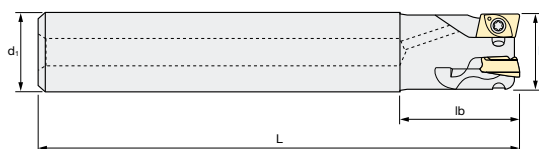
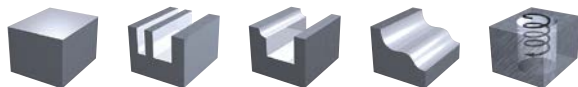


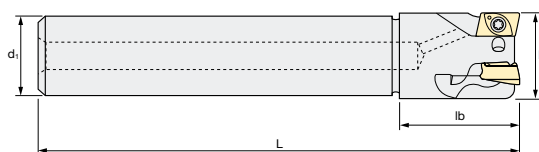
Indexable Milling Tools

ASM | Shank Type (Short/Long)

Q max	Jet	▽	▽▽	▽▽▽	HRC	No. of Teeth
High Efficient	Air Hole	Roughing	Semi-Finishing	Finishing	50	1 ~ 5



Standard type



Undercut type

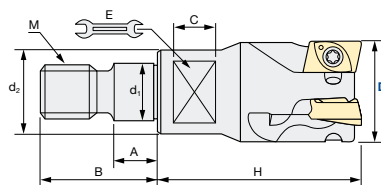
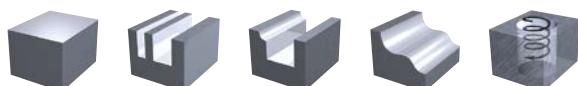


Tolerance D:	Maximum torque on screw:
-0.1 / -0.2	0.5 Nm

Shank Type									
	ID Code	Item Code	Flutes	D	L	lb	d ₁	Shape	Inserts
Short	FH116	ASM-0708S10R-1	1	8	75	16	10	Standard type	JDMT0702..R EDMT070220R (-T)
	FH117	ASM-0710S10R-2	2	10					
	FH118	ASM-0712S12R-3	3	12	80	20	12	Undercut type	
	FH119	ASM-0714S12R-3		14					
	FH120	ASM-0716S16R-4	4	16	90	25	16	Standard type	
	FH121	ASM-0717S16R-4		17	115	20		Undercut type	
	FH122	ASM-0720S20R-5	5	20	105	25	20	Standard type	
	FH123	ASM-0721S20R-5		21	140	20		Undercut type	
Long	FH124	ASML-0716S16R-4	4	16	115	50	16	Standard type	
	FH125	ASML-0720S20R-5	5	20	140	60	20		

ASM | Modular

Q max	Jet	▽	▽▽	▽▽▽	HRC	No. of Teeth
High Efficient	Air Hole	Roughing	Semi-Finishing	Finishing	50	1 ~ 8



D 16 - 32 with Airhole	Tolerance D:	Maximum torque on screw:
	-0.1 / -0.2	0.5 Nm

	Modular Type												
	ID Code	Item Code	Flutes	D	H	d ₁	M	d ₂	A	B	C	E	Inserts
Without Airhole	FH126	ASMM-0708R-1	1	8	20	6.5	M6	9.8	5.5	14.5	5	7	JDMT0702..R EDMT070220R (-T)
	FH127	ASMM-0710R-2	2	10				9.4					
	FH128	ASMM-0712R-3	3	12				9.8					
With Airhole	FH129	ASMM-0716R-4	4	16	25	8.5	M8	12.8	5.5	17	8	10	
	FH130	ASMM-0720R-5	5	20	30	10.5	M10	17.8		19	10	15	
	FH135	ASMM-0725R-6	6	25		12.5	M12	20.8		22		17	
	FH136	ASMM-0732R-8	8	32		17	M16	28.8	6	23	12	22	

