

# TETRAFEED

## XN20-06 | XN20-12

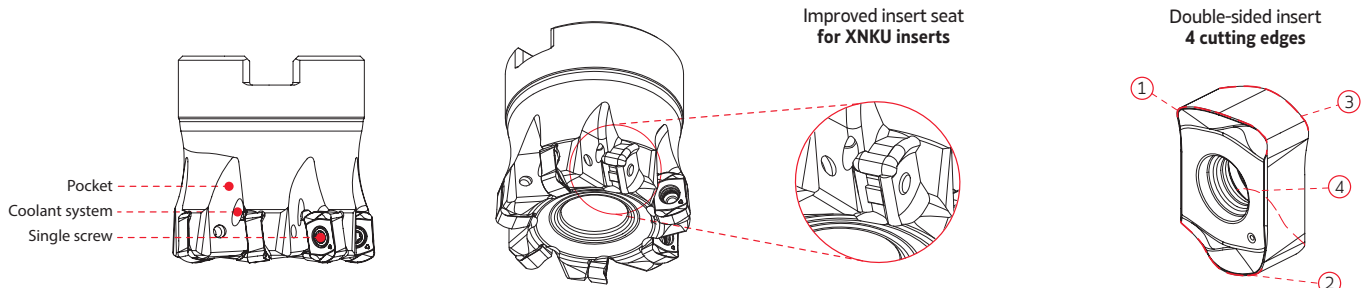
Double-sided  
high feed milling solution



# TETRAFEED XN20-06 | XN20-12

NEW

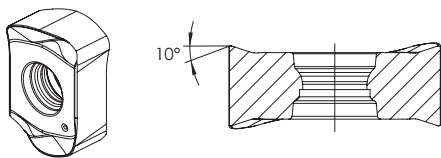
The tetrafeed line is expanding! With the XNKU 06 and XNKU 12, there are no limits for high feed machining of either small or large sized components. The 4 cutting edge negative insert allows to achieve feeds of up to 0.059 in and depth of cut of 0.059 in, leading to higher productivity.



