MITSUBISHI MATERIALS

Screw-in Tools

EASY TO USE SCREW-IN HEADS FOR DIE AND MOLD MACHINING





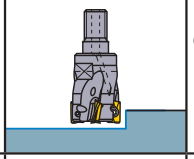
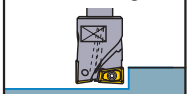
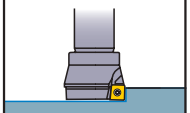
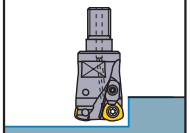
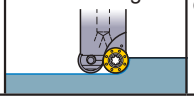
TOOL NEWS B128A

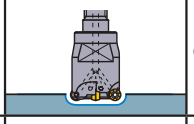
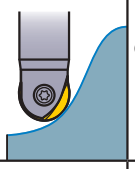
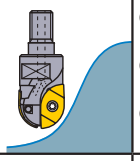
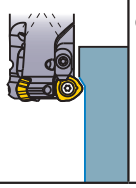
SCREW-IN TOOLS

Features

Screw-in tools can be used for a wide variety of machining applications.

Screw-in Head

Product Name	Application	Feature
APX3000 / 4000 	●Shoulder Milling ●Copy Milling ●Face Milling 	●11°, 15° positive, low cutting force insert. ●High accuracy, high quality vertical wall. ●With through coolant holes.
AQX 	●Pocket Milling ●Copy Milling ●Drilling ●Shoulder Milling ●Face Milling 	●The center bottom cutting edge enables drilling without previously formed hole. ●High rigidity body design. ●With through coolant holes.
ASX400 	●Shoulder Milling ●Face Milling 	●Precise but inexpensive molded type 20° positive inserts. ●Economical 4 cutting edge inserts. ●Curved cutting edge and high rigidity holder. ●With through coolant holes.
AJX 	●Pocket Milling ●Face Milling 	●High rigidity double clamp structure. ●Suitable for high feed cutting. ●13°, 15° positive insert. ●Special insert design with 3 cutting edges. ●With through coolant holes.
ARP 	●Slot Milling ●Shoulder Milling ●Contour Milling ●Corner Radius Milling ●Copy Milling ●Face Milling 	●Precision M-class 15°positive insert. ●Effective for various machining applications. ●Air / coolant through.

Product Name	Application	Feature
ARX 	●Slot Milling ●Corner Radius Milling ●Copy Milling ●Face Milling 	●15° positive, close tolerance M-class insert. ●Effective for various machining applications. ●With through coolant holes.
SRF 	●Radius Milling ●Copy Milling 	●S-shaped cutting edges provide sharpness similar to that of solid end mills. ●Highly accurate ball/ corner radius tolerance allows for high precision finishing.
SRM2 	●Curved Face Milling ●Copy Milling ●Contour Milling 	●Suitable for roughing to semi-finishing of small and medium molds. ●Low resistance chipbreaker. ●High rigidity body design. ●With through coolant holes.
PMC 		●1 directional cutting with large overhang. ●Unique shape of curved edge gives high rigidity and low resistance.

Screw-in Holders

Straight Shank

Steel shank type : General machining
Carbide shank type : High rigidity applications



BT30 / 40 Arbor

Integral tool for a shorter overhang!



HSK63A Arbor

Effective when used on high speed, low rigidity machining centers!

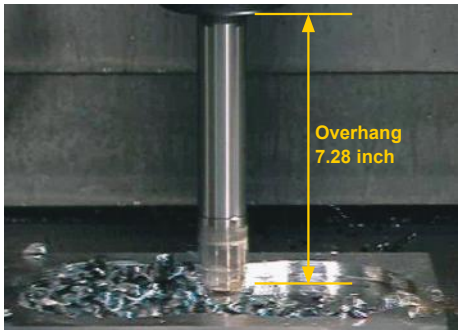


Cutting Performance

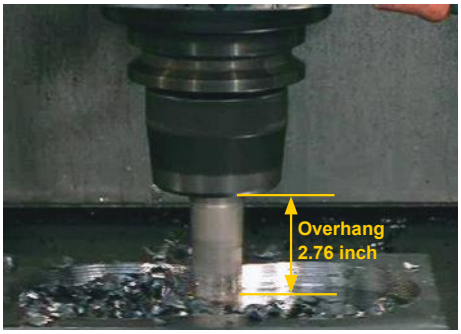
Carbide Shank Holder

Possible to machine with overhangs of up to 6xD (standard type: 2xD)

<Screw-in Tool>
Carbide Shank : SC32M16S280LW
Screw-in Head : AJX12R322AM1645



<Standard Arbor>
Arbor : BT50 milling chuck
Holder : AJX12R322SA32S



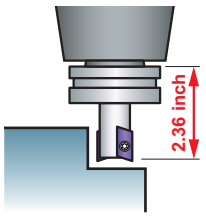
<Cutting Conditions>
Workpiece : AISI 4140
Insert : JDMW12420ZDSR-FT (VP15TF)
Cutting speed : 490 SFM
Feed rate : 157 inch/min
Feed per tooth : .052—.094 IPT
Depth of cut : .079 inch (Axial)
1.260 inch (Radial)
Cutting mode : Dry cutting

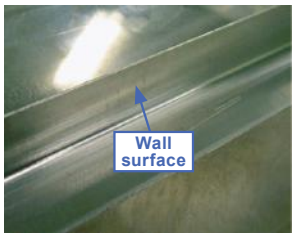
* The overhang length differs depending the tool and cutting conditions.

BT Shank Arbor

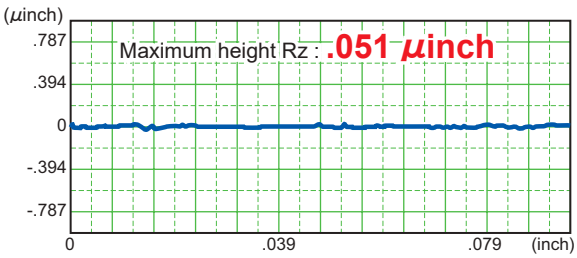
Compact size enables high quality machining!

<Screw-in Tool>
BT Arbor : SC20M10S10-BT30
Screw-in Head : APX3000R203M10A30



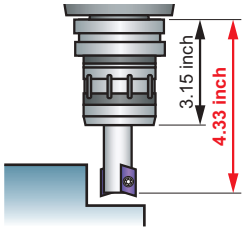


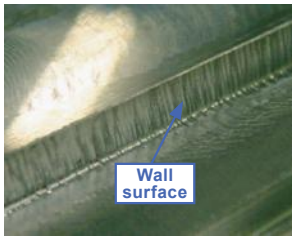
Roughness curve



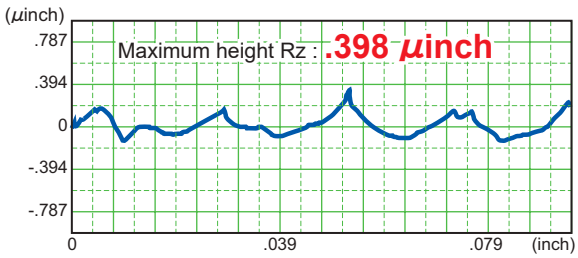
<Cutting Conditions>
Workpiece : AISI 1055
Insert : AOMT123608PEER-M (VP15TF)
Cutting speed : 525 SFM
Feed rate : 30.1 inch/min
Feed per tooth : .004 IPT
Depth of cut : .236 inch (Axial)
.394 inch (Radial)
Cutting mode : Dry cutting

