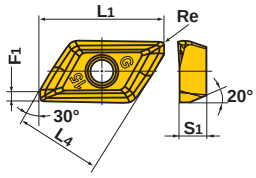
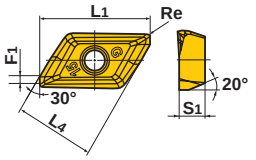
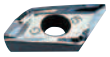
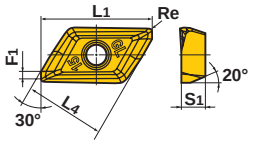
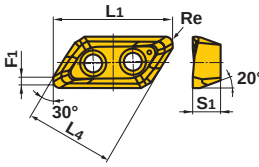
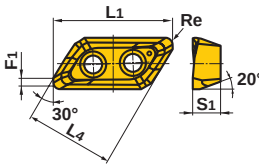
Work Material			MP9120	VP15TF	LC15TF	TF15
	P	Steel		◐		
	M	Stainless Steel		◐		
	K	Cast Iron		✣		
	N	Non-ferrous Metal			✣	◐
	S	Heat-resistant Alloy, Titanium Alloy	◐	◐		
	H	Hardened Materials		◐		

Cutting Conditions (Guide):
●: Stable Cutting ◐: General Cutting ✣: Unstable Cutting

Honing:
E: Round F: Sharp

Shape	Order Number	Class	Honing	Coated MP9120	Coated VP15TF	Coated LC15TF	Carbide TF15	L1	L4	S1	F1	Re	Geometry
BXD4000	XDGT1550PDER-G04	G	E		●			22	16	5	1.5	0.4	
	1550PDER-G08	G	E		●			22	16	5	1.1	0.8	
	1550PDER-G12	G	E		●			22	16	5	0.7	1.2	
	1550PDER-G16	G	E		●			22	16	5	0.4	1.6	
	1550PDER-G20	G	E		●			21.7	16	5	0.2	2.0	
	1550PDER-G30	G	E		●			20	16	5	0.6	3.0	
	1550PDER-G32	G	E		●			20	16	5	0.4	3.2	
	1550PDER-G40	G	E		●			19	16	5	0.5	4.0	
	1550PDER-G50	G	E		●			18	16	5	0.4	5.0	
BXD4000	XDGT1550PDFR-G04	G	F			●	●	22	16	5	1.5	0.4	
	1550PDFR-G08	G	F			●	●	22	16	5	1.1	0.8	
	1550PDFR-G12	G	F			●	●	22	16	5	0.7	1.2	
	1550PDFR-G16	G	F			●	●	22	16	5	0.4	1.6	
	1550PDFR-G20	G	F			●	●	21.7	16	5	0.2	2.0	
	1550PDFR-G30	G	F			●	●	20	16	5	0.6	3.0	
	1550PDFR-G32	G	F			●	●	20	16	5	0.4	3.2	
	1550PDFR-G40	G	F			●	●	19	16	5	0.5	4.0	
	1550PDFR-G50	G	F			●	●	18	16	5	0.4	5.0	
BXD4000	XDGT1550PDFR-GL04	G	F				●	22	16	5	1.5	0.4	
	1550PDFR-GL08	G	F				●	22	16	5	1.1	0.8	
AXD4000 ➲K044	XDGX175004PDFR-GL	G	F			★	●	23	17.5	5	1.7	0.4	
	175008PDFR-GL	G	F			★	●	23	17.5	5	1.3	0.8	
	175012PDFR-GL	G	F			★	●	23	17.5	5	0.9	1.2	
	175016PDFR-GL	G	F			★	●	22	17.5	5	1.4	1.6	
	175020PDFR-GL	G	F			★	●	22	17.5	5	1.0	2.0	
	175024PDFR-GL	G	F			★	●	22	17.5	5	0.6	2.4	
	175030PDFR-GL	G	F			★	●	21.1	17.5	5	0.8	3.0	
	175032PDFR-GL	G	F			★	●	21.1	17.5	5	0.6	3.2	
	175040PDFR-GL	G	F			★	●	20	17.5	5	0.8	4.0	
	175050PDFR-GL	G	F			★	●	19.4	17.5	5	0.4	5.0	
AXD4000 ➲K044	NEW XDGX175004PDER-GM	G	E	●				23.0	17.5	5	1.7	0.4	
	NEW 175008PDER-GM	G	E	●				23.0	17.5	5	1.3	0.8	
	NEW 175012PDER-GM	G	E	●				23.0	17.5	5	0.9	1.2	
	NEW 175016PDER-GM	G	E	●				22.0	17.5	5	1.4	1.6	
	NEW 175020PDER-GM	G	E	●				22.0	17.5	5	1.0	2.0	
	NEW 175024PDER-GM	G	E	●				22.0	17.5	5	0.6	2.4	
	NEW 175030PDER-GM	G	E	●				21.1	17.5	5	0.8	3.0	
	NEW 175032PDER-GM	G	E	●				21.1	17.5	5	0.6	3.2	
	NEW 175040PDER-GM	G	E	●				20.0	17.5	5	0.5	4.0	
	NEW 175050PDER-GM	G	E	●				19.4	17.5	5	0.4	5.0	

ROTATING INSERTS

= MIRACLE SIGMA