

Multi Turn



KORLOY Innovative multifunctional tool

Innovative combination for internal & external machining

- ▣ Reduced set-up times in complex machining cycles
- ▣ Double coolant supply for high durability

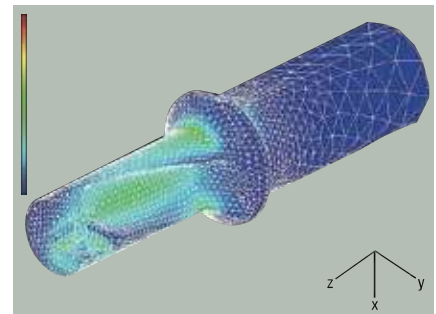
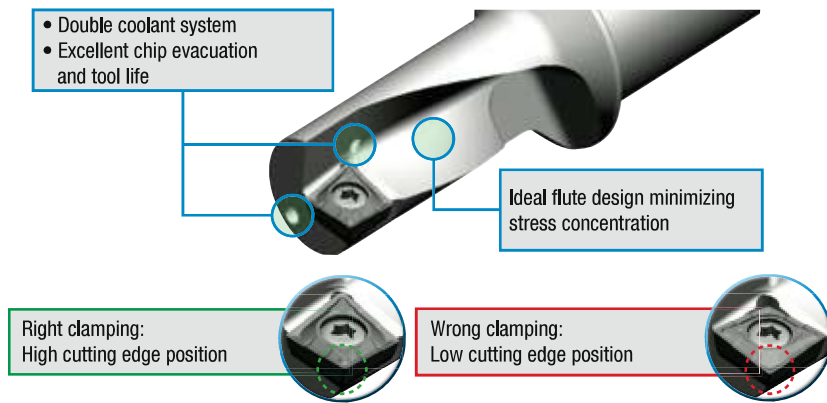


Multi Turn

Features

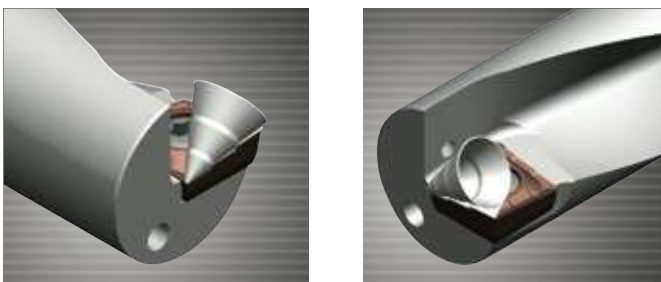
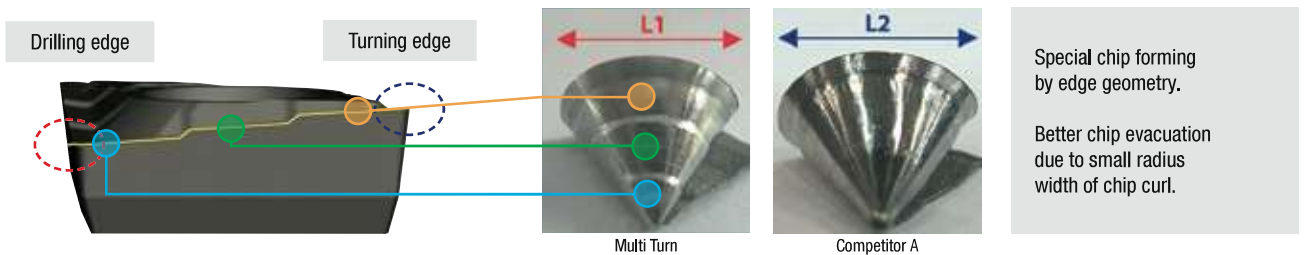
- Improved surface roughness and reduced cutting load by inclined cutting edge.
- Stepping designed cutting edge enables stable machining by minimizing cutting edge part on workpiece when drilling starts.
- Excellent cutting performance due to better chip curling while drilling.
- Helix-angled flute design enables smooth chip evacuation and excellent drilling.
- Through coolant system leads longer tool life and smooth chip evacuation.

