

PRODUCT NEWS

PN-E-005

SERIES EXPANSION

KALIP TEKNİK

DIJET®

EXSKS SERIES

05 type

- Bore type $\Phi 40 - \Phi 63$
- Modular type $\Phi 20 - \Phi 40$
- Shank type $\Phi 20 - \Phi 33$

07 type

- Bore type $\Phi 50 - \Phi 100$
- Modular type $\Phi 32 - \Phi 42$
- Shank type $\Phi 32 - \Phi 40$

09 type

- Bore type $\Phi 50 - \Phi 160$



EXSKS-05 type



EXSKS-07 type



EXSKS-09 type

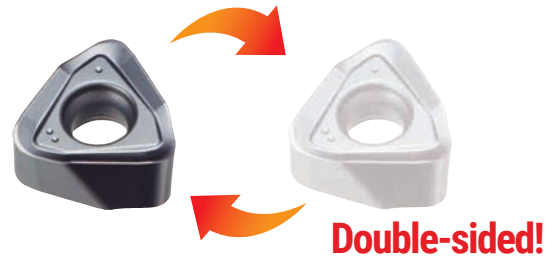


KALIP TEKNİK

www.kalipteknik.com.tr

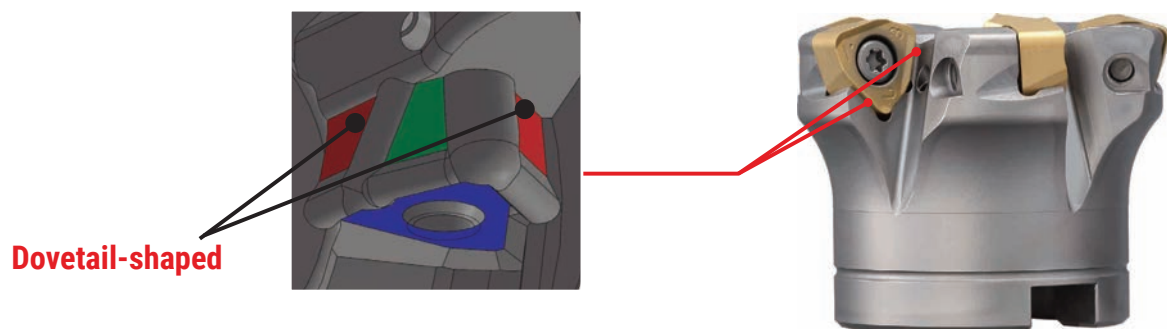
High-feed milling tools with double sided inserts which achieve ultimate high-feed machining

Feature 1 Economical double-sided insert (with 6 cutting edges)



Feature 2 Strong Clamping System

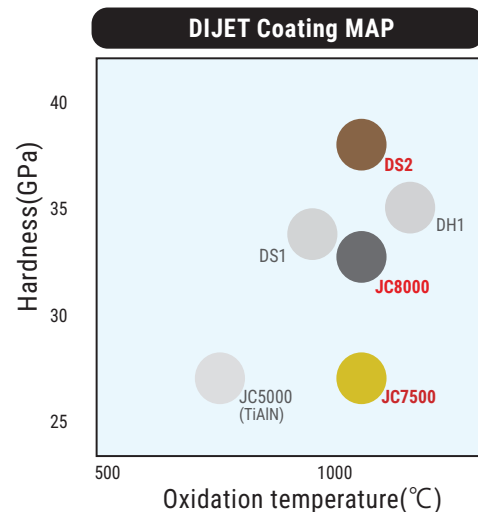
Dovetail-shaped binding faces in pocket prevents movement of inserts from the cutting force with a single screw

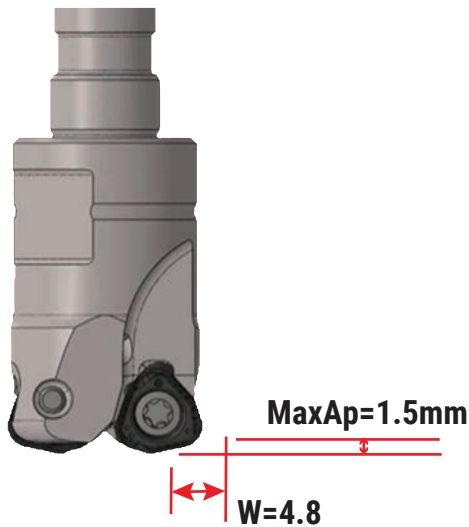


Feature 3

ISO	P					M					K				H		
	P01	P10	P20	P30	P40	M01	M10	M20	M30	M40	K01	K10	K20	K30	H01	H10	H20
Applicable range			JC8050					JC8050									
		JC8118										JC8118			JC8118		
			DS250					DS250									
			JC7560					JC7560									

	NEW DS2 Coating	JC8000 (DV Coating)	JC7500 Coating
Composition	TiAlSiN	AlTiCrN	AlTiCrN
Hardness (GPa)	36 - 38	32 - 34	27 - 28
Oxidation temperature (°C)	1100 - 1200	1000 - 1200	1000 - 1100
Coefficient of friction	0.3	0.65	0.5





EXSKS-05 type

Multi-blade specifications with small diameters result in high feed machining possibilities.

