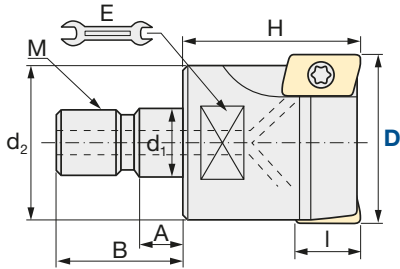
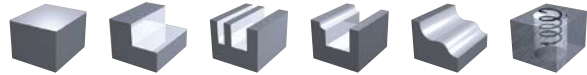


AHUM15 | High Feed Ultra Modular Type

Q max High Efficient	Jet Air Hole	▽ Roughing	▽▽▽ Finishing	HRC 50	No. of Teeth 2 - 4
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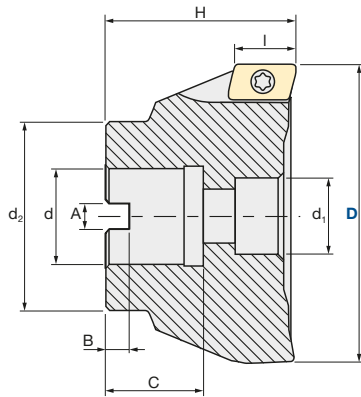
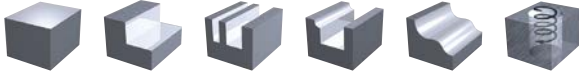
Diameter Holder only [mm]	Fastening Torque [Nm]
D25 - 42 mm:	-0.1/-0.2 mm 3.0 Nm

Modular Type												
ID Code	Item Code	Flutes	D	H	d ₁	M	d ₂	A	B	E	I	Inserts
FH068	AHUM-1525R-2	2	25	35	12.5	12	20.8	6	20	17	14	JDMT1505..R.. JDET-1505..R..
FH066	AHUM-1532R-3-M16	3	32	40	17	16	28.8		22	22		
FH176	AHUM-1535R-3-M16		35									
FH067	AHUM-1540R-4-M16	4	40	45								
FH177	AHUM-1542R-4-M16		42									

ASC | Carbide Shanks for Modular Mills & **AS** | Steel Shanks for Modular Mills: page 8

AHUB15 | High Feed Ultra Bore Type

Q max High Efficient	Jet Air Hole	▽ Roughing	▽▽▽ Finishing	HRC 50	No. of Teeth 4 ~ 14
--------------------------------	------------------------	----------------------	-------------------------	------------------	-------------------------------



Diameter Holder only [mm]	Fastening Torque [Nm]
D40 - 100 mm:	-0.1/-0.2 mm
D125 - 160 mm:	-0.1/-0.25 mm
D200 mm:	-0.1/-0.3 mm
D250 mm:	-0.1/-0.45 mm
	3.0 Nm

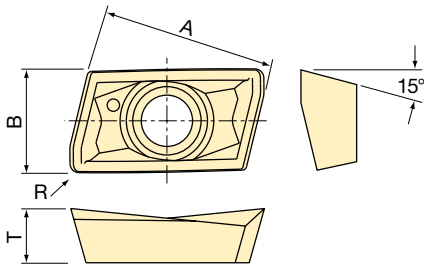
Face Mill												
ID Code	Item Code	Flutes	D	H	d	d ₁	d ₂	A	B	C	I	Inserts
FH060	AHUB-1540RM-4-16	4	40	45	16	11.5	35	8.4	5.6	18	14	JDMT1505..R.. JDET-1505..R..
FH061	AHUB-1550RM-5-22	5	50		22	18	40	10.4	6.3	20		
FH062	AHUB-1550RM-5-27		50	27	20	45	12.4	7	22			
FH178	AHUB-1552RM-5-22	6	52	50	22	18	40	10.4	6.3	20		
FH063	AHUB-1563RM-6-27		63									
FH179	AHUB-1566RM-6-27	7	66	50	27	20	60	12.4	7	22		
FH064	AHUB-1580RM-7-27		80									
FH065	AHUB-15100RM-8-32	8	100	63	32	26	70	14.4	8	25		
FH211	AHUB-15125RM-8-40		125		40	32.5	90	16.4	9	29		
FH212	AHUB-15160RM-10-40	10	160	63	56	114	25.7	14	49			
FH213	AHUB-15200RM-12-60	12	200		60	60+screw				145		
FH214	AHUB-15250RM-14-60	14	250	180								

