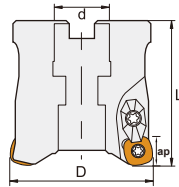


- ◆ Economical 4 cutting edges, has a unique R shape to enable maximum cutting depth of 2mm.
- ◆ Special design for high feed machining, offers 3 to 5 times the deep cutting of conventional products, reducing cutting time and processing costs.
- ◆ Black oxide processing applied for excellent corrosion resistance effect also increase surface hardness.
- ◆ To avoid the strain in second processing, finishing will be done after pre-harden.

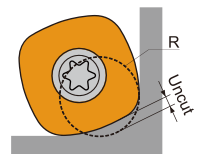
ASRFF



Order No.	D	L	d	T	ap	Inserts	Screw	Wrench	Clamp	Clamp Screw
IASRFF03-0500220	50	22	50	3	2	SDMT1205 SDNW1205	MS4011A	TF15	YR-06	MS4008ES
IASRFF03-0500222	50	22.225	50	3	2					
IASRFF04-0500220	50	22	50	4	2					
IASRFF04-0500222	50	22.225	50	4	2					
IASRFF03-0630220	63	22	50	3	2					
IASRFF03-0630222	63	22.225	50	3	2					
IASRFF04-0630220	63	22	50	4	2					
IASRFF04-0630222	63	22.225	50	4	2					
IASRFF04-0800317	80	31.75	55	4	2					
IASRFF04-0800320	80	32	55	4	2					
IASRFF05-0800317	80	31.75	55	5	2					
IASRFF05-0800320	80	32	55	5	2					

■ Corner R Programming

Designation	Approx. R (mm)	
	Input. R	Uncut
SDNW1205 / SDMT1205	4.5	0.83



- ◆ Economical 4-corner type, especially design for high feed cutting.
- ◆ Reducing cutting time and processing costs.
- ◆ Unique R shape to achieve maximum cutting depth of 2mm.

Specification

Inserts	Designation	Grade					Dimensions (mm)						Drawing			
		CX21NS	CX31NA	CX31NS	CX41NS	CX41NA	A	B	S	r	d1	t1				
	P Steel	◎	◎	◎	○	○										
	M Stainless steel	○	○	○	◎	◎										
	K Cast iron	◎	○	○	○	○										
							◎ 1st choice ○ 2st choice									
	SDMT 1205ZDTN-MG		✓	✓			12.7	-	5.56	15	4.6	-				
	SDMT 1205ZDTN-RG		✓	✓			12.7	-	5.56	15	4.6	-				
	SDNW 1205ZDTN-RG		✓	✓	✓	✓	12.7	-	5.56	15	4.6	-				

MG: Low cutting force and chattering reduction.

HG: Strong edge strength for roughing.

Recommended Cutting Conditions

Working Material	Vc	fz	ap
Carbon Steel (HB85-225)	100 ~ 220	0.8 ~ 1.8	~ 1.5
Stainless 300 Series	70 ~ 150	0.6 ~ 1.2	~ 1.2
Cast Iron (HB140-220)	100 ~ 220	0.8 ~ 1.8	~ 1.5