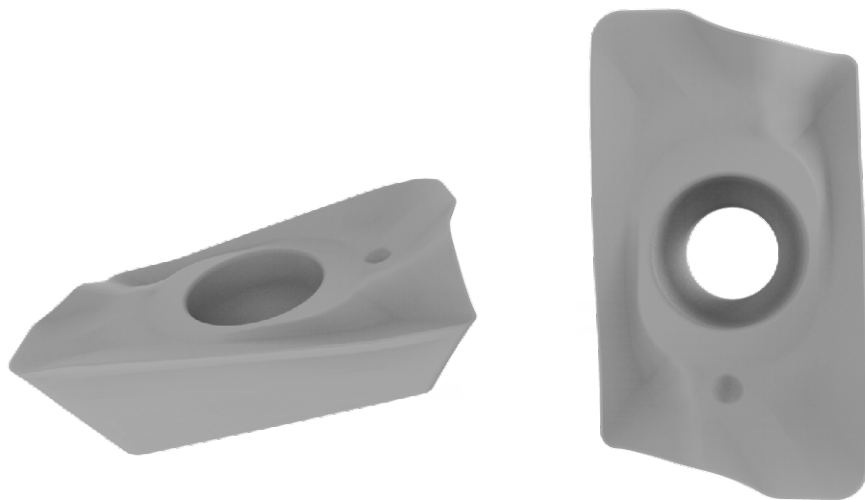




NEW PRODUCT RELEASE

PIONEERS OF MULTI-MAT™



NEW SHOULDER MILLING INSERT – 2 CUTTING EDGES

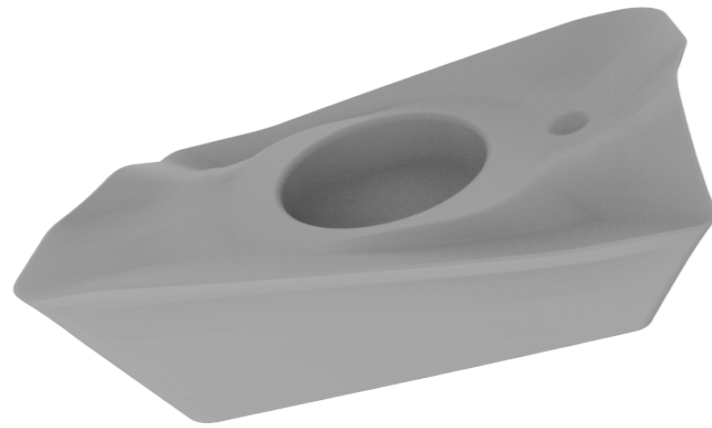
NEW SHOULDER MILLING INSERT

2 CUTTING EDGES

LT 3130



LT 3000



ADVANTAGES

- 2 Cutting edges – Waved shape for smoother cutting
- True and precise 90° – No mismatch after multiple passes
- Wiper flat – Optimized for better surface finish

PRODUCT OVERVIEW

- Available in MAGIA and MAGIA PRO
- Replaces existing competitor inserts
- Recommended for Helical Interpolation or Ramping Down

MAGIA PRO

DESIGNATION	GRADE	RADIUS (mm)	MATERIAL RECOMMENDATION	CATALOG #
BPKT 11T308 PETR	LT 3130	0.80		M0002931

MAGIA

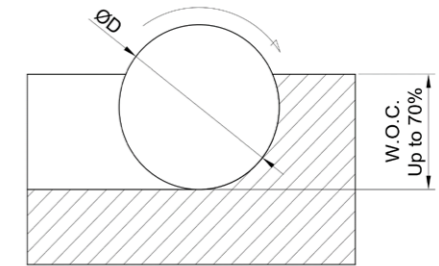
DESIGNATION	GRADE	RADIUS (mm)	MATERIAL RECOMMENDATION	CATALOG #
BPKT 11T308 PETR	LT 3000	0.80		M0002930



CUTTING PARAMETERS

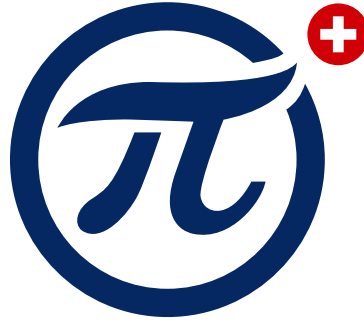


Side Milling up to 70%
BPKT 11T308 PETR



Material Group	Lamina Gr. N°	Material Examples	Hardness	D.O.C		Feed		Vc		Advised D.O.C [mm]	Advised Feed [mm/t]	Advised Vc [m/min]		
				min [mm]	max [mm]	min [mm]	max [mm]	min [mm]	max [mm]					
P Non Alloyed Low Alloyed High Alloyed	1	C35, Ck45, 1020, 1045, 1060, 28Mn6	125 HB	0.5	9	0.13	0.26	190	330	2	0.17	250		
			190 HB						300			220		
			250 HB						250			200		
	2	42CrMo4, St50, Ck60, 4140, 4340, 100Cr6	180 HB			0.11	0.21	150	210		0.15	180		
			230 HB				0.18	130	190		0.13	150		
			280 HB				0.21	150	240		0.15	200		
			350 HB				0.18	130	170		0.13	140		
	3	X40CrMoV5, H13, M42, D3, S6-5-2, 12Ni19	220 HB			0.08	6.4	0.18	90		150	1.5	0.13	130
			280 HB								130		120	
320 HB			110	100										
4	304, 316, X5CrNi18-9	180 HB	0.11	9	0.21	190	250	2	0.15	220				
		240 HB					0.08		160		210	190		
		5					X2CrNiN23-4, S31500		290 HB		0.08	6.4	0.15	70
310 HB	120		90											
6	410, X6Cr17, 17-4PH, 430	200 HB	0.11	9	0.21	150	210	2	0.15	190				
		42 HRC					6.4		0.16		90	150	1.5	0.12
K Grey Malleable & Nodular	7	GG20, GG40, EN-GJL-250, N030B	150 HB	0.5	9	0.13	0.26	150	240	2	0.17	200		
			200 HB						220			180		
			250 HB						190			160		
	8	GGG40, GGG70, 50005	150 HB			0.11	0.23	100	200		0.15	180		
			200 HB						180			150		
			250 HB						150			130		
9	Incoloy 800, Inconel 700, Stellite 21	240 HB	0.08	6.4	0.15	30	50	1.5	0.12	32				
		250 HB					30		30					
		350 HB					30		30					
10	TiAl6V4, T40	-	0.08	6.4	0.15	30	60	1.5	0.13	40				
		-					0.16		40		70	55		
H Steel Chilled Cast Iron White Cast Iron	11	G-X300CrMo15, Ni-Hard 2, X100 CrMo13, 440C, G-X260NiCr42	55 HRc	0.5	3.2	0.07	40	60	1	0.09	40			
			400 HB					2.6		50				
			45 HRc					1.9		60				
			50 HRc					1		70				
			55 HRc					1		80				
12	AlSi12	130 HB	0.5	9	0.13	0.26	200	400	2	0.18	280			

- For slot milling: Reduce the feed rate to 75%.
- Recommended for Ramping Down or Helical Interpolation.
- Cutting parameters recommended for stable part clamping and short tool/cutter overhang.
- Must be reduced in case of vibrations.



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