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

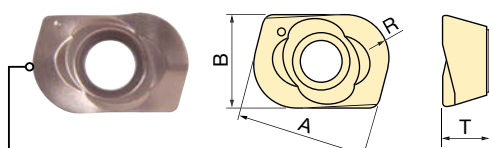
EDMT: D 8 (Z1) – D 32 (Z8): Page 5

JDMT: D 8 (Z1) – D 32 (Z8): Page 6–7

Indexable Milling Tools

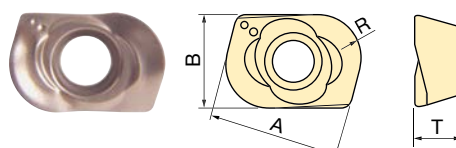
INSERTS ASM/AHU | Mini

EDMT070220R - **T** Standard Type



Insert with 2.0 mm corner R for low-depth, high-feed-rate cutting ($a_{p \max} = 0.3 \text{ mm}$)

EDMT070220R Low-force breaker type

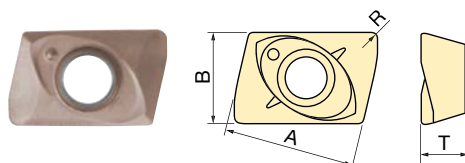


Insert with 2.0 mm corner R for low-depth, high-feed-rate cutting ($a_{p \max} = 0.3 \text{ mm}$)

ID Code	Item Code	Tolerance Class	Target Hardness of Workpiece			Size				Shape
			Soft	Grade	Hard	A	B	R	T	
WF663	EDMT070220R	M		JM4060	JX1020	6.4	4.3	2	2.5	Low-force type
WF664	EDMT070220R-T									Standard type
WF709	EDMT070220R-T									
WF710	EDMT070220R-T									
WF711	EDMT070220R									Low-force type
WF712	EDMT070220R									

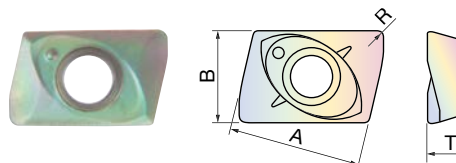
JM4060	JM Coating
JP4020	JP Coating
JX1020	PVD Coating/Dry Cutting

JDMT07020..R



Insert with 5 mm flute length for shoulder cutting ($a_{p \max} = 5.0 \text{ mm}$)

JDMT07020..R DLC Coated



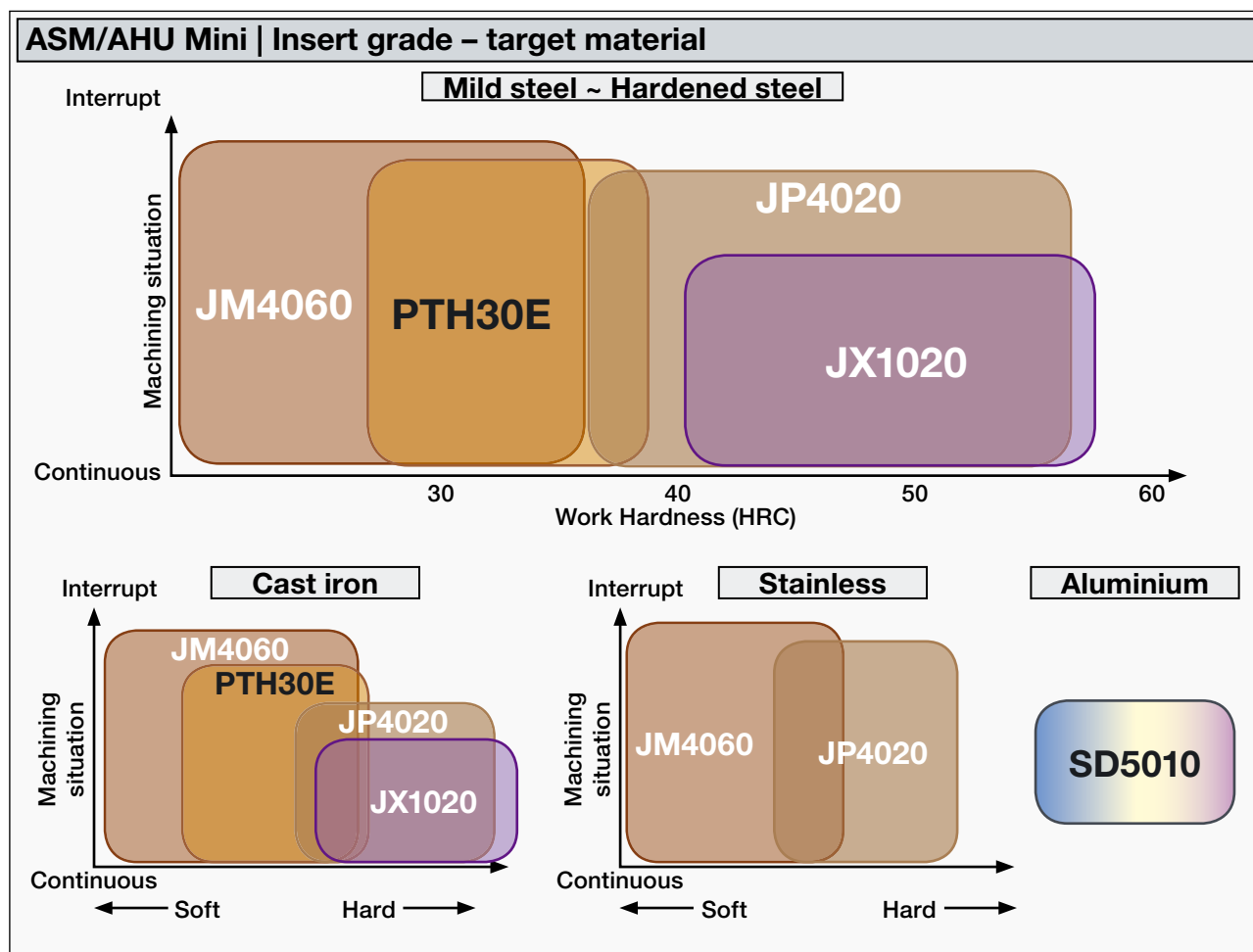
Insert with 5 mm flute length for shoulder cutting ($a_{p \max} = 5.0 \text{ mm}$)