<Standard Arbor>
Arbor : BT30 milling chuck
Holder : APX3000R203SA20SA

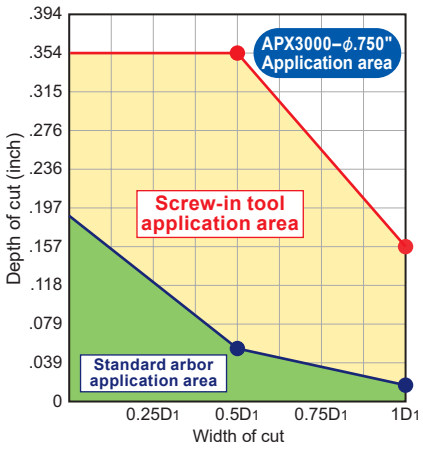


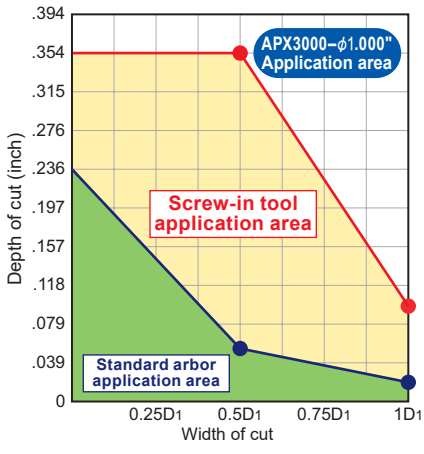


Roughness curve



A wide application range





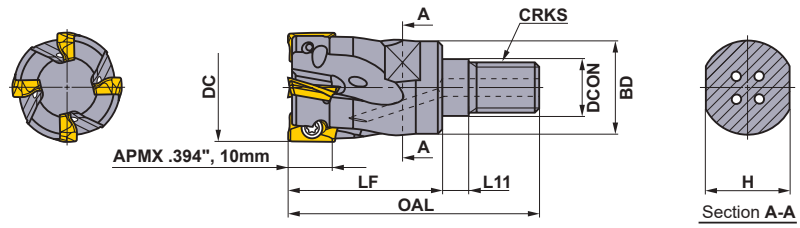
<Cutting Conditions>
Workpiece : AISI 1055
Cutting speed : 525 SFM
Feed per tooth : .004 IPT
Cutting mode : Dry cutting
D1 : Cutting edge diameter

SCREW-IN TOOLS

APX3000

P M K N S H





With Air / coolant through.

Right hand tool holder only.

DC	Order Number	Stock	Number of Teeth	Dimensions (inch)							WT *3	*1 Insert Screw	Wrench	Anti-seize Lubricant	Insert
				LF	OAL	DCON	BD	L11	H	CRKS *2					
.625	**APX3000UR102AM08A30**	●	2	1.181	1.890	.335	.512	.236	.394	M8	.2	TPS25	TIP07F	MK1KS	AO□T1236
.750	APX3000UR**122AM10A30**	●	2	1.181	1.929	.413	.709	.236	.551	M10	.2	TPS25	TIP07F	MK1KS	AO□T1236
.750	APX3000UR**123AM10A30**	●	3	1.181	1.929	.413	.709	.236	.551	M10	.2	TPS25	TIP07F	MK1KS	AO□T1236
.875	APX3000UR**142AM10A30**	●	2	1.181	1.929	.413	.709	.236	.551	M10	.2	TPS25-1	TIP07F	MK1KS	AO□T1236
.875	APX3000UR**143AM10A30**	●	3	1.181	1.929	.413	.709	.236	.551	M10	.2	TPS25-1	TIP07F	MK1KS	AO□T1236
1.000	APX3000UR**163AM12A35**	●	3	1.378	2.244	.492	.827	.236	.748	M12	.4	TPS25-1	TIP07F	MK1KS	AO□T1236
1.000	APX3000UR**164AM12A35**	●	4	1.378	2.244	.492	.827	.236	.748	M12	.4	TPS25-1	TIP07F	MK1KS	AO□T1236
1.125	APX3000UR**184AM12A35**	●	4	1.378	2.244	.492	.827	.236	.748	M12	.4	TPS25-1	TIP07F	MK1KS	AO□T1236
1.250	APX3000UR**205AM16A40**	●	5	1.575	2.480	.669	1.142	.236	.945	M16	.7	TPS25-1	TIP07F	MK1KS	AO□T1236
1.375	APX3000UR**225AM16A40**	●	5	1.575	2.480	.669	1.142	.236	.945	M16	.7	TPS25-1	TIP07F	MK1KS	AO□T1236

*1 Clamp Torque (lbf-in) : TPS25=8.9, TPS25−1=8.9
*2 Clamp Torque of the Head (lbf-ft) : M8=17.1, M10=33.8, M12=59.2, M16=66.7
*3 WT : Mass (lbs)

METRIC Standard

With Air / coolant through.

DC	Order Number	Stock	Number of Teeth	Dimensions (mm)							WT *3	*1 Insert Screw	Wrench	Anti-seize Lubricant	Insert
				LF	OAL	DCON	BD	L11	H	CRKS *2					
16	**APX3000R162M08A30**	★	2	30	48	8.5	48	6	10	M8	0.1	TPS25	TIP07F	MK1KS	AO□T1236
18	APX3000R**182M08A30**	★	2	30	48	8.5	48	6	10	M8	0.1	TPS25	TIP07F	MK1KS	AO□T1236
20	APX3000R**203M10A30**	★	3	30	49	10.5	49	6	14	M10	0.1	TPS25	TIP07F	MK1KS	AO□T1236
22	APX3000R**223M10A30**	★	3	30	49	10.5	49	6	14	M10	0.1	TPS25-1	TIP07F	MK1KS	AO□T1236
25	APX3000R**254M12A35**	★	4	35	57	12.5	57	6	19	M12	0.2	TPS25-1	TIP07F	MK1KS	AO□T1236
28	APX3000R**284M12A35**	★	4	35	57	12.5	57	6	19	M12	0.2	TPS25-1	TIP07F	MK1KS	AO□T1236
30	APX3000R**304M16A40**	★	4	40	63	17	63	6	24	M16	0.3	TPS25-1	TIP07F	MK1KS	AO□T1236
32	APX3000R**325M16A40**	★	5	40	63	17	63	6	24	M16	0.3	TPS25-1	TIP07F	MK1KS	AO□T1236
35	APX3000R**355M16A40**	★	5	40	63	17	63	6	24	M16	0.3	TPS25-1	TIP07F	MK1KS	AO□T1236
40	APX3000R**406M16A40**	★	6	40	63	17	63	6	24	M16	0.3	TPS25-1	TIP07F	MK1KS	AO□T1236

*1 Clamp Torque (lbf-in) : TPS25=8.9, TPS25−1=8.9
*2 Clamp Torque of the Head (lbf-ft) : M8=17.1, M10=33.8, M12=59.2, M16=66.7
*3 WT : Mass (kg)

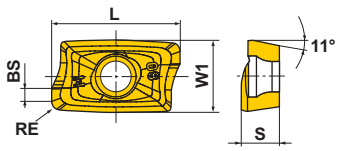
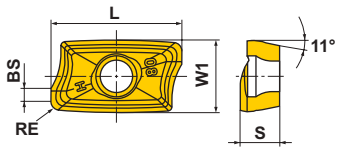
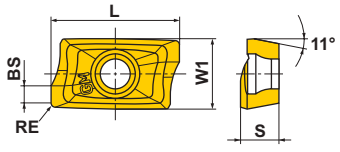
● : Inventory maintained. ★ : Inventory maintained in Japan.
<10 inserts in one case>

INSERTS

Work Material		
P	Steel	
M	Stainless Steel	
K	Cast Iron	
N	Non-ferrous Metal	
S	Heat-resistant Alloy, Titanium Alloy	
H	Hardened Steel	

Cutting Conditions (Guide) :
● : Stable Cutting ◕ : General Cutting ✣ : Unstable Cutting

