Made in Taiwan

CR49

W490

Indexable Milling Tools

High Efficient Shoulder, Side and Face Milling

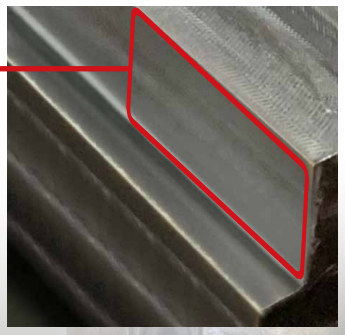
捨棄式高效率方肩銑削 , 側銑削與平面銑削

2021.09

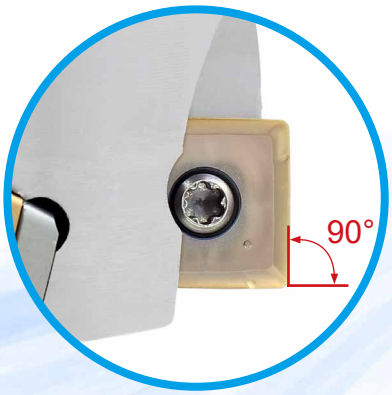
- An insert with 4 cutting edges is more cost effective.
  具有 4 個切削角的刀片更具成本效益
- Repeat side milling to reduce burs and to get good surface finishing.
  多次進行無毛刺的方肩銑削與獲得良好的表面光潔度
- Light and quiet cutting performance provide an optimal utilization on low power machines.
  輕快且安靜的切削性能使低功率機床獲得最佳利用
- Suitable for large cutting depths :
  大切削深度：

  Maximum depth of W49008T3 is 5.5 mm
  W49008T3 的最大深度為 5.5 mm

  Maximum depth of W4901404 is 9 mm
  W4901404 的最大深度為 9 mm



Repeated side milling without burr at intersection.
進行多次側銑
在交接處無毛刺產生

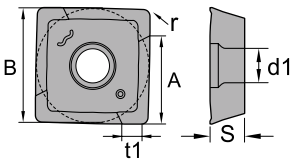


https://youtu.be/sQInOyNx9oU

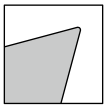
CR49 Series 捨棄式高效率方肩銑削 , 側銑削與平面銑削

Insert Specification

Insert	Dimensions (mm)					
	A	B	S	r	d1	t1
NEW W49008T308	5.6	8.5	3.3	0.8	2.8	1.2
W490140408	10.3	13.8	3.9	0.8	4.1	2.0



Insert Geometry

Shape	Chipbreaker	Application
	 SG	Sharp geometry design for finishing cutting in steel, stainless and difficult-to-cut material.

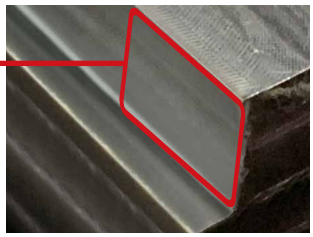
Insert Grade

Grade Type	Coating Type	Properties	Application	Working Material						Industry Area
				P	M	K	N	S	H	
CX23TS	PVD	• High Wear resistance	• Continuous finishing machining • For Hardened steel and Cast iron	●	●	●		●	●	• Die and mould • Hardened parts • Aircraft parts
CX32HS	PVD	• Wear resistance • Impact resistance	• Medium machining • For Carbon steel, Alloy steel, Stainless steel and High temperature alloy	●	●	●		○	○	• Auto parts • Machinery parts • Aircraft parts
CX33TS				●	●	●		●	●	
CX43TS	PVD	• High Impact resistance • High toughness	• Roughing or interrupted machining • For Carbon steel, Alloy steel, Stainless steel and High temperature alloy	●	●	●		●		• Auto parts • Machinery parts • Aircraft parts

Case Study 1

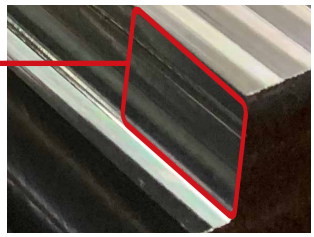
Tool : 50mm / 4t
Insert : W490140408-SG CX33TS
Working Material : S45C
Vc : 200 m/min
fz : 0.13 mm/t
ap : 5 mm (total depth 20mm)
ae : 5 mm