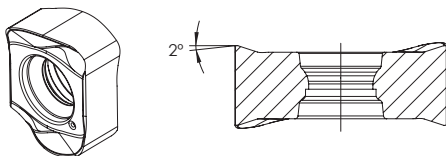
# XNKU 06T3 | 1205

NEW

XNKU 06T310-MP

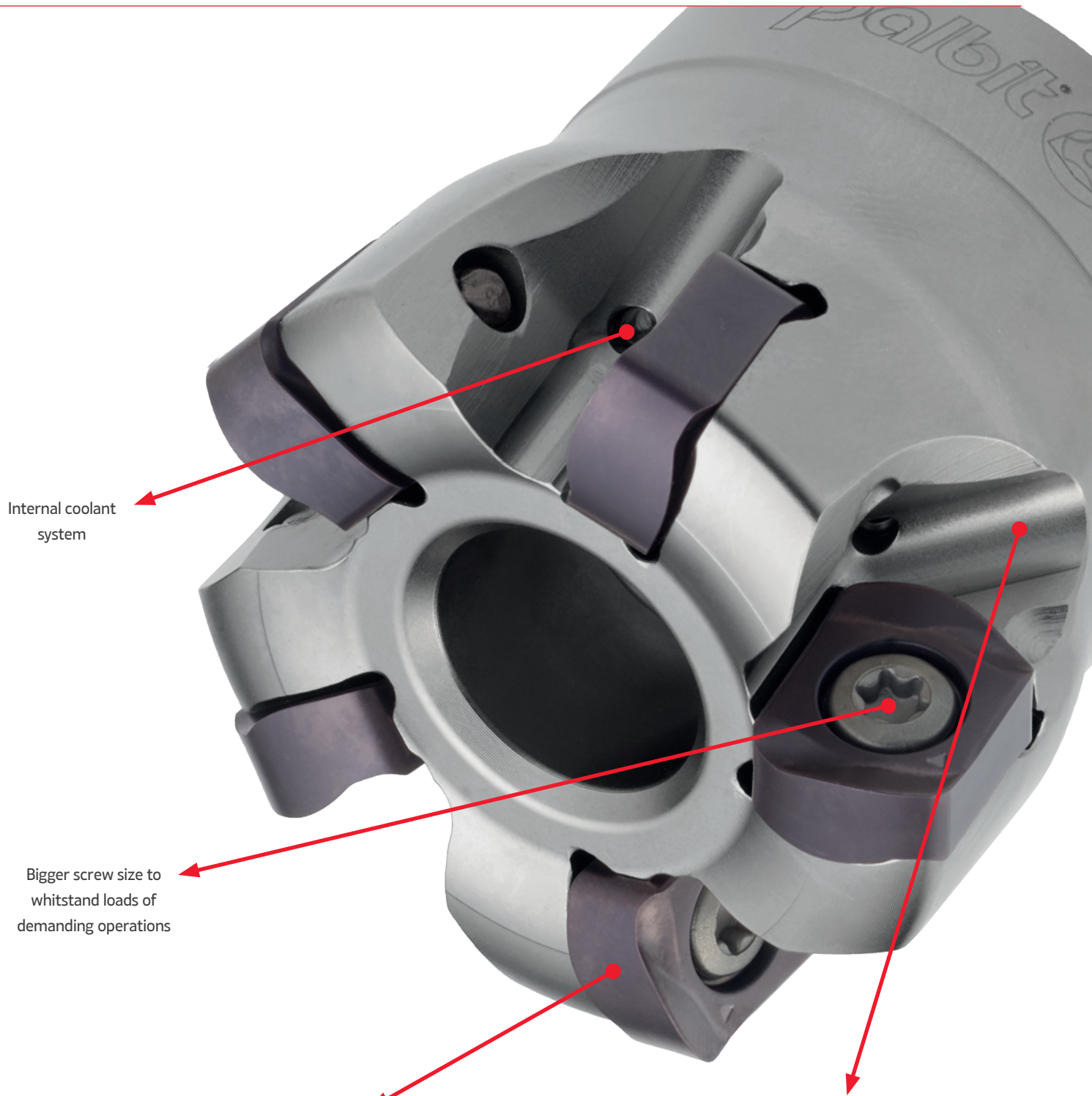


XNKU 120516-MP



## GEOMETRY FEATURES || Características geométricas | Características geométricas

Geometry	Features   Características   Características
Geometry <b>MP</b> General machining	Geometry with a reinforced cutting edge for general applications on different materials.



Internal coolant system

Bigger screw size to withstand loads of demanding operations

### Insert Width

- Robust insert with large cross section;

### Cutting edge

- Improved cutting edge;  
- Improved wear resistance;

### Double-sided insert

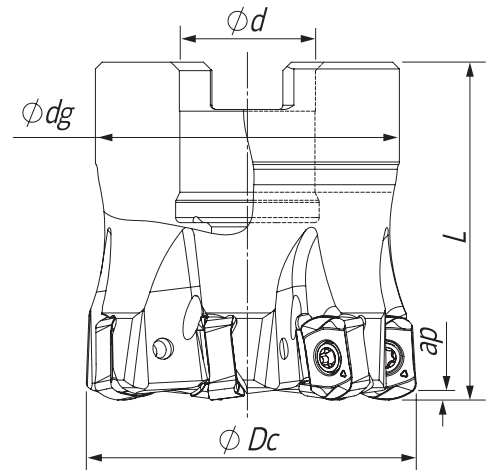
- Double-sided insert with 4 cutting edges;

### Design

- Optimized design for better chip evacuation;

### Pocket

- Strong pocket design for better cutter body durability;  
- Improved insert seat;

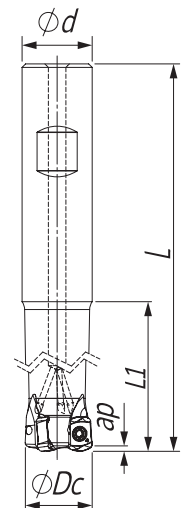


**Arbor Mounting**  
 $\kappa_r=20^\circ$  |  $\gamma_p=-7^\circ$  |  $R_p=0.071$

Order code Código	Reference Referência Referencia		Dimensions   Dimensões   Dimensiones (in)					Specifications		Insert	Stock
			$\phi Dc$	$\phi d/M$	$\phi dg$	L		Ap max (in)	Arbor Type		
181169900	XN20 D1.50-A.500/1.50-07-06	7	1.500	0.500	1.450	1.500	0.434	0.040	A	XNKU 06...	
181170000	XN20 D2.00-A.750/1.50-08-06	8	2.000	0.750	1.770	1.500	0.725	0.040	A	XNKU 06...	
181170100	XN20 D2.50-A1.00/1.50-09-06	9	2.500	1.000	1.850	1.500	1.100	0.040	A	XNKU 06...	

Stock item | Produto de stock | Itens de stock

Available under request | Disponível sobre consulta | Disponible bajo consulta

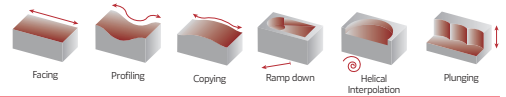


**Weldon Shank**  
 $\kappa_r=20^\circ$  |  $\gamma_p=-7^\circ$  |  $R_p=0.071$

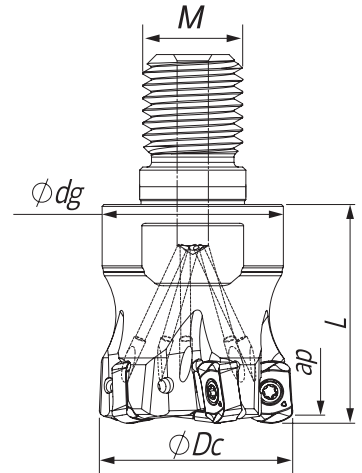
Order code Código	Reference Referência Referencia		Dimensions   Dimensões   Dimensiones (in)					Specifications		Insert	Stock
			$\phi Dc$	$\phi d/M$	L	L1		Ap max (in)	Arbor Type		
181170200	XN20 D.625-W.625/3.50-02-06	2	0.625	0.625	3.500	1.250	0.224	0.040	A	XNKU 06...	
181170300	XN20 D.750-W.750/4.00-03-06	3	0.750	0.750	4.000	1.750	0.372	0.040	A	XNKU 06...	
181170400	XN20 D1.00-W1.00/5.00-04-06	4	1.000	1.000	5.000	2.500	0.782	0.040	A	XNKU 06...	
181170500	XN20 D1.25-W1.25/5.00-05-06	5	1.250	1.250	5.000	2.500	1.316	0.040	A	XNKU 06...	

