~ 130	165 ~ 425	0.10 ~ 0.20	0.004" ~ 0.008"	~ 4.5	~ .1772"
Cast Iron (HB140-220)	80 ~ 200	260 ~ 720	0.13 ~ 0.25	0.005" ~ 0.010"	~ 7.0	~ .2756"



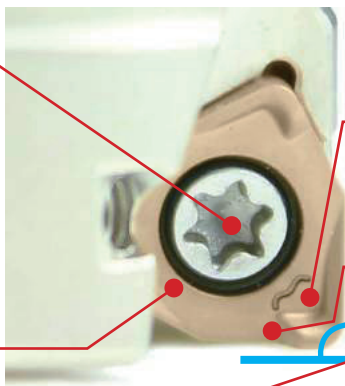
Economical solution in various 90° square shoulder milling applications!!!

- XNMX is the best solution with the economy of six cutting edges while providing the highest performance.
- Available in multiple grades and chipbreakers.
- Especially suited for small and medium sized milling machines.



6 cutting edges

· Single center lock screw hole for easy and strong clamping force.



· Suitable for different materials by optimized geometries.

- Chip evacuation improvement design.
- Reduction of cutting load during machining.

- Special flat design for surface roughness improvement.
- Decreasing cutting force during high feed machining.

· True 90° square shoulder angle, one milling operation without mismatch on machining walls.