

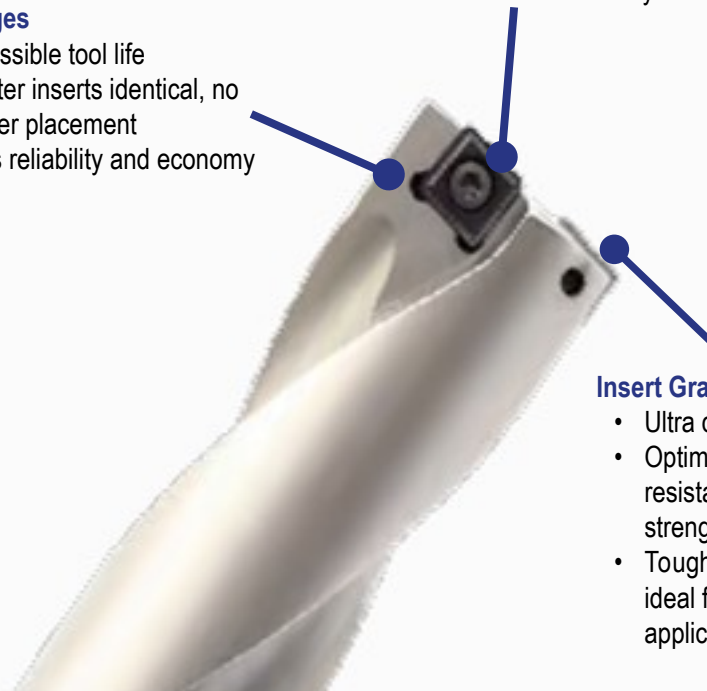
QXF

New MS Chipbreaker

- Designed for sticky and long chipping materials
- Ideal for stainless steel and heat resistant alloys

Four cutting edges

- Maximum possible tool life
- Inner and outer inserts identical, no confusion over placement
- High process reliability and economy



Insert Grade ET602

- Ultra dense PVD coating
- Optimised for thermal resistance and added strength
- Tough carbide substrate, ideal for demanding applications

Tool: **QXF3D3300 3xD**

Material: **D2 Tool steel**

Drilling depth: **60mm**

Method: **Through hole**

Hardness: **180-190HB**

Toolholder: **Hydraulic chuck**

Size: **ø33mm**

v_c : **120 m/min**

Coolant: **Through coolant**

Insert: **SPMX 090408 ET602**

f_n : **0.1 mm/rev**

Machine: **Vertical Machining Centre**

Test was stopped at 300 μ m insert flank wear