Stock item | Produto de stock | Itens de stock

Available under request | Disponível sobre consulta | Disponible bajo consulta



**Threaded Coupling**  
 $K_r=20^\circ$  |  $\gamma_p=-7^\circ$  |  $R_p=0.071$



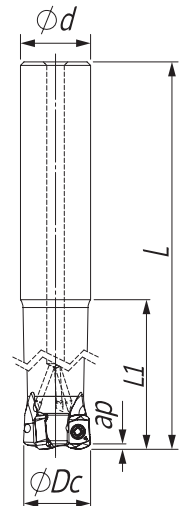
Order code Código	Reference Referência Referencia		Dimensions   Dimensões   Dimensiones (in)					Specifications	Insert	Stock
			$\phi Dc$	$\phi d/M$	$\phi dg$	L				
181169400	XN20 D.625-R-08/.984-02-06	2	0.625	M8	0.580	0.985	0.050	0.040	XNKU 06...	
181169500	XN20 D.750-R-10/1.18-03-06	3	0.750	M10	0.730	1.180	0.090	0.040	XNKU 06...	
181169600	XN20 D1.00-R-12/1.18-04-06	4	1.000	M12	0.905	1.180	0.145	0.040	XNKU 06...	
181169700	XN20 D1.25-R-16/1.38-05-06	5	1.250	M16	1.180	1.380	0.340	0.040	XNKU 06...	
181169800	XN20 D1.50-R-20/1.58-06-06	6	1.500	M20	1.440	1.575	0.455	0.040	XNKU 06...	

Stock item | Produto de stock | Itens de stock

Available under request | Disponível sobre consulta | Disponible bajo consulta



**Cylindrical Shank**  
 $K_r=20^\circ$  |  $\gamma_p=-7^\circ$  |  $R_p=0.071$



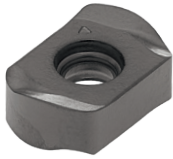
Order code Código	Reference Referência Referencia		Dimensions   Dimensões   Dimensiones (in)					Specifications	Insert	Stock
			$\phi Dc$	$\phi d/M$	L	L1				
181170600	XN20 D.625-C.625/6.00-02-06	2	0.625	0.625	6.000	2.000	0.458	0.040	XNKU 06...	
181170700	XN20 D.750-C.750/6.50-03-06	3	0.750	0.750	6.500	2.950	0.632	0.040	XNKU 06...	
181170800	XN20 D1.00-C1.00/7.00-04-06	4	1.000	1.000	7.000	4.000	1.106	0.040	XNKU 06...	
181170900	XN20 D1.25-C1.25/8.00-05-06	5	1.250	1.250	8.000	5.000	2.074	0.040	XNKU 06...	
181171000	XN20 D1.50-C1.50/5.00-06-06	6	1.500	1.500	5.000	2.250	1.973	0.040	XNKU 06...	

Stock item | Produto de stock | Itens de stock

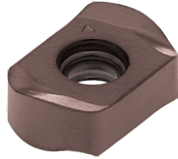
Available under request | Disponível sobre consulta | Disponible bajo consulta

## XNKU 06T3... | Inserts | Pastilhas | Plaquetas

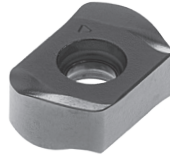
XNKU-MP  
(PHP grade)



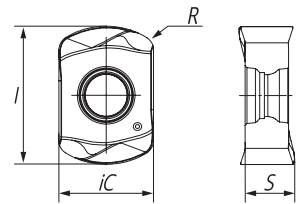
XNKU-MP  
(PHH grade)



XNKU-MP  
(PHS grade)



XNKU-MP



		P				M		K		S		Dimensions Dimensões Dimensiones (in)			
		CVD	PVD			CVD	PVD	CVD	PVD	CVD	PVD				
	<sup>(2)</sup> Grade code	T9	G4	T1	P4	T9	X9	T9	T1	T9	X9	iC	S	I	R
<sup>(1)</sup> Geometry code	ISO Reference	PHS740	PHP910	PHP920	PHP930	PHS740	PHH930	PHS740	PHP920	PHS740	PHH930				
1112802	XNKU 06T310-MP											0.270	0.142	0.394	0.039

First choice | Primeira opção | 1ª opção

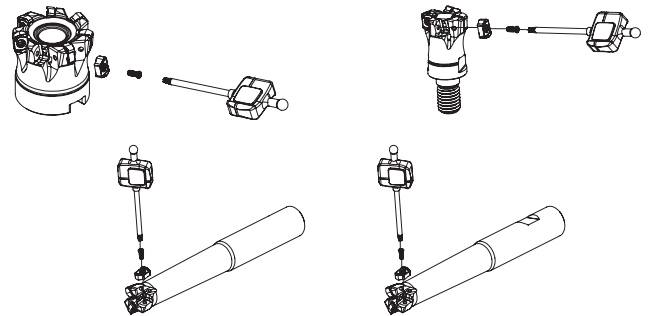
Stock item | Produto de stock | Itens de stock

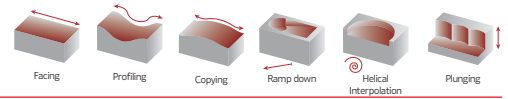
Available under request | Disponível sobre consulta  
Disponível bajo consulta

