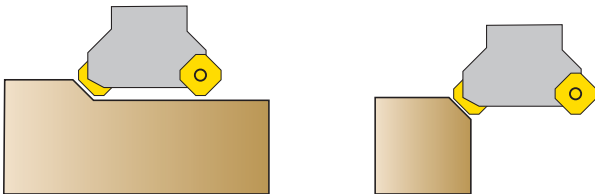


Comprehensive Milling Cutter with High Productivity

1. Adjustable pitch of cutter by change the number of insert for specific cutter diameter, and several chip breakers of insert offer wide available application range.
2. Light cutter body allow high speed machining without chattering, thus it is possible to use at the machine having low horse power.
3. Smooth cutting with low cutting force accomplished with high rake angle.



■ Machining Example



■ Chip-Breakers

	Chip-Breakers	Cutting edge shape	Use and Features of Chip Breakers
Light cutting	Non C/B		Superior surface roughness at finishing due to ground-type cermet insert.
	F2		Superior cutting quality for light and difficult-to-cut material cutting through the low-cutting-resistance type of chip breaker
General cutting	M		Suitable for wide range of cutting due to special shape design for general cutting.
Roughing	R8		Tough cutting edge provide stable and consistent cutting performance even at severe intermittent cutting.
For Aluminum	A		Superior cutting quality for aluminum cutting resulted form applying of proper cutting-edge treatment and buffing of surface.

■ Recommended cutting condition

ISO	C/B Grade	F2		M		R8		A	
		V(sfm)	fz(ipt)	V(sfm)	fz(ipt)	V(sfm)	fz(ipt)	V(sfm)	fz(ipt)
P	PM25C	650~1000	0.002~0.008	500~1000	0.004~0.012	500~800	0.004~0.012	-	-
	PM30P	650~1000	0.002~0.008	500~1000	0.004~0.012	330~800	0.004~0.012	-	-
M	MM30P	330~600	0.002~0.006	390~600	0.004~0.012	-	-	-	-
	PM30C	390~650	0.002~0.006	390~650	0.004~0.012	-	-	-	-
K	NCM320K	500~800	0.002~0.008	500~800	0.004~0.012	-	-	-	-
						-	-	-	-
Aluminum	KTM10U					-	-	1150~3300	0.004~0.014



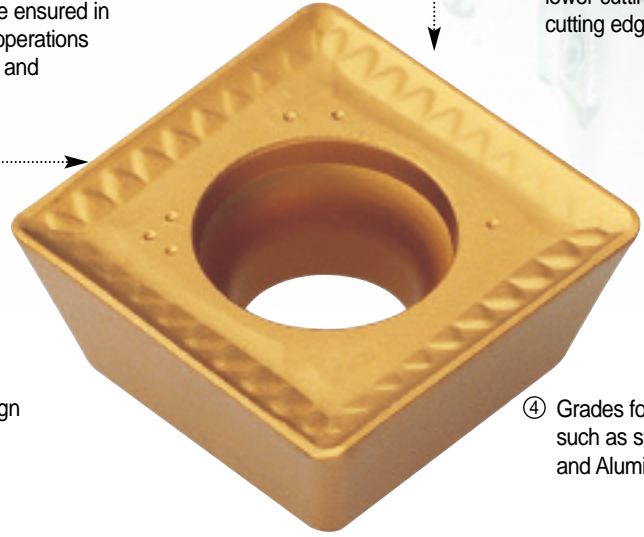
Features of Max Mill Insert

① Extremely excellent tool life ensured in high feed and high depth operations with low cutting resistance and stronger toughness

② Innovative curve cutting edge makes lower cutting resistance and stronger cutting edge

③ Peculiar chip-breaker design ensures free chip flow

④ Grades for most materials are available such as steels, stainless steel, cast irons and Aluminum



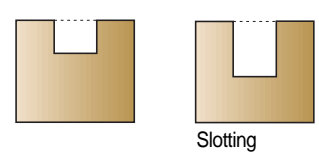
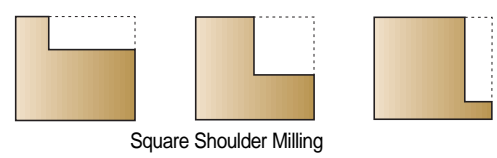
■ Inserts Feature & Application

- Innovative curve cutting edge and chip-breaker design ensures ideal 90 degree cutting and lower cutting resistance
- Various applications are available with multi-functional cutters(Facing, Slotting, Square shoulder milling and etc.)
- Improved inserts life time with optimized per each application
- Excellent performance ensured at large depth of cutting operations due to strong cutting edge and low cutting resistance

Chip -breaker	Cutting Edge Shape		Recommendation C/B and Grades (● : 1 st Choice)									
			Low carbon steels Soft Steels		High carbon steels Alloy Steels		Stainless steels		Cast Irons		Aluminum alloys	
			C/B	Grade	C/B	Grade	C/B	Grade	C/B	Grade	C/B	Grade
F2		Low cutting Resistance Type	●	○PM25C ○PM30P ●PM30C		●PM25C ○PM30P ○PM30C	●	○PM25C ○PM30P ●PM30C	●	●KM20C	-	-
M		Reinforced Cutting Edge Type		○PM25C ○PM30P ●PM30C	●	●PM25C ○PM30P ○PM30C	●	○PM25C ○PM30P ●PM30C	●	●KM20C	-	-
A		Sharp Cutting Edge Type	-	-	-	-	-	-	-	-	●	●KTM10U

■ Advice

1. The cutting speed and feed can be adjusted in accordance with the machine's power and conditions of work-piece.
2. We recommend you operate them with small Radial depth(RD) and large Axial depth(AD) on square shoulder milling applications.
3. We recommend you use the compressed air during the slotting and pocket milling applications for the better chip removal.
4. For chattering during the operation, decrease the cutting speed.



Milling Cutters

Insert Choice(Chip Breaker/Grade)

ISO(Work-piece)	Low Cutting Resistance Type	General Type	Stronger Cutting Edge Type
P	F2 / PM25C	M / PM25C	M / PM30P
M	F2 / PM30C	F2 / PM30C	M / PM30C
K	F2 / KM20C	F2 / KM20C	F2 / KM20C
Al	KTM10U	KTM10U	KTM10U

Recommended Cutting Conditions

Work-piece	Cutter Diameter (φ) Insert Grade	ø1.25 ~ 2.50		ø3.150 ~ 4.921	
		V(sfm)	fz(ipf)	V(sfm)	fz(ipf)
P	PM25C	325 ~ 825	0.002 ~ 0.012	400 ~ 825	0.003 ~ 0.012
	PM30C	325 ~ 725	0.002 ~ 0.01	400 ~ 725	0.003 ~ 0.01
	PM30P	325 ~ 725	0.002 ~ 0.01	325 ~ 725	0.004 ~ 0.01
M	PM30C	250 ~ 600	0.002 ~ 0.008	250 ~ 600	0.004 ~ 0.01
K	KM20C	600 ~ 825	0.003 ~ 0.01	600 ~ 825	0.004 ~ 0.001
Aluminum	KTM10U	1300 ~ 3275	0.002 ~ 0.016	1300 ~ 3275	0.004 ~ 0.016

