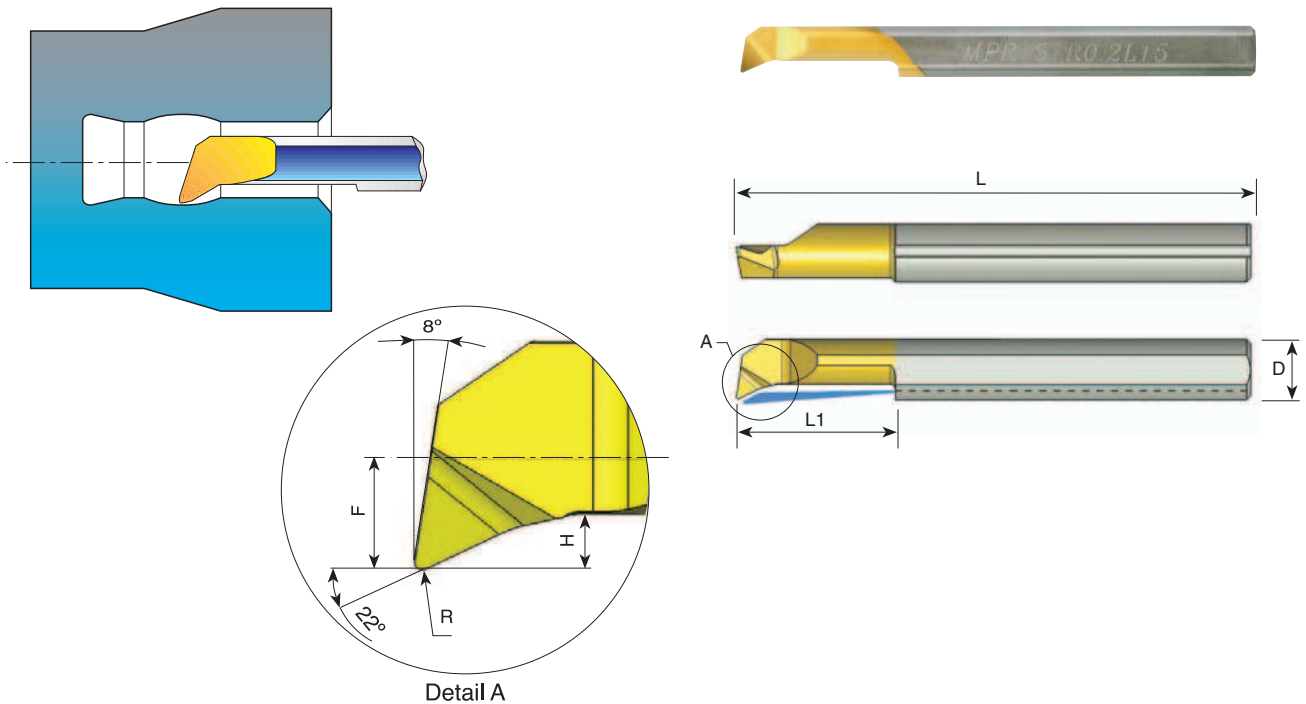


## MPR Bars Profiling and Boring - with Coolant Channel



D	Ordering Code	L	L1	R	H	F	Min. Bore Dia.	Holder*
3.0	<b>MPR 1 R0.05 L4</b>	39	4	0.05	0.2	0.5	1.0	SIM 0020 H3
3.0	<b>MPR 1.5 R0.10L6</b>	39	6	0.10	0.3	0.7	1.5	SIM 0020 H3
3.0	<b>MPR 2 R0.15 L5</b>	39	5	0.15	0.5	0.8	2.1	SIM 0020 H3
3.0	<b>MPR 2 R0.15L10</b>	39	10	0.15	0.5	0.8	2.1	SIM 0020 H3
3.0	<b>MPR 3 R0.05L10</b>	39	10	0.05	0.7	1.3	3.1	SIM 0020 H3
3.0	<b>MPR 3 R0.05L15</b>	39	15	0.05	0.7	1.3	3.1	SIM 0020 H3
3.0	<b>MPR 3 R0.2 L10</b>	39	10	0.20	0.7	1.3	3.1	SIM 0020 H3
3.0	<b>MPR 3 R0.2 L15</b>	39	15	0.20	0.7	1.3	3.1	SIM 0020 H3
4.0	<b>MPR 4 R0.2 L10</b>	50	10	0.20	0.8	1.7	4.1	SIM 0020 H4
4.0	<b>MPR 4 R0.2 L15</b>	50	15	0.20	0.8	1.7	4.1	SIM 0020 H4
5.0	<b>MPR 5 R0.2 L15</b>	50	15	0.20	1.2	2.1	5.1	SIM 0020 H5
5.0	<b>MPR 5 R0.2 L22</b>	50	22	0.20	1.2	2.1	5.1	SIM 0020 H5
6.0	<b>MPR 6 R0.2 L15</b>	50	15	0.20	1.4	2.8	6.1	SIM 0020 H6
6.0	<b>MPR 6 R0.2 L22</b>	50	22	0.20	1.4	2.8	6.1	SIM 0020 H6
8.0	<b>MPR 8 R0.2 L15</b>	63	15	0.20	1.6	3.8	8.1	SIM 0020 H8
8.0	<b>MPR 8 R0.2 L22</b>	63	22	0.20	1.6	3.8	8.1	SIM 0020 H8
10.0	<b>MPR 10R0.2 L35</b>	72	35	0.20	2.0	4.8	10.1	SIM 0020 H10

Order example: MPR 4 R0.2 L15 BXC

For L.H. bars specify MPL instead of MPR

\* 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