

# XMP01

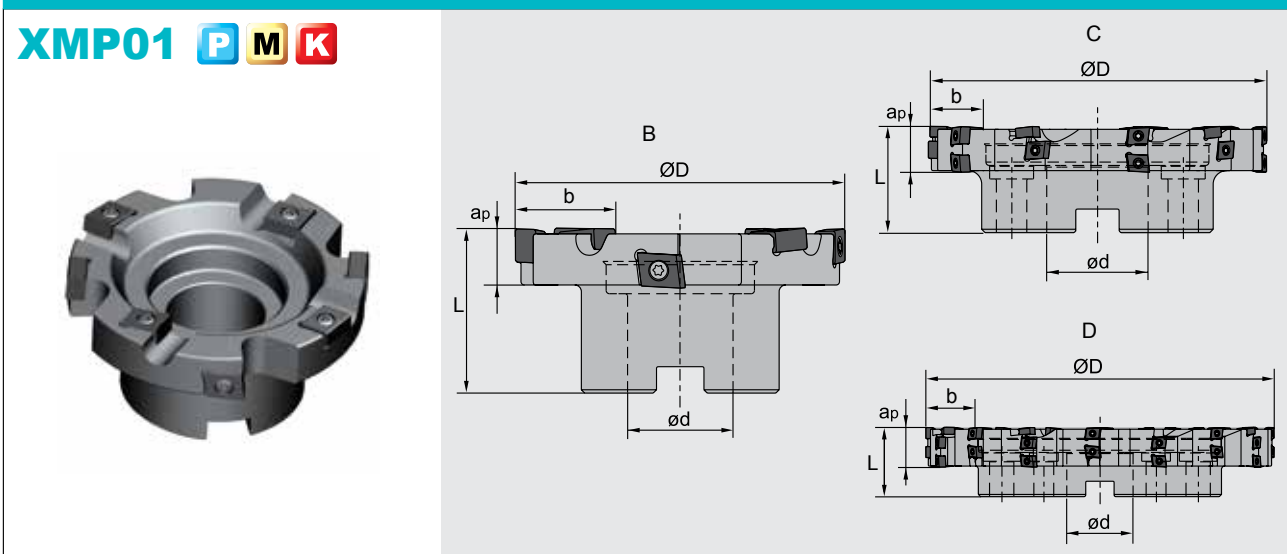
Boring and milling  
Bohren und Fräsen



## **XMP01 Feature** **XMP01 Eigenschaft**

- Complex function milling, mainly use for large-diameter hole and cavity profile milling;
- Versatility for face milling and side milling in  $\kappa r=90^\circ$
- Vertical insert, two types of chipbreaker for different materials and machining operations.
- Universal Fräser für die Bearbeitung von großen Bohrungen;
- Auch für den Einsatz von Planfräsen und Eckfräsen geeignet;
- Vertikale Wendschneidplatte. Zwei WSP-Geometrien für verschiedene Materialien und Bearbeitungen

### Boring milling cutters · Bohren und Fräsen



### Specification of tools · Werkzeug Beschreibung

Type Typ	Stock Lager	Dimensions (mm) Abmessungen					No. of teeth Zähne Z	Zeff ( peripheral teeth/end teeth ) ( Eckplatte / Planplatte )	Coupling Aufnahme	Weight Gewicht (kg)
		ØD	ød	L	b	ap				
<b>XMP01</b> -080X18-B27-CNE1210-08	●	80	27	50	18	15	8	2/2	B	0.67
-100X18-B32-CNE1210-08	●	100	32	50	18	20	8	2/2	A	0.99
-125X27-B40-CNE1210-15	●	125	40	63	27	22.5	15	3/2	B	2.46
-160X27-C40-CNE1210-18	●	160	40	63	27	25	18	4/2	C	3.7
-200X27-C60-CNE1210-21	●	200	60	63	27	31.5	21	5/2	C	5.46
-250X36-C60-CNE1210-32	○	250	40	63	36	56.5	32	6/2	C	9.79
-315X36-D60-CNE1210-42	○	315	60	63	36	47.5	42	8/2	D	17.65
-400X36-D60-CNE1210-52	○	400	60	63	36	90	52	10/2	D	27.36

