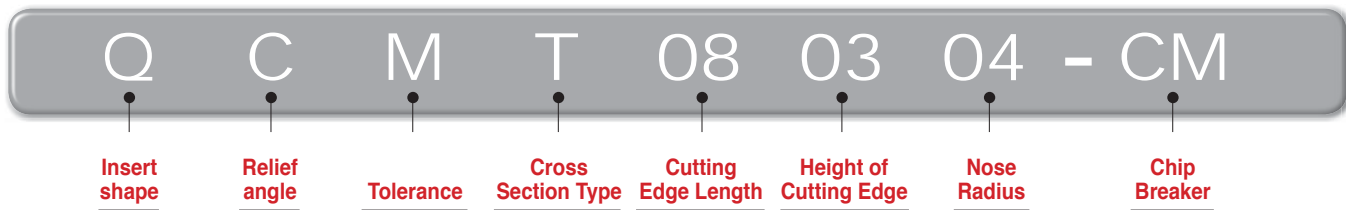


Multi Turn

Holder code system

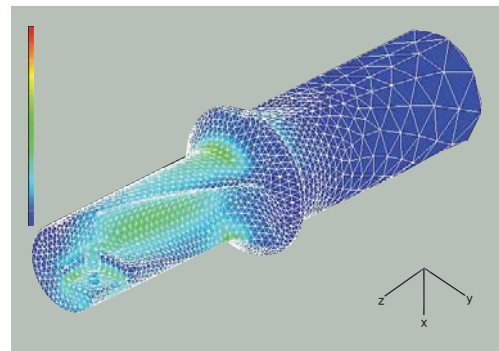
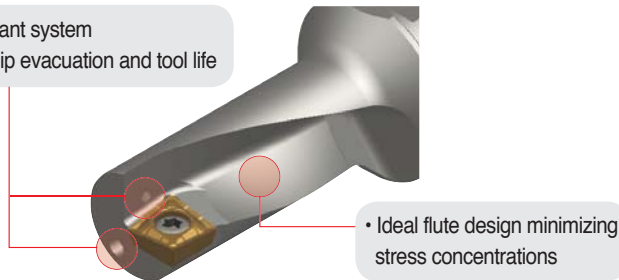


Insert code system



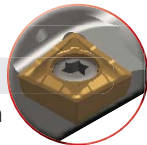
Tool design by FEM analysis

- Double coolant system
- Excellent chip evacuation and tool life



* Clamping tip

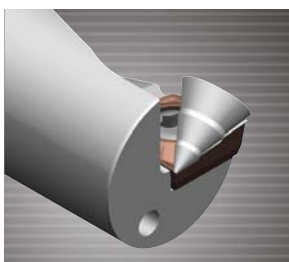
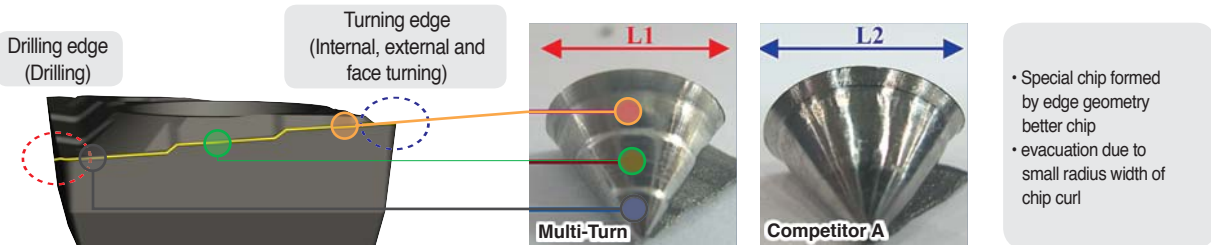
Correct: High cutting edge position
Wrong: Low cutting edge position



- Minimized stress during cutting, prevented damage from vibration and longer tool life

Optimized design

Creative stepping cutting edge

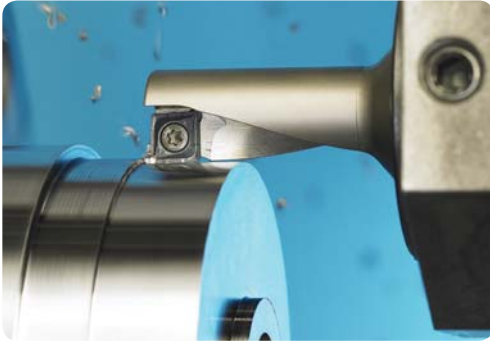


| Comparison | Multi turn | Competitor A | Competitor B |
|-------------------------------|------------|--------------|--------------|
| Feed f_n (mm/rev) = 0.08 | | | |
| Feed f_n (mm/rev) = 0.10 | | | |
| Chip width (rate) | 80% | 100% | 120% |

