

Multifunctional tool for drilling and turning

TUNGB^{ORE}MINI

Tungaloy Report No. 529S3-G



For more information

Expansion of **DMIN 8mm** to the lineup

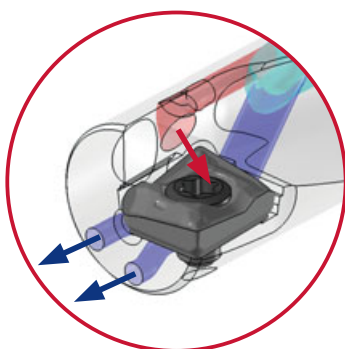


New toolholders for the minimum bore diameter (DMIN) range of ø8 mm

New Line ups

	Minimum bore diameter: DMIN (mm)								
	ø8	ø10	ø12	ø14	ø16	ø18	ø20	ø25	ø32
TUNGB ^{ORE} MINI	New	Line up							

Features

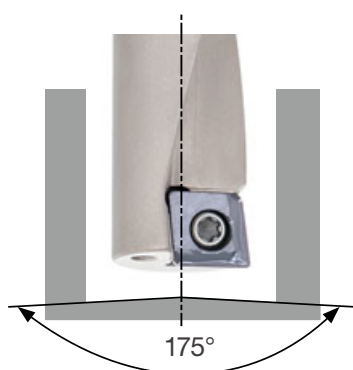


Optimized through-coolant ensures effective chip evacuation during machining

Single-sided insert with 2 corners

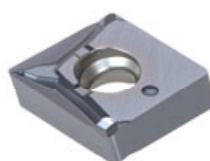


The flute is designed to promote smooth chip flow, while ensuring tool rigidity



Creates a near-flat hole bottom

Optimized chipbreaker design enables effective chip control in all applications



XOMU-PS

For toolholders for
DMIN = 10 - 32 mm



New

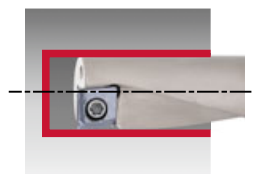
XCMT-PS

For toolholders for
DMIN = 8 mm

CUTTING PERFORMANCE

Drilling

P	Holder	: TBM08RF12-2.25
	Insert	: XCMT040102R-PS AH725
	Workpiece material	: S45C / C45
	Cutting speed	: $V_c = 100$ m/min
	Application	: Drilling
	Coolant	: Internal



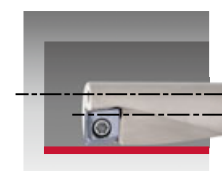
Drilling

0.02	0.03	0.04	0.05
Feed: f (mm/rev)			

Stable machining and excellent chip control during hole making process.

Internal turning

P	Holder	: TBM08RF12-2.25
	Insert	: XCMT040102R-PS AH725
	Workpiece material	: S45C / C45
	Cutting speed	: $V_c = 150$ m/min
	Application	: Internal turning
	Coolant	: Internal

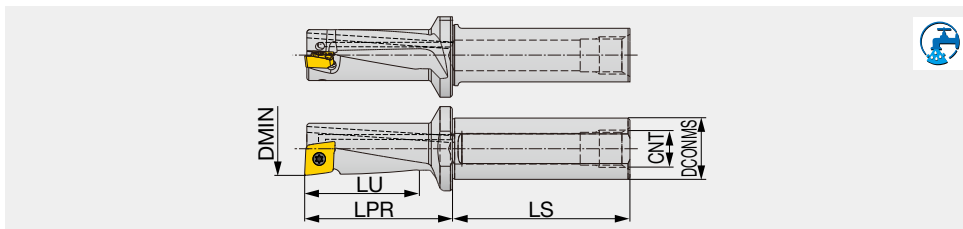


Turning

Depth of cut: ap (mm)	1				
	0.5				
	0.2				
		0.04	0.06	0.1	0.12
		Feed: f (mm/rev)			

Excellent chip control during I.D. finishing operation.