- Bore type $\Phi 40 - \Phi 63$
- Modular type $\Phi 20 - \Phi 40$
- Shank type $\Phi 20 - \Phi 33$

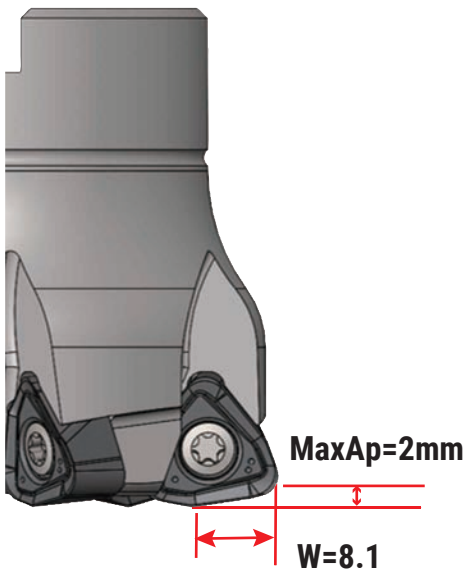
WNMU050320ZER-PM

- For general applications
- Grade : JC8118 / JC8050



WNMU050320ZER-PL

- Low cutting force
- Sharp cutting edge
- Grade : JC8118/JC8050/DS250



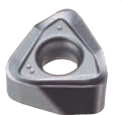
EXSKS-07 type

Specifications achieve both insert strength and sharpness allowing stable high-feed machining.

- Bore type $\Phi 50 - \Phi 100$
- Modular type $\Phi 32 - \Phi 42$
- Shank type $\Phi 32 - \Phi 50$

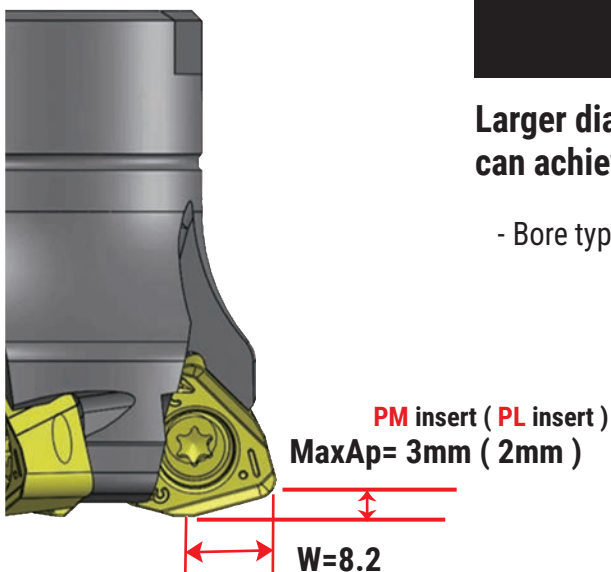
WNMU070620ZER-PM

- For general applications
- Grade : JC8118 / JC8050



WNMU070620ZER-PL

- Low cutting force
- Sharp cutting edge
- Grade : JC8118/JC8050/DS250



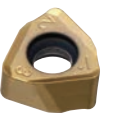
EXSKS-09 type

Larger diameters using thick high-rigid inserts can achieve high-feed machining with larger depth of cut.

- Bore type $\Phi 50 - \Phi 160$

WNMU090720ZER-PM

- Suitable for face milling and pocket machining, with ap=1.4mm or more
- Grade : JC8118/JC8050/JC7560



WNMU090828ZER-PL

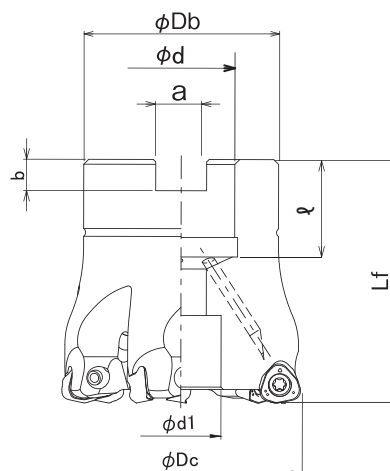
- Suitable for pocket machining with ap = 0.6 - 1.2 mm
- Optimized cutting edges reduce fluctuations during corner machining
- Grade : JC8118/JC8050





EXSKS-05 TYPE

Bore Type



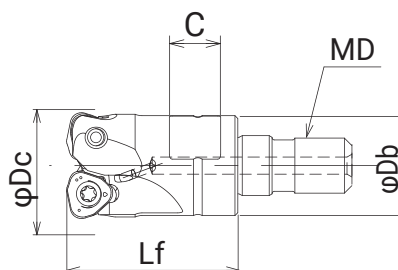
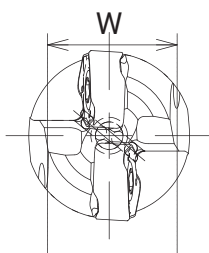
Cat.No.	Stock	No. of inserts	Dimensions (mm)								Arbor set bolt	Weight (kg)	Insert
			φDc	Lf	φDb	φd	φd1	a	b	ℓ			
EXSKS-5040R-05-16	●	5	40	45	35	16	13.5	8.4	5.8	19	M8	0.25	WNMU050320ZER-PM WNMU050320ZER-PL
EXSKS-7050R-05-22	●	7	50	50	40	22	16.5	10.4	6.3	20	M10	0.39	
EXSKS-7052R-05-22	●	7	52	50	40	22	16.5	10.4	6.3	20	M10	0.41	
EXSKS-8063R-05-22	●	8	63	50	48	22	17	10.4	6.3	20	M10	0.65	

Note) All cutters are supplied without inserts or wrenches.