Tool design by FEM analysis



Minimized stress during cutting, prevented damage from vibration and longer tool life. **Optimized design**

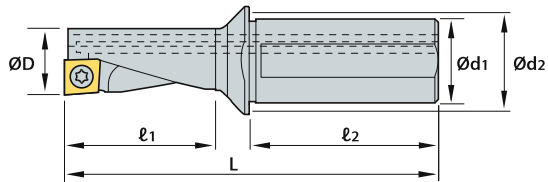
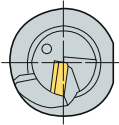
Innovative stepping cutting edge



Comparison	Multi Turn	Competitor A	Competitor B
fn 0.08 (mm/rev)			
fn 0.10 (mm/rev)			
Chip width	80%	100%	120%

Holder


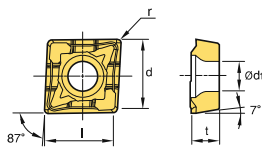

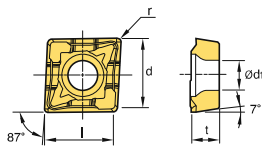

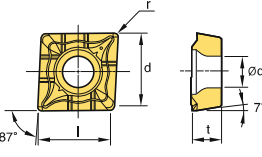
MT (Multi Turn)



(mm)

Designation	ØD	Ød1	Ød2	l1	l2	L	Insert	Screw	Wrench
MT10R-1.5D	10	12	16	15,0	40,0	60,0	QC_T050204-__	FTNA0204S	TW06P
MT10R/L-2.25D	10	12	16	22,5	42,0	69,5	QC_T050204-__	FTNA0204S	TWP06P
MT12R/L1.5D	12	16	20	27,0	45,0	78,0	QC_T060204-__	FTNA02205S	TWP06P
MT12R/L2.25D	12	16	20	27,0	45,0	78,0	QC_T060204-__	FTNA02205S	TWP06P
MT14R-1.5D	14	16	20	31,5	45,0	83,5	QC_T070304-__	FTKA02555	TWP07P
MT14R/L-2.25D	14	16	20	31,5	45,0	83,5	QC_T070304-__	FTKA02555	TWP07P
MT16R-1.5D	16	20	25	36,0	50,0	94,0	QC_T080304-__	FTNA0306	TWP09P
MT16R/L-2.25D	16	20	25	36,0	50,0	94,0	QC_T080304-__	FTNA0306	TWP09P
MT20R-1.5D	20	25	32	45,0	56,0	111,0	QC_T10T304-__	FTNA03508	TWP15P
MT20R/L-2.25D	20	25	32	45,0	56,0	111,0	QC_T10T304-__	FTNA03508	TWP15P
MT25R/L-2.25D	25	32	40	56,5	61,0	130,0	QC_T130408-__	FTNC04509	TW20S
MT32R/L-2.25D	32	40	50	72,0	74,0	160,0	QC_T170508-__	FTNC04511	TW20S

Applicable inserts

Picture	Designation	Grades					Geometry
		P	M	K	N	S	
	QCMT-CM	PC5300 NC3120 NC3215 NC3220 NC3225	PC5300	PC5300 NC6210 NC6315		PC5300	
	QCMT(B)-CM				H01		
	QCGT-CA				H01		

(mm)

