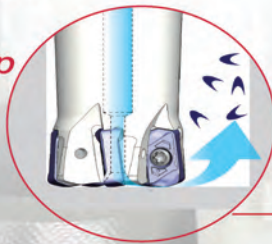


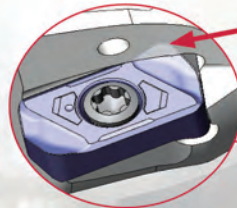
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## Features:

*Excellent chip evacuation with air hole*

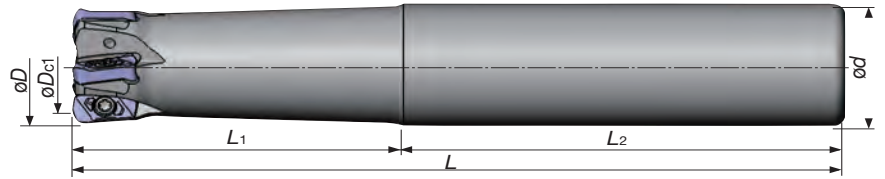


*Protection for unused edge of insert*

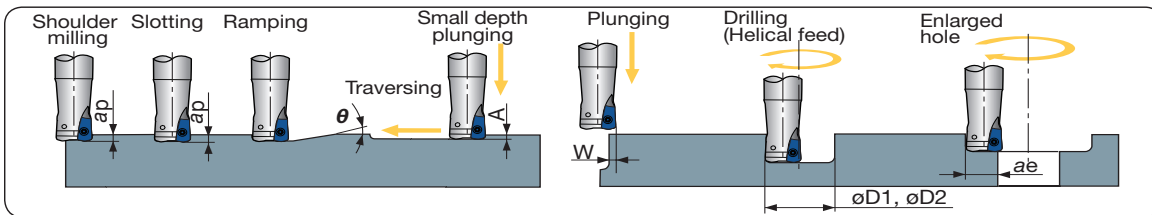


*High density for efficient machining  
Provides excellent performance on small machines due to low cutting forces.*

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Cutter	No. of inserts	Insert	Dimensions (in)						Weight	Air hole	Price W/ 30 Inserts
			$\phi D$	$\phi d$	$\phi Dc1$	L	$L_1$	$L_2$			
EXN03R062U0062-02	2	LNMU03***Insert	.625	.625	.374	4.00	1.25	2.75	0.05	With	440.77
EXN03R068U0062-02	2	LNMU03***Insert	.688	.625	.433	4.00	1.25	2.75	0.05		440.77
EXN03R075U0075-03	3	LNMU03***Insert	.750	.750	.496	5.00	2.00	3.00	0.10		487.01
EXN03R087U0075-03	3	LNMU03***Insert	.875	.750	.634	5.00	2.00	3.00	0.10		487.01
EXN03R100U0100-05	5	LNMU03***Insert	1.00	1.00	.756	5.50	2.50	3.00	0.18		583.92
EXN03R112U0100-05	5	LNMU03***Insert	1.125	1.00	.882	5.50	2.50	3.00	0.18		583.92
EXN03R125U0125-06	6	LNMU03***Insert	1.25	1.25	1.008	6.00	3.00	3.00	0.31		595.86
EXN03R062U0062-02L	2	LNMU03***Insert	.625	.625	.374	6.00	2.00	4.00	0.08		461.56
EXN03R068U0062-02L	2	LNMU03***Insert	.688	.625	.433	6.00	1.00	5.00	0.08		461.56
EXN03R075U0075-03L	3	LNMU03***Insert	.750	.750	.496	6.50	3.50	3.00	0.13		514.73
EXN03R087U0075-03L	3	LNMU03***Insert	.875	.750	.634	6.50	1.25	5.25	0.13		514.73
EXN03R100U0100-04L	4	LNMU03***Insert	1.00	1.00	.756	7.00	4.00	3.00	0.23		577.73
EXN03R112U0100-04L	4	LNMU03***Insert	1.125	1.00	.882	7.00	1.50	5.50	0.23		577.73
EXN03R125U0125-05L	5	LNMU03***Insert	1.25	1.25	1.008	8.00	5.00	3.00	0.41		595.86