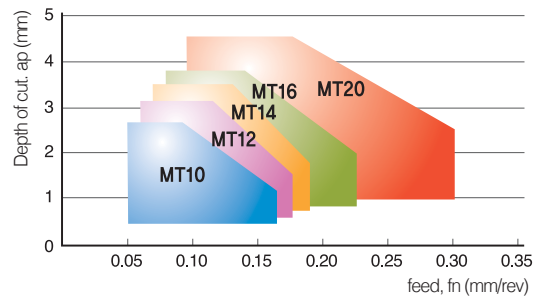
B Technical Information for Multi Turn

🔗 User's guide

External / Internal turning



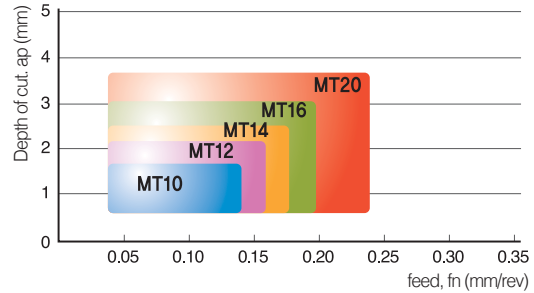
● Application range



Facing



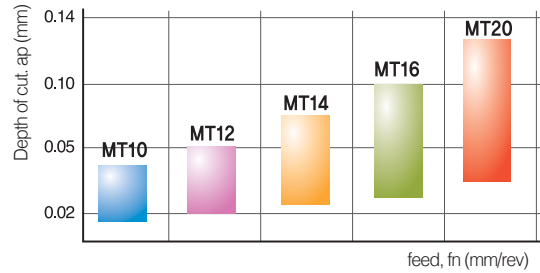
● Application ranges of facing



Drilling

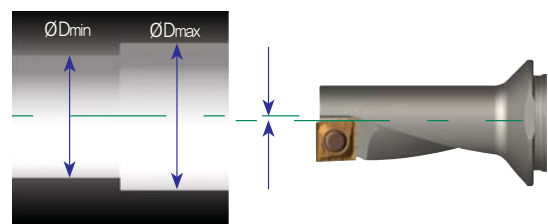


● Drilling feed range by designation



Offset (Diameter compensation)

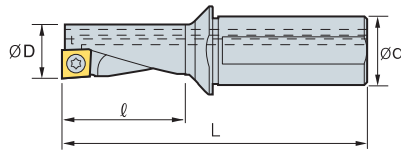
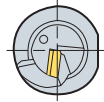
| Disignation | Machined diameter (mm) | ØDmin (mm) | ØDmax (mm) |
|---------------|------------------------|------------|------------|
| MT10R/L-2.25D | 10 | 9.85 | 10.35 |
| MT12R/L-2.25D | 12 | 11.85 | 12.35 |
| MT14R/L-2.25D | 14 | 13.85 | 14.35 |
| MT16R/L-2.25D | 16 | 15.85 | 16.35 |
| MT20R/L-2.25D | 20 | 19.85 | 20.35 |
| MT25R/L-2.25D | 25 | 24.85 | 25.35 |
| MT32R/L-2.25D | 32 | 31.85 | 32.35 |



Drill diameter is adjustable by the offset compensation



MT (Multi-Turn)



| Designation | | ØD | Ød | ℓ | L | Insert | Screw | Wrench |
|-------------|-------------|----|----|------|-------|------------|------------|--------|
| MT | 10R/L-2.25D | 10 | 12 | 22.5 | 69.5 | QC□T050204 | FTNA0204S | TW06P |
| | 12R/L-2.25D | 12 | 16 | 27.0 | 78.0 | QC□T060204 | FTNA02205S | TW06P |
| | 14R/L-2.25D | 14 | 16 | 31.5 | 83.5 | QC□T070304 | FTKA02555 | TW07P |
| | 16R/L-2.25D | 16 | 20 | 36.0 | 94.0 | QC□T080304 | FTNA0306 | TW09P |
| | 20R/L-2.25D | 20 | 25 | 45.0 | 111.0 | QC□T10T304 | FTNA03508 | TW15P |
| | 25R/L-2.25D | 25 | 32 | 56.5 | 130.0 | QC□T130408 | FTNC04509 | TW20S |
| | 32R/L-2.25D | 32 | 40 | 72.0 | 160.0 | QC□T170508 | FTNC04511 | TW20S |

(mm)

↻ Applicable inserts B133

↻ Insert

| Picture | Designation | Coated | | | | Uncoated | | Dimensions (mm) | | | | | Configuration |
|---------|----------------|--------|--------|--------|--------|----------|-----|-----------------|------|------|-----|-----------------|---------------|
| | | NC3120 | NC3225 | NC6315 | PC5300 | H01 | H05 | l | d | t | r | Ød ₁ | |
| | QCMT 050204-CM | | ● | ● | ● | | | 5.0 | 5.4 | 2.10 | 0.4 | 2.3 | |
| | 060204-CM | | ● | ● | ● | | | 6.0 | 6.4 | 2.38 | 0.4 | 2.5 | |
| | 070304-CM | | ● | ● | ● | | | 7.0 | 7.4 | 3.18 | 0.4 | 2.8 | |
| | 080304-CM | | ● | ● | ● | | | 8.0 | 8.4 | 3.18 | 0.4 | 3.4 | |
| | 10T304-CM | | ● | ● | ● | | | 10.0 | 10.4 | 3.97 | 0.4 | 4.0 | |
| | 130408-CM | | ● | ● | ● | | | 12.7 | 13.5 | 4.76 | 0.8 | 5.5 | |
| | 170508-CM | | ● | ● | ● | | | 16.7 | 17.5 | 5.56 | 0.8 | 5.5 | |
| | QCGT 050204-CA | | | | | ● | | 5.0 | 5.4 | 2.10 | 0.4 | 2.3 | |
| | 060204-CA | | | | | ● | | 6.0 | 6.4 | 2.38 | 0.4 | 2.5 | |
| | 070304-CA | | | | | ● | | 7.0 | 7.4 | 3.18 | 0.4 | 2.8 | |
| | 080304-CA | | | | | ● | | 8.0 | 8.4 | 3.18 | 0.4 | 3.4 | |
| | 10T304-CA | | | | | ● | | 10.0 | 10.4 | 3.97 | 0.4 | 4.0 | |
| | 130408-CA | | | | | ● | | 12.7 | 13.5 | 4.76 | 0.8 | 5.5 | |
| | 170508-CA | | | | | ● | | 16.7 | 17.5 | 5.56 | 0.8 | 5.5 | |

●: Stock item