Multi Turn

➔ Recommended cutting condition

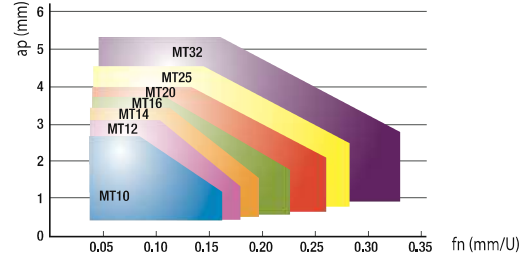
Workpiece		Hardness (HB)	PC5300		NC3225		NC6315		H01	
			Turning	Drilling	Turning	Drilling	Turning	Drilling	Turning	Drilling
P	Low-carbon steel ($\leq 0.25\% C$)	80-180	100-180	100-150	150-300	100-150	-	-	-	-
	High-carbon steel ($> 0.25\% C$)	180-280	90-160	60-140	100-180	70-120	-	-	-	-
	Low alloy steel	140-260	70-120	50-120	100-180	70-120	-	-	-	-
	High alloy steel	200-350	60-110	50-100	80-150	60-100	-	-	-	-
M	Austenite	135-275	80-150	50-110	-	-	-	-	-	-
	Martensite	135-275	90-170	60-120	-	-	-	-	-	-
K	Gray cast iron	150-220	120-240	120-200	-	-	100-200	70-140	-	-
	Ductile cast iron	130-240	120-200	100-180	-	-	100-180	70-120	-	-
N	Aluminium alloy	30-150	-	-	-	-	-	-	200-500	140-220
	Copper alloy	150-160	-	-	-	-	-	-	150-300	140-200
S	HRSA	130-400	30-70	30-90	-	-	-	-	-	-



External / Internal turning



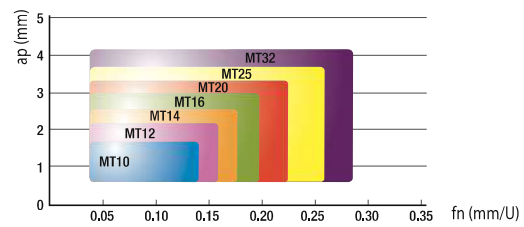
Application range



Facing



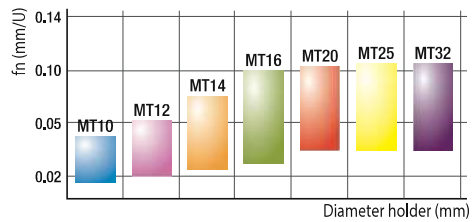
Application range



Drilling

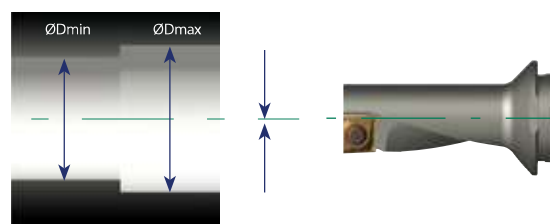


Drilling feed range



Offset (Diameter compensation)

Designation	Machined diameter (mm)	ØDmin (mm)	ØDmax (mm)
MT10R/L - __, __D	10	9,85	10,35
MT12R/L - __, __D	12	11,85	12,35
MT14R/L - __, __D	14	13,85	14,35
MT16R/L - __, __D	16	15,85	16,35
MT20R/L - __, __D	20	19,85	20,35
MT25R/L - __, __D	25	24,85	25,35
MT32R/L - __, __D	32	31,85	32,35



Drill diameter is adjustable by the offset compensation

Multi Turn

➔ Cutting performance

Comparison of chip controls (Drilling)

Multi Turn	Competitor A	Multi Turn	Competitor A
	 NG		 NG
	 NG		 NG
	 NG		
Diameter (12mm)		Diameter (16mm)	

- **Holder :**
MT12R / MT16R-2,25D
- **Insert :**
QCMT060204/080304-CM NC3220
- **Workpiece:**
Low alloy steel (SCM440)
- **Cutting conditions:**
vc: 100 m/min
fn: 0.04-0.12 mm/rev
wet