Remark: (1) special ap,b,D possible on request of the Customers  
(1) besondere ap,b,D möglich nach Anfrageen

(2) Zeff means the effective teeth  
(2) Zeff bedeutet die wirkungsvolle zähne

### Spare parts · Ersatzteile

Diameter Durchmesser φD	Insert WSP	Clamp Screw Schraube	Wrench Schlüssel	
Ø80-Ø400	CNE121006*	I60M4X12	WT15IP	

Applicable tool  
Werkzeug **B11-B18**

Tools code key  
Werkzeug ISO **B26-B27**

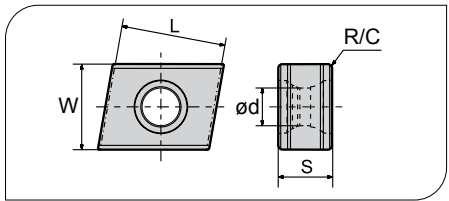
Grade selection guide  
Sortenauswahl **B19-B23**

Technical data  
Technische Daten **B215-B220**

# Milling · Fräsen

## Indexable Milling Tools · Wendeschneidplattenfräser

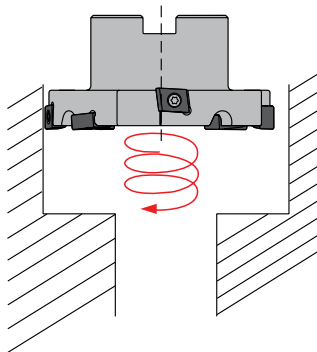
### Applicable inserts · Wendeschneidplatten



- Ideal Machining Condition / Gute Bearbeitungsbedingungen
- Normal Machining Condition / Normale Bearbeitungsbedingungen
- Unfavorable Machining Condition / Ungünstige Bearbeitungsbedingungen

Workpiece Material / Werkstoffe	P	M	K	N	S	YBC301	YBC302	YBC401	YBM251	YBM253	YBM351	YBD152	YBD252	YBG102	YBG202	YBG205	YBG212	YBG152	YBG252	YNG151	YNG151C	YC30S	YD101	YD201
P Steel / Stahl	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●
M Stainless Steel / Rostfreier Stahl	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●
K Cast iron / Gusseisen	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●
N Non-ferrous material / Ne Metalle	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●
S Heat-resistant steel / Warmfester Stahl	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●

Insert WSP	Type Typ	Dimensions (mm) / Abmessungen					CVD Coating / CVD Beschicht.						PVD Coating / PVD Beschicht.					Cermets / Cermet		Carbide uncoat. / unbe. Hartmetall				
		L	W	S	R/C	ød	YBC301	YBC302	YBC401	YBM251	YBM253	YBM351	YBD152	YBD252	YBG102	YBG202	YBG205	YBG212	YBG152	YBG252	YNG151	YNG151C	YC30S	YD101
	<b>CNE121006A</b>	12.8	10.0	6.35	0.4	4.4					●	○												
	<b>CNE121006B</b>	12.0	10.0	6.35	0.6	4.4					○	●												



### Recommended cutting data · Empfohlene Schnittdaten

Workpiece material / Werkstückstoff	Hardness HB / Härte	Grade / Sorte	Cutting data / Schnittdaten				
			V (m/min)	f (mm/zeff)	a <sub>pmax</sub>		
					CNE121006A	CNE121006B	
<b>P</b> Low-carbon steel / Soft steel / Niedriglegierter Kohlenstoffstahl / Baustahl	≤180	YBM253	270 (220-350)	0.2 (0.15-0.3)	15-90	15-90	
	180-280	YBM253	260 (200-320)	0.2 (0.15-0.3)	15-90	15-90	
	280-350	YBM253	240 (180-300)	0.2 (0.15-0.3)	15-90	15-90	
<b>M</b> stainless steel / Edelstahl	≤270	YBM253	230 (180-300)	0.2 (0.1-0.3)	15-90	15-90	
<b>K</b> Cast iron / Gusseisen	180-250	YBD152	270 (150-300)	0.2 (0.15-0.3)	15-90	15-90	

● Ex Stock / ab Lager ○ On demand / auf Anfrage