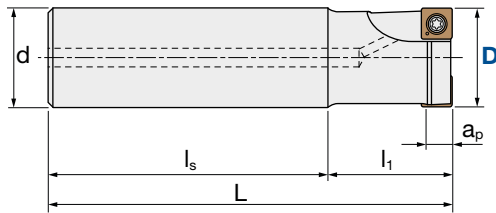
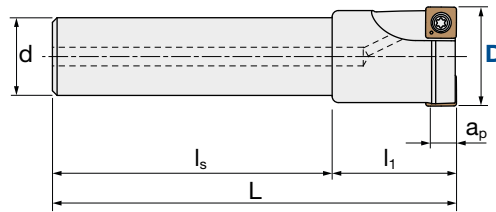


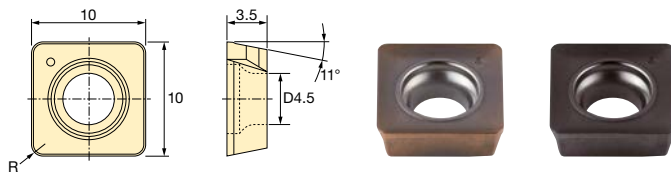
**SS4P | Easy Cut 4 Corners Shoulder Mill SS4P**

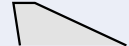
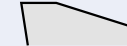
<b>V max</b> High Speed	<b>▽</b> Roughing	<b>▽▽</b> Semi Finishing	<b>HRC</b> 40	<b>No. of Teeth</b> 2-4
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**A – Standard Type**

**B – Undercut Type**


Diameter Holder only [mm]	Fastening Torque [Nm]
<b>0/-0.25 mm</b>	<b>2.9 Nm</b>

ID Code	Item Code	Flutes	D	a <sub>p</sub>	l <sub>1</sub>	l <sub>s</sub>	L	d	Shape	Shank	Coolant Hole	Inserts
FH600	<b>SS4P3025S25-2</b>	2	<b>25</b>	8	35	85	120	25	A	Steel	•	SPMT10030...R-FW SPMT100308R-TFW
FH601	<b>SS4P3032S32-3</b>	3	<b>32</b>		45		130	32	B			
FH602	<b>SS4P3040S32-4</b>	4	<b>40</b>									


**INSERTS SS4P | Easy Cut 4 Corners Shoulder Mill SS4P**



Cross sections of cutting edges:	
	
<b>Fig.1: FW Type</b> General Purpose	<b>Fig.2: TFW Type</b> Hardened surface milling; Heavy interrupt milling

Inserts	Tolerance Class	Grade		Size (mm)			Cross Section Shape
		GX2140	JP4120	R	T	Inscribed Circle	
Item code		ID-Code					
<b>SPMT100304R-FW</b>	M	WF775	WF772	0.4	3.5	10	Fig.1
<b>SPMT100308R-FW</b>		WF776	WF773	0.8			Fig.2
<b>SPMT100308R-TFW</b>		WF777	WF774				


**GX2140**


 **CVD** - For heavy roughing of mild steels | Recommended for dry cutting

 **CVD** - für große Schruppvolumina in Bau- sowie Vergütungsstählen  
Trockenbearbeitung ist zu empfehlen.


 **CVD** - Sgrossatura pesante di acciaio da costruzione | Raccomandato per taglio a secco


 **CVD** - Grosse ébauche pour acier doux | Recommandé en usinage à sec


 **CVD** - Para grandes desbastes de aceros blandos | Recomendado para el mecanizado en seco


 **CVD** - Para desbaste pesado de aço macio | Recomendado para corte a seco


**JP4120**


 **PVD** - Grade for pre-hardened steels or hardened steels | Employs a fine carbide substrate with an excellent balance between wear resistance and toughness and the new „AJ Coating“ to provide wear resistance and chipping resistance. Highly versatile with excellent wear resistance and chipping resistance when machining steel materials.