Honing :
E : Round **F :** Sharp

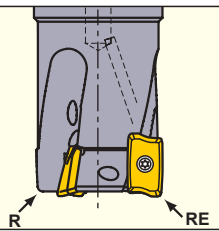
Shape	Order Number	Class	Honing	Coated								Carbide		Dimensions (inch)					Geometry
				MC5020	MP6120	MP6130	MP7130	MP9120	MP9130	VP15TF	VP20RT	TF15		L	W1	S	BS	RE	
General M Breaker	**AOMT123602PEER-M**	M	E		●	●	●	●	●	●	●			.472	.260	.142	.071	.008	
	**AOMT123604PEER-M**	M	E		●	●	●	●	●	●	●			.472	.260	.142	.063	.016	
	AOMT123608PEER-M	M	E		●	●	●	●	●	●	●			.472	.260	.142	.047	.031	
	AOMT123610PEER-M	M	E		●	●	●	●	●	★	★			.472	.260	.142	.039	.039	
	AOMT123612PEER-M	M	E		●	●	●	●	●	●	●			.472	.260	.142	.031	.047	
	AOMT123616PEER-M	M	E		●	●	●	●	●	●	●			.472	.260	.142	.016	.063	
	AOMT123620PEER-M	M	E		●	●	●	●	●	●	●			.472	.260	.142	.016	.079	
Strong Cutting Edge Type H Breaker	**AOMT123604PEER-H**	M	E	●	●	●	●	●	●	●	●			.472	.260	.142	.063	.016	
	**AOMT123608PEER-H**	M	E	●	●	●	●	●	●	●	●			.472	.260	.142	.047	.031	
	AOMT123616PEER-H	M	E	●	●	●	●	●	●	●	●			.472	.260	.142	.016	.063	
For Machining of Aluminium Alloys GM Breaker	**AOGT123602PEFR-GM**	G	F									●		.472	.260	.142	.071	.008	
	**AOGT123604PEFR-GM**	G	F									●		.472	.260	.142	.063	.016	
	AOGT123608PEFR-GM	G	F									●		.472	.260	.142	.047	.031	

(Note) For the recomemded cutting conditions, refer to the general catalogue or B055A Tool News.

■ = MIRACLE SIGMA

NOTE ON USE OF INSERTS WITH LARGE CORNER RADII

When using inserts with corner radius RE≥R.094", please machine the holder with a radius form as shown on the right table.



RE	R
.094"	.106" (B-Holder)
.118"	
.125"	

R : Holder end radius
RE : Insert corner radius

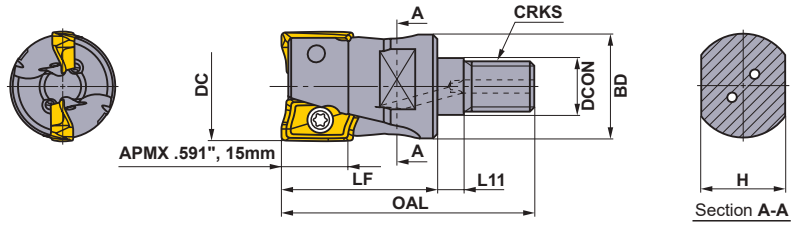
Or B-Holders are available as non stock, produced to order only.
"Order numbers"; Please add "B" to the end of the order number of A-Holders.
Ex) APX3000R162M08A30→APX3000R162M08A30B

SCREW-IN TOOLS

APX4000

P M K N S H





With Air / coolant through.

DC	Order Number	Stock	Number of Teeth	Dimensions (inch)							WT *3	*1 Insert Screw	Wrench	Anti-seize Lubricant	Insert
				LF	OAL	DCON	BD	L11	H	CRKS *2					
1.000	**APX4000UR162AM12A35**	●	2	1.378	2.244	.492	.925	.236	.748	M12	.4	TPS4	TIP15W	MK1KS	AO□T1848
1.125	APX4000UR**182AM12A35**	●	2	1.378	2.244	.492	.925	.236	.748	M12	.4	TPS4	TIP15W	MK1KS	AO□T1848
1.250	APX4000UR**203AM16A40**	●	3	1.575	2.480	.669	1.122	.236	.945	M16	.7	TPS4	TIP15W	MK1KS	AO□T1848
1.375	APX4000UR**223AM16A40**	●	3	1.575	2.480	.669	1.122	.236	.945	M16	.7	TPS4	TIP15W	MK1KS	AO□T1848

∗1 Clamp Torque (lbf-in) : TPS4=31, TPS43=31
∗2 Clamp Torque of the Head (lbf-ft) : M12=59.2, M16=66.7
∗3 WT : Mass (lbs)

METRIC Standard

With Air / coolant through.

DC	Order Number	Stock	Number of Teeth	Dimensions (mm)							WT *3	*1 Insert Screw	Wrench	Anti-seize Lubricant	Insert
				LF	OAL	DCON	BD	L11	H	CRKS *2					
25	**APX4000R252M12A35**	★	2	35	57	12.5	23.5	6	19	M12	0.2	TPS4	TIP15W	MK1KS	AO□T1848
28	APX4000R**282M12A35**	★	2	35	57	12.5	23.5	6	19	M12	0.2	TPS4	TIP15W	MK1KS	AO□T1848
32	APX4000R**322M16A40**	★	2	40	63	17	28.5	6	24	M16	0.3	TPS4	TIP15W	MK1KS	AO□T1848
32	APX4000R**323M16A40**	★	3	40	63	17	28.5	6	24	M16	0.3	TPS4	TIP15W	MK1KS	AO□T1848
35	APX4000R**352M16A40**	★	2	40	63	17	28.5	6	24	M16	0.3	TPS4	TIP15W	MK1KS	AO□T1848
35	APX4000R**353M16A40**	★	3	40	63	17	28.5	6	24	M16	0.3	TPS4	TIP15W	MK1KS	AO□T1848
40	APX4000R**403M16A40**	★	3	40	63	17	28.5	6	24	M16	0.3	TPS43	TIP15W	MK1KS	AO□T1848
40	APX4000R**404M16A40**	★	4	40	63	17	28.5	6	24	M16	0.3	TPS43	TIP15W	MK1KS	AO□T1848

∗1 Clamp Torque (N • m) : TPS4=31, TPS43=31
∗2 Clamp Torque of the Head (N • m) : M12=59.2, M16=66.7
∗3 WT : Mass (kg)

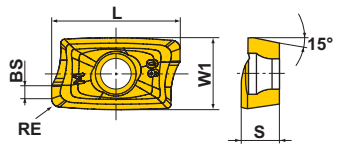
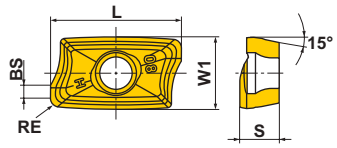
● : Inventory maintained. ★ : Inventory maintained in Japan.
<10 inserts in one case>

INSERTS

Work Material		
P	Steel	
M	Stainless Steel	
K	Cast Iron	
S	Heat-resistant Alloy, Titanium Alloy	
H	Hardened Steel	

Cutting Conditions (Guide) :
● : Stable Cutting ◕ : General Cutting ✠ : Unstable Cutting

Honing :
E : Round **F :** Sharp

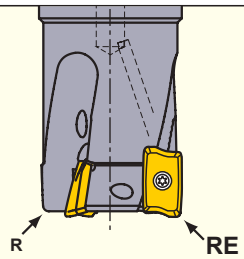
Shape	Order Number	Class	Honing	Coated								Dimensions (inch)					Geometry
				MC5020	MP6120	MP6130	MP7130	MP9120	MP9130	VP15TF	VP20RT	L	W1	S	BS	RE	
General M Breaker	**AOMT184804PEER-M**	M	E		●	●	●	●	●	●	●	.709	.354	.189	.071	.016	
	AOMT**184808PEER-M**	M	E		●	●	●	●	●	●	●	.709	.354	.189	.055	.031	
	AOMT**184810PEER-M**	M	E		●			●	●	★		.709	.354	.189	.039	.039	
	AOMT**184812PEER-M**	M	E		●			●	●	●		.709	.354	.189	.031	.047	
	AOMT**184816PEER-M**	M	E		●	●	●	●	●	●	●	.709	.354	.189	.016	.063	
	AOMT**184820PEER-M**	M	E		●			●	●	★		.709	.354	.189	.016	.079	
Strong Cutting Edge Type H Breaker	**AOMT184804PEER-H**	M	E	●	●	●	●	●	●	●	●	.709	.354	.189	.071	.016	
	AOMT**184808PEER-H**	M	E	●	●	●	●	●	●	●	●	.709	.354	.189	.055	.031	
	AOMT**184816PEER-H**	M	E	●	●	●	●	●	●	●	●	.709	.354	.189	.016	.063	

(Note) For the recomemded cutting conditions, refer to the general catalogue or B055A Tool News.

