

Multi Turn Features and Benefits

The innovative Multi Turn system replaces 3 tools with 1 multifunctional tool for drilling, boring, turning and face turning applications.

- Double through coolant system.
- Stepped cutting edge insert geometry for better cutting action and improved surface finish.
- Save space in your tool post and money on your tooling by using just 1 tool for 4 applications.
- 1 insert replaces the need for different styles for each individual tool.



Turning & Boring Cutting Data



Tool	Cut depth (mm)	Feed (mm/rev)
MT10	0.3~2.6	0.05~0.16
MT12	0.5~3.1	0.06~0.17
MT14	0.8~3.4	0.07~0.19
MT16	0.9~3.8	0.08~0.22
MT20	1.0~4.5	0.10~0.30

Face Turning Cutting Data



Tool	Cut depth (mm)	Feed (mm/rev)
MT10	0.6~1.6	0.04~0.14
MT12	0.6~2.1	0.04~0.16
MT14	0.6~2.5	0.04~0.17
MT16	0.6~3.0	0.04~0.20
MT20	0.6~3.8	0.04~0.24

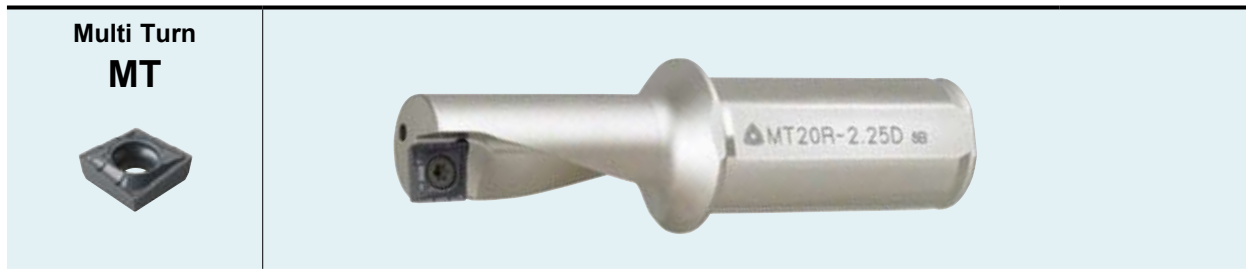
Drilling Cutting Data



Tool	Feed (mm/rev)
MT10	0.018~0.04
MT12	0.02~0.05
MT14	0.025~0.075
MT16	0.03~0.10
MT20	0.035~0.13

Surface Speed (m/min)

	Workpiece	NC3120		PC9030		NC6110	
		Turning	Drilling	Turning	Drilling	Turning	Drilling
P	Low carbon steel	150~300	100~150				
	High carbon steel	100~180	70~120				
	Low alloy steel	100~180	70~120				
	High alloy steel	80~150	60~100				
M	Austenitic stainless			140~210	100~150		
	Martensitic stainless			150~230	100~150		
K	Grey cast iron					100~200	70~140
	Ductile cast iron					100~180	70~120



Designation	£	Diameter	Shank	Flute Length	Overall Length	Inserts	Screw
MT10R-2.25D	£105.00	10mm	12mm	22	69	QCMT05	FTNA03508
MT12R-2.25D	£108.00	12mm	16mm	27	78	QCMT06	FTNA0306
MT14R-2.25D	£110.00	14mm	16mm	31	83	QCMT07	FTKA02555
MT16R-2.25D	£112.00	16mm	20mm	36	94	QCMT08	FTNA02205S
MT20R-2.25D	£132.00	20mm	25mm	45	110	QCMT10	FTNA0204S

Multi Turn Insert Selection

Designation	£	GRADES			Dimensions				
		NC3120	PC9030	NC6110	l	d	t	r	
QCMT 050204-CM	£4.33	•	•	•	5	5.4	2.10	0.4	
QCMT 060204-CM	£4.33	•	•	•	6	6.4	2.38	0.4	
QCMT 070304-CM	£4.33	•	•	•	7	7.4	3.18	0.4	
QCMT 080304-CM	£4.33	•	•	•	8	8.4	3.18	0.4	
QCMT 10T304-CM	£4.33	•	•	•	10	10.4	3.97	0.4	

Drilling Offsets

Part	Dia	Min-Max Drill Offset
MT10R- 2.25D	10	9.85-10.35mm
MT12R- 2.25D	12	11.85-12.35mm
MT14R- 2.25D	14	13.85-14.35mm
MT16R- 2.25D	16	15.85-16.35mm
MT20R- 2.25D	20	19.85-20.35mm