Insert order code = (1) Geometry Code + (2) Grade Code

## SPARE PARTS Complementos | Repuestos

Cutter ØDc	Insert Screw 	Key (Torx) 	Order separately	
			Key (Torx - lbf/in) 	Torque Value 
XN-A-06 - 1.500-2.500	P0250704	XT08	DT0812	10.6
XN-R-06 - 0.625-1.500	P0250704	XT08	DT0812	10.6
XN-W-06 - 0.265-1.250	P0250704	XT08	DT0812	10.6
XN-C-06 - 0.625-1.500	P0250704	XT08	DT0812	10.6





## GRADES SELECTION GUIDE | Guia para selecção de graus | Tabla para selección de calidades

ISO	PSM	Material	HB (Brinell)	Grades				
				← Wear Resistance			Toughness →	
				PHP910	PHP920	PHP930	PHH930	PHS740
P	1	Unalloyed Steel	125-220	✓	✓	✓		✓
	2	Low-Alloyed Steel	220-280	✓	✓	✓		✓
	3	High-Alloyed Steel	280-380	✓	✓	✓		✓
M	4	SS - Ferritic / Martensitic	200-330				✓	✓
	5	SS - Austenitic	200-330				✓	✓
	6	SS - Austenitic-ferritic (Duplex)	230-260				✓	✓
K	7	Malleable Cast Iron	130-230	✓	✓			✓
	8	Grey Cast Iron	180-245	✓	✓			✓
	9	Nodular Cast iron	160-250	✓	✓			✓
S	11	Heat Resistant Super Alloys	200-320				✓	✓

Good Conditions  
 Average Conditions  
 Difficult Conditions

## RECOMMENDED CUTTING CONDITIONS | Condições de corte recomendadas | Condiciones de corte recomendables

ISO	PSM	Material	HB (Brinell)	Vc (SFM)					Feed fz (in/t)
				← Wear Resistance			Toughness →		
				PHP910	PHP920	PHP930	PHH930	PHS740	
P	1	Unalloyed Steel	125-220	590-820	590-820	525-755	-	525-755	0.020-0.060
	2	Low-Alloyed Steel	220-280	525-790	560-690	490-625	-	490-620	0.020-0.060
	3	High-Alloyed Steel	280-380	460-755	525-655	460-590	-	460-590	0.020-0.060
M	4	SS - Ferritic / Martensitic	200-330	-	-	-	425-560	395-590	0.020-0.055
	5	SS - Austenitic	200-330	-	-	-	330-525	330-490	0.020-0.055
	6	SS - Austenitic-ferritic (Duplex)	230-260	-	-	-	260-455	230-420	0.020-0.055
K	7	Malleable Cast Iron	130-230	590-985	590-1050	-	-	525-985	0.020-0.060
	8	Grey Cast Iron	180-245	525-820	560-920	-	-	490-850	0.020-0.060
	9	Nodular Cast iron	160-250	490-690	330-790	-	-	260-720	0.020-0.060
S	11	Heat Resistant Super Alloys	200-320	-	-	-	100-245	100-230	0.020-0.050

(Note 1) Cutting conditions  $a_e/D_c=70\%$ .

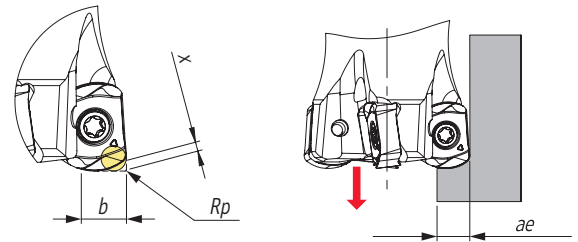
(Note 2) It's possible to occur vibrations in certain cases. Please reduce depth of cut and / or reduce cutting conditions in following cases:

- When using long shank;
- When using long tool overhang with arbor type;
- When application has poor clamping rigidity or when using a low rigidity machine.

(Note 3) When using  $\phi D_c=0.625$  in apply 70% or less feed (fz) from the table.

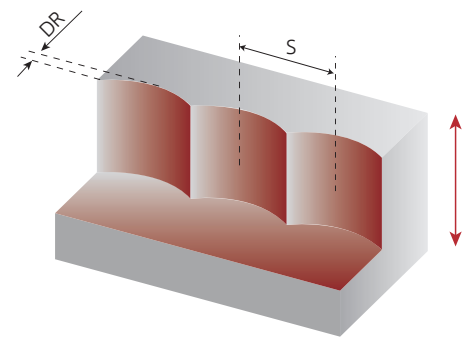
## PROGRAMMING DATA | Dados para programação | Datos para la programación

Insert	Programming Data			
	Rp	X	b	ae
XNKU 06T310-MP	0.071	0.016	0.142	0.134



## PLUNGING | Mergulho | Plunge

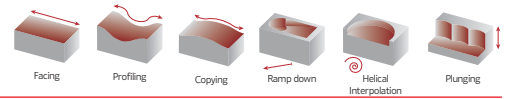
L ≤ 3Dc	L > 3Dc	S max.
fz (in/t)		
0.004-0.006	0.002-0.004	$S_{max} = \sqrt{D_c \cdot D_r - D_r^2}$



