

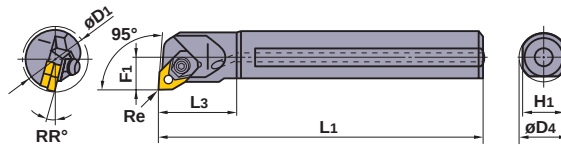
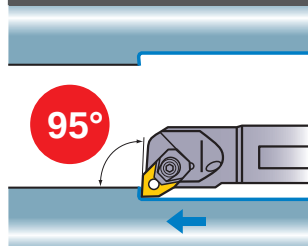
BORING BARS

M TYPE
BORING BARS

- The minimum cutting diameter is $\phi 63$.
- Negative trigon shape insert.
- Double clamp type.
- l/d is 3 times the diameter.

MWLN

With coolant hole

WN $\circ$ inserts

Right hand tool holder only.

Finish	Light	Medium
FH	LM	MP
		
(08)	(08)	(08)
Medium	Medium	Stainless
MA	GM	MM
		
(08)	(08)	(08)

Order Number	Stock	Insert Number		Dimensions (mm)						Min. Cutting Diameter D1	Standard Corner Radius Re								
	R			D4	L1	L3	F1	H1	RR°			Shim	Shim Pin	Clamp Bridge	Side Lock Plate	Spring	Clamp Screw	Wrench	Plug
A50UMWLN08	●	WNMA WNMG	0804	50	350	80	35	63	9	63	0.8	WPS WC43	CCP44	CCK13	CPT24	MES2	SLCS105	HKY25R HKY40R	HGM-PT3/8

★ Clamp Torque (N • m) : SLCS105=7.0

RECOMMENDED CUTTING CONDITIONS

Work Material	Hardness	Cutting Mode	$l/d \leq 3$			$l/d = 3 - 4$		
			Cutting Speed (m/min)	Feed (mm/rev)	Depth of Cut (mm)	Cutting Speed (m/min)	Feed (mm/rev)	Depth of Cut (mm)
P Carbon Steel, Alloy Steel	180—350HB	Medium Cutting	110 (80—140)	0.25 (0.1—0.4)	—5.0	110 (80—140)	0.2 (0.1—0.3)	—4.0
M Stainless Steel	≤ 200 HB	Medium Cutting	80 (60—100)	0.2 (0.1—0.3)	—4.0	70 (50—100)	0.15 (0.1—0.25)	—3.0
K Cast Iron	Tensile Strength ≤ 350 MPa	Medium Cutting	80 (60—100)	0.25 (0.1—0.4)	—5.0	80 (60—100)	0.2 (0.1—0.3)	—4.0

(Note 1) Insert photo, letters show chip breaker style, figures show insert dimensions.

(Note 2) When using inserts with right or left hand chip breakers, please use left hand inserts for right hand holders and right hand inserts for left hand holders.

● : Inventory maintained.

 WN $\circ$ type inserts > A119—A123
 CBN inserts > B031