■ = MIRACLE SIGMA

NOTE ON USE OF INSERTS WITH LARGE CORNER RADII

When using inserts with corner radius RE≥R.125", please machine the holder with a radius form as shown on the right table.



RE	R
.125"	.098" B-Holders
.157"	
.197"	.197" C-Holders
.250"	

R : Holder end radius
RE : Insert corner radius

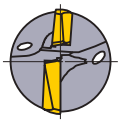
Or additional B-Holders and C-Holders are available as non stock, produced to order only.
"Order numbers"; Please replace the last letter "A" of A-Holders to "B" or "C".
In case of screw-in holders, please add "B" or "C" to the end of the order number of A-Holders.
Ex) APX4000R08007CA→APX4000R08007CC
APX4000R252M12A35→APX4000R252M12A35C

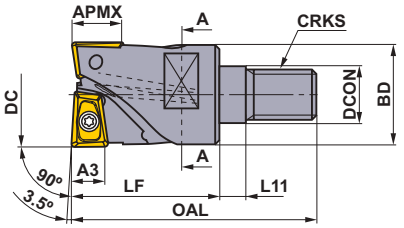
SCREW-IN TOOLS

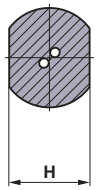
AQX

P M K N S H









Section **A-A**

METRIC Standard

With Air / coolant through.

Right hand tool holder only.

DC	Order Number	Stock	Number of Teeth	Dimensions (mm)									WT *5	*3	① ②	
				LF	OAL	DCON	BD	L11	H	CRKS *4	A3 *1	APMX *2		Insert Screw	Wrench	Insert
16	**AQXR162M08A30**	★	2	30	48	8.5	14.7	6	10	M8	4.5	7.4	0.1	TS2A	①TKY06F	QO○T0830R
17	**AQXR172M08A30**	★	2	30	48	8.5	14.5	6	10	M8	4.5	7.4	0.1	TS2A	①TKY06F	QO○T0830R
20	**AQXR202M10A30**	★	2	30	49	10.5	18.6	6	14	M10	6	9.2	0.2	TS25	①TKY08F	QO○T1035R
21	**AQXR212M10A30**	★	2	30	49	10.5	18.5	6	14	M10	6	9.2	0.2	TS25	①TKY08F	QO○T1035R
25	**AQXR252M12A35**	★	2	35	57	12.5	23.5	6	19	M12	7.5	11.5	0.2	TS33	②TKY08D	QO○T1342R
26	**AQXR262M12A35**	★	2	35	57	12.5	23.5	6	19	M12	7.5	11.5	0.2	TS33	②TKY08D	QO○T1342R
32	**AQXR322M16A40**	★	2	40	63	17	28.5	6	24	M16	9.5	14.5	0.3	TS407	②TKY15D	QO○T1651R
33	**AQXR332M16A40**	★	2	40	63	17	28.5	6	24	M16	9.5	14.5	0.3	TS407	②TKY15D	QO○T1651R
35	**AQXR352M16A40**	★	2	40	63	17	28.5	6	24	M16	11	16	0.3	TS407	②TKY15D	QO○T1856R
40	**AQXR402M16A45**	★	2	45	68	17	28.5	6	24	M16	12	18	0.3	TS55	②TKY25D	QO○T2062R

*1 Dimension A3 represents the depth of cut when the cutting edge consists of 2 inserts.
*2 APMX: Maximum depth of cut.
*3 Clamp Torque (lbf-in) : TS2A=5.3, TS25=8.9, TS33=8.9, TS407=31, TS55=66
*4 Clamp Torque of the Head (lbf-ft) : M8=17.1, M10=33.8, M12=59.2, M16=66.7
*5 WT : Mass (kg)

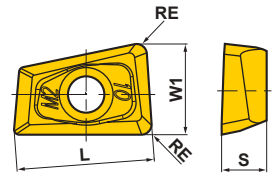
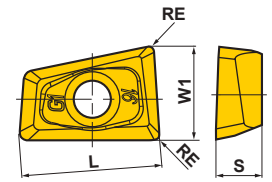
● : Inventory maintained. ★ : Inventory maintained in Japan.
<10 inserts in one case>

INSERTS

Work Material			Coated				Carbide		
			VP15TF	VP30RT			HTi10		
	P	Steel	●	✣					
	M	Stainless Steel	◔	✣					
	K	Cast Iron	✣						
	N	Non-Ferrous Metal					◔		
	S	Heat-resistant Alloy, Titanium Alloy	◕						
	H	Hardened Materials	◕						

Cutting Conditions :
● : Stable Cutting ◔ : General Cutting ✣ : Unstable Cutting

Honing :
E : Round **F** : Sharp

Shape	Order Number	End Mill Dia.	Class	Honing	Coated VP15TF	Coated VP30RT	Carbide HTi10	Dimensions (mm) L	W1	S	RE	Geometry
M breaker	**QOMT0830R-M2**	ϕ16,17	M	E	●	●		8.4	5.5	3	0.8	
	QOMT**1035R-M2**	ϕ20,21	M	E	★	★		10.6	7	3.5	0.8	
	QOMT**1342R-M2**	ϕ25,26	M	E	★	★		13.1	8.7	4.2	0.8	
	QOMT**1651R-M2**	ϕ32,33	M	E	●	●		16.5	11	5.1	0.8	
	QOMT**1856R-M2**	ϕ35	M	E	★	★		18	12	5.6	0.8	
	QOMT**2062R-M2**	ϕ40	M	E	★	★		20.4	13.6	6.2	0.8	
G breaker	**QOGT0830R-G1**	ϕ16,17	G	F*	★		●	8.4	5.5	3	0.4	
	QOGT**1035R-G1**	ϕ20,21	G	F*	★		★	10.6	7	3.5	0.4	
	QOGT**1342R-G1**	ϕ25,26	G	F*	★		★	13.1	8.7	4.2	0.4	
	QOGT**1651R-G1**	ϕ32,33	G	F*	★		●	16.5	11	5.1	0.4	
	QOGT**1856R-G1**	ϕ35	G	F*	★		★	18	12	5.6	0.4	
	QOGT**2062R-G1**	ϕ40	G	F*	★		★	20.4	13.6	6.2	0.4	

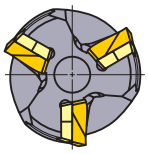
★Grade VP15TF has “E” honing.
(Note) For the recomemded cutting conditions, refer to the general catalogue or B021A Tool News.

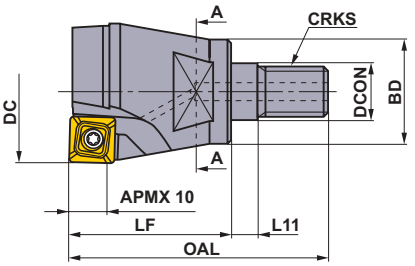
SCREW-IN TOOLS

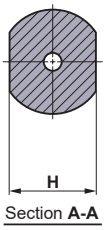
ASX400

P M K N S H









METRIC Standard

With Air / coolant through.

Right hand tool holder only.