S max and DR corresponding cutting diameter Dc (in)							
DR (in)	Dc (in)						
	0.625	0.750	1.000	1.250	1.500	2.000	2.500
0.039	0.151	0.167	0.194	0.217	0.239	0.277	0.310
0.079	0.208	0.230	0.270	0.304	0.335	0.390	0.437
0.118	0.245	0.273	0.323	0.365	0.404	0.471	0.530

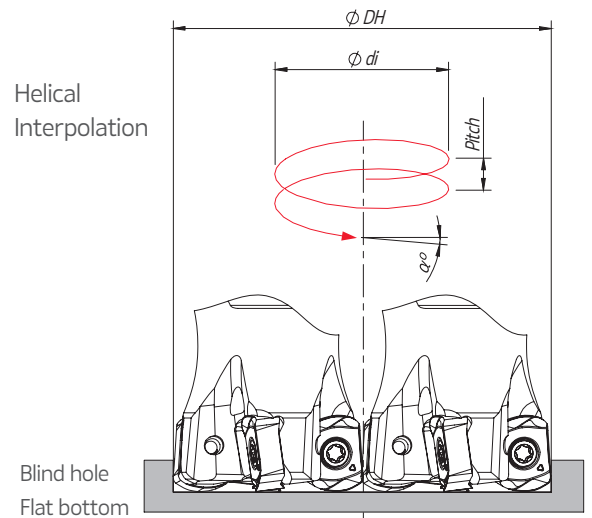
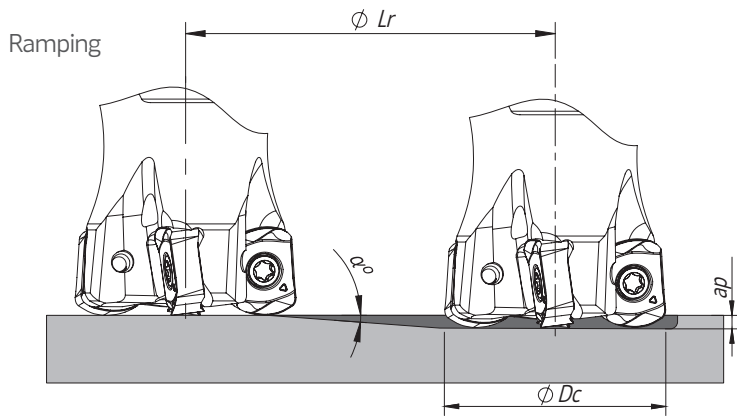
Note: Recommended for L ≤ 4 Dc for extra long tool this step and side cut must be reduced.





## RAMPING AND HELICAL INTERPOLATION

Descida em rampa e interpolação helicoidal | Bajada en rampa e interpolación circular



$$\phi di = \phi DH - \phi Dc$$

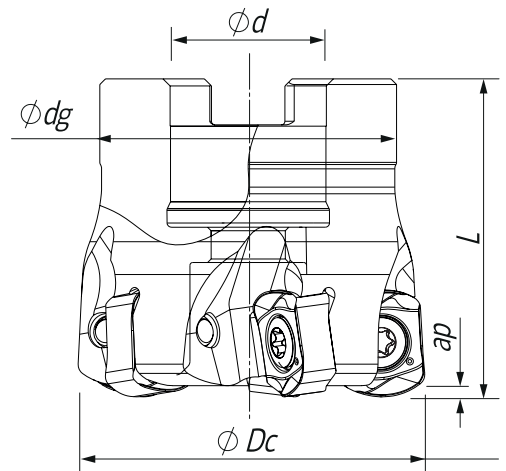
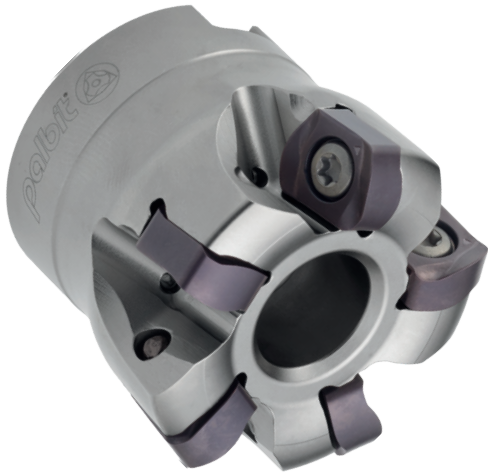
$\phi Dc$	Ramping			Helical Interpolation		
	Max Ramp $\alpha^\circ$	Max $a_p$	Min Lr	$\phi DH_{min}$	$\phi DH_{max}$	Max Pitch/Rev.
0.625	0.5	0.039	4.469	0.966 -	- 1.171	0.009 0.014
0.750	0.5	0.039	4.469	1.216 -	- 1.421	0.012 0.018
1.000	0.8	0.039	2.793	1.716 -	- 1.921	0.031 0.039
1.250	0.8	0.039	2.793	2.216 -	- 2.421	0.039 0.039
1.500	0.4	0.039	5.586	2.716 -	- 2.921	0.026 0.031
2.000	0.3	0.039	7.448	3.716 -	- 3.921	0.028 0.031
2.500	0.25	0.039	8.938	4.716 -	- 4.921	0.030 0.030

Note: During helical interpolation do not exceed max Pitch.

(\*) Down cutting is recommended, tool pass rotation should be counter-clockwise.

