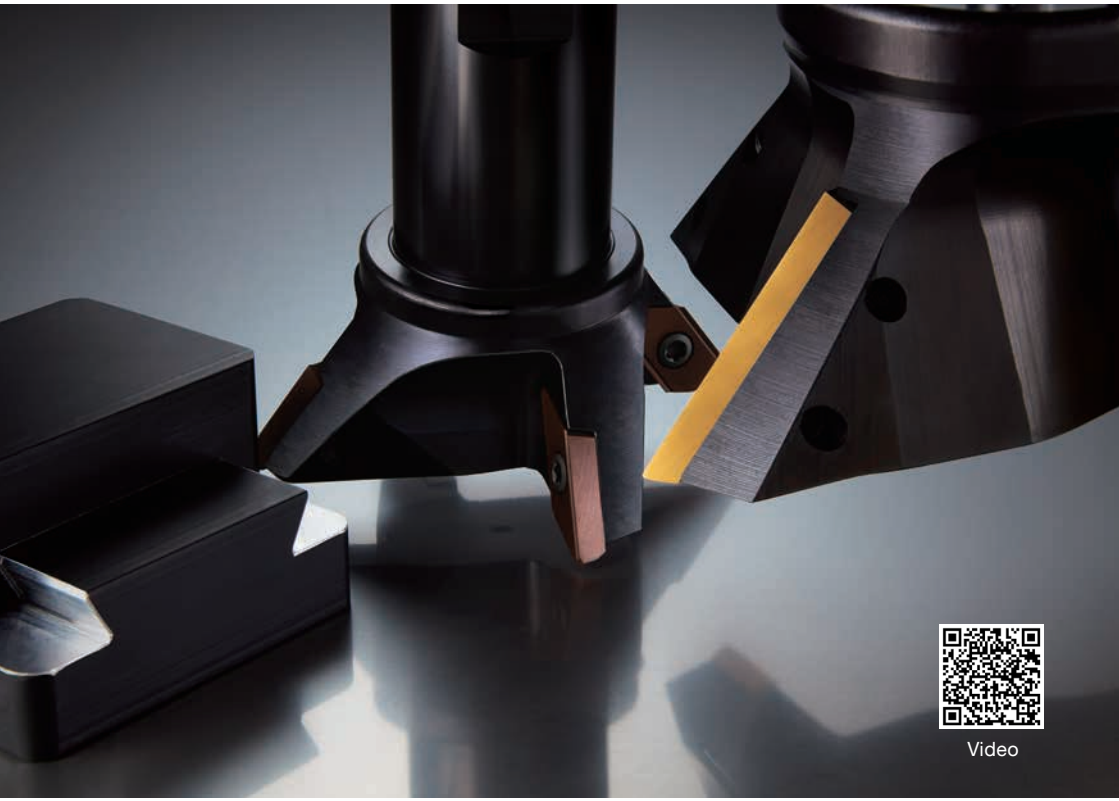
DOVETAIL MILLING CUTTERS SERIES



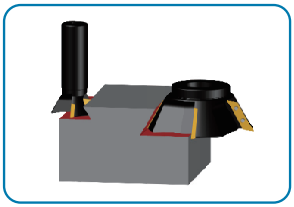
Features

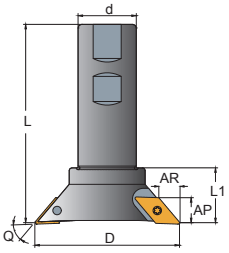
- Available in materials: P K M N S H
- Cost **100~300%** SAVING
- Applicable Machines: CNC Milling machine
- Efficiency **300%** UP
- Durability **300%** UP