Soft Target Hardness of Workpiece Hard													
		Tolerance Class	Corner-R	Grade					Size				
ID Code	Item Code			SD5010	JM4060	PTH30E	JP4020	JX1020	A	B	R	T	
WF665	JDMT070202R	M	0.2						6.4	4.3	0.2	2.45	
WF666	JDMT070202R					•							
WF671	JDMT070202R			•									
WF667	JDMT070204R		0.4					•			0.4		
WF668	JDMT070204R					•							
WF672	JDMT070204R			•									
WF669	JDMT070208R		0.8					•			0.8		
WF670	JDMT070208R					•							
WF673	JDMT070208R			•									
WF689	JDMT070202R		0.2				•				0.2		
WF690	JDMT070202R					•							
WF691	JDMT070204R		0.4				•				0.4		
WF692	JDMT070204R					•							
WF693	JDMT070208R		0.8				•				0.8		
WF694	JDMT070208R					•							

SD5010	DLC Coating
JM4060	JM Coating
PTH30E	TH Coating
JP4020	JP Coating
JX1020	PVD Coating/Dry Cutting

Parts	Clamp Screw ID-Code	Item-Code	Wrench ID-Code	Item-Code
	ET052	240-140	ET053	106-T6

Indexable Milling Tools



ASM/AHU | Mini | Recommended Cutting Conditions for **EDMT** Inserts

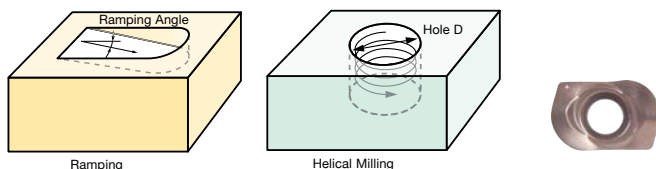
PLEASE NOTE:

The values in these tables are only recommended under the following conditions:

1. The use of a machining centre and toolholder with highest precision, concentricity and rigidity
2. All components – including machine and controller – are of the latest technology