Cutting Conditions | Schnittwerte | Condizioni di taglio | Condiciones de Corte | Conditions de coupe | Valores de corte:

D 25 (Z2) - D 250 (Z14):

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INSERTS



JDMT-150530-R



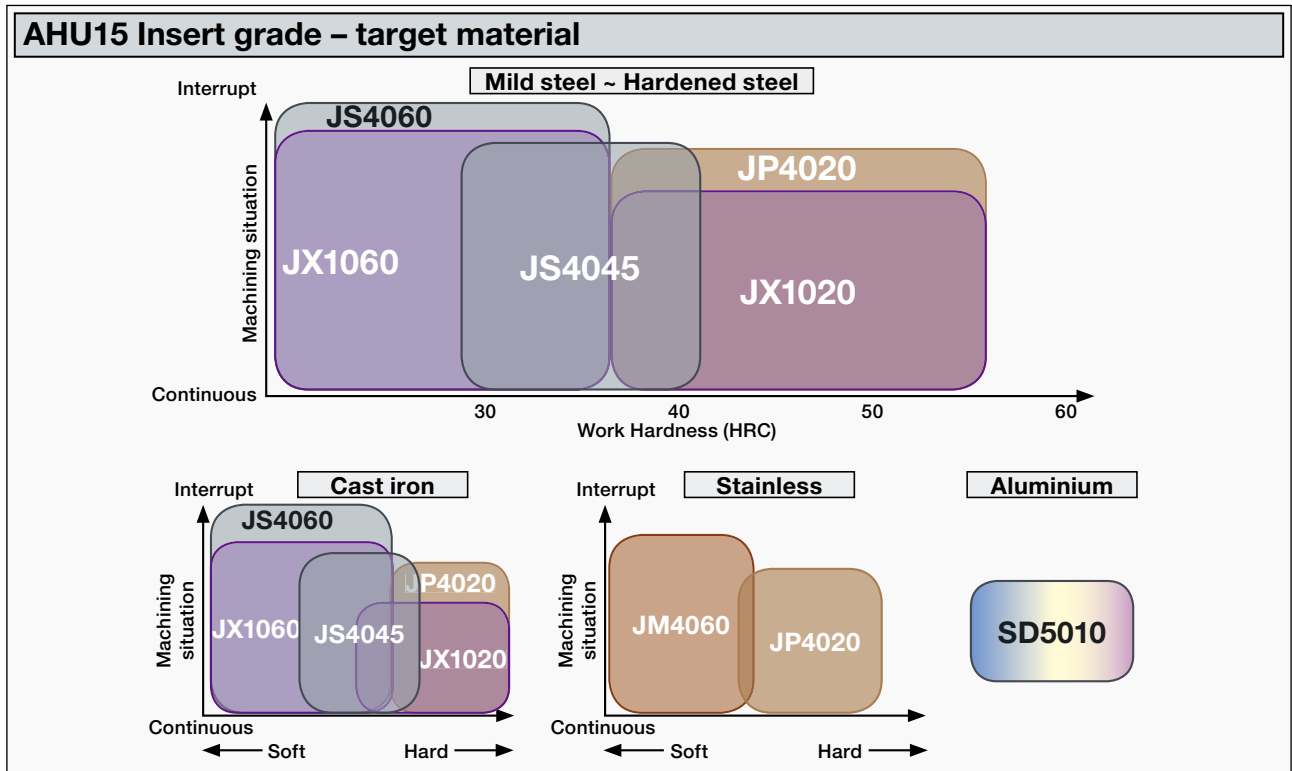
JDMT-150504-R-FW






-  In case of bigger corner-R than R2.0, modification of body is needed.
-  Für Eckenradien über R 2.0 muss der Halter entsprechend modifiziert werden.
-  In caso di raggio torico R maggiore di 2 è necessario modificare opportunamente il corpo fresa.
-  Si el radio de placa es superior a R 2.0, el soporte debe modificarse.
-  Si le rayon de tore est supérieur à R 2, une modification du porte plaquettes s'avère nécessaire.
-  Se o raio da plaquete for maior que R 2.0 , precisa de mudar o corpo.

Inserts			Target Hardness of Workpiece						Size (mm)			
			Grade									
Item Code	Tolerance Class	Corner-R	SD5010	JM4060	JX1060	JS4060	JS4045	JP4020	JX1020	A	B	T
