



ONHU05

16 Corner Roughing Insert

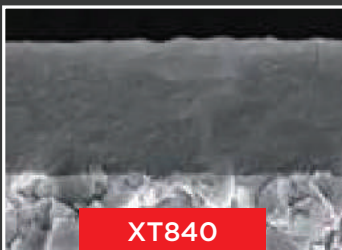
Innovative Solutions
Indian Values



Features & Benefits

- Fully ground circumference
- Double-sided standard inserts with 16 cutting edges
- 0.8 mm corner radius
- 16 cutting edges per indexable insert with negative basic shape
- Extremely effective for Face Milling applications of A_p up to 2.5mm. in P|M|K|H|S
- Small insert with 16 corners can help with economics of scale and increase productivity.
- Small insert size can enable working on low power machines as well.
- Available in R geometry roughing.

Grade Information



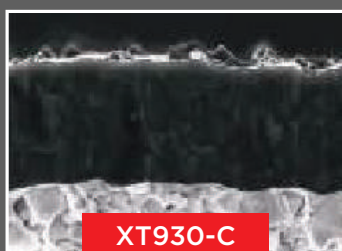
P10-P30 | K10-K25 | M10-M25

Composition: Do 105 % moed cartides 20%,
WC balance | firain size 1-2 Qm) Hardness HV30 1400
Casting specification: PVO TAIT First choice for dry
machining of steels and Dat high cutting speehs



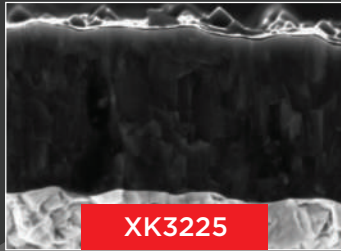
M10-M35 | P10-P35 | S05-515

Composition: Co 10.0% other 1.5%;
rest TC | Grain size: coarse Coating: PVD TIAITAN
Particularly suitable for the machining of high-alloy steels,
Stainless Steels and Superalloys (austenitic).



P15-P35 | M15-M35 | H05-H15

Ultra find grade with Nano coating for high heat resistance
and toughness. Special AlTiMeN coating gives it a bronze
shade and higher temperature resistance! The first choice
for general-purpose machining of stainless steel. It can be
used for supplementary machining of soft steels.



K15-K35 | P15-P25

- Yellow Coating
- Around 7-9 μ Al₂O₃ and 6-8 μ TiCN, which is for improving wear resistance and toughness to protect the basic impact.

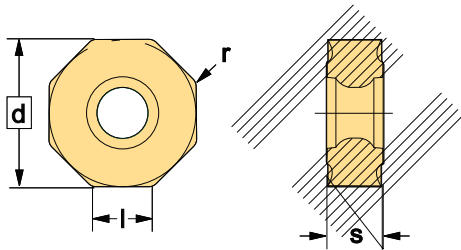


Recommended Cutting Condition

ISO	Material Group	Relative Materials (DIN)	Hardness HB				
				XT840	XT930	XT930-C	XK3225
P	Non-alloy steel	9 SMn 28, C35C50, C40E, C45E, 49 CrMo 4	125-250	90-250			120-160
	Low alloy steel	13 CrMo 44, 40NiCrM022, 58 CrV 4l	200-350	80-220	80-220	80-180	
	High alloy steel	X 40 CrMoV 5 1, X100 CrMoV 5 1, S6-5-5	200-325	80-180	80-180	60-160	110-140
M	Ferritic/martensitic Stainless steel	X6Cr13, X10CrA118, X20CrNi175	200-240	200-240	80-180	60-220	
	Austenitic Stainless steel	X5 CrNi 18 9, X5 CrNiMo 17 13 3, X6 CrNiTi 18 9	180	180	80-180	60-180	
K	Grey cast iron	GG15, GG20, GGG40, GG-35	180-260	180-260			120-240
	Malleable castiron	GTS-35-10, GTS-35, GTS70-02, 20mN5	130-230	90-240			120-180
S	Fe, Ni or Co based	X12 NiCrAlTi 31 20, TiAl5Sn2	200-350		40-120	40-120	
	Titanium and Ti-alloy based	TiCu2, TiAl6V4, TiAl6V4ELI			30-100	30-100	
H	Hardended steel	C 105 W1.75 CrMoNiW 6 7	55-60 Hrc		30-90	30-120	
	Chilled cast iron	G-X 260 NiCr 4 2, X15 CrNiSi 25 20	400				
	Cast iron	G-X 300 CrMo 15 3	55 Hrc				



Insert Table



Designation	Tolerance Class	No. of Cutting Edges (z)	Insert Thickness (s)	Diameter (d)	Length (l)	Corner Radius (r)	XT840	XT930	XT930-C	XK3225
ONHU050408-AR	H	16	4.86mm	12.7mm	5.26mm	0.8mm	●	●	●	●

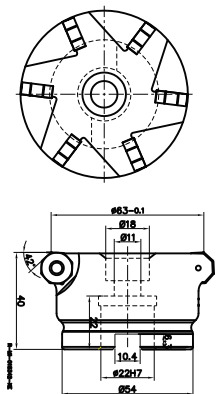
● Stockable ○ Non Stockable



Cutter Table

Designation	D	d	L	Z	Availability
XTSM-D40-Z4-A16-ONHU05	40	16	40	4	●
XTSM-D50-Z5-A22-ONHU05	50	22	40	5	●
XTSM-D63-Z6-A22-ONHU05	63	22	40	6	●
XTSM-D80-Z7-A27-ONHU05	80	27	50	7	●
XTSM-D100-Z8-A32-ONHU05	100	32	50	8	●
XTSM-D125-Z10-A40-ONHU05	125	40	63	10	●

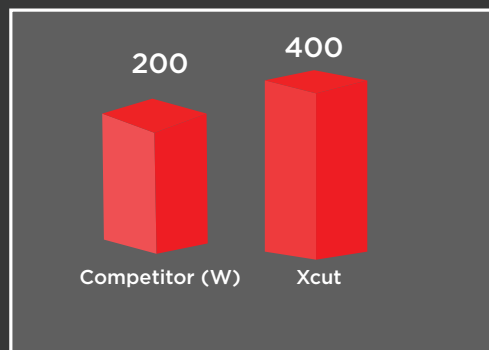
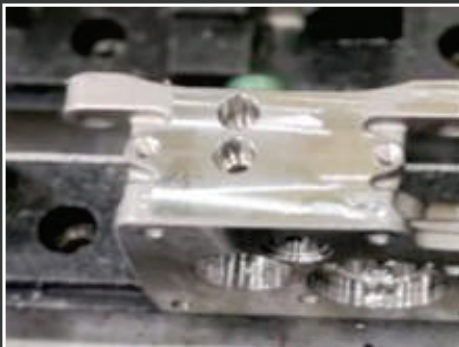
● Stockable ○ Non Stockable





Case Study

ONHU05		
Product Description	ONHU050408 AR-XT930-C	
Material & Hardness	ULL.2/SS Alloy (D1 48 15)	
Parameters	Competitor (D)	XCUT
Depth of Cut	1	1
Vc: m/min	126	100
Fz: mm/tooth	0.1	0.14
Improved Productivity By 16% and Tool Life By 100%		



Tool Life (No. Of Comp)



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