(\*) In case of ramping and helical interpolation, apply 70% or less feed (fz) from recommended cutting conditions table.





**Arbor Mounting**  
 $K_r=20^\circ$  |  $\gamma_p=-7^\circ$  |  $R_p=0.130$

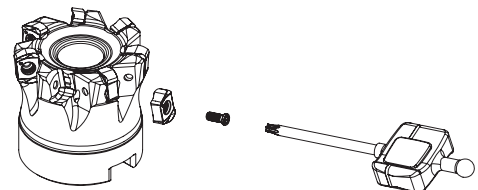
Order code Código	Reference Referência Referencia		Dimensions   Dimensões   Dimensiones (in)					Specifications		Insert	Stock
			$\phi Dc$	$\phi d$	$\phi dg$	L		Ap max (in)	Arbor Type		
181187500	XN20 D2.00-A.750/1.97-05-12	5	2.000	0.750	1.772	1.969	0.919	0.059	A	XNKU 12...	<input type="radio"/>
181187600	XN20 D2.50-A.750/1.97-06-12	6	2.500	0.750	1.772	1.969	1.247	0.059	A	XNKU 12...	<input type="radio"/>
181187700	XN20 D3.00-A1.00/2.48-07-12	7	3.000	1.000	2.205	2.480	2.330	0.059	A	XNKU 12...	<input type="radio"/>
181187800	XN20 D4.00-A1.50/2.48-10-12	10	4.000	1.500	3.386	2.480	4.884	0.059	A	XNKU 12...	<input type="radio"/>

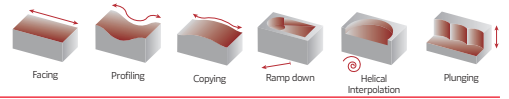
Stock item | Produto de stock | Itens de stock

Available under request | Disponível sobre consulta | Disponible bajo consulta

## SPARE PARTS Complementos | Repuestos

Cutter $\phi Dc$	Order separately			
	Insert Screw	Key (Torx)	Key (Torx - lbf/in)	Torque Value
XN20-12 - 2.00-4.00				43.3

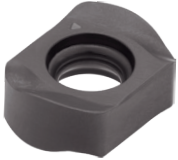




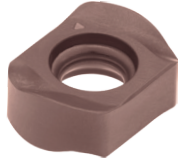
XNKU 1205... || Inserts | Pastilhas | Plaquetas



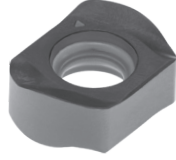
XNKU-MP  
(PHP grade)



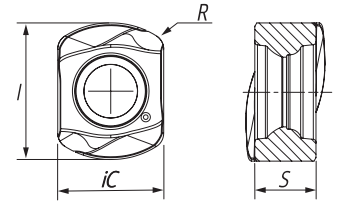
XNKU-MP  
(PHH grade)



XNKU-MP  
(PHS grade)



XNKU-MP



		P				M		K			S		Dimensions Dimensões Dimensiones (in)			
		CVD	PVD			CVD	PVD	CVD	PVD		CVD	PVD				
	<sup>(2)</sup> Grade code	T9	X5	T1	P4	T9	X9	T9	X5	T1	T9	X9	iC	S	I	R
<sup>(1)</sup> Geometry code	ISO Reference	PHS740	PHP910	PHP920	PHP930	PHS740	PHH930	PHS740	PHP910	PHP920	PHS740	PHH930				
1113071	XNKU 120516-MP	⊗	⊗	⊗	○	⊗	○	⊗	⊗	⊗	⊗	○	0.461	0.232	0.591	0.063

⊗ First choice | Primeira opção | 1ª opción



⊗ Stock item | Produto de stock | Itens de stock

○ Available under request | Disponível sobre consulta  
Disponibile bajo consulta

Insert order code = (1) Geometry Code + (2) Grade Code

## GRADES SELECTION GUIDE | Guia para selecção de graus | Tabla para selección de calidades

ISO	PSM	Material	HB (Brinell)	Grades				
				← Wear Resistance			Toughness →	
				PHP910	PHP920	PHP930	PHH930	PHS740
P	1	Unalloyed Steel	125-220	✓	✓	✓		✓
	2	Low-Alloyed Steel	220-280	✓	✓	✓		✓
	3	High-Alloyed Steel	280-380	✓	✓	✓		✓
M	4	SS - Ferritic / Martensitic	200-330				✓	✓
	5	SS - Austenitic	200-330				✓	✓
	6	SS - Austenitic-ferritic (Duplex)	230-260				✓	✓
K	7	Malleable Cast Iron	130-230	✓	✓			✓
	8	Grey Cast Iron	180-245	✓	✓			✓
	9	Nodular Cast iron	160-250	✓	✓			✓
S	11	Heat Resistant Super Alloys	200-320				✓	✓