PRODUCT SPECIFICATIONS

Dovetail Toolholders

- Inserts P. 337
- Cutting Data P. 338 - 339



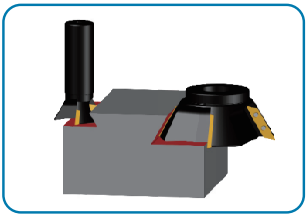


XD

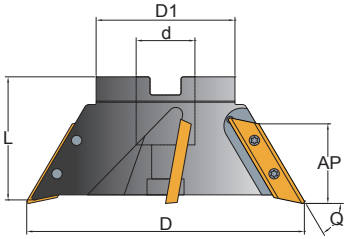
Order Code	Dimensions (mm)							Z	KG	MAX. RPM	Inserts XDGT	Screw	Key
	D	d	Q	L	AP	AR	L1						
XD2040-50	40	20	50	110	10	8		2	0.31	17000	120308	C03506	T10P
XD2040-55			55		10.5	7							
XD2040-60			60		11	6							
XD3260-45	60	32	45		13	10		3	0.76	7500	190408	C04008	T15P
XD3260-50			50		14	11							
XD3260-55			55		15	10							
XD3260-60			60		16	9							
XD3280-45	80		45		13	10		4	0.97	6500			
XD3280-50			50		14	11							
XD3280-55			55		15	10							
XD3280-60			60		16	9							

Dovetail Milling Cutters

- Inserts P. 337
- Cutting Data P. 338 - 339



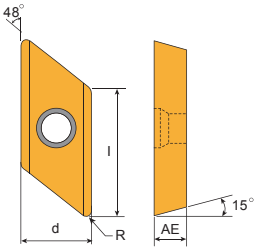
Big "AP"is available with insert XDGT40. Achieve better surface finising.



XV

Order Code	Dimensions (mm)						Z	KG	MAX. RPM	Inserts XDGT	Screw	Key
	D	D1	d	L	AP	Q						
XV120-45-25.4	120	60	25.4	55	30	45	4	1.28	6000	400408	C04011	T15P
XV120-50-25.4					31	50						
XV120-55-25.4					33	55						
XV120-60-25.4					35	60						
XV120-45-27			27		30	45						
XV120-50-27					31	50						
XV120-55-27					33	55						
XV120-60-27					35	60						

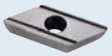
XDGT Inserts

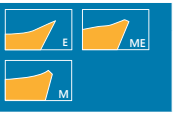


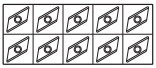
Tolerances (mm)

d	AE
±0.015	±0.015

Code	Dimensions (mm)				
	l	d	AE	R	Angle
120308	13	8.3	3.10	0.8	48°
190408	16	10.45	4.45		
400408	40		4.70		

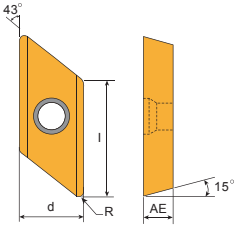
Inserts	Order Code	Grades										
		Coated					Cermet			Uncoated		
		B100	C200	C250	F20	F30	CE25	CE100	CE60	K10	CE	
	XDGT120308R-E				■							
	XDGT120308R-ME	◎				■						
	XDGT120308TR-M	◎										
	XDGT190408R-E				■							
	XDGT190408R-ME	◎				■						
	XDGT190408TR-M	◎										
	XDGT400408R-E				■							
	XDGT400408R-ME	◎				■						
	XDGT400408TR-M	◎										





Inserts 10 PCS / Box

Inserts
2 PCS / Box

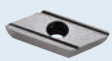


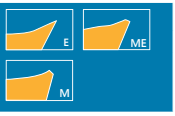
Tolerances (mm)

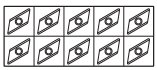
d	AE
±0.015	±0.015

＊ Only for 45° Dovetail Holder

Code	Dimensions (mm)				
	l	d	AE	R	Angle
120308N	11	8.3	3.10	0.8	43°
190408N	15	10.45	4.45		
400408N	40		4.70		