DC	Order Number	Stock	Number of Teeth	Dimensions (mm)							WT *3	*1			*1	
				LF	OAL	DCON	BD	L11	H	CRKS *2		Insert Screw	Insert Wrench	Shim	Shim Screw	Shim Wrench
32	**ASX400R322AM1640**	★	2	40	63	17	29	6	24	M16	0.3	TPS35	TIP15T	—	WCS503507H	HKY35R
40	ASX400R**403AM1645**	★	3	45	68	17	29	6	24	M16	0.3	TPS35	TIP15T	STASX400N	WCS503507H	HKY35R

*1 Clamp Torque (lbf-in) : WCS503507H=44, TPS35=31
*2 Clamp Torque of the Head (lbf-ft) : M16=66.7
*3 WT : Mass (kg)

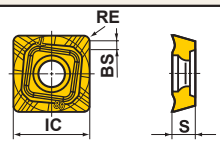
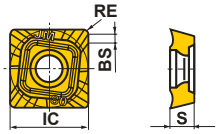
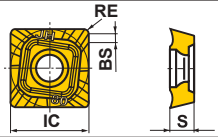
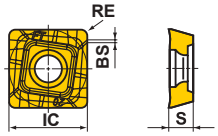
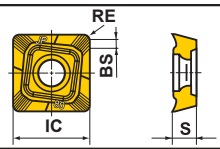
● : Inventory maintained. ★ : Inventory maintained in Japan.
<10 inserts in one case>

INSERTS

Work Material		
P	Steel	
M	Stainless Steel	
K	Cast Iron	
N	Non-ferrous Metal	
S	Heat-resistant Alloy, Titanium Alloy	
H	Hardened Steel	

Cutting Conditions :
● : Stable Cutting ◐ : General Cutting
✣ : Unstable Cutting

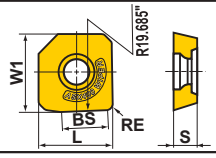
Honing :
E : Round **F** : Sharp **T** : Chamfer

Application	Shape	Order Number	Class	Honing	Coated											Cermet		Carbide		Dimensions (inch)				Geometry
					F7010	F7030	MC5020	MP6120	MP6130	MP7130	MP7140	MP9120	MP9130	VP15TF	VP30RT	NX4545		HTi10		IC	S	BS	RE	
Finish—Light Cutting	JL Breaker 	SOET12T308PEER-JL	E	E		●		●	●	●	●	●	●	●	●	●				.500	.156	.055	.031	
Light—Rough Cutting	JM Breaker 	SOMT12T308PEER-JM	M	E	●	●	●	●	●	●	●	●	●	●	●	●				.500	.156	.055	.031	
Medium—Heavy Cutting	JH Breaker 	SOMT12T308PEER-JH	M	E		●	●	●	●	●	●	●	●	●	●					.500	.156	.055	.031	
Heavy Interrupted Cutting	FT Breaker 	SOMT12T320PEER-FT	M	E			●	●				●	●	●						.500	.156	.055	.079	
For Aluminium Alloy	JP Breaker 	SOGT12T308PEFR-JP	G	F														●		.500	.156	.055	.031	

(Note) For the recomemded cutting conditions, refer to the general catalogue or B023A Tool News.

■ = MIRACLE SIGMA

WIPER INSERTS

Shape	Order Number	Class	Honing	Carbide		Cermet		Dimensions (inch)					Geometry
				HTi05T		NX2525		L	W1	S	BS	RE	
	WOEW12T308PEER8C	E	E	●				.492	.520	.156	.315	.031	
	WOEW12T308PETR8C	E	T			●		.492	.520	.156	.315	.031	

(Note) For the recomemded cutting conditions, refer to the general catalogue or B023A Tool News.

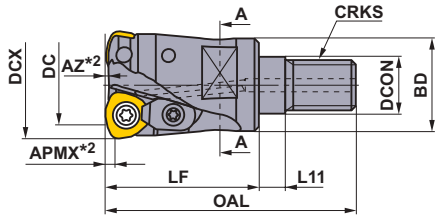
SCREW-IN TOOLS

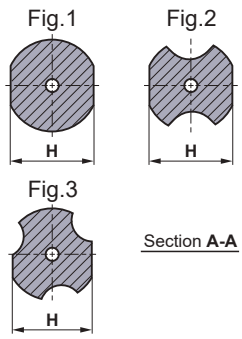
AJX

P M K N S H









Air / coolant through.

Right hand tool holder only.

DCX	Order Number	Stock	Number of Teeth	Dimensions (inch)								WT *3	Type (Fig.)
				DC	LF	OAL	DCON	BD	L11	H	CRKS *1		
.625	**AJXU06R102AM0830**	●	2	.346	1.181	1.890	.335	.512	.236	.394	M8	.2	1
.750	AJXU**08R122AM1030**	●	2	.417	1.181	1.929	.413	.709	.236	.551	M10	.2	2
.750	AJXU**06R123AM1030**	●	3	.472	1.181	1.929	.413	.709	.236	.551	M10	.2	3
.875	AJXU**08R142AM1030**	●	2	.535	1.181	1.929	.413	.709	.236	.551	M10	.2	2
.875	AJXU**06R143AM1030**	●	3	.595	1.181	1.929	.413	.709	.236	.551	M10	.2	3
1.000	AJXU**09R162AM1235**	●	2	.602	1.378	2.244	.492	.827	.236	.748	M12	.4	2
1.000	AJXU**08R163AM1235**	●	3	.661	1.378	2.244	.492	.827	.236	.748	M12	.2	1
1.125	AJXU**09R182AM1235**	●	2	.728	1.378	2.244	.492	.827	.236	.748	M12	.4	2
1.125	AJXU**08R183AM1235**	●	3	.784	1.378	2.244	.492	.827	.236	.748	M12	.2	1
1.250	AJXU**09R203AM1645**	●	3	.854	1.772	2.677	.669	1.142	.236	.945	M16	.4	1
1.375	AJXU**09R223AM1645**	●	3	.976	1.772	2.677	.669	1.142	.236	.945	M16	.4	1

*1 Clamp Torque of the Head (lbf-ft) : M8=17.1, M10=33.8, M12=59.2, M16=66.7
*2 Refer to page 13 for the max. depth of cut (**APMX**), and maximum drilling depth (**AZ**)
*3 WT : Mass (lbs)

SPARE PARTS

DCX	Order Number	Insert Screw *1	Insert Wrench	Clamp Bridge	Clamp Bridge Screw *1	Spring	Insert
.625	**AJXU06R102AM0830**	TS25	①TKY08F	—	—	—	JOM□06
.750	AJXU**08R122AM1030**	TS33	①TKY08D	—	—	—	JOM□08
.750	AJXU**06R123AM1030**	TS25	①TKY08F	—	—	—	JOM□06
.875	AJXU**08R142AM1030**	TS33	①TKY08D	—	—	—	JOM□08
.875	AJXU**06R143AM1030**	TS25	①TKY08F	—	—	—	JOM□06
1.000	AJXU**09R162AM1235**	TS351	②TKY10D	AMS3	AJS3010T10	ASS2	JDM□09
1.000	AJXU**08R163AM1235**	TS33	①TKY08D	—	—	—	JOM□08
1.125	AJXU**09R182AM1235**	TS351	②TKY10D	AMS3	AJS3010T10	ASS2	JDM□09
1.125	AJXU**08R183AM1235**	TS33	①TKY08D	—	—	—	JOM□08
1.250	AJXU**09R203AM1645**	TS351	②TKY10D	AMS3	AJS3010T10	ASS2	JDM□09
1.375	AJXU**09R223AM1645**	TS351	②TKY10D	AMS3	AJS3010T10	ASS2	JDM□09

*1 Clamp Torque (lbf-in) : TS25=8.9, TS33=8.9, TS351=22, TS407=31, TS43=31, AJS3010T10=22, AJS4012T15=31

● : Inventory maintained. ★ : Inventory maintained in Japan.
<10 inserts in one case>

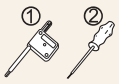
METRIC Standard

With Air / coolant through.

