

Cutting Data for XN08 Series Tools		NP25MP	NP35MP	NM35MP	NM40MP	NK20MP	NM10MP	RTK20
P	Steel, Unalloyed low carbon	600-950	500-750			650-980		
	Steel, Low to Medium Alloy 160 - 255 Hbn	525-750	420-590			590-820		
	Steel, Alloy and tool Steels 200 - 340 Hbn	475-690	360-625			525-725		
	High Tensile steels 240 - 340 Hbn	360-560				390-590		
M	Austenetic (304, 304L, 316, 316L)	295-492	265-460	360-590	320-590			
	Duplex (323, 329, F55, 2205)	265-450	265-450	325-530	285-530			
	Super Austenetic (310 Modified)	240-400	240-400	295-475	255-475			
	Stainless, PF Series (17-4, 630)	200-320	200-320	235-390	205-380			
K	Grey Cast Iron	Ferritic/Pearl	295-930			490-1050		
		Pearlitic	240-760			400-860		
	Nodular Cast Iron	Ferritic	260-820			430-925		
		Pearlitic	140-450			230-510		
S	High Temp	G 200 HB		95-210	95-195			
	Alloy FE	AG 280 HB		70-150	70-140			
	Ni / Co	GO 320 HB		50-150	50-135			
	Titanium Alloys			100-215	100-195			
N	Aluminum						1600-9500	1300-8200
	Copper , Copper Alloys						525-1650	395-1310

Depth of Cut & Feed Range

Edge Geometry	Depth of Cut	Feed Per Tooth
TP	.040, .150, .275	.006, .0085, .012
TK	.040, .150, .275	.007, .010, .014
TM	.040, .150, .275	.006, .008, .011
TN	.040, .150, .275	.008, .012, .016

Ramp Angles

Cutter Diameter	Max Ramp Angle
2	0.5
2.5	0.4
3	0.25
4	0.17
6	0.07

XN08 Grade Descriptions

NP25MP - (HC-P25/M25)

Multipurpose grade for milling unalloyed, low alloyed, high alloyed and stainless steel. The PVD coated grade is especially suitable for high cutting speeds in dry / wet machining under stable conditions.

NP35MP - (HC-P35/M35)

Universal Steel milling grade. PVD coated on a tough substrate for milling most of the usual steel categories. Especially suitable for dry milling at low to medium speeds under difficult conditions.

NM35MP - (HC-M35/S35)

Wear resistant PVD coating, fine grain grade for machining stainless and austenitic stainless materials, suitable for wet or dry machining.

NM40MP - (HC-M40)

Extremely tough, relatively fine-grained substrate with thin smooth PVD coating. Ideal grade for milling austenitic stainless steels and materials from the Duplex group at low to medium cutting speeds. May be used in wet milling applications but with minimal coolant.

NK20MP - (HC-K20/P10)

Tough K20 substrate and a thick PVD coating for machining cast iron. Also suited as a finishing grade for steel cutting and the machining of cold work steels of 54 HRC.

NM10MP - (HC-N10/S20)

Ideal grade for machining aluminum materials and other non-ferrous metals. Due to the ultra-thin PVD TiAlN layer this grade is also suited for finishing stainless steels and grey cast iron.

RTK20 - (HW-N10)

Uncoated grade for machining non-ferrous metals and aluminum.

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