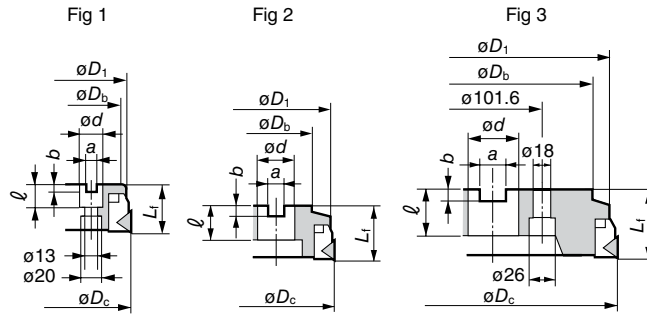


# CPG 4000 Type

Rake Angle	Radial	0°
	Axial	+6°



## Shoulder Milling for Steel, Stainless Steel & Cast Iron



Body Imperial

Cat. No. (R)	Stock	Cat. No. (L)	Stock	Dimensions (mm)								No. of Teeth	Weight (kg)	Fig
				$\phi D_c$	$\phi D_1$	$\phi D_b$	$L_f$	$\phi d$	$a$	$b$	$\ell$			
<b>CPG 4080R</b>	●	<b>CPG 4080L</b>		*80	77	60	50	<b>25.4</b>	9.5	6	25	5	1.2	1
<b>4100R</b>	●	<b>4100L</b>		<b>100</b>	98	75	60	<b>31.75</b>	12.7	8	32	6	2.0	2
<b>4125R</b>	●	<b>4125L</b>		<b>125</b>	121	75	60	<b>38.1</b>	15.9	10	38	8	3.3	2
<b>4160R</b>	●	<b>4160L</b>		<b>160</b>	155	100	60	<b>50.8</b>	19.1	11	38	10	5.5	2
<b>4200R</b>	●	<b>4200L</b>		<b>200</b>	194	130	60	<b>47.625</b>	25.4	13.5	38	12	8.6	3
<b>CPG 4250R</b>		<b>CPG 4250L</b>		<b>250</b>	243	200	70	<b>47.625</b>	25.4	13.5	52	14	17.9	3
<b>4315R</b>		<b>4315L</b>		<b>315</b>	308	240	70	<b>47.625</b>	25.4	13.5	52	18	25.5	3

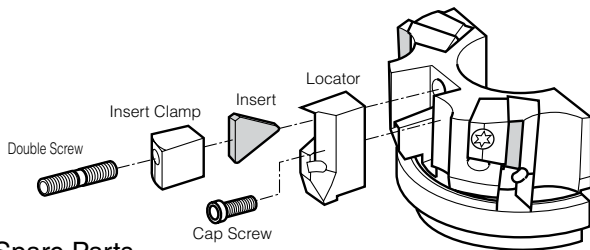
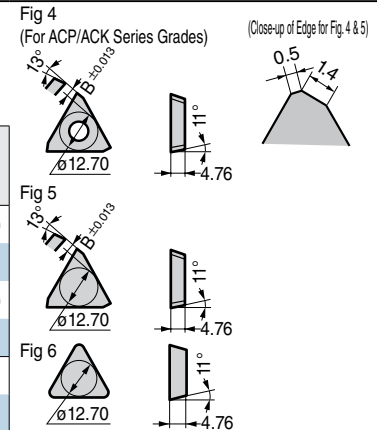


Inserts are not included.  
\*Please use hexagonal bolt (JISB1176) M12 x 30-35 mm for securing  $\phi 80$  mm Cutter to the arbour.

## Inserts

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

Application	Grade	Coated Carbide						Carbide				Cermet				Fig
		High Speed/Light	P		K		M									
		General Purpose	P		K		M		P P K K							
	Roughing	P		K		M										
Cat. No.		ACP100	ACP200	ACP300	ACK200	ACK300	EH20Z	A30	A30N	H10E	G10E	T1500A	T1200A	T130A	T250A	
<b>TPCH 43R</b>					●	●	●				●					4(5)
<b>43L</b>											●					5
<b>43TR</b>		●	●	●					●	●		●	▲		●	4(5)
<b>43TL</b>									●							5
<b>TPMN 432</b>								●			●	▲	●			6
<b>433</b>								●			●					6



## Spare Parts

Applicable Cutters	Locator	Insert Clamp	Double Screw	Cap Screw	Spanner
CPG4080R	LCP40R	PTW40R	WB8-22T	BX0508	TT27 LH040
CPG4100R to CPG4125R	LCP40R	PTW41R	WB8-22T	BX0510	TT27 LH040
CPG4160R to CPG4500R	LCP40R	PTW41R	WB8-30T	BX0510	TT27 LH040
CPG4080L	LCP40L	PTW40L	WB8-22T	BX0508	TT27 LH040
CPG4100L to CPG4125L	LCP40L	PTW41L	WB8-22T	BX0510	TT27 LH040
CPG4160L to CPG4500L	LCP40L	PTW41L	WB8-30T	BX0510	TT27 LH040

TT27-Double Screw Spanner, LH040-Cap Screw Spanner

## 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	80-110-140	0.10-0.18-0.25	ACP200
	Soft Steel	$\leq 180$ HB	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	—	100-125-150	0.10-0.18-0.25	ACP300
K	Cast Iron	250HB	60-90-120	0.10-0.18-0.25	ACK200

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.

▲ mark : To be replaced by new item (Please confirm stock availability)