JDMT-1505-R04-FW	M	0.4-FW		WF358		WF357	WF367	WF356		16	9.12	5
JDMT-1505-R08-FW		0.8-FW		WF361	WF185	WF360	WF368	WF359	WF183			
JDMT-1505-R20		2.0		WF364		WF363	WF369	WF362				
JDMT-1505-R20-FW		2.0-FW					WF370					
JDMT-1505-R30		3.0					WF371					
JDET-1505-R04-FA	E	0.4-FA	WF365									

- SD5010** PVD · For Aluminium
- JM4060** PVD · For stainless steels & carbon steels < 35HRC
- JX1060** PVD · For carbon steels < 35HRC
- JS4060** PVD · For carbon steels < 35HRC

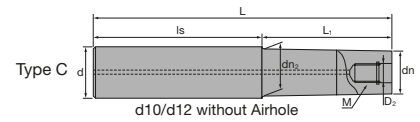
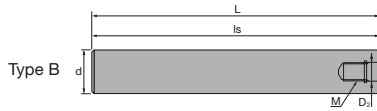
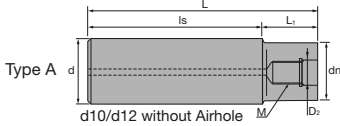
- JS4045** PVD · For general steels 30–40HRC
- JP4020** PVD · For pre-hardened steels 40–55 HRC
- JX1020** PVD · For pre-hardened steels 40–55HRC



Parts	Clamp Screw 		Wrench 	
	ID-Code	Item-Code	ID-Code	Item-Code
AHU-M 	ET038	412-141	ET049	105-T15
AHU-B 				
AHUB-1540RM-4-16 	Special screw			
	ID-Code	Item-Code		
	ET050	K06-676		