MEX-05 TYPE

Modular Type



Cat.No.	Stock	No. of inserts	Dimensions (mm)						Insert
			φDc	Lf	φDb	MD	C	W	
MEX-2020-05-M10	●	2	20	30	18	M10	9	14	WNMU050320ZER-PM WNMU050320ZER-PL
MEX-2021-05-M10	○	2	21	30	18	M10	9	14	
NEW MEX-2025-05-M12	●	2	25	35	23	M12	11	19	
MEX-3025-05-M12	●	3	25	35	23	M12	11	19	
MEX-3026-05-M12	○	3	26	35	23	M12	11	19	
MEX-3028-05-M12	○	3	28	28	23	M12	11	19	
MEX-4030-05-M16	○	4	30	43	27	M16	12	22	
NEW MEX-3032-05-M16	●	3	32	43	29	M16	12	22	
MEX-4032-05-M16	●	4	32	43	29	M16	12	22	
MEX-4033-05-M16	○	4	33	43	29	M16	12	22	
MEX-4035-05-M16	●	4	35	43	29	M16	12	22	
MEX-5040-05-M16	●	5	40	43	32	M16	14	26	

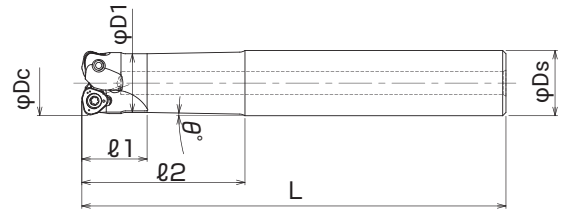
Note) All cutters are supplied without inserts or wrenches.

Screw	Torque(N.m)	Wrench
TSW-307H	2.1	A-10

Through
coolant
hole

EXSKS-05 TYPE

Shank Type



Cat.No.	Stock	No. of inserts	Dimensions (mm)							Inserts
			φDc	ℓ1	ℓ2	L	φd1	φDs	θ°	
EXSKS-2020-05-50-S20	●	2	20	20	50	130	18	20	1	WNMU050320ZER-PM WNMU050320ZER-PL
EXSKS-2020-05-80-S20	○	2	20	20	80	160	18	20	0.5	
EXSKS-2021-05-50-S20	○	2	21	20	50	130	18	20	1	
EXSKS-2021-05-80-S20	○	2	21	20	80	160	18	20	0.5	
EXSKS-3025-05-60-S25	●	3	25	25	60	140	23	25	1	
EXSKS-3025-05-100-S25	○	3	25	25	100	180	23	25	0.5	
EXSKS-3026-05-60-S25	○	3	26	25	60	140	23	25	1	
EXSKS-3026-05-100-S25	○	3	26	25	100	180	23	25	0.5	
EXSKS-4032-05-70-S32	●	4	32	30	70	150	29	32	1.5	
EXSKS-4032-05-120-S32	○	4	32	30	120	200	29	32	0.5	
NEW EXSKS-4033-05-70-S32	○	4	33	30	70	150	29	32	1.5	
NEW EXSKS-4033-05-120-S32	○	4	33	30	120	200	29	32	0.5	

Note) All cutters are supplied without inserts or wrenches.

Screw	Torque(N.m)	Wrench
TSW-307H	2.1	A-10

Insert

Fig 1

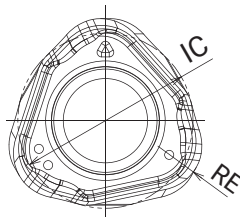
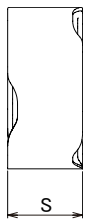
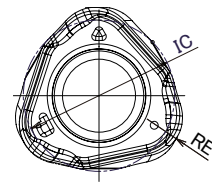


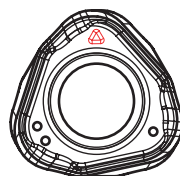
Fig 2



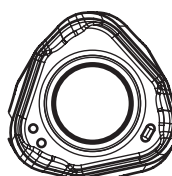
Cat.No.	Tolerance	PVD coated			Dimensions (mm)			Fig.
		JC8118	JC8050	DS250	RE	IC	S	
WNMU050320ZER-PM	M	●	●		2	7.7	3.9	1
NEW WNMU050320ZER-PL	M	●	●	●	2	7.7	3.9	2

Note) 10 inserts per case.

GRADE MARKING



JC8050/DS250



JC8118

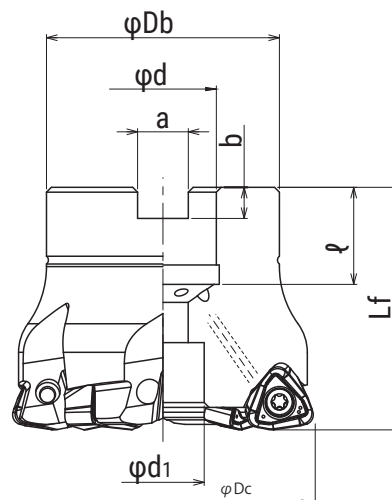
● : Standard stock items

○ : Stock in Japan



EXSKS-07 TYPE

Bore Type



Cat.No.	Stock	No. of inserts	Dimensions (mm)								Arbor set bolt	Weight (kg)	Insert
			φDc	Lf	φDb	φd	φd1	a	b	φ			
EXSKS-5050R-07-22	●	5	50	50	40	22	16.5	10.4	6.3	20	M10	0.38	WNMU070620ZER-PM WNMU070620ZER-PL
EXSKS-5052R-07-22	●	5	52	50	40	22	16.5	10.4	6.3	20	M10	0.40	
EXSKS-6063R-07-22	●	6	63	50	48	22	17	10.4	6.3	20	M10	0.64	
EXSKS-7080R-07-27	●	7	80	55	65	27	20	12.4	7	22	M12X1.75X35★	1.23	
EXSKS-8100R-07-32	●	8	100	50	85	32	26	14.4	8	25	M16X2X25★	1.76	

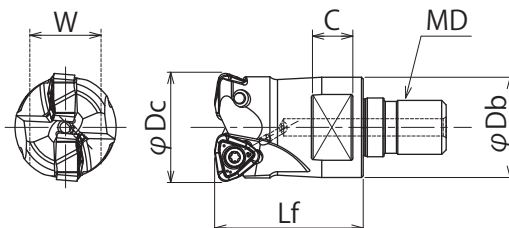
Note) All cutters are supplied without inserts or wrenches.

