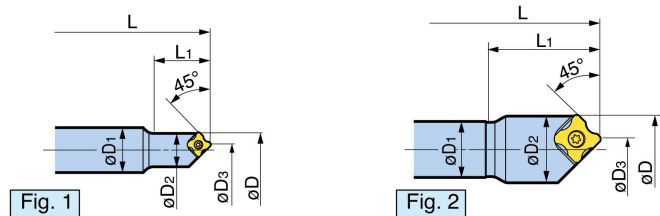
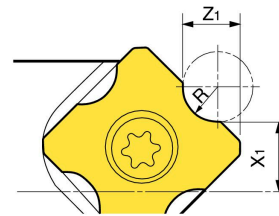




Front R chamfering



R-dimensions



Model	Fig.	ϕD	ϕD_1	ϕD_2	ϕD_3	L	L_1	No. of Insert	R	X ₁	Z ₁	Insert Model
ST16-RC061-20	1	12.3	16	11.9	4.5	94	20	1	0.5	3.61	1.93	RC06....
									1	3.35	2.18	
									1.5	3.09	2.43	
									2	2.83	2.68	
ST20-RC121-40	2	24.4	20	23.8	8.9	121	40	1	1	7.17	3.79	RC12....
									2	6.65	4.29	
									3	6.13	4.79	
									4	5.60	5.29	

Recommended cutting condition

Workpiece material	Cutting speed (mm/min)	Feed rate (mm/tooth)	Coolant
Structural, carbon or alloy steel	100 – 350	0.05 – 0.2	Dry
Prehardened steel less than HRC40	60 – 80	0.05 – 0.1	Wet
Stainless steel	100 – 250	0.08 – 0.2	Dry / Wet
Cast iron	100 – 350	0.05 – 0.25	Dry
Aluminum	100 – 800	0.05 – 0.25	Dry / Wet

1. The table is a reference to determine cutting conditions. It should be adjusted according to the condition of the machine tool and workpiece.

2. Wet cutting is generally recommended to obtain good surface quality.
3. In case of built-up edge occurs when cutting aluminum and stainless steel, use soluble oil.