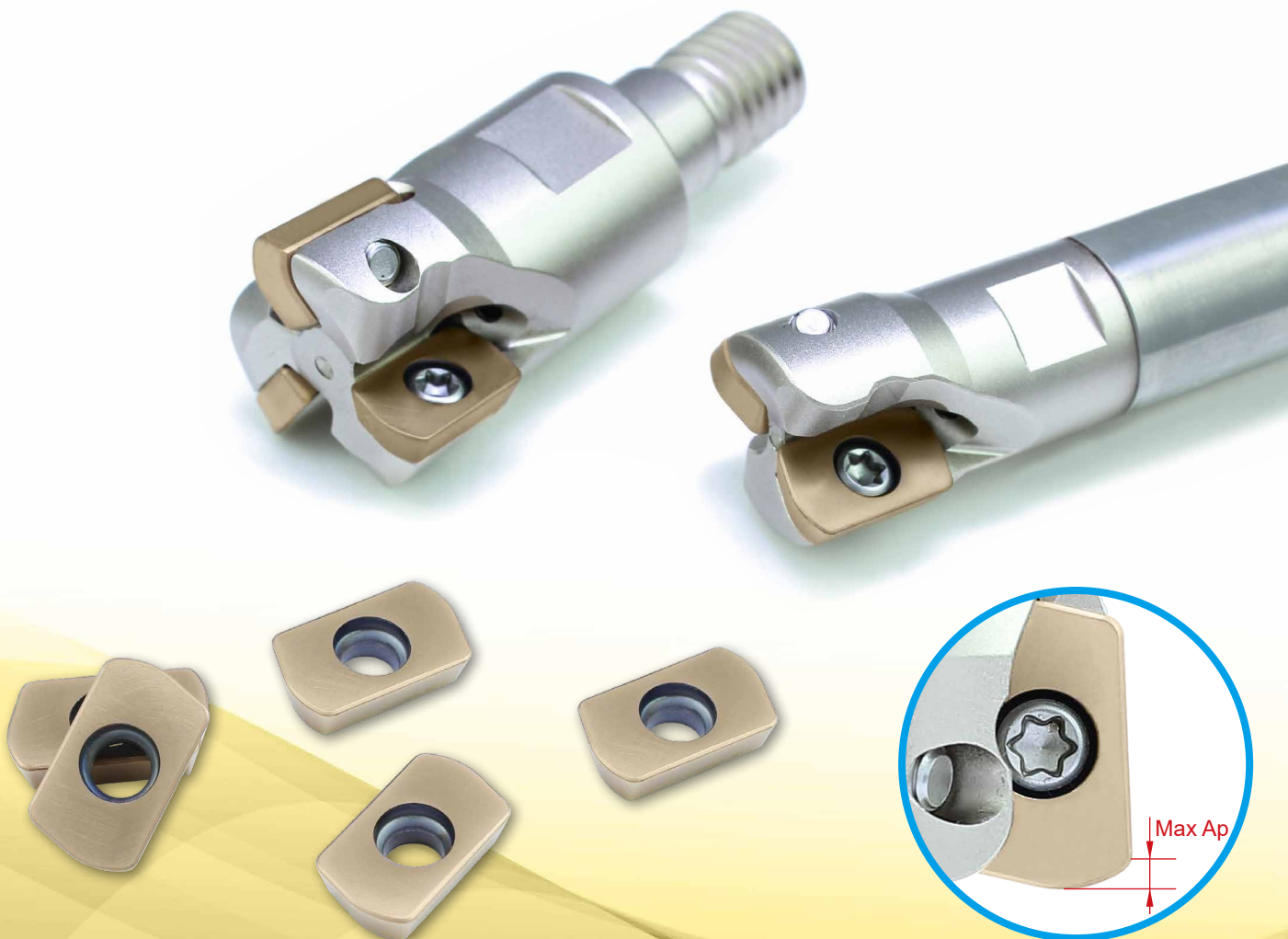


# *CASR High Feed Face Milling*

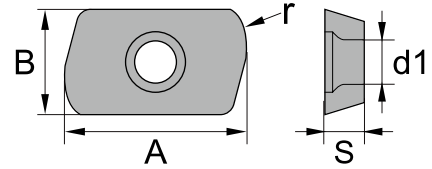
## *Single sided, 2 cutting edges*

- *High feed milling and high efficiency machining.*
- *Exceptional milling performance - save time, save cost.*
- *Suitable for face milling, ramping and plunging.*



