

- ◆ Shoulder milling with great cutting performance and low cutting force.
- ◆ Multifunction application with strong cutting edge and great chip evacuation.
- ◆ Nickel contain plating applied for excellent corrosion resistance effect also increase surface hardness.
- ◆ To avoid the strain in second processing, finishing will be done after pre-harden.

### JD15E



Order No.	D	L1	L	d	T	ap	Inserts	Screw	Wrench
IJD15E02-0250125	25	40	125	40	2	14	JDMT1505	TS4005	TK15
IJD15E02-0250180	25	75	180	75	2	14			
IJD15E03-0320140	32	45	140	45	3	14			
IJD15E03-0320200	32	90	200	90	3	14			



- ◆ Good cutting performance and cutting edge strength.
- ◆ Lower cutting force.
- ◆ Good chip evacuation.

## Specification

	P	Steel	◎	◎	◎	○	○											◎ 1st choice    ○ 2st choice
	M	Stainless steel	○	○	○	◎	◎											
	K	Cast iron	◎	○	○	○	○											
Inserts	Designation	Grade					Dimensions (mm)						Drawing					
		CX21NS	CX31NA	CX31NS	CX41NS	CX41NA	A	B	S	r	d1	t1						
	<b>JDMT 150508R-MG</b>		✓	✓			15.1	9.12	5.0	0.8	4.5	-						

Milling Inserts & Tools

## Recommended Cutting Conditions

Working Material	Vc	fz	ap
Carbon Steel (HB85-225)	80 ~ 200	0.12 ~ 0.30	~ 12.0
Stainless 300 Series	50 ~ 110	0.10 ~ 0.25	~ 7.0
Cast Iron (HB140-220)	80 ~ 180	0.12 ~ 0.30	~ 11.0