



# SNKU12T5

Exclusive For  
***Cast Iron Machining***

Innovative Solutions  
Indian Values



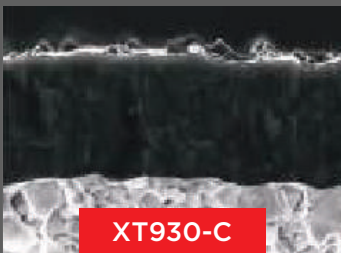
## SNKU12T5

### Features & Benefits

- First choice for cast iron machining.
- Negative insert geometry helps in reducing load on machine and manages the cutting force
- Can take higher DOC at higher cutting speeds
- Special chamfer in the insert helps increase tool life
- 8 cutting edges per indexable insert with negative basic shape
- Available in 2 Corner radii (0.8 CR has chamfer & 1.2 CR with Geometry)



### Grade Information



XT930-C

#### P15-P35 | M15-M35 | H05-H15

Ultra fine 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.

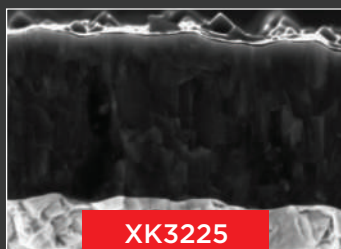


XK3220

#### K15-K30

Thick  $\text{Al}_2\text{O}_3$  over TiCN coating combined with strong impact resistance matrix keeps the insert stable at high temperature. TiCN layer with antiwear material abrasion performance lead to the best wear resistant of the face of clearance angle.

High wear resistance substrate provides added stability to machine Gray & Ductile Cast Iron at higher vc



XK3225

#### K15-K35 | P15-P25

- Black Coating
- Around 7-9  $\mu$   $\text{Al}_2\text{O}_3$  and 6-8  $\mu$  TiCN, which is for improving wear resistance and toughness to protect the basic impact.

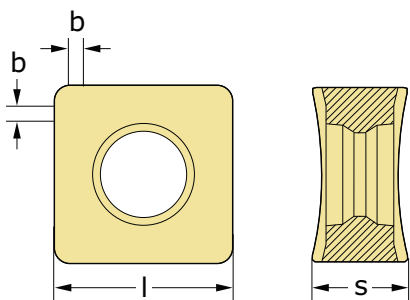


## Recommended Cutting Condition

ISO	Material Group	Relative Materials (DIN)	Hardness HB	XT930-C	XK3220	XK3225
P	Non-alloy steel	9 SMn 28, C35C50, C40E, C45E, 49 CrMo 4	125-250	90-250		
	Low alloy steel	13 CrMo 44, 40NiCrMo22, 58 CrV 4l	200-350	80-220		80-220
	High alloy steel	X 40 CrMoV 5 1, X100 CrMoV 5 1, S6-5-5	200-325	80-180		80-180
M	Ferritic/martensitic Stainless steel	X6Cr13, X10CrA118, X20CrNi175	200-240	140-200		
	Austenitic Stainless steel	X5 CrNi 18 9, X5 CrNiMo 17 13 3, X6 CrNiTi 18 9	180	180		
K	Grey cast iron	GG15, GG20, GGG40, GG-35	180-260		100-270	80-220
	Malleable cast iron	GTS-35-10, GTS-35, GTS70-02, 20mN5	130-230		100-270	80-220
S	Fe, Ni or Co based	X12 NiCrAlTi 31 20, TiAl5Sn2	200-350			
	Titanium and Ti-alloy based	TiCu2, TiAl6V4, TiAl6V4ELI				
H	Hardened steel	C 105 W1.75 CrMoNiW 6 7	55-60 Hrc	60-110		
	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	No. of Cutting Edges (Z)	Length (l)	Corner Radius (b)	Insert Thickness (s)	XT930-C	XK3220	XK3225
SNKU12T512- NN	8	12.7 mm	1.2mm	5.77 mm	●	●	●
SNKU12T5Z-NN	8	12.7 mm	0.8mm	5.77 mm	●	●	●

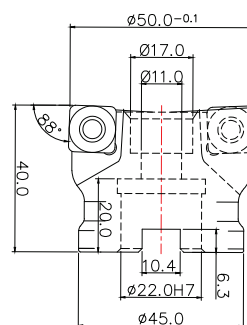
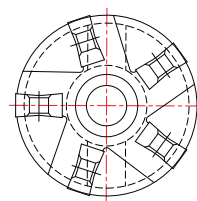
● Stockable ○ Non Stockable



## Cutter Table

Designation	D	d	L	Z	Availability
XTSM-D40-Z3-A16-SNKU12T5	40	16	40	4	○
XTSM-D40-Z4-A16-SNKU12T5	40	16	40	4	●
XTSM-D50-Z4-A22-SNKU12T5	50	22	40	5	●
XTSM-D50-Z5-A22-SNKU12T5	50	22	40	5	●
XTSM-D63-Z5-A22-SNKU12T5	63	22	40	6	○
XTSM-D63-Z6-A22-SNKU12T5	63	22	40	6	●
XTSM-D80-Z6-A27-SNKU12T5	80	27	50	7	○
XTSM-D80-Z7-A27-SNKU12T5	80	27	50	7	●
XTSM-D100-Z8-A32-SNKU12T5	100	32	50	8	●
XTSM-D125-Z9-A40-SNKU12T5	125	40	63	9	●
XTSM-D160-Z10-A40-SNKU12T5	140	40	63	12	○

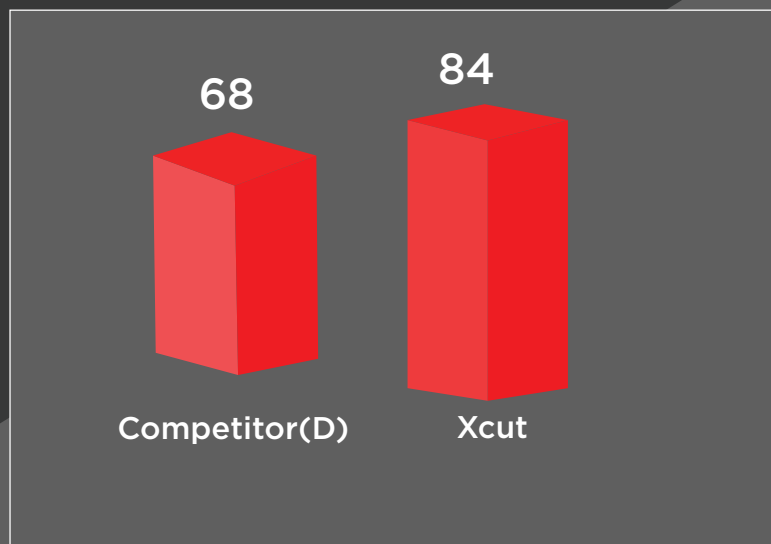
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## Case Study

SNKU12T5		
Product Description	SNKU12T512-NN-XK3225	
Material & Hardness	SG Housing (280 BHN)	
Parameters	Competitor (D)	XCUT
Depth of Cut	2mm	2.5mm
Vc: m/min	225	225
Fz: mm/tooth	0.22	0.22
Life Increased By 17%		



Tool Life (No. Of Comp)



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