

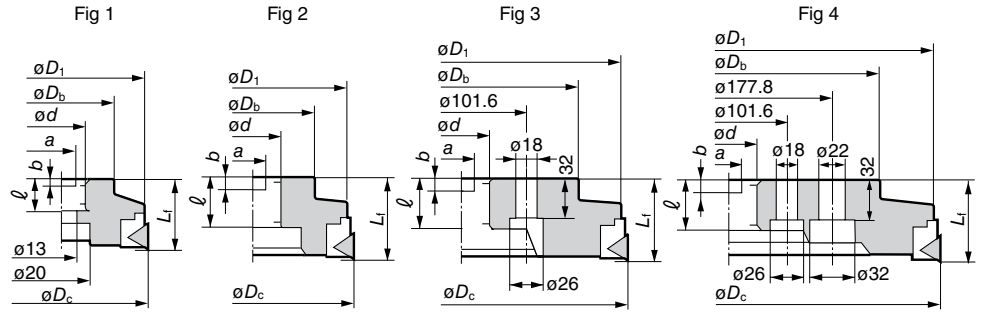
CHG 4000Type

Rake Angle	Radial	+4°
	Axial	+15°

16mm 90°

P	M	K	N	S	H
Steel	Stainless Steel	Cast Iron	Non-Ferrous Metal	Exotic Alloy	Hardened Steel

Shoulder Milling for Steel, Stainless Steel, Non-Ferrous & Cast Iron



Body Imperial

Cat. No.	Stock	Dimensions (mm)								No. of Teeth	Weight (kg)	Fig
		øD _c	øD ₁	øD _b	L _i	ød	a	b	l			
CHG 4080R	●	*80	78	60	50	25.4	9.5	6	25	4	1.3	1
4100R	●	100	96	70	63	31.75	12.5	8	32	5	2.0	2
4125R	●	125	120	80	63	38.1	15.9	10	38	6	3.1	2
4160R	●	160	154	100	63	50.8	19.1	11	38	8	5.3	2
4200R	●	200	193	130	63	47.625	25.4	13.5	38	10	8.1	3
CHG 4250R	●	250	242	180	63	47.625	25.4	13.5	40	12	13.8	3
4315R	●	315	307	240	63	47.625	25.4	13.5	40	14	21.9	4

Inserts are not included.



*Please use hexagonal bolt (JISB1176) M12 x 30-35 mm for securing ø80 mm Cutter to the arbour.

Inserts

P Steel **M** Stainless Steel **K** Cast Iron **N** Non-Ferrous Metal **S** Exotic Alloy **H** Hardened Steel

Application	Coated Carbide						Carbide			Cermel	SUMIDIA			Fig	
	High Speed/Light	P	M	K	N	H	P	K	N	T250A	DA150	DA1000	DA2200		
General Purpose	●	●	●	●	●	●	●	●	●	●	●	●	●		
Roughing	●	●	●	●	●	●	●	●	●	●	●	●	●		
Cat. No.	ACP100	ACP200	ACP300	ACK200	ACK300	EH20Z	A30N	G10E	H1	T250A	DA150	DA1000	DA2200		
TEEN 43R *								●	●		●		▲	5-A	
NF-TEEN 43R														●	5-A
TEEN 43TR	●	●	●				●			●					6(5)-B
TEKN 43R				●	●	●		●							6(5)-A
43TR	●	●	●				●			●					6(5)-B

Fig 5

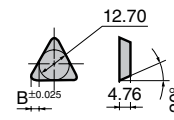
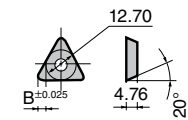
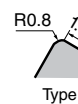


Fig 6 ACP/ACK Series Grades



Type A

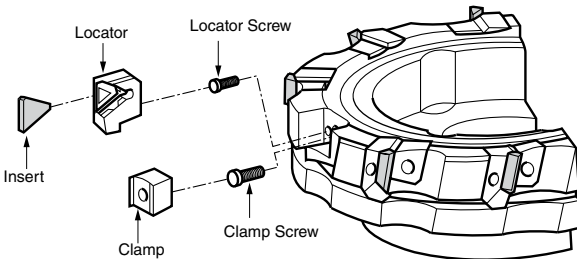


Type B

*TEEN43R can be made-to-order in grade DL1000.

· Upper side and wiper edge of H1 have mirrored finish.

· Some E class precision inserts have different shapes.



Spare Parts

Applicable Cutters	Locator	Clamp	Clamp Screw	Locator Screw	Spanners
CHG 4080R to CHG 4125R	LCH4R	CHWR	FBX0811	FBH0512	TH030 TH040
CHG 4160R to CHG 4315R			FBX0817		

* TH030: for locator screw TH040: for clamp screw

Clamp Screw	Size	(N·m)	Locator Screw	Size	(N·m)	(N·m) Recommended Tightening Torque (N·m)
	M8	8.0		M5	5.0	

Recommended Cutting Conditions

ISO	Work Material	Hardness	Cutting Speed v _c (m/min) Min. - Optimum - Max.	Feed Rate f _z (mm/t) Min. - Optimum - Max.	Grade
P	General Steel	180 to 280HB	80-115-150	0.10-0.18-0.25	ACP200
	Soft Steel	≤180HB	100-125-150	0.10-0.15-0.20	ACP200
	Die Steel	200 to 220HB	60-80-100	0.10-0.15-0.20	ACP200
M	Stainless Steel	—	80-115-150	0.05-0.10-0.15	ACP300
K	Cast Iron	250HB	60-90-120	0.10-0.18-0.25	ACK200
N	Non-Ferrous	—	300-650-1000	0.10-0.20-0.30	DA1000 H1

Note The cutting conditions above are a guide. Actual conditions will need to be adjusted according to machine rigidity, work clamp rigidity, cutting depth, and other factors.