DCX	Order Number	Stock	Number of Teeth	Dimensions (mm)								WT *2	Type (Fig.)
				DC	LF	OAL	DCON	BD	L11	H	CRKS *1		
16	**AJX06R162AM0830**	★	2	8.9	30	48	8.5	13	6	10	M8	0.1	1
17	**AJX06R172AM0830**	★	2	9.9	30	48	8.5	13	6	10	M8	0.1	1
20	**AJX08R202AM1030**	★	2	11.4	30	49	10.5	18	6	14	M10	0.1	2
20	**AJX06R203AM1030**	★	3	12.9	30	49	10.5	18	6	14	M10	0.1	3
22	**AJX08R222AM1030**	★	2	13.4	30	49	10.5	18	6	14	M10	0.1	2
22	**AJX06R223AM1030**	★	3	14.9	30	49	10.5	18	6	14	M10	0.1	3
25	**AJX09R252AM1235**	★	2	14.9	35	57	12.5	21	6	19	M12	0.2	2
25	**AJX08R253AM1235**	★	3	16.4	35	57	12.5	21	6	19	M12	0.1	1
28	**AJX09R282AM1235**	★	2	17.9	35	57	12.5	21	6	19	M12	0.2	2
30	**AJX12R302AM1645**	★	2	18.3	45	68	17	29	6	24	M16	0.3	2
28	**AJX08R283AM1235**	★	3	19.4	35	57	12.5	21	6	19	M12	0.1	1
30	**AJX09R303AM1645**	★	3	20.0	45	68	17	29	6	24	M16	0.2	1
32	**AJX12R322AM1645**	★	2	20.3	45	68	17	29	6	24	M16	0.3	2
32	**AJX09R323AM1645**	★	3	21.9	45	68	17	29	6	24	M16	0.2	1
35	**AJX12R352AM1645**	★	2	23.3	45	68	17	29	6	24	M16	0.3	2
35	**AJX09R353AM1645**	★	3	24.9	45	68	17	29	6	24	M16	0.2	1
40	**AJX12R403AM1645**	★	3	28.3	45	68	17	29	6	24	M16	0.3	2
40	**AJX09R404AM1645**	★	4	29.9	45	68	17	29	6	24	M16	0.2	1

*1 Clamp Torque of the Head (lbf-ft) : M8=17.1, M10=33.8, M12=59.2, M16=66.7
*2 WT : Mass (kg)

SPARE PARTS

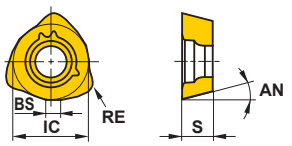
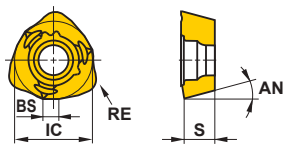
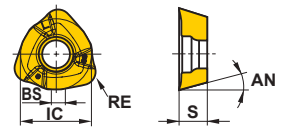
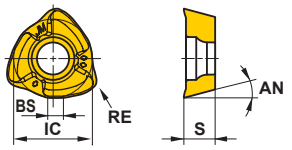
DCX	Order Number	 *1			 *1		
		Insert Screw	Insert Wrench	Clamp Bridge	Clamp Bridge Screw	Spring	Insert
16	**AJX06R162AM0830**	TS25	①TKY08F	–	–	–	JOM□06
17	**AJX06R172AM0830**	TS25	①TKY08F	–	–	–	JOM□06
20	**AJX08R202AM1030**	TS33	①TKY08D	–	–	–	JOM□08
20	**AJX06R203AM1030**	TS25	①TKY08F	–	–	–	JOM□06
22	**AJX08R222AM1030**	TS33	①TKY08D	–	–	–	JOM□08
22	**AJX06R223AM1030**	TS25	①TKY08F	–	–	–	JOM□06
25	**AJX09R252AM1235**	TS351	②TKY10D	AMS3	AJS3010T10	ASS2	JOM□09
25	**AJX08R253AM1235**	TS33	①TKY08D	–	–	–	JOM□08
28	**AJX09R282AM1235**	TS351	②TKY10D	AMS3	AJS3010T10	ASS2	JOM□09
30	**AJX12R302AM1645**	TS407	②TKY15D	AMS4	AJS4012T15	ASS2	JOM□12
28	**AJX08R283AM1235**	TS33	①TKY08D	–	–	–	JOM□08
30	**AJX09R303AM1645**	TS351	②TKY10D	AMS3	AJS3010T10	ASS2	JOM□09
32	**AJX12R322AM1645**	TS43	②TKY15D	AMS4	AJS4012T15	ASS2	JOM□12
32	**AJX09R323AM1645**	TS351	②TKY10D	AMS3	AJS3010T10	ASS2	JOM□09
35	**AJX12R352AM1645**	TS43	②TKY15D	AMS4	AJS4012T15	ASS2	JOM□12
35	**AJX09R353AM1645**	TS351	②TKY10D	AMS3	AJS3010T10	ASS2	JOM□09
40	**AJX12R403AM1645**	TS43	②TKY15D	AMS4	AJS4012T15	ASS2	JOM□12
40	**AJX09R404AM1645**	TS351	②TKY10D	AMS3	AJS3010T10	ASS2	JOM□09

*1 Clamp Torque (lbf-in) : TS25=8.9, TS33=8.9, TS351=22, TS407=31, TS43=31, AJS3010T10=22, AJS4012T15=31

INSERTS

Work Material		
P	Steel	
M	Stainless Steel	
K	Cast Iron	
S	Heat-resistant Alloy, Titanium Alloy	
H	Hardened Materials	

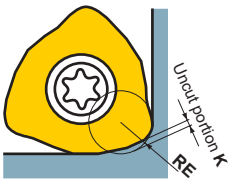
Cutting Conditions :
● : Stable Cutting ◔ : General Cutting ✣ : Unstable Cutting

Shape	Order Number	Class	Coated									Dimensions (inch)					Geometry
			FH7020	MP6120	MP6130	MP7130	MP7140	MP9120	MP9130	VP15TF	VP30RT	AN	IC	S	BS	RE	
	JOMW06T215ZZSR-FT	M	●	●	●	●	●			●	●	13°	.250	.109	.047	.059	
	JOMW080320ZZSR-FT	M	●	●	●	●	●			●	●	13°	.315	.125	.055	.079	
	JDMW09T320ZDSR-FT	M	●	●	●	●	●			●	●	15°	.375	.156	.071	.079	
	JDMW120420ZDSR-FT	M	●	●	●	●	●			●	●	15°	.472	.187	.098	.079	
Strong Cutting Edge 	JDMT120420ZDSR-ST	M	●	●	●	●	●			●	●	15°	.472	.187	.098	.079	
	JOMT06T216ZZER-JL	M				●	●	●	●			13°	.250	.109	.047	.071	
	JOMT080322ZZER-JL	M				●	●	●	●			13°	.315	.125	.055	.102	
	JDMT09T323ZDER-JL	M				●	●	●	●			15°	.375	.156	.071	.091	
	JDMT120423ZDER-JL	M				●	●	●	●			15°	.472	.187	.098	.091	
Lower Cutting Resistance 	JOMT06T215ZZSR-JM	M	●	●	●	●	●			●	●	13°	.250	.109	.047	.059	
	JOMT080320ZZSR-JM	M	●	●	●	●	●			●	●	13°	.315	.125	.055	.079	
	JDMT09T320ZDSR-JM	M	●	●	●	●	●			●	●	15°	.375	.156	.071	.079	
	JDMT120420ZDSR-JM	M	●	●	●	●	●			●	●	15°	.472	.187	.098	.079	

(Note) For the recomemded cutting conditions, refer to the general catalogue or B028A Tool News.
(Note) Setting heights for ST chipbeaker and the other chipbreakers differ slightly.
If an ST type chipbreaker is used, please check the tool length offset height.

= MIRACLE SIGMA

NOTE FOR PROGRAMMING



When using the ***AJX***,
please program the approximate radius as indicated.
The approximate uncut portions for the program are as follows.

Holder Type		Insert size	Breaker	Approx. **RE**(inch)	Uncut portion **K**(inch)	**APMX**	**AZ**
AJXU06	**AJX06**	**JOM○06**	**FT/JM/ST**	.079	.013	.039	.012
			JL	.098	.013	.024	.012
AJXU08	**AJX08**	**JOM○08**	**FT/JM/ST**	.098	.018	.059	.020
			JL	.079	.016	.035	.020
AJXU09	**AJX09**	**JDM○09**	**FT/JM/ST**	.118	.019	.079	.039
			JL	.118	.018	.047	.039
—	**AJX12**	**JDM○12**	**FT/JM/ST**	.118	.025	.079	.059
			JL	.118	.021	.047	.059

(Note) The uncut portion may change slightly depending on cutting conditions.

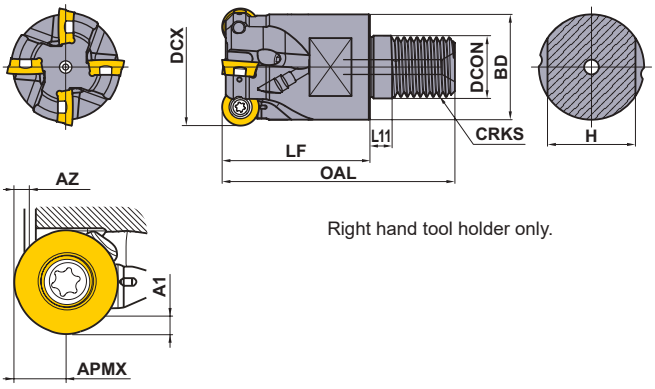
● : Inventory maintained. ★ : Inventory maintained in Japan.
<10 inserts in one case>

SCREW-IN TOOLS

ARP

P | **M** | K | N | **S** | H





Right hand tool holder only.