Screw	Torque(N.m)	Wrench
TSW-410H	3.5	A-15T



MEX-07 TYPE

Modular Type



Cat.No.	Stock	No. of inserts	Dimensions (mm)						Insert
			φDc	Lf	φDb	MD	C	W	
MEX-2032-07-M16	●	2	32	43	29	M16	12	22	WNMU070620ZER-PM WNMU070620ZER-PL
MEX-3035-07-M16	●	3	35	43	29	M16	12	22	
MEX-4040-07-M16	●	4	40	43	32	M16	14	26	
MEX-4042-07-M16	●	4	42	43	32	M16	14	26	

Note) All cutters are supplied without inserts or wrenches.

Screw	Torque(N.m)	Wrench
TSW-410H	3.5	A-15

EXSKS-07 TYPE

Shank Type



Fig.1

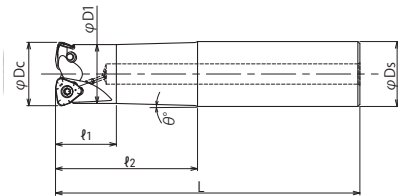
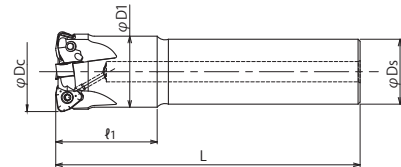


Fig.2



Cat.No.	Stock	No. of inserts	Dimensions (mm)							Fig.	Insert
			φDc	ℓ1	ℓ2	L	φd1	φDs	θ°		
EXSKS-2032-07-70-S32	○	2	32	30	70	150	29	32	1.5	1	WNMU070620ZER-PM WNMU070620ZER-PL
EXSKS-2032-07-120-S32	○	2	32	30	120	200	29	32	0.6	1	
EXSKS-3035-07-40-S32	○	3	35	40	-	150	31	32	-	2	
EXSKS-3035-07-40L-S32	○	3	35	40	-	200	31	32	-	2	
EXSKS-4040-07-50-S32	○	4	40	50	-	150	35	32	-	2	
EXSKS-4040-07-50L-S32	○	4	40	50	-	200	35	32	-	2	

Note) All cutters are supplied without inserts or wrenches.

Screw	Torque(N.m)	Wrench
TSW-410H	3.5	A-15

Insert

Fig 1

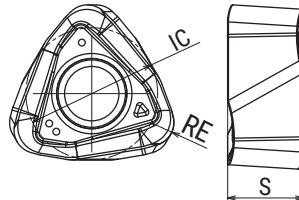
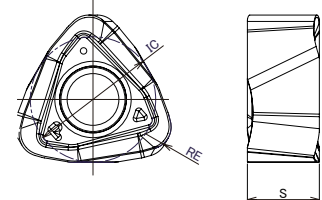


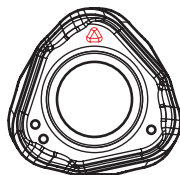
Fig 2



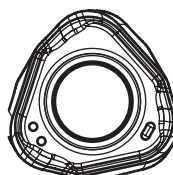
Cat.No.	Tolerance	PVD coated			Dimensions (mm)			Fig.
		JC8118	JC8050	DS250	RE	IC	S	
WNMU070620ZER-PM	M	●	●		2	11.2	6.4	1
NEW WNMU070620ZER-PL	M	●	●	●	2	11.2	6.4	2

Note) 10 inserts per case.

GRADE MARKING



JC8050/DS250



JC8118



EXSKS-09
TYPE

Bore Type

P

M

K

H



Fig.1
Through coolant hole

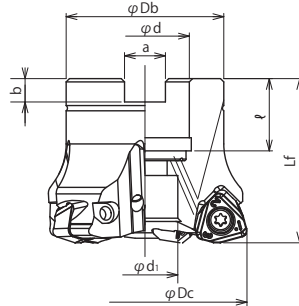


Fig.2
Without coolant hole

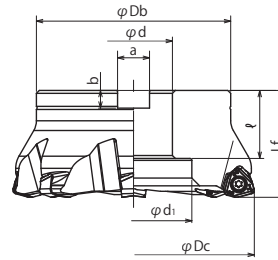
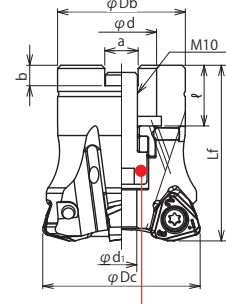