Tool life comparison

Turning Carbon steel (C45)	Turning Low alloy steel	Drilling und Turning Low alloy steel
<ul style="list-style-type: none"> ■ Holder : MT14R-2,25D ■ Insert : QCMT070304-CM NC3220 ■ Application: External turning and facing (Roughing & finishing) ■ Cutting conditions: vc: 180 m/min fn: 0.1-0,2 mm/rev ap: 0.5-1.2 mm wet 	<ul style="list-style-type: none"> ■ Holder : MT12R-2,25D ■ Insert : QCMT060204-CM NC3220 ■ Application: External turning and facing (Roughing & finishing) ■ Cutting conditions: vc: 180 m/min fn: 0.1-0.2 mm/rev ap: 0.5-1.2 mm wet 	<ul style="list-style-type: none"> ■ Holder : MT16R-2,25D ■ Insert : QCMT080304-CM NC3220 ■ Application: Drilling, facing, external and internal turning (Roughing & finishing) ■ Cutting conditions: vc: 100 - 180 m/min fn: 0.05-0.2 mm/rev ap: 0.5-2.0 mm / wet
<div style="display: flex; justify-content: space-between; align-items: center;"> <div style="background-color: #90EE90; padding: 5px; border: 1px solid black;">50 min</div> <div style="color: green; font-weight: bold;">Multi Turn</div> </div> <div style="display: flex; justify-content: space-between; align-items: center; margin-top: 5px;"> <div style="background-color: #D3D3D3; padding: 5px; border: 1px solid black;">25 min</div> <div>Competitor</div> </div>	<div style="display: flex; justify-content: space-between; align-items: center;"> <div style="background-color: #90EE90; padding: 5px; border: 1px solid black;">45 min</div> <div style="color: green; font-weight: bold;">Multi Turn</div> </div> <div style="display: flex; justify-content: space-between; align-items: center; margin-top: 5px;"> <div style="background-color: #D3D3D3; padding: 5px; border: 1px solid black;">22 min</div> <div>Competitor</div> </div>	<div style="display: flex; justify-content: space-between; align-items: center;"> <div style="background-color: #90EE90; padding: 5px; border: 1px solid black;">11 Pcs.</div> <div style="color: green; font-weight: bold;">Multi Turn</div> </div> <div style="display: flex; justify-content: space-between; align-items: center; margin-top: 5px;"> <div style="background-color: #D3D3D3; padding: 5px; border: 1px solid black;">6 Pcs.</div> <div>Competitor</div> </div>

Comparison on surface roughness

 Multi Turn	 <ul style="list-style-type: none"> ■ Visible roughness Glossy surface → Superior ■ Measurement Ra: 0.47µm Rz: 4.56 µm
 Competitor	 <ul style="list-style-type: none"> ■ Visible roughness Hazy surface → Interior ■ Measurement Ra: 0.70 µm Rz: 5.92 µm

Advantages of Multi Turn

Standard tools



Using tool - Single

3 different kinds of tools
(External, internal, drill)



Multi Turn

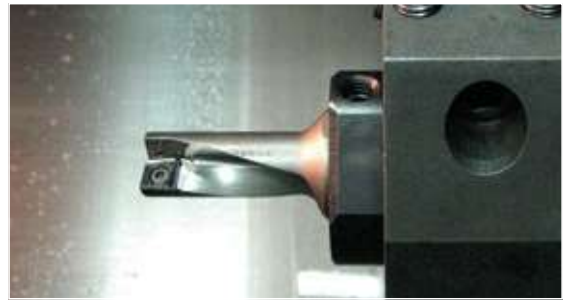


Preparatory time of work - Reduced

20 min. → 5 min.

Operating time - Reduced

10 min. / Pcs. → 8 min. / Pcs.



Productivity comparison

Standard tools	
Preparatory time of work	20 min.
Operating time (50 Pcs.)	(50 * 10) 500 min.
Total production time	520 min.
Reduced production time (Productivity improved)	-