 **PVD** - für vorgehärtete und gehärtete Stähle | Verbindet feinkörniges Hartmetall-Substrat mit der hervorragenden Balance zwischen Verschleißfestigkeit und Härte der neuen „AJ Beschichtung“. Vielseitige Beschichtung mit höchster Verschleißfestigkeit und Beständigkeit gegen Absplinterung für die Bearbeitung von Stählen.

 **PVD** - Grado per acciai bonificati o temprati | Viene utilizzato un substrato in micro grana con un'eccezionale bilanciamento tra resistenza all'usura e tenacità abbinato al nuovo rivestimento „AJ“ resistente ad usura e scheggiatura. Estremamente versatile nella lavorazione di acciaio.

 **PVD** - Nuance pour les aciers pré-traités et les aciers trempés | Combinaison d'un substrat carbure apportant un bon équilibre résistance à l'usure/dureté et le nouveau revêtement „AJ“ apportant une grande résistance à l'usure et à l'écaillage. Très polyvalent, il est adapté aux aciers.

 **Calidad PVD para aceros templados o pre-templados** | Tiene un sustrato de metal duro fino con una excelente equilibrio entre la resistencia al desgaste y la tenacidad y que junto al nuevo "Recubrimiento AJ" le proporciona una elevada resistencia al desgaste y a la micro-rotura. Altamente versátil, con excelente resistencia al desgaste y a la micro-rotura en el mecanizado de aceros.

 **PVD** - Grau para aços pré-tratados ou temperados | Utiliza uma fina camada de substrato de carboneto com um equilíbrio excelente entre resistência ao desgaste e robustez e aplica o novo revestimento „AJ“ que proporciona resistência ao desgaste e facilita a remoção de aparas. Altamente versátil com excelente resistência ao desgaste e facilidade de remoção de aparas na maquinação de aço com durezas de 30 a 50 HRC.