Fig.3
Through coolant hole



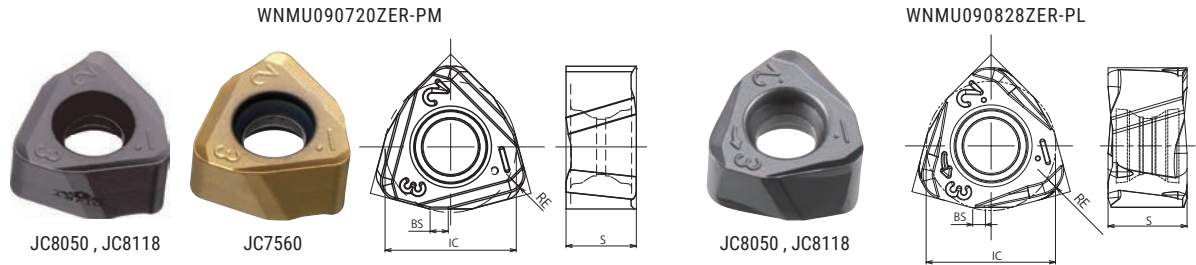
Set bolt built into
the cutter body

Cat.No.	Stock	No. of inserts	Dimensions (mm)								Arbor set bolt	Weight (kg)	Fig.	Inserts 
			ϕDc	L_f	ϕDb	ϕd	ϕd_1	a	b	ℓ				
EXSKS-3050R-22	○	3	50	55	40	22	9.6	10.4	6.3	19	M10×1.5×25	0.4	3	WNMU090720ZER-PM WNMU090828ZER-PL
EXSKS-4050R-22	●	4	50	55	40	22	9.6	10.4	6.3	19	M10×1.5×25	0.3	3	
EXSKS-4052R-22	●	4	52	50	40	22	17	10.4	6.3	20	M10	0.4	1	
EXSKS-4063R-22	○	4	63	50	48	22	17	10.4	6.3	20	M10	0.5	1	
EXSKS-5063R-22	●	5	63	50	48	22	17	10.4	6.3	20	M10	0.5	1	
EXSKS-5063R-27	●	5	63	50	48	27	20	12.4	7	22	M12×1.75×30	0.5	1	
EXSKS-5066R-27	●	5	66	50	48	27	20	12.4	7	22	M12×1.75×30	0.5	1	
EXSKS-6080R-27	●	6	80	55	65	27	37	12.4	7	22	M12×1.75×40	0.9	1	
EXSKS-7100R-32	●	7	100	70	85	32	26	14.4	8	32	M16×2×45	1.9	1	
EXSKS-8125R-40	●	8	125	70	100	40	32	16.4	9	35	M20×2.5×45	3.9	1	
EXSKS-9160R-40	●	9	160	55	100	40	85	16.4	9	35	M20	3.9	2	

Note) All cutters are supplied without inserts or wrenches.

Screw	Torque(N.m)	Wrench
CSW-513H	5.5	A-20

Insert



Cat.No.	Tolerance	PVD coated			Dimensions (mm)			
		JC8118	JC8050	JC7560	IC	S	BS	RE
WNMU090720ZER-PM	M	●	●	●	14	7.66	1.94	2
WNMU090828ZER-PL	M	●	●		13.91	8.66	1.37	2.8

Note) 1.10 inserts per case.

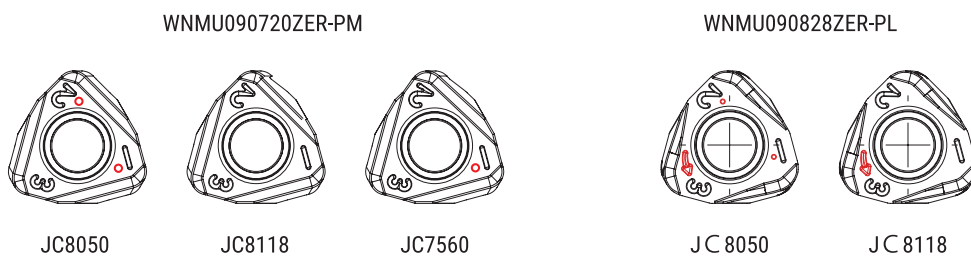
2. When using PL inserts, tool dia. will be smaller than PM insert.

In case dia. $\phi 100$ holder, tool dia. is 0.06mm smaller.

In case dia. $\phi 125$ holder, tool dia. is 0.11mm smaller.

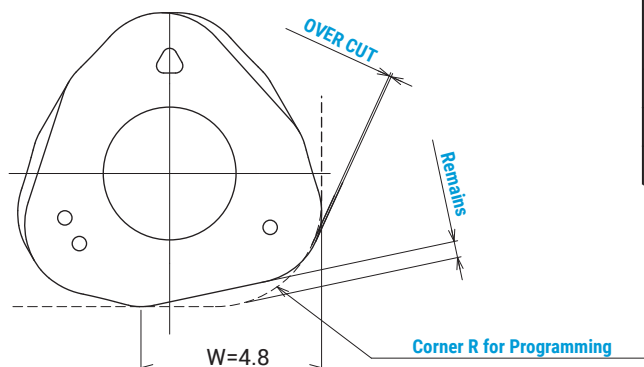
In case dia. $\phi 160$ holder, tool dia. is 0.15mm smaller

GRADE MARKING



EXSKS-05 TYPE

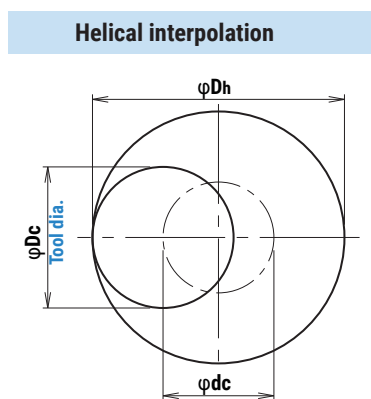
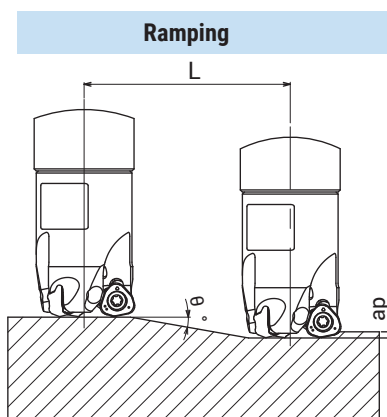
Definition of corner shape for programming



Corner radius for programming	Remains	Over cut
R2.0	0.59	0
R2.5 (Std.)	0.5	0
R3.0	0.41	0.13

(mm)

Attention for profile milling



● Calculation of tool pass dia.

$$\varphi Dc = \varphi Dh - \varphi Dc$$

Tool pass dia. Bore dia. Tool dia.