Ramping with EDMT-type inserts



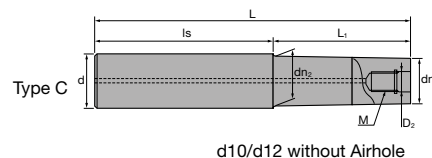
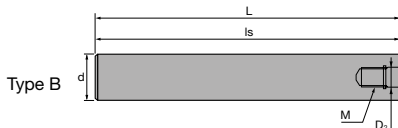
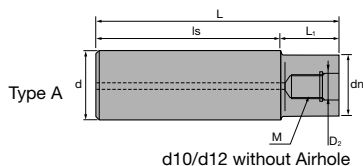
Insert	Cutting edge D (mm)	D 8	D 10	D 12	D 16	D 20	D 25	D 32
EDMT	Ramping Angle °	6.4	6.6	4.1	2.2	1.4	1	0.8
	Helical Milling / Hole Dia. (mm)	10 ~ 15	13 ~ 19	17 ~ 23	25 ~ 31	33 ~ 39	43 ~ 49	57 ~ 63

1. The ramp angle should be set within the ranges listed above. Use at ramp angles of 0.5° is recommended.
2. For hole diameters outside the ranges listed above, a pilot hole should be drilled before milling.

1. Der Rampenfräswinkel sollte innerhalb der oben aufgelisteten Bereiche sein. Empfohlen wird ein Winkel von 0,5°.
2. Für Bohrungen mit einem größeren Durchmesser als oben aufgeführt sollte vor dem Helikalfräsen eine Startbohrung durchgeführt werden.

Indexable Milling Tools

ASC | Carbide Shanks for Modular Mills



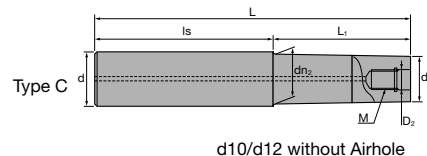
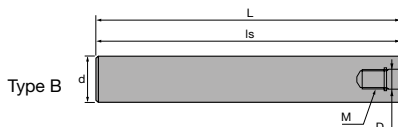
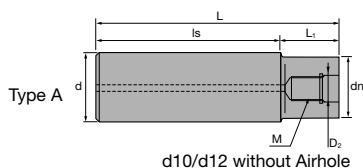
Carbide Shank											
	ID Code	Item Code	D ₂	M	L	L ₁	Is	dn	dn ₂	d	Type
Without Airhole	FH137	ASC10-6.5-74-24	6.5	M6	74	24	50	9.3	-	10	A
	FH254	ASC10-6.5-84-34			84	34					
	FH255	ASC10-6.5-114-24			114	24					
	FH138	ASC10-6.5-114-49				49	65	11	11.5	12	C
	FH139	ASC12-6.5-74-24			74	24	50				
	FH256	ASC12-6.5-94-44			94	44					
	FH257	ASC12-6.5-129-24			129	24	105				
	FH140	ASC12-6.5-129-64				64	65				
With Airhole	FH141	ASC16-8.5-95-30	8.5	M8	95	30	65	14.5	15.5	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				95	65				
	FH143	ASC20-10.5-120-50	10.5	M10	120	50	70	18	-	20	A
	FH261	ASC20-10.5-170-90Z			170	90	80	18.5	19.5		C
	FH144	ASC20-10.5-220-50			220	50	170	18	-		A
	FH262	ASC20-10.5-220-120Z				120	100	18.5	19.5	20	C
	FH263	ASC20-10.5-270-150Z			270	150	120				
	FH264	ASC20-10.5-270-50Z			270	50	220	23	-	25	A
	FH145	ASC25-12.5-145-65	12.5	M12	145	65	80				
	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				195	120	28	-	32	A
	FH147	ASC32-17-160-80	17	M16	160	80	80				
	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.

Indexable Milling Tools

AS | Steel Shanks for Modular Mills



Steel Shank											
	ID Code	Item Code	D ₂	M	L	L ₁	ls	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. 328.2*

🇩🇪 Weitere Informationen über modulare Werkzeugaufnahmen finden Sie in unserem Prospekt: *Indexable Modular Series No. 328.2*

🇪🇸 Para obtener más información sobre conos modulares consulte nuestro folleto *Indexable Modular Series No. 328.2*

🇮🇹 Per maggiori informazioni riguardanti la gamma dei mandrini avvitabili consultate il catalogo *Indexable Modular Series No. 328.2*

🇫🇷 Pour de plus amples informations concernant les attachements modulaires, voyez SVP notre brochure *Indexable Modular Series No. 328.2*

🇵🇹 Para mais informações sobre Cones Modulares consulte o nosso folheto *Indexable Modular Series No. 328.2*