Productivity comparison

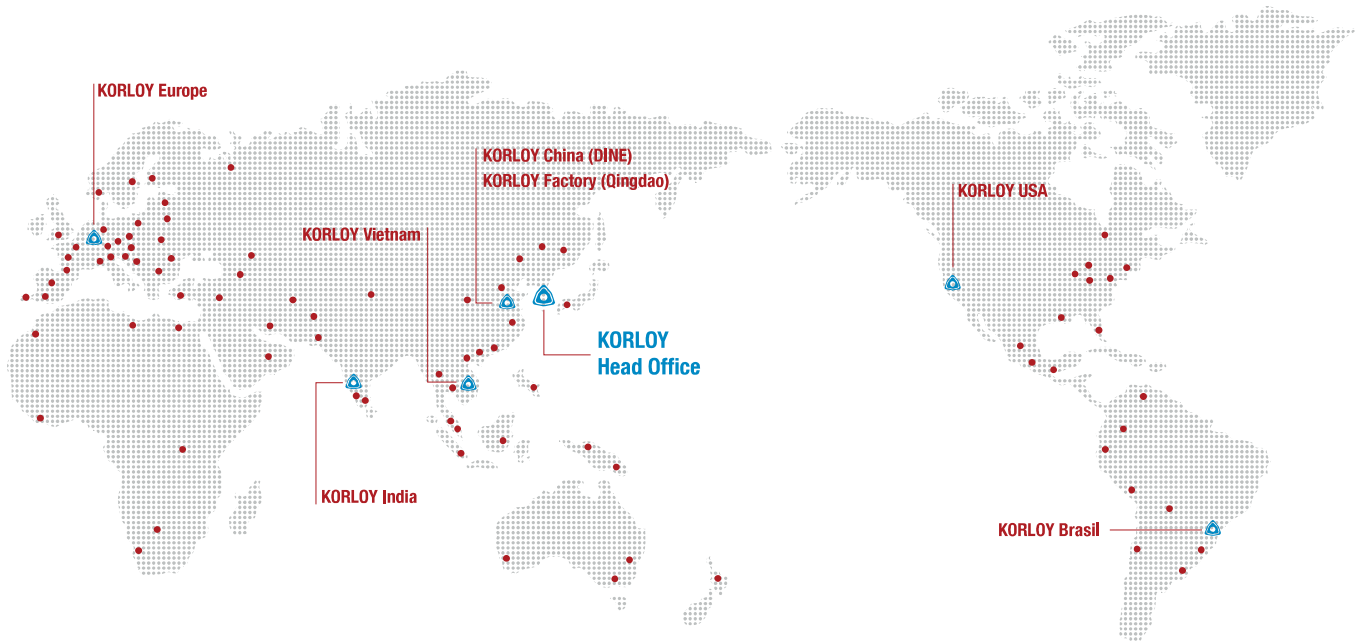
Multi Turn	
Preparatory time of work	5 min.
Operating time (50 Pcs.)	(50 * 8) 400 min.
Total production time	405 min.
Reduced production time (Productivity improved)	22% less Time (22% improved)



Finished goods



→ Superior productivity and cost reduction achieved




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Av. Aruana 280, conj.12, WLC, Alphaville, Barueri, CEP06460-010, SP, Brasil



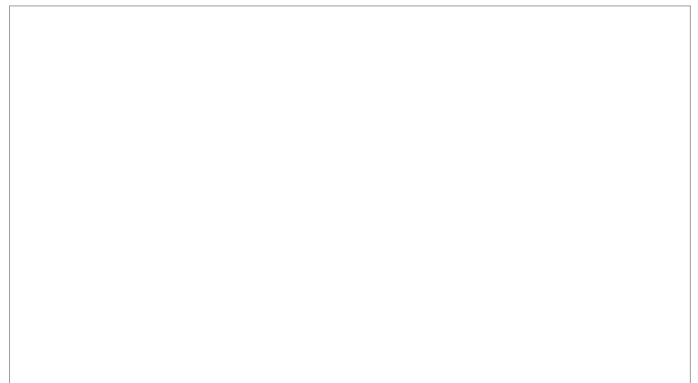
No. 133 Le Loi street, Hoa Phu ward, Thu Dau Mot city, Binh Duong proviende, Vietnam



Ground Dongjing Road 56 District Free Trade Zone, Qingdao, China



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