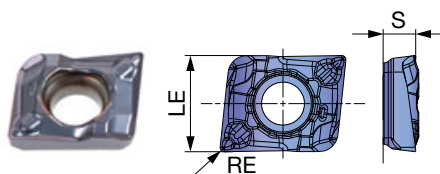
Maximum hole depth for $L/D = 2.25$



Torque*: Recommended clamping torque (N·m)

■ INSERT

XCMT-PS



★ : First choice

- : New product
- : Line up

STANDARD CUTTING CONDITIONS

Drilling

ISO	Workpiece materials	Cutting speed Vc (m/min)	Minimum bore diameter: DMIN (mm)								
			ø8	ø10	ø12	ø14	ø16	ø18	ø20	ø25	ø32
P	Low carbon steel Carbon steel	50 - 180	0.02 - 0.05	0.02 - 0.05	0.02 - 0.07	0.01 - 0.075	0.01 - 0.08	0.05 - 0.13	0.05 - 0.13	0.05 - 0.14	0.05 - 0.14
M	Stainless steel	50 - 160	0.02 - 0.05	0.02 - 0.05	0.02 - 0.07	0.01 - 0.075	0.01 - 0.08	0.05 - 0.13	0.05 - 0.13	0.05 - 0.14	0.05 - 0.14
K	Cast iron	50 - 180	0.02 - 0.05	0.02 - 0.05	0.02 - 0.07	0.01 - 0.075	0.01 - 0.08	0.05 - 0.13	0.05 - 0.13	0.05 - 0.14	0.05 - 0.14
N	Aluminium alloys	100 - 300	0.02 - 0.05	0.02 - 0.05	0.02 - 0.07	0.01 - 0.075	0.01 - 0.08	0.05 - 0.13	0.05 - 0.13	0.05 - 0.14	0.05 - 0.14

Internal turning

ISO	Workpiece materials	Cutting speed Vc (m/min)	Minimum bore diameter: DMIN (mm)								
			ø8	ø10	ø12	ø14	ø16	ø18	ø20	ø25	ø32
P	Low carbon steel Carbon steel	50 - 180	Depth of cut: ap (mm)								
			0.2 - 2.5	0.5 - 3	0.5 - 3.5	0.5 - 4.5	0.5 - 5	0.5 - 5.5	0.5 - 6	0.5 - 6.5	0.5 - 7
			Feed: f (mm/rev)								
			0.02 - 0.12	0.05 - 0.2	0.05 - 0.2	0.05 - 0.2	0.05 - 0.2	0.1 - 0.3	0.1 - 0.3	0.1 - 0.3	0.1 - 0.4

ISO	Workpiece materials	Cutting speed Vc (m/min)	Minimum bore diameter: DMIN (mm)								
			ø8	ø10	ø12	ø14	ø16	ø18	ø20	ø25	ø32
M	Stainless steel	50 - 160	Depth of cut: ap (mm)								
			0.2 - 2.5	0.5 - 3	0.5 - 3.5	0.5 - 4.5	0.5 - 5	0.5 - 5.5	0.5 - 6	0.5 - 6.5	0.5 - 7
			Feed: f (mm/rev)								
			0.02 - 0.12	0.05 - 0.2	0.05 - 0.2	0.05 - 0.2	0.05 - 0.2	0.1 - 0.3	0.1 - 0.3	0.1 - 0.3	0.1 - 0.4

ISO	Workpiece materials	Cutting speed Vc (m/min)	Minimum bore diameter: DMIN (mm)								
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K	Cast iron	50 - 180	Depth of cut: ap (mm)								
			0.2 - 2.5	0.5 - 3	0.5 - 3.5	0.5 - 4.5	0.5 - 5	0.5 - 5.5	0.5 - 6	0.5 - 6.5	0.5 - 7
			Feed: f (mm/rev)								
			0.02 - 0.12	0.05 - 0.2	0.05 - 0.2	0.05 - 0.2	0.05 - 0.2	0.1 - 0.3	0.1 - 0.3	0.1 - 0.3	0.1 - 0.4

ISO	Workpiece materials	Cutting speed Vc (m/min)	Minimum bore diameter: DMIN (mm)								
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			0.2 - 2.5	0.5 - 3	0.5 - 3.5	0.5 - 4.5	0.5 - 5	0.5 - 5.5	0.5 - 6	0.5 - 6.5	0.5 - 7
			Feed: f (mm/rev)								
			0.02 - 0.12	0.05 - 0.2	0.05 - 0.2	0.05 - 0.2	0.05 - 0.2	0.1 - 0.3	0.1 - 0.3	0.1 - 0.3	0.1 - 0.4

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