 Good Conditions  
 Average Conditions  
 Difficult Conditions

## RECOMMENDED CUTTING CONDITIONS | Condições de corte recomendadas | Condiciones de corte recomendables

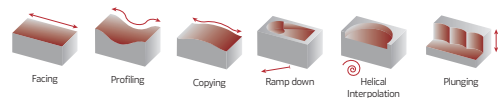
ISO	PSM	Material	HB (Brinell)	Vc (SFM)					Feed fz (in/t)
				← Wear Resistance			Toughness →		
				PHP910	PHP920	PHP930	PHH930	PHS740	
P	1	Unalloyed Steel	125-220	591-820	591-820	525-755	-	525-755	0.020-0.060
	2	Low-Alloyed Steel	220-280	525-788	558-689	492-624	-	492-624	0.020-0.060
	3	High-Alloyed Steel	280-380	460-755	525-656	460-591	-	460-591	0.020-0.060
M	4	SS - Ferritic / Martensitic	200-330	-	-	-	427-558	394-591	0.020-0.056
	5	SS - Austenitic	200-330	-	-	-	328-525	328-492	0.020-0.056
	6	SS - Austenitic-ferritic (Duplex)	230-260	-	-	-	263-460	230-427	0.020-0.056
K	7	Malleable Cast Iron	130-230	591-984	591-1050	-	-	525-984	0.020-0.060
	8	Grey Cast Iron	180-245	525-820	558-919	-	-	492-853	0.020-0.060
	9	Nodular Cast iron	160-250	492-689	328-788	-	-	263-722	0.020-0.060
S	11	Heat Resistant Super Alloys	200-320	-	-	-	99-246	99-230	0.020-0.052

(Note 1) Cutting conditions  $a_e/D_c=70\%$ .

(Note 2) It's possible to occur vibrations in certain cases. Please reduce depth of cut and / or reduce cutting conditions in following cases:

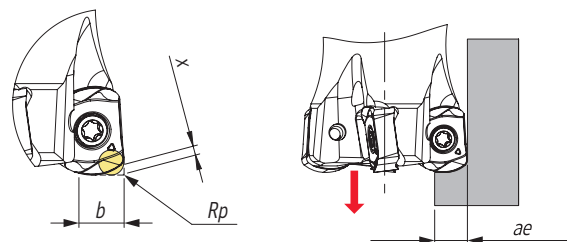
- When using long shank;
- When using long tool overhang with arbor type;
- When application has poor clamping rigidity or when using a low rigidity machine.

(Note 3) When using  $\varnothing D_c=16\text{mm}$  apply 70% or less feed (fz) from the table.



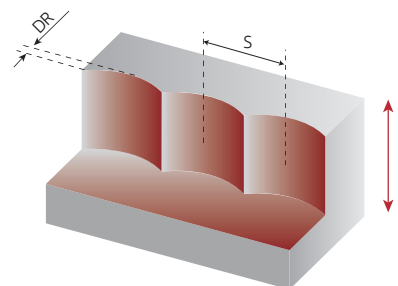
## PROGRAMMING DATA | Dados para programação | Datos para la programación

Insert	Programming Data			
	Rp	X	b	ae
XNKU 120516-MP	0.130	0.026	0.296	0.280



## PLUNGING | Mergulho | Plunge

L ≤ 3Dc	L > 3Dc	S max.
fz (in/t)		
0.004-0.006	0.004-0.005	$S_{max} = \sqrt{Dc \cdot Dr - Dr^2}$



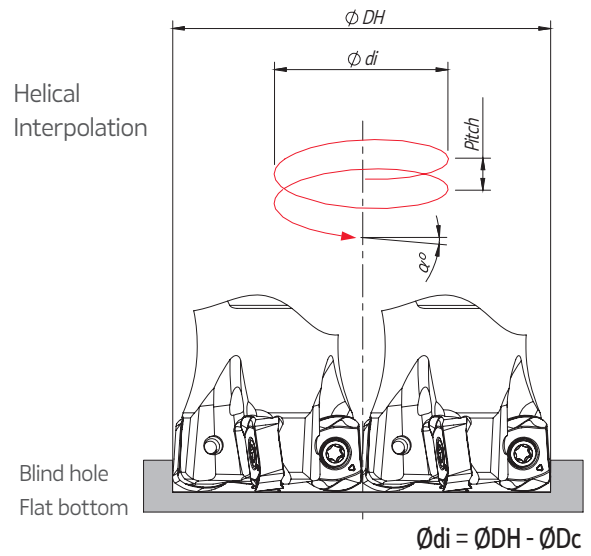
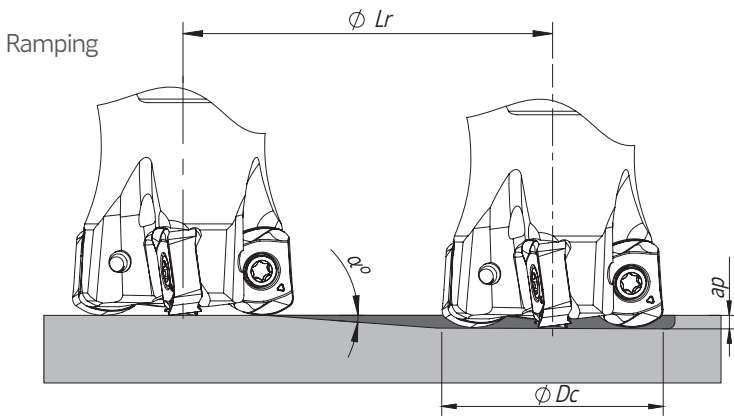
S max and DR corresponding cutting diameter Dc (in)				
DR (in)	Dc (in)			
	2.000	2.500	3.000	4.000
0.039	0.277	0.310	0.340	0.393
0.079	0.390	0.437	0.480	0.557
0.118	0.471	0.530	0.583	0.677
0.157	0.538	0.607	0.668	0.777
0.197	0.596	0.674	0.743	0.866
0.236	0.645	0.731	0.808	0.942
0.276	0.690	0.783	0.867	1.014

Note: Recommended for L ≤ 4 Dc for extra long tool this step and side cut must be reduced.



