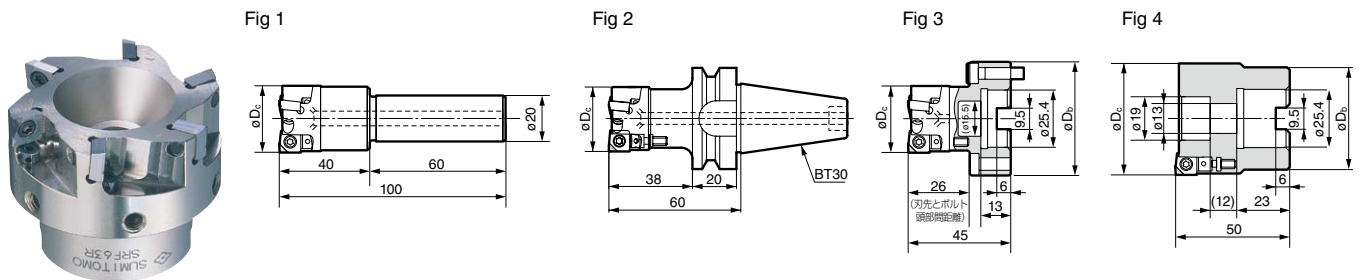


Rake Angle	Radial	-2° to +4°	5mm	90°	<table border="1"> <tr> <td>P</td><td>M</td><td>K</td><td>N</td><td>S</td><td>H</td> </tr> <tr> <td>Steel</td><td>Stainless Steel</td><td>Cast Iron</td><td>Non-Ferrous Metal</td><td>Exotic Alloy</td><td>Hardened Steel</td> </tr> <tr> <td>×</td><td>×</td><td>×</td><td>○</td><td>○</td><td>×</td> </tr> </table>	P	M	K	N	S	H	Steel	Stainless Steel	Cast Iron	Non-Ferrous Metal	Exotic Alloy	Hardened Steel	×	×	×	○	○	×
	P	M				K	N	S	H														
Steel	Stainless Steel	Cast Iron	Non-Ferrous Metal	Exotic Alloy	Hardened Steel																		
×	×	×	○	○	×																		
Axial	+6°																						

Aluminum Milling Cutter

SRF Type

High-speed Finishing for Non-Ferrous Metal



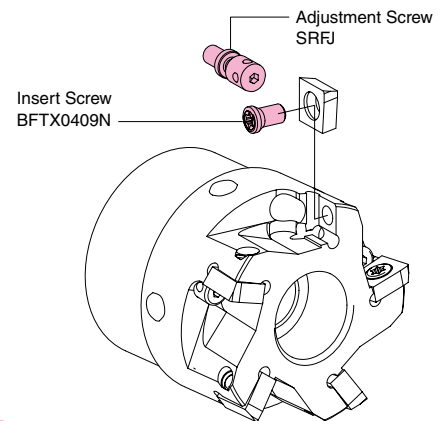
Body Imperial

Cat. No.	Stock	ϕD_c (mm)	ϕD_c (mm)	No. of Teeth	Fig.	Weight (kg)
SRF 30R-ST	●	30	—	3	1	0.34
40R-ST	●	40	—	4	1	0.50
SRF 30R-BT30	●	30	—	3	2	0.57
40R-BT30	●	40	—	4	2	0.72
SRF 30R	●	30	50.0	3	3	0.27
40R	●	40	50.0	4	3	0.35
50R	●	50	46.5	5	4	0.59
63R	●	63	45.0	6	4	0.67

Inserts are not included.

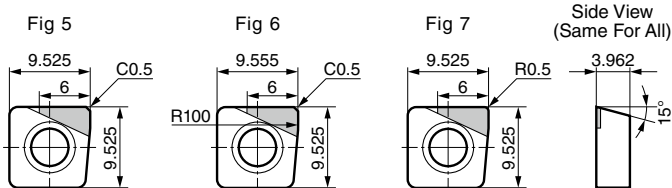


Please use hexagonal bolt (JISB1176) M12 x 30-35 mm for securing $\phi 50$ and $\phi 63$ cutter to the arbour.



Inserts

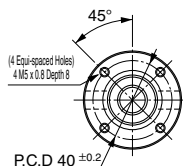
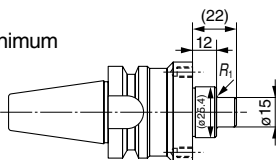
Wiper Insert



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

Grade		SUMIDIA		Fig	Cutting Edge
Application	High Speed/Light	N	N		
	General Purpose	N	N		
	Roughing	N	N		
Cat. No.	DA1000	DA2200	Fig	Cutting Edge	
NF-SNEW 09T3ADTR	●	▲	5	Standard	
09T3ADTR-U	●	▲	6	Wiper	
09T3ADTR-R	●	▲	7	Nose Radius	

- Standard inserts and wiper inserts can be used on the same cutter body.
- Inserts with nose radius can reduce the clattering. These cannot be used with wiper inserts.
- Inserts can be reground 3 times (up to minimum IC diameter 9.225mm).
- Do not mix new and reground inserts, or even inserts with different regrind amount on the same cutter.
- When using reground inserts, it is advisable to re-confirm insert height and cutting diameter with a tool pre-setter.
- Arbour for SRF30R, SRF40RS



When using SRF30R and SRF40R cutters, there is a requirement to modify the arbour as shown above.

1. Reduce part of the arbour's adaptor shaft from $\phi 25.4$ mm to $\phi 15$ mm.
2. Add 4 tap holes for (M5) cap screws. Please use a hexagonal bolt M5 x 20 mm for securing the body.

Spare Parts

Insert Screw	Adjustment Screw	Spanners
BFTX0409N	SRFJ	TH015
4.0 N·m		TTX15W

Recommended Tightening Torque (N·m)

Maximum Depth Of Cut Guide (SRF50R, 5 Teeth)

The table below contains guidelines on the maximum depth of cut determined from internal tests. '○' marks indicate the possible application range. Actual cutting conditions should be set based on actual machine and work characteristics.

Depth of Cut a_p (mm)	Feed Rate	Feed Rate v_f (mm/min)		
		2,500	4,000	5,000
		Feed Rate Per Tooth f_z (mm/t)		
		0.05	0.08	0.10
0.5		○	○	○
1.0		○	○	○
1.5		○	○	○
2.0		○	○	○
2.5		○	○	○
3.0		○	○	○
3.5		○	○	○
4.0		○	○	○
4.5		○	○	○
5.0		○	○	○

Cutting Conditions

Cutter: SRF50R

Insert: NF-SNEW 09T3ADTR (DA1000)

$n = 10,000\text{min}^{-1}$

Arbour: BT30 FMA25.4-45

Work: A-5052

Width: 35mm at depth of cut indicated above



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

H115

Milling Cutters

Face Milling

Radius

Multi-Purpose

Shoulder Milling

R/Copying

Groove/T-Slot

Chamfering

Aluminum/Light Alloys

High-Speed Cast Iron