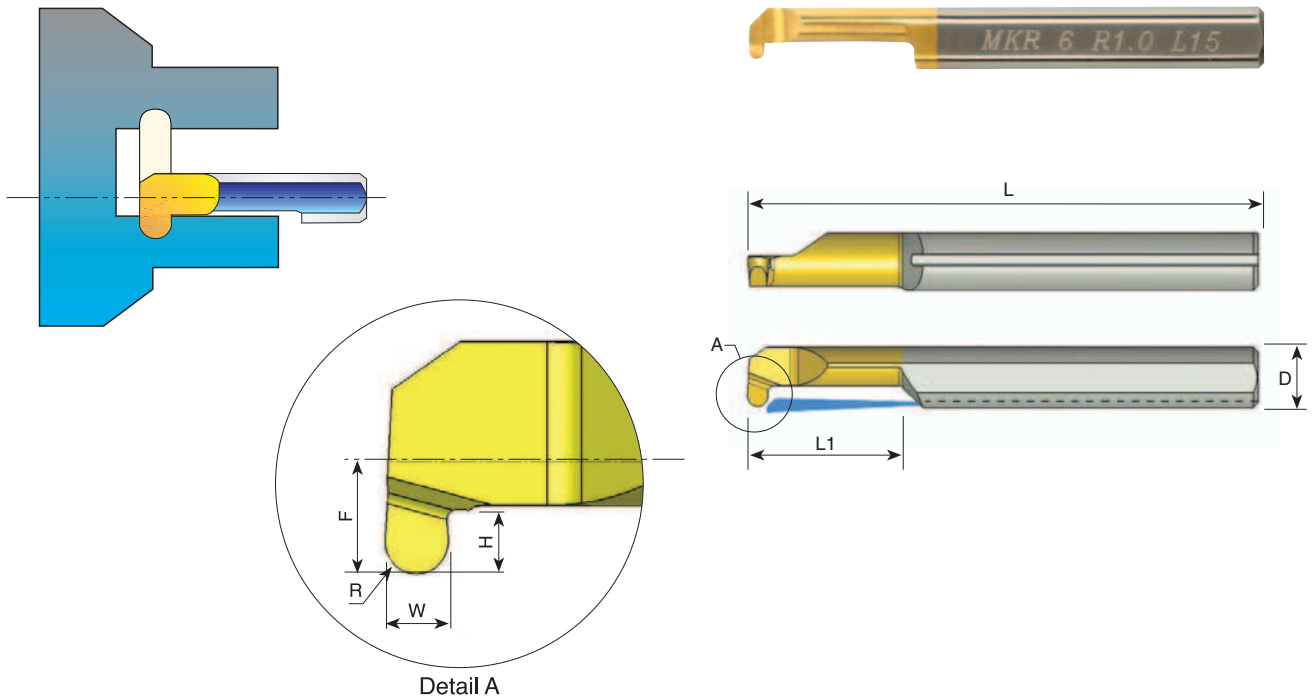


## MKR Bars Full Radius Grooving - with Coolant Channel



D	Ordering Code	L	L1	R	W	H	F	Min. Bore Dia.	Holder*
4.0	<b>MKR 4 R0.5 L10</b>	50	10	0.50	1.0	1.0	1.7	4.1	SIM 0020 H4
4.0	<b>MKR 4 R0.75 L10</b>	50	10	0.75	1.5	1.0	1.7	4.1	SIM 0020 H4
5.0	<b>MKR 5 R0.5 L15</b>	50	15	0.50	1.0	1.2	2.3	5.1	SIM 0020 H5
5.0	<b>MKR 5 R0.75 L15</b>	50	15	0.75	1.5	1.2	2.3	5.1	SIM 0020 H5
5.0	<b>MKR 5 R1.0 L15</b>	50	15	1.00	2.0	1.2	2.3	5.1	SIM 0020 H5
6.0	<b>MKR 6 R0.5 L15</b>	50	15	0.50	1.0	1.6	2.8	6.1	SIM 0020 H6
6.0	<b>MKR 6 R0.75 L15</b>	50	15	0.75	1.5	1.6	2.8	6.1	SIM 0020 H6
6.0	<b>MKR 6 R1.0 L15</b>	50	15	1.00	2.0	1.6	2.8	6.1	SIM 0020 H6

Order example: MKR 5 R1.0 L15 BXC

For L.H. bars specify MKL instead of MKR

\* For additional holders see page 156

# Technical Section

Carbide Grade: **BXC (P30 - P50, K25 - K40)**

PVD TiN coated grade for low cutting speed, Works well with a wide range of stainless steels.

## Cutting speed for Tiny Tools

ISO Standard	Materials	Cutting Speed m/min
<b>P</b>	Low & Medium Carbon Steel	20-140
	High Carbon Steel	30-100
	Alloy Steels & Treated Steels	40- 90
<b>M</b>	Stainless Steels	20- 90
	Cast Steels	40- 90
<b>K</b>	Cast Iron	40-120
<b>N</b>	Non-Ferrous & Aluminium	50-120
<b>S</b>	Super alloy and Titanium	15- 30
<b>H</b>	Hard Materials	13- 30

**Recommended Feed Rate: 0.01 - 0.03 mm/rev**

## Threading Passes

Pitch:	mm	0.5	0.7	0.8	1.0	1.25	1.5
	TPI	48	36	32	24	20	16
Number of Passes		6-12	7-14	7-16	8-18	8-20	10-22