## RAMPING AND HELICAL INTERPOLATION

Descida em rampa e interpolação helicoidal | Bajada en rampa e interpolación circular



$\phi Dc$	Ramping			Helical Interpolation		
	Max Ramp $\alpha^\circ$	Max $a_p$	Min Lr	$\phi DH_{min}$	$\phi DH_{max}$	Max Pitch/Rev.
2.000	0.8	0.059	4.225	3.716	-	0.059
				-	3.921	0.059
2.500	0.6	0.059	5.634	4.716	-	0.059
				-	4.921	0.059
3.000	0.5	0.059	6.761	5.716	-	0.059
				-	5.921	0.059
4.000	0.35	0.059	9.658	7.716	-	0.059
				-	7.921	0.059

Note: During helical interpolation do not exceed max Pitch.

(\*) Down cutting is recommended, tool pass rotation should be counter-clockwise.

(\*) In case of ramping and helical interpolation, apply 70% or less feed (fz) from recommended cutting conditions table.

# TEST REPORTS

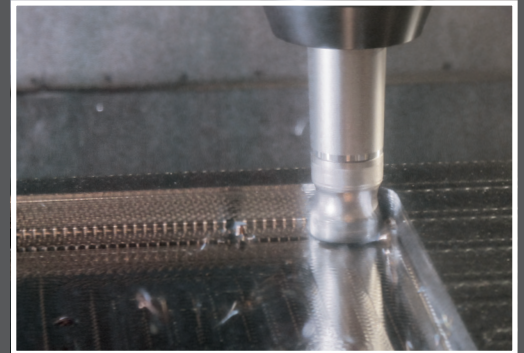
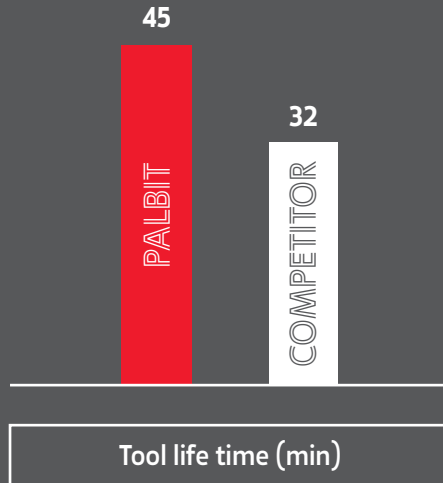
## TETRAFEED XN20-06 - TEST REPORT

Toolholder: XN20 D1.25-R-16/1.38-05-06

Insert: XNKU 06T310-MP

Grade: PHH930

**+40%  
Tool Life  
Time**



Workpiece material: stainless steel, AISI 316

Cutting speed: Vc	394 SFM
Feed per tooth: fz	0.039 in/t
Depth of cut: ap	0.020 in
Width of cut: ae	0.945 in
Method of machining	Ramping and Helical Interpolation
Coolant	Dry

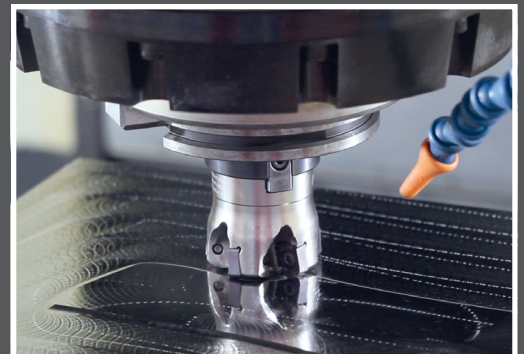
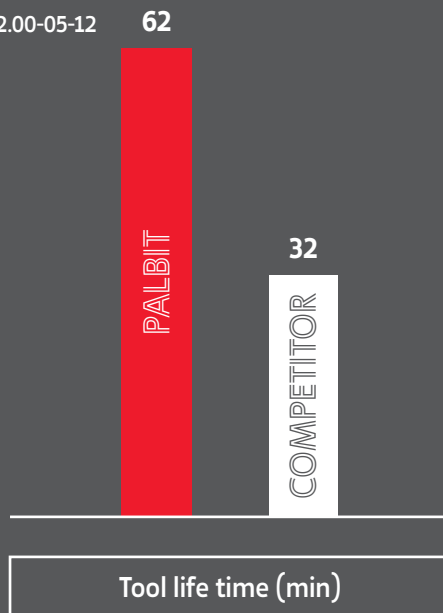
## TETRAFEED XN20-12 - TEST REPORT

Toolholder: XN20 D2.00-A.750/2.00-05-12

Insert: XNKU 120516-MP

Grade: PHP920

**+94%  
Tool Life  
Time**



Workpiece material: 1.2738 | 34-36 HRC, Mould Steel

Cutting speed: Vc	656 SFM
Feed per tooth: fz	0.047 in/t
Depth of cut: ap	0.039 in
Width of cut: ae	60%
Method of machining:	Facing
Coolant	Air



**TETRAFEED**  
XN20-06 | XN20-12

NEW

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