● Depth of cut per one circuit should not exceed max. depth of cut ap.

● Down cutting is recommended, so tool pass rotation should be counterclockwise.

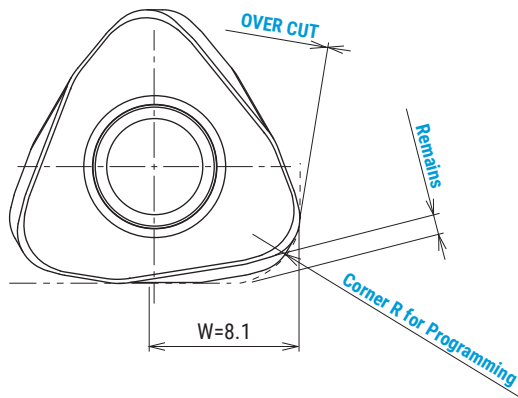
● To obtain a flat bottom surface when helical milling, it requires to remove "the uncut part" in the center of the work material at a final pass.

- In case of ramping and helical interpolation, apply 70% or less feed speed from standard cutting condition table.
- In case of drilling, apply 50% or less Z axis feed speed from standard cutting condition table.
- Long consecutive chips may come out in case of drilling, confirm the safe condition sufficiently.

Cat. No.	Tool dia. (mm)	EFF. Cutting dia. (mm)	Max. depth of cut (mm) ap	Ramping		Helical interpolation			Max. drilling depth Z (mm)
				Max. ramping angle θ°	Total cutting length at Max ap	Min. bore dia. Dh min (mm)	Max. bore dia. Dh min (mm)	Dh min (mm)	
EXSKS-*020/MEX-*020	20	10	1.5	2.8	31	28	36	31	0.4
EXSKS-*021/MEX-*021	21	11	1.5	2.6	34	30	38	33	0.4
EXSKS-*025/MEX-*025	25	15	1.5	1.8	48	38	46	41	0.4
EXSKS-*026/MEX-*026	26	16	1.5	1.7	51	40	48	43	0.4
MEX-*028	28	18	1.5	1.5	58	44	52	47	0.4
MEX-*030	30	20	1.5	1.3	67	48	56	51	0.4
EXSKS-*032/MEX-*032	32	22	1.5	1.2	72	52	60	55	0.4
EXSKS-*033/MEX-*033	33	23	1.5	1.1	79	54	62	57	0.4
MEX-*035	35	25	1.5	1	86	58	66	61	0.4
EXSKS-*040/MEX-*040	40	30	1.5	0.8	108	68	76	71	0.4
EXSKS-*050	50	40	1.5	0.6	144	88	96	91	0.4
EXSKS-*052	52	42	1.5	0.6	144	92	100	95	0.4
EXSKS-*063	63	53	1.5	0.5	172	114	122	117	0.4

EXSKS-07 TYPE

Definition of corner shape for programming

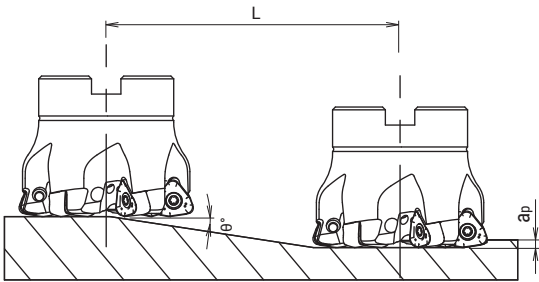


Corner radius for programming	Remains	Over cut
R3.0 (Std.)	0.8	0
R3.5	0.73	0.06
R4.0	0.66	0.21

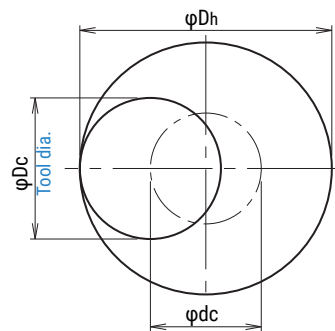
(mm)

Attention for profile milling

Ramping



Helical interpolation



● Calculation of tool pass dia.

$$\phi Dc = \phi Dh - \phi Dc$$

Tool pass dia. Bore dia. Tool dia.

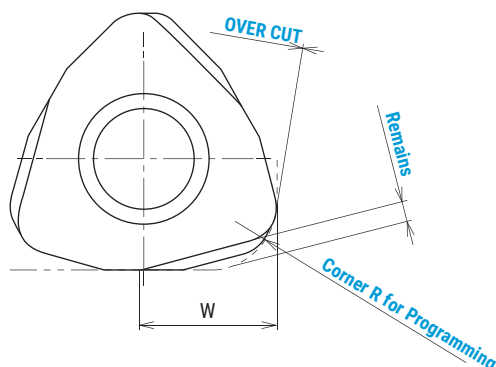
- Depth of cut per one circuit should not exceed max. depth of cut ap.
- Down cutting is recommended, so tool pass rotation should be counterclockwise.
- To obtain a flat bottom surface when helical milling, it requires to remove "the uncut part" in the center of the work material at a final pass.

