

CART 90° Mini Shoulder Milling *Single sided, 2 cutting edges*



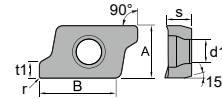
Suitable for small power machine !

- *Ø10,Ø11,Ø12,Ø13 cutter with 2 teeth and Ø16,Ø20,Ø21 cutter with 3 teeth.*
- *Strong Pocket design with excellent chip evacuation.*
- *Extreme well ramping and slotting capabilities.*
- *Unique geometry designed for low cutting force.*



Insert Specification

Insert	Dimensions (mm)				
	A	B	S	r	d1
WRT070204	4.30	6.4	2.38	0.4	2.2
WRT100308	6.35	9.3	3.4	0.8	2.9



Insert Geometry

Shape	Chipbreaker	Application
	RG	Strong geometry design for rough cutting in steel, alloy steel and hardened steel.

Insert Grade

Grade Type	Machining Application	Industry area
CX22HS	<ul style="list-style-type: none"> • Continuous semi-finishing machining • For hardened steel and cast Iron 	<ul style="list-style-type: none"> • Die and mould • Hardened parts
CX32HS	<ul style="list-style-type: none"> • Medium machining • For carbon steel, alloy steel and stainless steel 	<ul style="list-style-type: none"> • Auto parts • Machinery parts
CX43TS	<ul style="list-style-type: none"> • Roughing or interrupted machining • For carbon steel, alloy steel, stainless steel and high temperature alloy. 	<ul style="list-style-type: none"> • Auto parts • Machinery parts • Aircraft parts

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

Recommended Cutting Conditions

for WRT0702

Working Material	Vc	fz	ap
Carbon Steel (HB85-225)	120 ~ 250	0.08 ~ 0.20	0.3 ~ 5.0
Stainless 300 Series	100 ~ 180	0.05 ~ 0.15	0.3 ~ 3.0
Cast Iron (HB140-220)	120 ~ 250	0.08 ~ 0.20	0.3 ~ 4.0
High temp. & Titanium alloy	40 ~ 100	0.05 ~ 0.12	0.3 ~ 3.0
Hardened steel	50 ~ 100	0.05 ~ 0.13	0.3 ~ 3.0

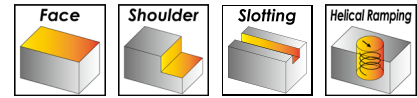
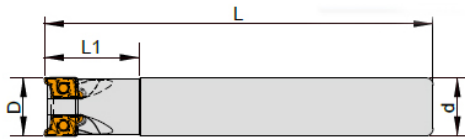
for WRT1003

Working Material	Vc	fz	ap
Carbon Steel (HB85-225)	120 ~ 250	0.10 ~ 0.22	0.5 ~ 7.0
Stainless 300 Series	100 ~ 180	0.08 ~ 0.18	0.5 ~ 4.0
Cast Iron (HB140-220)	120 ~ 250	0.10 ~ 0.22	0.5 ~ 6.0
High temp. & Titanium alloy	40 ~ 100	0.07 ~ 0.14	0.5 ~ 4.0
Hardened steel	50 ~ 100	0.07 ~ 0.15	0.5 ~ 4.0

Order Code

Insert	Order No.	Designation	Working Material					
			P	M	K	N	S	H
	IWRT070204RG22HS	WRT070204-RG-CX22HS	●	○	●		○	●
	IWRT070204RG32HS	WRT070204-RG-CX32HS	●	●	●		○	○
	IWRT070204RG43TS	WRT070204-RG-CX43TS	●	●	●		●	
	IWRT100308RG22HS	WRT100308-RG-CX22HS	●	○	●		○	●
	IWRT100308RG32HS	WRT100308-RG-CX32HS	●	●	●		○	○
	IWRT100308RG43TS	WRT100308-RG-CX43TS	●	●	●		●	

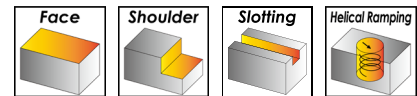
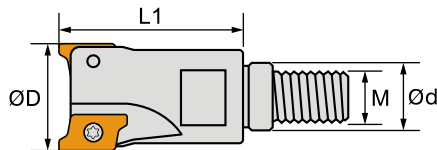
CARTE - Milling tools



Order No.	D	L1	L	d	T	Inserts	Screw	Wrench
ICARTE702010100	10	18	100	10	2	WRT0702	ITS2003	ITK06
ICARTE702011100	11	18	100	10	2			
ICARTE702013100	13	20	100	12	2			
ICARTE703016150	16	30	150	16	3			
ICARTE102017150	17	30	150	16	2	WRT1003	ITS2515	ITK08
ICARTE103021150	21	30	150	20	3			
ICARTE104026150	26	40	150	25	4			

Customize available.

CARTM - Modular tools



Order No.	D	L1	M	d	T	Inserts	Screw	Wrench
ICARTM702010050	10	18	M5	5.5	2	WRT0702	ITS2003	ITK06
ICARTM702011050	11	18	M5	5.5	2			
ICARTM702012060	12	20	M6	6.5	2			
ICARTM702013060	13	20	M6	6.5	2			
ICARTM103017080	17	30	M8	8.5	3	WRT1003	ITS2515	ITK08
ICARTM103021100	21	32	M10	10.5	3			

Customize available.

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