### Insert Specification

Insert	Dimensions (mm)				
	A	B	S	r	d1
ISR145	12	7.0	3.0	1.45	3.4



### Insert Grade

Grade Type	Machining Application	Industry area
<b>CX22HS</b>	<ul style="list-style-type: none"> <li>Continuous semi-finishing machining</li> <li>For Hardened steel and Cast Iron</li> </ul>	<ul style="list-style-type: none"> <li>Die and mould</li> <li>Hardened parts</li> </ul>
<b>CX32HS</b>	<ul style="list-style-type: none"> <li>Medium machining</li> <li>For Carbon steel, Alloy steel and Stainless steel</li> </ul>	<ul style="list-style-type: none"> <li>Auto parts</li> <li>Machinery parts</li> </ul>
<b>CX43TS</b>	<ul style="list-style-type: none"> <li>Roughing or interrupted machining</li> <li>For Carbon steel, Alloy steel, Stainless steel and High temperature alloy</li> </ul>	<ul style="list-style-type: none"> <li>Auto parts</li> <li>Machinery parts</li> <li>Aircraft parts</li> </ul>

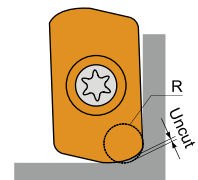
※ Different grades for various applications are available to select, please contact us for more information.

### Order Code

Insert	Order No.	Designation	Working Material					
			P	M	K	N	S	H
	IISR14522HS	ISR145-CX22HS	●	○	●		○	●
	IISR14532HS	ISR145-CX32HS	●	●	●		○	○
	IISR14543TS	ISR145-CX43TS	●	●	●		●	

### Corner R Programming

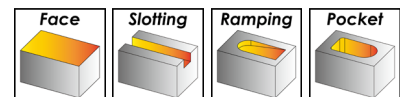
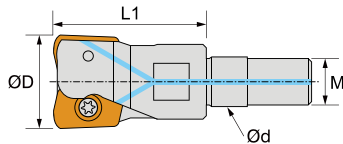
Designation	Approx. R (mm)	
	Input. R	Uncut
ISR145	1.5	0.3



### Recommended Cutting Conditions

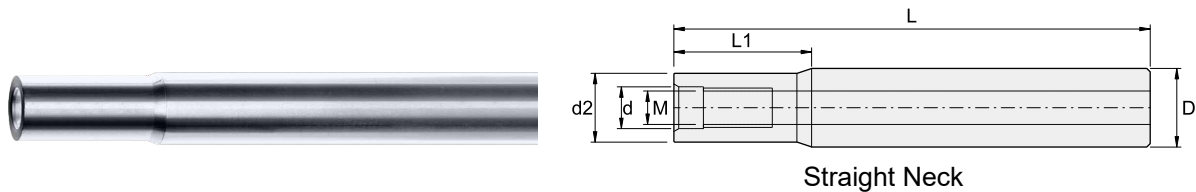
Working Material	Vc	fz	ap
Carbon Steel (HB85-225)	120 ~ 250	0.5 ~ 1.6	0.3 ~ 0.8
Stainless 300 Series	100 ~ 180	0.5 ~ 1.2	0.3 ~ 0.6
Cast Iron (HB140-220)	120 ~ 250	0.5 ~ 1.6	0.3 ~ 0.8
High temp. & Titanium alloy	50 ~ 100	0.5 ~ 0.8	0.3 ~ 0.5
Hardened steel	60 ~ 100	0.5 ~ 1.0	0.3 ~ 0.5

### CASRM - Modular tools



Order No.	D	L1	d	M	T	Coolant	Inserts	Screw	Wrench
ICASRM102016081	16	26	8.5	M8	2	•	ISR145	IMS3006B	ITK09
ICASRM103020101	20	30	10.5	M10	3	•			

### SWMEB - Carbide Adapter (Straight Neck)



Order No.	Dimensions (mm)					
	D	L	L1	d	d2	M
ISWMEB16150082	16	150	32	8.5	13	M8
ISWMEB20150102	20	150	40	10.5	17	M10

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