- In case of ramping and helical interpolation, apply 70% or less feed speed from standard cutting condition table.
- In case of drilling, apply 50% or less Z axis feed speed from standard cutting condition table.
- Long consecutive chips may come out in case of drilling, confirm the safe condition sufficiently.

Cat. No.	Tool dia. (mm)	EFF. Cutting dia. (mm)	Max. depth of cut (mm) ap	Ramping		Helical interpolation			Max. drilling depth Z (mm)
				Max. ramping angle theta°	Total cutting length at Max ap	Min. bore dia. Dh min (mm)	Max. bore dia. Dh min (mm)	Dh min (mm)	
EXSKS-*032/MEX-*032	32	15	2	2.2	53	41	60	48	0.5
EXSKS-*035/MEX-*035	35	18	2	2.1	55	47	66	54	0.5
EXSKS-*040/MEX-*040	40	23	2	2	58	57	76	64	0.5
MEX-*042	42	25	2	1.8	64	61	80	68	0.5
EXSKS-*050	50	33	2	1.5	77	77	96	84	0.5
EXSKS-*052	52	35	2	1.2	96	81	100	88	0.5
EXSKS-*063	63	46	2	1	115	103	122	110	0.5
EXSKS-*080	80	63	2	0.8	144	137	156	144	0.5
EXSKS-*100	100	83	2	0.5	230	178	198	183	0.6

EXSKS-09 TYPE

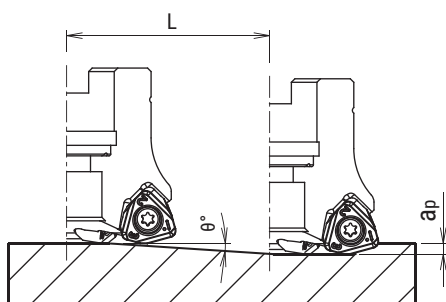
Definition of corner shape for programming



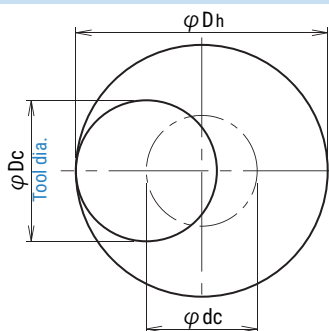
Insert	W	Corner radius for programming	Remains	Over cut
WNMU090720ZER-PM	8.2	R3.0	1.41	0
		R3.5	1.30	0
		R4.0	1.19	0.025
Insert	W	Corner radius for programming	Remains	Over cut
WNMU090828ZER-PL	8.4	R3.0	1.18	0
		R3.5	1.06	0
		R4.0	0.95	0.010

Attention for profile milling

Ramping



Helical interpolation



● Calculation of tool pass dia.

$$\varphi_{dc} = \varphi_{Dh} - \varphi_{Dc}$$

Tool pass dia. Bore dia. Tool dia.

- Depth of cut per one circuit should not exceed max. depth of cut ap.
- Down cutting is recommended, so tool pass rotation should be counterclockwise.
- To obtain a flat bottom surface when helical milling, it requires to remove "the uncut part" in the center of the work material at a final pass.

- In case of ramping and helical interpolation, apply 70% or less feed speed from standard cutting condition table.
- In case of drilling, apply 50% or less Z axis feed speed from standard cutting condition table.
- Long consecutive chips may come out in case of drilling, confirm the safe condition sufficiently.

WNMU090720ZER-PM

Cat. No.	Tool dia. (mm)	EFF. Cutting dia. (mm)	Max. depth of cut (mm) ap	Ramping		Helical interpolation			Max. drilling depth Z (mm)
				Max. ramping angle θ°	Total cutting length at Max ap	Min. bore dia. Dh min (mm)	Max. bore dia. Dh min (mm)	Dh min (mm)	
EXSKS-*050	50	33	3	2.5	69	73	96	81	1.1
EXSKS-*052	52	35	3	2.4	72	77	100	85	1.2
EXSKS-*063	63	46	3	1.8	96	99	122	107	1.2
EXSKS-*066	66	49	3	1.7	102	105	128	113	1.2
EXSKS-*080	80	63	3	1.3	133	133	156	141	1.3
EXSKS-*100	100	83	3	1	172	173	196	181	1.3
EXSKS-*125	125	108	3	0.9	191	223	246	231	1.3
EXSKS-*160	160	143	3	0.7	246	293	316	301	1.7

WNMU090828ZER-PL

Cat. No.	Tool dia. (mm)	EFF. Cutting dia. (mm)	Max. depth of cut (mm) ap	Ramping		Helical interpolation			Max. drilling depth Z (mm)
				Max. ramping angle θ°	Total cutting length at Max ap	Min. bore dia. Dh min (mm)	Max. bore dia. Dh min (mm)	Dh min (mm)	
EXSKS-*050	50	33	2	2.3	50	74	96	82	1
EXSKS-*052	52	35	2	2.2	53	78	100	86	1
EXSKS-*063	63	46	2	1.8	64	100	122	108	1.2
EXSKS-*066	66	49	2	1.7	68	106	128	114	1.2
EXSKS-*080	80	63	2	1.3	89	134	156	142	1.3
EXSKS-*100	99.94	83	2	1	115	174	195	182	1.3
EXSKS-*125	124.89	108	2	0.9	128	224	245	232	1.4
EXSKS-*160	159.85	142	2	0.7	164	294	315	302	1.6