With Air / coolant through.

GAMP:+4°
GAMF:-6°—-7°

	DCX	Order Number	Stock	Number of Teeth	Dimensions (inch)								*2 WT	APMX	A1	AZ
					RE (APMX)	LF	OAL	DCON	BD	L11	H	CRKS*1				
NEW	1.000	**ARP5UPR1603AM1235**	●	3	.197	1.378	2.244	.492	.925	.236	.748	M12	.198	.197	—	.016
NEW	1.250	**ARP5UPR2004AM1640**	●	4	.197	1.575	2.480	.669	1.122	.236	.945	M16	.397	.197	.039	.026
NEW	1.250	**ARP6UPR2003AM1640**	●	3	.236	1.575	2.480	.669	1.122	.236	.945	M16	.375	.236	.039	.024
NEW	1.500	**ARP6UPR2404AM1640**	●	4	.236	1.575	2.480	.669	1.122	.236	.945	M16	.441	.236	.098	.045

*1 Clamp Torque of the Head (lbf-ft) : M12=59.2, M16=66.7
*2 WT : Mass (lbs)

SPARE PARTS

DCX	Order Number	*1 Insert Screw	Wrench	Anti-seize Lubricant	Insert
1.000	**ARP5UPR1603AM1235**	TPS351B	TIP10D	MK1KS	RP◌T1040
1.250	**ARP5UPR2004AM1640**	TPS351B	TIP10D	MK1KS	RP◌T1040
1.250	**ARP6UPR2003AM1640**	TPS4	TIP15D	MK1KS	RP◌T1248
1.500	**ARP6UPR2404AM1640**	TPS4	TIP15D	MK1KS	RP◌T1248

*1 Clamp Torque (lbf-in) : TPS351B = 22, TPS4 = 31

	≤140PSI (≤5.3gal/min)	←Standard→ (140PSI-720PSI)	≥720PSI (≥7.9gal/min)	≥1000PSI (≥13.2gal/min)
Nozzle Dia.	ø.024"	ø.031"	ø.047"	ø.063"
Order Number	**HSD04004H06**	**HSD04004H08**	**HSD04004H12**	**HSD04004H16**

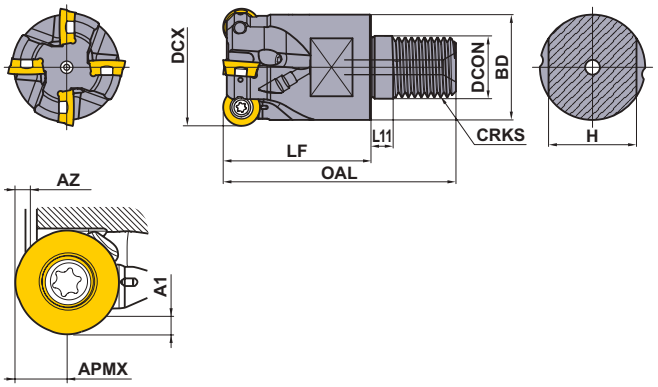
Select and use alternate nozzles from below list depending on coolant pressure.
Clamp Torque (lbf-in) : HSD0400H◌◌=13
The part number for a plug screw without a through nozzle is HSS04004.

SCREW-IN TOOLS

ARP

P | M | K | N | S | H





METRIC Standard

With Air / coolant through.

GAMP:+4°
GAMF:-6°—-7°

Right hand tool holder only.

DCX	Order Number	Stock	Number of Teeth	Dimensions (mm)								*2 WT	APMX	A1	AZ
				RE (APMX)	LF	OAL	DCON	BD	L11	H	CRKS*1				
25	ARP5PR2502AM1235	★	2	5	35	57	12.5	23.5	6	19	M12	0.1	5	—	0.4
25	ARP5PR2503AM1235	★	3	5	35	57	12.5	23.5	6	19	M12	0.09	5	1	0.65
32	ARP5PR3203AM1640	★	3	5	40	63	17	28.5	6	24	M16	0.16	5	—	0.4
32	ARP5PR3204AM1640	★	4	5	40	63	17	28.5	6	24	M16	0.15	5	1	0.65
32	ARP6PR3202AM1640	★	2	6	40	63	17	28.5	6	24	M16	0.18	6	1	0.6
32	ARP6PR3203AM1640	★	3	6	40	63	17	28.5	6	24	M16	0.17	6	2.5	1.15
40	ARP6PR4003AM1640	★	3	6	40	63	17	28.5	6	24	M16	0.2	6	1	0.6
40	ARP6PR4004AM1640	★	4	6	40	63	17	28.5	6	24	M16	0.2	6	2.5	1.15

*1 Clamp Torque of the Head (lbf-ft) : M12=59.2, M16=66.7
*2 WT : Mass (kg)

SPARE PARTS

DCX	Order Number	Stock	*1 Insert Screw	Wrench	Insert
25	ARP5PR2502AM1235	★	TPS351B	TIP10D	RP○T1040
25	ARP5PR2503AM1235	★	TPS351B	TIP10D	RP○T1040
32	ARP5PR3203AM1640	★	TPS351B	TIP10D	RP○T1040
32	ARP5PR3204AM1640	★	TPS351B	TIP10D	RP○T1040
32	ARP6PR3202AM1640	★	TPS4	TIP15D	RP○T1248
32	ARP6PR3203AM1640	★	TPS4	TIP15D	RP○T1248
40	ARP6PR4003AM1640	★	TPS4	TIP15D	RP○T1248
40	ARP6PR4004AM1640	★	TPS4	TIP15D	RP○T1248

*1 Clamp Torque (lbf-in) : TPS351B = 22, TPS4 = 31

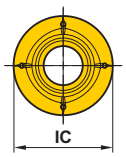
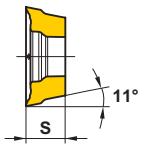
● : Inventory maintained. ★ : Inventory maintained in Japan.
<10 inserts in one case>

INSERTS

Work Material		
	P	Steel
	M	Stainless Steel
	K	Cast Iron
	N	Non-ferrous Metal
	S	Heat-resistant Alloy, Titanium Alloy
	H	Hardened Steel

Cutting Conditions (Guide) :
● : Stable Cutting ◔ : General Cutting ✣ : Unstable Cutting

Honing :
E : Round

Shape		Order Number	Class	Honing	Coated MC7020	Coated MP7130	Coated MP9130	Cermet		Carbide		Dimensions (mm) IC	Dimensions (mm) S	Geometry
	Ground	**RPHT1040M0E4-L**	H	E	●	●	●					10	3.97	 
		RPHT**1040M0E4-M**	H	E	●	●	●					10	3.97	
		RPHT**1040M0E4-R**	H	E	●	●	●					10	3.97	
		RPHT**1248M0E4-L**	H	E	●	●	●					12	4.76	
		RPHT**1248M0E4-M**	H	E	●	●	●					12	4.76	
		RPHT**1248M0E4-R**	H	E	●	●	●					12	4.76	
	Sintered	**RPMT1040M0E4-L**	M	E	●	●	●					10	3.97	
		RPMT**1040M0E4-M**	M	E	●	●	●					10	3.97	
		RPMT**1040M0E4-R**	M	E	●	●	●					10	3.97	
		RPMT**1248M0E4-L**	M	E	●	●	●					12	4.76	
		RPMT**1248M0E4-M**	M	E	●	●	●					12	4.76	
		RPMT**1248M0E4-R**	M	E	●	●	●					12	4.76	

(Note) For the recomemded cutting conditions, refer to the B222A Tool News.