ASC | Carbide Shanks for Modular Mills

MMC Hitachi Tool Engineering Europe GmbH



Carbide Shank		ID Code	Item Code	D ₂	M	L	L ₁	Is	dn	dn ₂	d	Type	
Without Airhole	FH137	ASC10-6.5-74-24	6.5	M6	74	24	50	9.3	-	10	10	A	
	FH254	ASC10-6.5-84-34			84	34							
	FH255	ASC10-6.5-114-24			114	24							90
	FH138	ASC10-6.5-114-49			114	49							65
	FH139	ASC12-6.5-74-24	11	M6	74	24	50	11	11.5	12	12	C	
	FH256	ASC12-6.5-94-44			94	44							
	FH257	ASC12-6.5-129-24			129	24							105
	FH140	ASC12-6.5-129-64			129	64							65
With Airhole	FH141	ASC16-8.5-95-30	8.5	M8	95	30	65	14.5	15.5	16	16	C	
	FH258	ASC16-8.5-120-55			120	55							
	FH142	ASC16-8.5-140-75			140	75							
	FH260	ASC16-8.5-160-30			160	30							130
	FH259	ASC16-8.5-160-95	160	95	65								
	FH143	ASC20-10.5-120-50	10.5	M10	120	50	70	18	-	20	20	A	
	FH261	ASC20-10.5-170-90Z			170	90	80	18.5	19.5				
	FH144	ASC20-10.5-220-50			220	50	170	18	-				
	FH262	ASC20-10.5-220-120Z			220	120	100	18.5	19.5				
	FH263	ASC20-10.5-270-150Z	270	M10	150	120	220	18.5	19.5	20	20	C	
	FH264	ASC20-10.5-270-50Z			50	220							
	FH145	ASC25-12.5-145-65	12.5	M12	145	65	80	23	-	25	25	A	
	FH146	ASC25-12.5-265-65			265		200						
	FH265	ASC25-12.5-215-115			215		115						100
	FH266	ASC25-12.5-265-145			265		145						120
	FH268	ASC25-12.5-315-65			315		65						250
	FH267	ASC25-12.5-315-195			315		195						120
	FH147	ASC32-17-160-80	17	M16	160	80	80	28	-	32	32	A	
FH269	ASC32-17-260-140	260			140	120							
FH148	ASC32-17-310-80	310			80	230							
FH270	ASC32-17-360-240	360			240	120							

- 🇬🇧 SUPER Lock milling chucks or shrink-fit holders can be used.
- 🇩🇪 SUPER Lock Aufnahmen oder Schrumpffutter können verwendet werden.
- 🇮🇹 Possono essere utilizzati mandrini a forte serraggio SUPER Lock.

- 🇪🇸 Aptos para amarrar en portapinzas SUPER Lock.
- 🇫🇷 Les attachements SUPER Lock peuvent être utilisés.
- 🇵🇹 Cones hidráulicos de grande aperto e aperto térmico podem ser usados.

AS | Steel Shanks for Modular Mills


Steel Shank		ID Code	Item Code	D ₂	M	L	L ₁	Is	dn	dn ₂	d	Type
Without Airhole	FH131	AS10-6.5-74-0	6.5	M6	74	-	74	-	-	-	10	B
	FH132	AS12-6.5-84-4			84	4	80	11	-	12	A	
With Airhole	FH133	AS16-8.5-95-15	8.5	M8	95	15	80	14.5	15.5	16	C	
	FH134	AS20-10.5-100-20	10.5	M10	100	20		18	-	20	A	
	FH271	AS25-12.5-115-35	12.5	M12	115	35		23	23	25		
	FH272	AS32-17-110-30	17	M16	110	30		28	28	32		

- 🇬🇧 SUPER Lock milling chucks can be used.
- 🇩🇪 SUPER Lock Aufnahmen können verwendet werden.
- 🇮🇹 Possono essere utilizzati mandrini a forte serraggio SUPER Lock.

- 🇪🇸 Aptos para amarrar en portapinzas SUPER Lock.
- 🇫🇷 Les attachements SUPER Lock peuvent être utilisés.
- 🇵🇹 Cones hidráulicos de grande aperto e aperto térmico podem ser usados.

- 🇬🇧 For further information about modular chucks please see our brochure *Indexable Modular Series No. 328*
- 🇩🇪 Weitere Informationen über modulare Werkzeugaufnahmen finden Sie in unserem Prospekt: *Indexable Modular Series No. 328*
- 🇪🇸 Para obtener más información sobre conos modulares consulte nuestro folleto *Indexable Modular Series No. 328*
- 🇮🇹 Per maggiori informazioni riguardanti la gamma dei mandrini avvitali consultate il catalogo *Indexable Modular Series No. 328*

- 🇫🇷 Pour de plus amples informations concernant les attachements modulaires, voyez SVP notre brochure *Indexable Modular Series No. 328*
- 🇵🇹 Para mais informações sobre Conos Modulares consulte o nosso folheto *Indexable Modular Series No. 328*



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