Comparison of repeated side milling



W490140408-SG

No burr at intersection



Other Inserts

Have burr at intersection

Case Study 2

Tool : 50mm / 4t
Insert : W490140408-SG CX33TS
Working Material : Cast Iron(FCD550)
Vc : 200 m/min
fz : 0.29 mm/t
ap : 8 mm, ae : 40 mm

https://youtu.be/sQInOyNx9oU

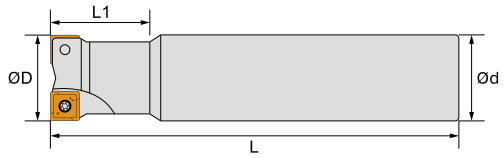
Recommended Cutting Conditions

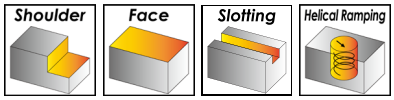
Working Material	Vc	W49008T3		W4901404	
		fz	ap	fz	ap
Carbon Steel / Alloy Steel	120 ~ 250	0.05 ~ 0.12	0.3 ~ 5.5	0.06 ~ 0.15	0.3 ~ 9
Stainless Steel	100 ~ 180	0.04 ~ 0.10	0.3 ~ 4.5	0.05 ~ 0.12	0.3 ~ 8
Cast Iron	120 ~ 250	0.05 ~ 0.12	0.3 ~ 5.5	0.06 ~ 0.15	0.3 ~ 9
Aluminum Alloy	300 ~ 1000	-	-	0.05 ~ 0.15	0.3 ~ 9
High Temperature Alloy	40 ~ 100	0.03 ~ 0.09	0.3 ~ 4.5	0.04 ~ 0.11	0.3 ~ 8
Hardened Steel	50 ~ 100	0.03 ~ 0.09	0.3 ~ 4.5	0.04 ~ 0.11	0.3 ~ 8

Order Code

Insert	Order No.	Designation	Working Material					
			P	M	K	N	S	H
	NEW IW49008T308SG23TS	W49008T308-SG-CX23TS	●	●	●		●	●
	NEW IW49008T308SG32HS	W49008T308-SG-CX32HS	●	●	●		○	○
	NEW IW49008T308SG33TS	W49008T308-SG-CX33TS	●	●	●		●	○
	NEW IW49008T308SG43TS	W49008T308-SG-CX43TS	●	●	●		●	○
	IW490140408SG23TS	W490140408-SG-CX23TS	●	●	●		●	●
	IW490140408SG32HS	W490140408-SG-CX32HS	●	●	●		○	○
	IW490140408SG33TS	W490140408-SG-CX33TS	●	●	●		●	○
	IW490140408SG43TS	W490140408-SG-CX43TS	●	●	●		●	○
	IW490140408SG30	W490140408-SG-CX30				●		

CR49E - Milling tools

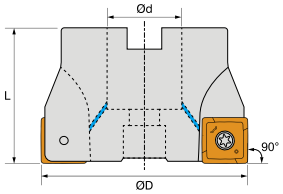


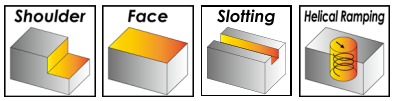


Order No.	D	L1	L	d	T	Inserts	Screw	Wrench	Stock
NEW ICR49E802020100	20	25	100	20	2	W49008T3	ITS2507	ITK08	●
NEW ICR49E802020150	20	25	150	20	2				●
NEW ICR49E803025100	25	32	100	20	3				●
NEW ICR49E803025150	25	32	150	20	3				●

● stock ○ by inquiry

CR49F - Milling tools





Order No.	D	L	d	T	Coolant	Inserts	Screw	Wrench	Stock
NEW ICR49F804040161	40	40	16	4	✓	W49008T3	ITS2507	ITK08	●
NEW ICR49F805050221	50	40	22	5	✓				●
NEW ICR49F806063221	63	40	22	6	✓				●
ICR49F404050221	50	40	22	4	✓	W4901404	ITS3505	ITK15	●
ICR49F405063221	63	40	22	5	✓				●
ICR49F407080271	80	50	27	7	✓				●

● stock ○ by inquiry