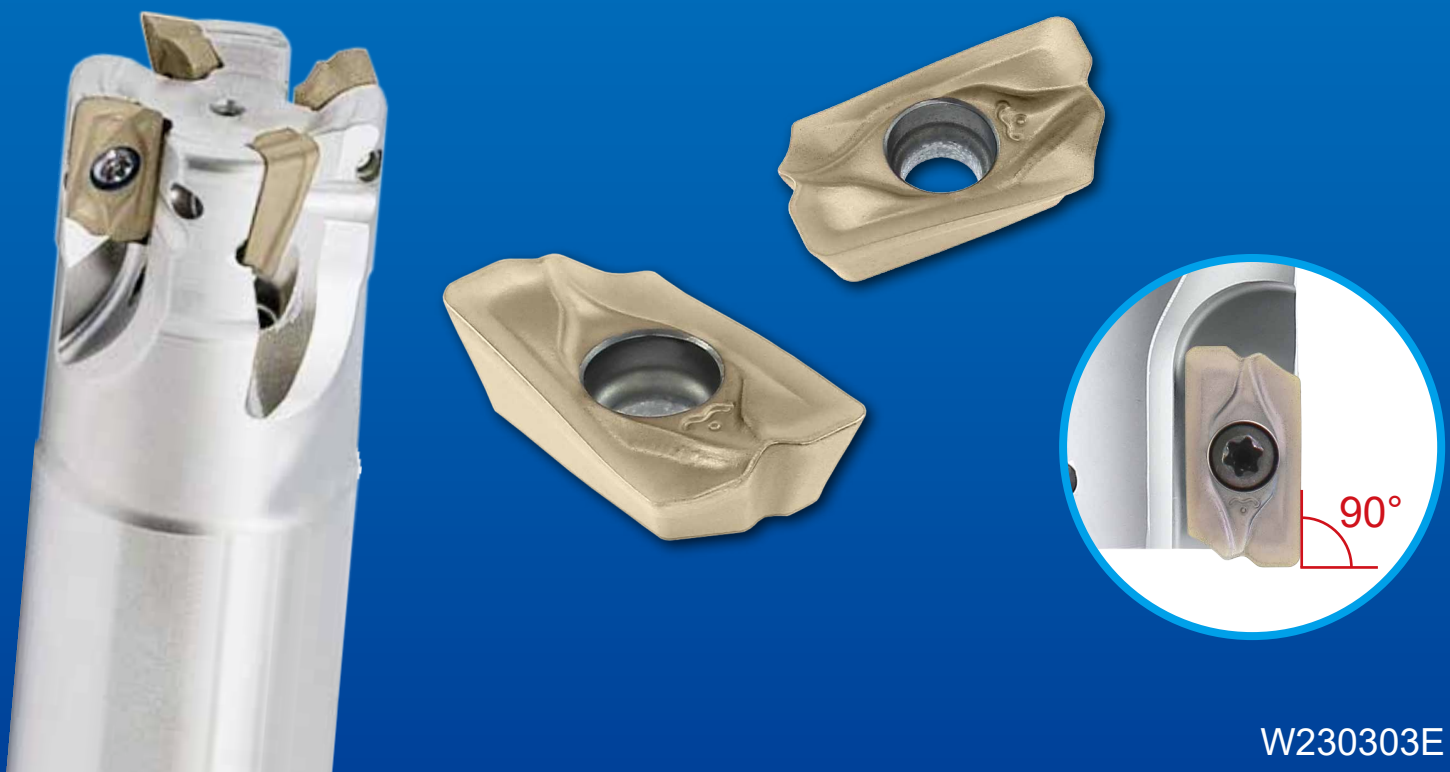


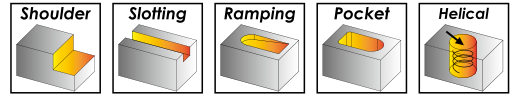
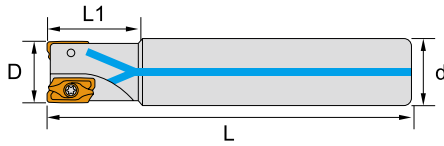
CAXD 90° Shoulder Milling

- For universal application with XDMT insert.
- Effectively reduce cutting resistance.
- Cutting edge design provides stable machining and reduces vibration during machining.
- Good chip removal design effectively improve tool life.



Shoulder Milling - CAXD

CAXDE - Milling tools



Insert Brand : Winstar, Ceratizit, ...

Order No.	D	L1	L	d	T	Coolant Hole	Inserts	Screw	Wrench	Stock
ICAXDE102016120	16	30	120	16	2		XDMT11T3	ITS2515	ITK08	○
ICAXDE103020120	20	30	120	20	3					●
ICAXDE103020151	20	35	150	20	3	✓				●
ICAXDE104025150	25	45	150	25	4					●
ICAXDE104025151	25	45	150	25	4	✓				●
ICAXDE105032150	32	45	150	32	5					●
ICAXDE105032151	32	45	150	32	5	✓				●

● stock ○ by inquiry

Insert Specifications

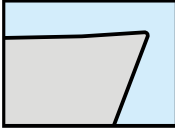
Insert	Dimensions (mm)						
	A	B	S	r	d1	t1	
XDMT11T308	10.6	6.8	3.8	0.8	2.8	1.4	

Insert Designation

Insert	Order No.	Designation	Working Material					
			P	M	K	N	S	H
	IXDMT11T308MG33TX	XDMT11T308-MG-CX33TX	●	●	●		●	●
	IXDMT11T308MG43TX	XDMT11T308-MG-CX43TX	●	●	○		●	
	IXDMT11T308MG47TA	XDMT11T308-MG-CX47TA	●	●	●		●	○

Shoulder Milling - CAXD

Insert Geometry

Chipbreaker	Application	
 MG	Low cutting force for medium cutting in carbon steel, alloy steel, stainless steel, cast iron and high temperature alloy.	

Insert Grade

Grade Type	Properties	Application	Working Material						Industry Area
			P	M	K	N	S	H	
CX33TX (PVD)	<ul style="list-style-type: none"> Wear resistance Anti-corrosion 	<ul style="list-style-type: none"> Medium to roughing General machining For carbon steel & alloy steel is 1st recommended 	●	●	●		●	●	<ul style="list-style-type: none"> Mold & Die Automotive Machinery Aerospace
CX43TX (PVD)	<ul style="list-style-type: none"> Tough substrate Anti-corrosion 	<ul style="list-style-type: none"> Medium to roughing Interrupted machining For stainless steel is 1st recommended 	●	●	○		●		<ul style="list-style-type: none"> Electronics Medical Aerospace
CX47TA (CVD)	<ul style="list-style-type: none"> High impact resistance High toughness 	<ul style="list-style-type: none"> Roughing Interrupted machining For alloy steel & exotic materials are recommended 	●	●	●		●	○	<ul style="list-style-type: none"> Machinery Aerospace Energy

Recommended Cutting Conditions

Working Material	XDMT11T3		
	Vc	fz	ap
Carbon Steel / Alloy Steel	120 ~ 250	0.10 ~ 0.22	0.3 ~ 10.0
Stainless Steel	100 ~ 180	0.08 ~ 0.18	0.3 ~ 8.0
Cast Iron	120 ~ 250	0.10 ~ 0.22	0.3 ~ 10.0
High Temperature Alloy	40 ~ 100	0.07 ~ 0.14	0.3 ~ 4.0
Hardened Steel	50 ~ 100	0.07 ~ 0.15	0.3 ~ 4.0