**SS4P | Recommended Cutting Conditions**

Work piece material	Recommend grade & Target hardness (HRC)		Emulsion	Mist	Air	Parameter	D 25 (Z2)	D 32 (Z3)	D 40 (Z4)
	30	40							
I Mild steel/ Carbon steel <20 HRC	GX2140					V <sub>c</sub> m/min	200	200	200
						n min <sup>-1</sup>	2546	1989	1592
						f <sub>z</sub> mm/t	0.25	0.25	0.25
						V <sub>f</sub> mm/min	1273	1492	1592
						a <sub>p</sub> mm	2.5	3.0	3.0
						a <sub>e</sub> mm	12.5	16.0	20.0
						Q cm <sup>3</sup> /min	40	72	95
II Alloy steel <30 HRC	GX2140					V <sub>c</sub> m/min	170	170	170
						n min <sup>-1</sup>	2166	1692	1354
						f <sub>z</sub> mm/t	0.23	0.23	0.23
						V <sub>f</sub> mm/min	996	1167	1245
						a <sub>p</sub> mm	2.5	3.0	3.0
						a <sub>e</sub> mm	12.5	16.0	20.0
						Q cm <sup>3</sup> /min	31	56	75
III Alloy steel/ Tool steel 30-40 HRC	GX2140	JP4120	•	•	•	V <sub>c</sub> m/min	140	140	140
						n min <sup>-1</sup>	1783	1393	1114
	f <sub>z</sub> mm/t	0.20	0.20	0.20					
	V <sub>f</sub> mm/min	713	836	891					
	a <sub>p</sub> mm	2.0	2.0	2.0					
	a <sub>e</sub> mm	12.5	16.0	20.0					
	Q cm <sup>3</sup> /min	18	27	36					
VII Cast Iron (GG) EN-JL10**/ EN-GJL-***	GX2140	JP4120	•	•	•	V <sub>c</sub> m/min	180	180	180
						n min <sup>-1</sup>	2292	1790	1432
	f <sub>z</sub> mm/t	0.25	0.25	0.25					
	V <sub>f</sub> mm/min	1146	1343	1432					
	a <sub>p</sub> mm	2.0	2.5	2.5					
	a <sub>e</sub> mm	12.5	16.0	20.0					
	Q cm <sup>3</sup> /min	29	54	72					
VIII Cast Iron (GGG) EN-JS10/ 20**/ EN-GJS-***	GX2140	JP4120	•	•	•	V <sub>c</sub> m/min	140	140	140
						n min <sup>-1</sup>	1783	1393	1114
	f <sub>z</sub> mm/t	0.2	0.2	0.2					
	V <sub>f</sub> mm/min	713	836	891					
	a <sub>p</sub> mm	2.0	2.5	2.5					
	a <sub>e</sub> mm	12.5	16.0	20.0					
	Q cm <sup>3</sup> /min	18	33	45					
IX Stainless steel (dry)	JP4120	•	•	•	•	V <sub>c</sub> m/min	250	250	250
						n min <sup>-1</sup>	3183	2487	1989
	f <sub>z</sub> mm/t	0.2	0.2	0.2					
	V <sub>f</sub> mm/min	1273	1492	1592					
	a <sub>p</sub> mm	2.0	2.5	2.5					
	a <sub>e</sub> mm	12.5	16.0	20.0					
	Q cm <sup>3</sup> /min	32	60	80					
IX Stainless steel (wet)	JP4120	•	•	•	•	V <sub>c</sub> m/min	120	120	120
						n min <sup>-1</sup>	1528	1194	955
	f <sub>z</sub> mm/t	0.2	0.2	0.2					
	V <sub>f</sub> mm/min	611	716	764					
	a <sub>p</sub> mm	2.0	2.5	2.5					
	a <sub>e</sub> mm	12.5	16.0	20.0					
	Q cm <sup>3</sup> /min	15	29	38					
X Titanium/ high alloy steel	JP4120	•	•	•	•	V <sub>c</sub> m/min	50	50	50
						n min <sup>-1</sup>	637	497	398
	f <sub>z</sub> mm/t	0.18	0.18	0.18					
	V <sub>f</sub> mm/min	223	261	279					
	a <sub>p</sub> mm	2.0	2.5	2.5					
	a <sub>e</sub> mm	12.5	16.0	20.0					
	Q cm <sup>3</sup> /min	6	10	14					

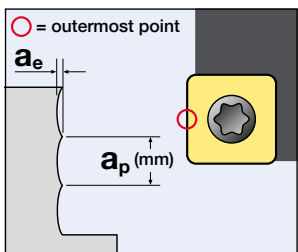
Maximum f<sub>z</sub> (mm/t) < 0.3  
Maximum a<sub>p</sub> (mm) < 8

**INSERTS | Improved cutting surface | Fine Wall Type SPMT...R-FW**

🇩🇪 Querschnitt der Schneidkanten: 🇮🇹 Sezione trasversale del filo tagliente: 🇫🇷 Coupes transversales des dents: 🇪🇸 Las secciones transversales de los filos de corte: 🇵🇹 Diagrama de secção da aresta de corte:

**Fig.1: FW Type**  
🇩🇪 Universal 🇮🇹 Impiego generico 🇫🇷 Usage général 🇪🇸 Uso general 🇵🇹 Uso Geral

**Fig.2: FFW Type**  
🇩🇪 Für geschmiedete Oberflächen; stark unterbrochene Schnitte 🇮🇹 Superfici forgiate; Forte taglio interrotto 🇫🇷 Surface forgée; Usinage aux chocs élevé 🇪🇸 Capas superficial de la forja; Fuerte corte intermitente 🇵🇹 Corte de superficies forjadas; Forte corte intermitente



Parts	Clamp Screw			Wrench	
Shape					
	ID-Code	Item-Code	Fastening Torque [Nm]	ID-Code	Item-Code
	ET038	412-141	2.9 Nm	ET012	104-T15