Cat. No.	Tool $\phi Dc$ (in)	Effective edge length $ap$ (in)	Max. ramping angle $\theta$	Max. plunging depth $A$ (in)	Max. cutting width in plunging $W$ (in)	Min. machinable hole $\phi D1$ (in)	Max. machinable hole $\phi D2$ (in)	Max. cutting width in enlarged hole $ae$ (in)
EXN03R062U0062-□□□	.625	.039	2.1°	.012	.138	.854	1.171	.487
EXN03R068U0062-□□□	.687	.039	1.7°	.012	.138	.980	1.296	.549
EXN03R075U0075-□□□	.750	.039	1.4°	.012	.138	1.106	1.421	.612
EXN03R087U0075-□□□	.875	.039	1.2°	.012	.138	1.354	1.671	.737
EXN03R100U0100-□□□	1.00	.039	1.0°	.012	.138	1.606	1.921	.862
EXN03R112U0100-□□□	1.125	.039	0.8°	.012	.138	1.854	2.171	.987
EXN03R125U0125-□□□	1.250	.039	0.7°	.012	.138	2.106	2.421	1.112

Work material	Hardness	Priority	Grades	Chip-breaker	Cutting Speed Vc (SFM)	Feed per tooth: fz (ipt)		
						Tool- $\phi$ : .625-.875	Tool- $\phi$ : 1.0-1.25	Plunging depth
Carbon steels (S45C, S56C etc.) (C45E, C55E etc.)	~ 300HB	First choice for low cutting force	AH725	MJ	330 - 980	.020 - .050	.020 - .060	.004
			AH725	ML		.020 - .030	.020 - .040	
			AH130	MJ		.020 - .050	.020 - .060	
Alloy steels (SCM440, SCr415 etc.) (42CrMo4, 17Cr3 etc.)	~ 300HB	First choice for low cutting force	AH725	ML	330 - 660	.020 - .050	.020 - .060	.004
			AH725	MJ		.020 - .030	.020 - .040	
			AH130	MJ		.020 - .050	.020 - .060	
Prehardened steels (NAK80, PX5 etc.)	30 ~ 40HRC	-	AH725	MJ	330 - 660	.020 - .050	.020 - .040	.004
			AH130	ML		.012 - .020	.012 - .030	
Stainless steels (SUS304, SUS316 etc.) (X5CrNi18-10, X5CrNiMo17-12-2 etc.)	~ 200HB	First choice for impact resistance	AH130	MJ	330 - 490	.012 - .031	.012 - .031	.003
			AH130	MJ		.012 - .031	.012 - .031	
Grey cast irons (FC250, FC300 / GG25, GG30 etc.)	150 ~ 250HB	-	AH725	MJ	330 - 980	.020 - .050	.020 - .060	.004
Ductile cast irons (FCD400 / GG40 etc.)			AH725	MJ		.020 - .050	.020 - .060	
Titanium alloy (Ti-6Al-4V etc.)	~ 40HRC	-	AH725	ML	100 - 200	.012 - .020	.012 - .030	.003
			AH725	MJ		.012 - .020	.012 - .030	
Hardened steels (SKD67 etc.) (X40CrMoV5-1 etc.)	40 ~ 50HRC	-	AH725	MJ	260 - 430	.004 - .008	.004 - .012	.002
	50 ~ 60HRC		AH725	MJ		160 - 230	.001 - .002	

- When chips stay in the cutting zone during slotting or pocketing, use air to remove chips from the work area.
- Tool overhang length must be as short as possible to avoid chatter. When the tool overhang length is long, decrease the number of revolutions and feed.
- Cutting conditions are generally limited by the rigidity and power of the machine and the rigidity of the workpiece. When setting the conditions, start from half of the values of the standard cutting conditions and then increase the value gradually while making sure the machine is running normally.

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