■ Recommended Cutting Conditions - EXSKS-05 type -

Material	Grade	Vc	fz	ap	ae
Carbon Steel below 250HB	JC8050 (JC8118)	120 - 200	0.7 - 1.2	0.4 - 1.0	0.7 Dc
Tool & Die Steel below 255HB	JC8050 (JC8118)	110 - 180	0.7 - 1.2	0.4 - 1.0	0.7 Dc
Mold Steel 30-36HRC	JC8118 (JC8050)	110- 180	0.7 - 1.2	0.4 - 1.0	0.7 Dc
Mold Steel 38-43HRC	JC8118 (JC8050)	80- 130	0.7 - 1.0	0.4 - 0.8	0.6 Dc
Hardened Die Steel 42-52HRC	JC8118	70- 100	0.5 - 0.8	0.5 - 0.7	0.5 Dc
Grey Cast Iron	JC8118 (JC8050)	130 - 200	0.8 - 1.4	0.5 - 1.0	0.7 Dc
Nodular Cast Iron	JC8118 (JC8050)	110 - 180	0.7 - 1,2	0.5 - 1.0	0.7 Dc
Austenitic Stainless Steel	JC8050 (DS250)	90 - 150	0.7 - 1.0	0.4 - 0.8	0.5 Dc
Martensitic Stainless Steel	JC8118 (DS250)	100 - 170	0.9 - 1.2	0.5 - 1.0	0.5 Dc

- Note
1. Please adjust cutting conditions according to machine rigidity or work rigidity. (the above table is guide for cutting on a BT50 machine.)
 2. In case of chatter occurring, recommended to reduce ap or rpm and keep feed per tooth.
 3. ap should be reduced when using on low rigidity machine.
 4. Use air blow.

■ Recommended Cutting Conditions - EXSKS-07 type -

Material	Grade	Vc	fz	ap	ae
Carbon Steel below 250HB	JC8050	120 - 200	1.1 - 1.5	0.5 - 1.5	0.7 Dc
Tool & Die Steel below 255HB	JC8050	100 - 180	1.1 - 1.5	0.5 - 1.5	0.7 Dc
Mold Steel 30-36HRC	JC8118	100 - 180	1.1 - 1.5	0.5 - 1.5	0.7 Dc
Mold Steel 38-43HRC	JC8118	80 - 130	1.0 - 1.3	0.4 - 1.2	0.6 Dc
Hardened Die Steel 42-52HRC	JC8118	70 - 100	0.8 - 1.0	0.4 - 1.0	0.5 Dc
Grey Cast Iron	JC8118	120 - 200	1.1 - 1.5	0.5 - 2.0	0.7 Dc
Nodular Cast Iron	JC8118	100 - 170	1.1 - 1.5	0.5 - 1.5	0.7 Dc
Austenitic Stainless Steel	JC8050 (DS250)	80 - 150	1.0 - 1.2	0.4 - 1.2	0.5 Dc
Martensitic Stainless Steel	JC8118 (DS250)	100 - 170	1.0 - 1.3	0.5~1.5	0.5 Dc

Note

1. Please adjust cutting conditions according to machine rigidity or work rigidity. (the above table is guide for cutting on a BT50 machine.)
2. In case of chatter occurring, recommended to reduce ap or rpm and keep feed per tooth.
3. ap should be reduced when using on low rigidity machine.
4. Use air blow.

■ Recommended Cutting Conditions - EXSKS-09 type -

Material	Grade	Vc	fz	ap	ae
Carbon Steel below 250HB	JC7560 JC8050 (JC8118)	100 - 150	1.0 - 2.0	0.4 - 2.0	0.7 Dc
Tool & Die Steel below 255HB	JC7560 JC8050 (JC8118)	100 - 150	1.0 - 2.0	0.4 - 2.0	0.7 Dc
Mold Steel 30-36HRC	JC7560 JC8050 (JC8118)	90 - 130	1.0 - 2.0	0.4 - 2.0	0.7 Dc
Mold Steel 38-43HRC	JC8118 (JC8050)	70 - 110	0.5 - 1.0	0.4 - 1.5	0.6 Dc
Hardened Die Steel 42-52HRC	JC8118	60 - 80	0.5 - 1.0	0.4 - 1.5	0.5 Dc
Grey Cast Iron	JC8118	100 - 190	1.0 - 2.0	0.4 - 2.5	0.7 Dc
Nodular Cast Iron	JC8118	100 - 190	1.0 - 2.0	0.4 - 2.5	0.7 Dc
Stainless Steel	JC8050 (JC7560)	100 - 150	1.0 - 1.5	0.4 - 2.0	0.5 Dc

Note

1. Please adjust cutting conditions according to machine rigidity or work rigidity. (the above table is guide for cutting on a BT50 machine.)
2. In case of chatter occurring, recommended to reduce ap or rpm and keep feed per tooth.
3. ap should be reduced when using on low rigidity machine.
4. Use air blow.

HIGH FEED TOOLS LINE-UP**SKS SERIES****QM SERIES**

PRODUCT	EXSKS 09	EXSKS/MEX 07	SKG/MSG	EXSKS/MEX 05	GMX/MXG	QXP/MQX	MPM/PME
Tool Dia (mm)	Φ50 - Φ160	Φ32 - Φ100	Φ25 - Φ100	Φ20 - Φ63	Φ16 - Φ66	Φ16 - Φ66	Φ10 - Φ32
Max. ap (mm)	3.0	2.0	1.5 - 2.5	1.5	1.0	1.0	0.4
No of corners	6	6	4	6	4	2	2
Insert Spec.	Double sided	Double sided	Single sided	Double sided	Double sided	Single sided	Single sided
Machine type	BT50	BT50	BT40 - 50	BT40 - 50	BT40 - 50	BT40 - 50	BT30 - 40
Program R	R 3.5	R 3.0	R 2.0 - 4.0	R 2.5	R 1.5	R 1.5	R 1.0

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