

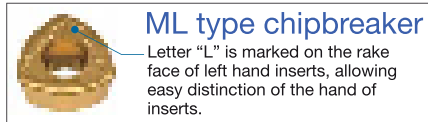
Right hand (R) shown.

Cat. No.	Stock		Dimensions (mm)				Applicable inserts	Clamp set	Clamping screw	Wrench
	R	L	h	b	L <sub>1</sub>	f				
XWXPR/L2525M09	●	●	25	25	150	32	WPMT090725ZPR/L-ML 2-132	CSY-20	CSTB-5	IP-20T
XWXPR/L3232P09	●	●	32	32	170	40				
XWXPR/L4040S09	●	●	40	40	250	50				

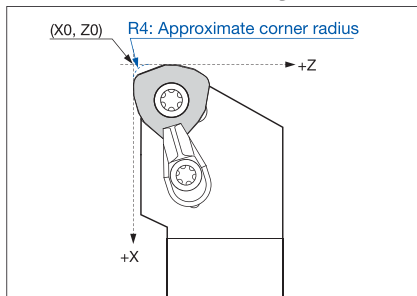
## Inserts

Cat. No.	Accuracy	Honing	Grades					Dimensions (mm)			
			T9115	T9125	T9015	T9025	AH120	A	B	T	r <sub>ε</sub>
			WPMT090725ZPR-ML	●	●	▲	▲	●	9	15	7
WPMT090725ZPL-ML	●	●	▲	▲	●						

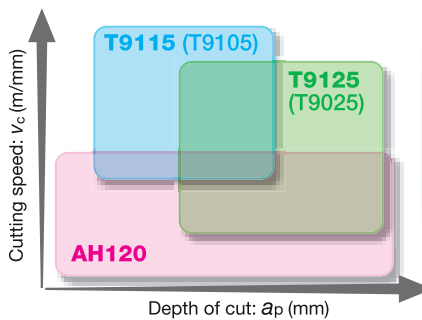
Note: Care should be taken not to confuse the hand of inserts to be used.



## Zero point setting method



## Application on areas



### First choice

- **T9125 (T9025)**
  - For low to medium speed machining and interrupted cutting.
  - Excels in chipping and impact resistance.
- **T9115 (T9015)**
  - For continuous machining at medium to high speeds.
  - Excels in both wear and impact resistance.
- **AH120 (Complementary grade for stainless and mild steels)**
  - In machining stainless and mild steels, if chipping or breakage occurs, use AH120.

## Standard cutting conditions

Work materials	Grades	Chipbreaker	Cutting speed v <sub>c</sub> (m/min)	Depth of cut a <sub>p</sub> (mm)	Feed f (mm/rev)
Mild and low carbon steels (JIS SS400, S25C, etc.) < 180 HB	T9125	ML	150 (100 - 250)	0.5 - 2.5	1.5 (0.5 - 2.5)
Carbon and alloy steels (JIS S50C, SCM440, etc.) < 300HB	T9115		150 (100 - 250)		
Stainless steels (JIS SUS304, SUS316, etc.) < 250 HB	T9125		150 (100 - 250)		
Grey and ductile cast irons (JIS FC250, FCD400, etc.)	T9115		150 (100 - 250)		

Note: When the side cutting edge is used for facing, the maximum feed is limited to within 1.0 mm/rev.