Inserts	Order Code	Grades										
		Coated					Cermet			Uncoated		
		B100	C200	C250	F20	F30	CE25	CE100	CE60	K10	CE	
	XDGT120308NR-E				■							
	XDGT120308NR-ME	◎				■						
	XDGT120308NTR-M	◎										
	XDGT190408NR-E				■							
	XDGT190408NR-ME	◎				■						
	XDGT190408NTR-M	◎										
	XDGT400408NR-E				■							
	XDGT400408NR-ME	◎				■						
	XDGT400408NTR-M	◎										





Inserts 10 PCS / Box

Inserts
2 PCS / Box

- ■ Steel ■ Stainless Steel ◎ Steel/Stainless Steel/Super alloy ■ Cast Iron ■ Aluminum ■ Steel/Cast Iron ◎ Steel/Stainless Steel/Cast Iron
- Prices and stocks are based on present conditions
- Please specify model numbers the and grade of inserts, ie.: XDGT120308R-E, F20

Dovetail

XDGT Insert Grade Selection

Material group	Recom. fz (mm/tooth)	Grades			
		XDGT ... M	XDGT ... ME	XDGT ... E	
1	0.08-0.25	-	B100	-	-
2	0.08-0.25	-	B100	-	-
3	0.08-0.25	-	B100	-	-
4	0.08-0.25	-	B100	-	-
5	0.06-0.20	-	B100	-	-
6	0.06-0.20	-	B100	-	-
7	0.08-0.15	-	B100	-	-
8	0.08-0.15	-	B100	-	-
9	0.07-0.15	-	B100	-	-
10	0.06-0.15	-	B100	-	-
11	0.10-0.15	-	B100	-	-
12	0.10-0.25	-	F30	-	-
13	0.10-0.25	-	F30	-	-
14	0.10-0.20	-	F30	-	-
15	0.05-0.20	-	F30	-	-
16	0.05-0.25	-	-	F20	-
17	0.06-0.25	-	-	F20	-
18	0.06-0.25	-	-	F20	-
19	0.05-0.08	-	B100	-	-
20	0.05-0.08	-	B100	-	-
21	0.06-0.08	-	B100	-	-
22	0.05-0.08	-	B100	-	-

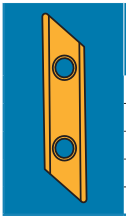
Recommended Cutting Data

• Recommended Cutting speed, Vc(m/min)

Material group	Grades																	
	B100			C250			F20			CE60	CE	K10	F30					
	fz (mm/tooth)																	
	0.08	0.15	0.20	0.08	0.15	0.20	0.08	0.15	0.25				0.08	0.15	0.25			
	Cutting Speed, V_c (m/min)																	
1	192	152	136	-			-			-	-	-	-					
2	168	132	116	-			-			-	-	-	-					
3	136	118	100	-			-			-	-	-	-					
4	124	104	84	-			-			-	-	-	-					
5	108	92	-	-			-			-	-	-	-					
6	92	72	-	-			-			-	-	-	-					
7	32	28	-	-			-			-	-	-	-					
8	108	89	79	-			-			-	-	-	-					
9	92	76	66	-			-			-	-	-	-					
10	76	60	54	-			-			-	-	-	-					
11	54	45	-	-			-			-	-	-	-					
12	-			-			-			-	-	-	170	145	125			
13	-			-			-			-	-	-	155	125	115			
14	-			-			-			-	-	-	110	90	-			
15	-			-			-			-	-	-	90	70	-			
16	-			-			1080	900	780	-	-	-	-					
17	-			-			950	900	770	-	-	-	-					
18	-			-			1080	900	780	-	-	-	-					
19	50	40	-	40	32	-	-			-	-	-	-					
20	35	30	-	28	24	-	-			-	-	-	-					
21	50	40	-	40	32	-	-			-	-	-	-					
22	50	40	-	40	32	-	-			-	-	-	-					

• Type Of Inserts

Code	Length of insert edge (mm)
120308	11
190408	18
-	-
-	-
-	-



Code	Length of insert edge (mm)
400408	39
-	-
-	-
-	-
-	-