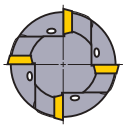
■ = MIRACLE SIGMA

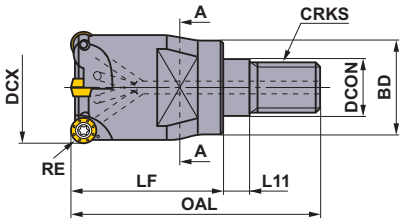
SCREW-IN TOOLS

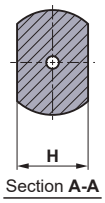
ARX

P M K N S H









METRIC Standard

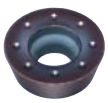
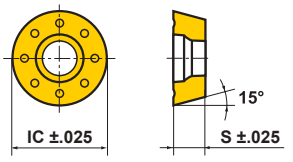
With Air / coolant through.

Right hand tool holder only.

DCX	Order Number	Stock	Number of Teeth	Dimensions (mm)								*3 WT	*1 Insert Screw	Insert Wrench	Insert
				RE	LF	OAL	DCON	BD	L11	H	*2 CRKS				
16	**ARX25R163M08A30**	★	3	2.5	30	48	8.5	14.7	6	10	M8	0.1	TPS20	TIP06F	RDMW0517
16	ARX**30R163M08A30**	★	3	3	30	48	8.5	14.6	6	10	M8	0.1	TPS22	TIP07FS	RDMW0620
17	ARX**25R173M08A30**	★	3	2.5	30	48	8.5	14.5	6	10	M8	0.1	TPS20	TIP06F	RDMW0517
17	ARX**30R173M08A30**	★	3	3	30	48	8.5	14.5	6	10	M8	0.1	TPS22	TIP07FS	RDMW0620
20	ARX**25R204M10A30**	★	4	2.5	30	49	10.5	18.6	6	14	M10	0.2	TPS20	TIP06F	RDMW0517
20	ARX**30R203M10A30**	★	3	3	30	49	10.5	18.5	6	14	M10	0.2	TPS22	TIP07FS	RDMW0620
22	ARX**25R224M10A30**	★	4	2.5	30	49	10.5	18.5	6	14	M10	0.2	TPS20	TIP06F	RDMW0517
22	ARX**30R224M10A30**	★	4	3	30	49	10.5	18.5	6	14	M10	0.2	TPS22	TIP07FS	RDMW0620
25	ARX**25R255M12A35**	★	5	2.5	35	57	12.5	23.6	6	19	M12	0.2	TPS20	TIP06F	RDMW0517
25	ARX**30R254M12A35**	★	4	3	35	57	12.5	23.4	6	19	M12	0.2	TPS22	TIP07FS	RDMW0620

*1 Clamp Torque (lbf-in) : TPS20=5.3, TPS22=5.3
*2 Clamp Torque of the Head (lbf-ft) : M8=17.1, M10=33.8, M12=59.2
*3 WT : Mass (kg)

INSERTS

Shape	Order Number	Coated VP15TF	Coated MP8010	Dimensions (mm) IC	S	Geometry
	**RDMW0517M0E**	★	★	5.0	1.70	
	RDMW**0620M0E**	★	★	6.0	1.99	
	RDMW**0724M0E**	★	★	7.0	2.38	

(Note) For the recomemded cutting conditions, refer to the general catalogue or B066A Tool News.

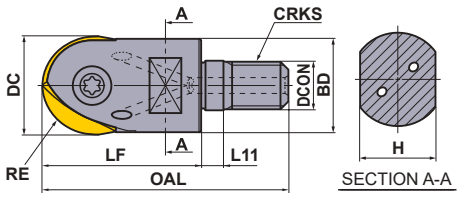
● : Inventory maintained. ★ : Inventory maintained in Japan.
<10 inserts in one case>

SCREW-IN TOOLS

SRF

P M K N S H





Ball nose and corner radius
With Air / coolant through.

Right hand tool holder only.

DC	Insert Type	Order Number	Stock	Number of Teeth	Dimensions (inch)								*1 WT
					RE	LF	OAL	DCON	BD	L11	H	CRKS	
.625	**SRFT0625**	**SRFHU10AM0830**	●	1	.3125	1.181	1.890	.335	.587	.236	.394	M8	.2
.750	**SRFT0750**	**SRFHU12AM1035**	●	1	.3750	1.378	2.126	.413	.724	.236	.551	M10	.2

*1 Ball nose type only
*2 WT : Mass (lbs)



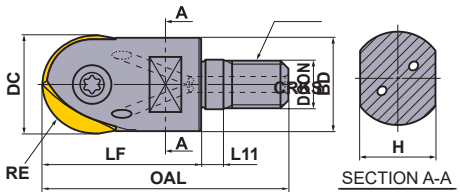
SPARE PARTS

Order Number	 *1 Insert Screw	 Insert Wrench	 Anti-seizure Lubricant
SRFHU10AM0830	RS4015T	TKY15T	MK1KS
SRF**HU12AM1035**	RS5020T	TKY20T	MK1KS

*1 Clamp Torque (lbf-in) : RS4015T=29, RS5020T=44,

● : Inventory maintained. ★ : Inventory maintained in Japan.
<2 inserts in one case>





METRIC Standard

Ball nose and corner radius type share the same respective holder
With Air/coolant though.

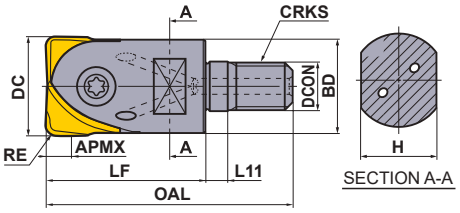
Right hand tool holder only.

DC	Insert Type	Order Number	Stock	Number of Teeth	Dimensions (mm)								*1 WT
					RE	LF	OAL	DCON	BD	L11	H	CRKS	
16	**SRFT16**	**SRFH16AM0830**	★	1	8	30	48	8.5	14.9	6	10	M8	0.1
20	SRF**T20**	SRF**H20AM1035**	★	1	10	35	54	10.5	18.4	6	14	M10	0.1
25	SRF**T25**	SRF**H25AM1240**	★	1	12.5	40	62	12.5	23.5	6	19	M12	0.1
30	SRF**T30**	SRF**H30AM1645**	★	1	15	45	68	17	28.1	6	24	M16	0.2
32	SRF**T32**	SRF**H30AM1645**	★	1	16	46	69	17	28.1	6	24	M16	0.2

*1 Ball nose type only

*2 WT : Mass (kg)





METRIC Standard

Ball nose and corner radius shared holder
The dimensions of the case of using corner radius insert
With Air/coolant though.

Right hand tool holder only.

DC	Insert Type	Order Number	Stock	Number of Teeth	Dimensions (mm)							*1 WT
					LF	OAL	DCON	BD	L11	H	CRKS	
16	**SUFT16R**	**SRFH16AM0830**	★	1	30	48	8.5	14.9	6	10	M8	0.1
20	**SUFT20R**	**SRFH20AM1035**	★	1	35	54	10.5	18.4	6	14	M10	0.1
25	**SUFT25R**	**SRFH25AM1240**	★	1	40	62	12.5	23.5	6	19	M12	0.1
30	**SUFT30R**	**SRFH30AM1645**	★	1	45	68	17	28.1	6	24	M16	0.2
32	**SUFT32R**	**SRFH30AM1645**	★	1	46	69	17	28.1	6	24	M16	0.2

*1 WT : Mass (kg)

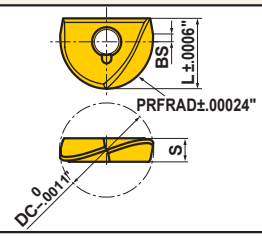
SPARE PARTS

Order Number	 *1 Insert Screw	 Insert Wrench	 Anti-seizure Lubricant
SRFHU10AM0830	RS4015T	TKY15T	MK1KS
SRFHU12AM1035	RS5020T	TKY20T	MK1KS
SRFH25AM1240	RS6025T	TKY25T	MK1KS
SRFH30AM1645	RS8030T	TKY30T	MK1KS

(Note 1) Fit inserts in the right direction. (Refer to the general catalogue or B065A Tool News)
(Note 2) Inch type insert can not be installed on the metric holder.
*1 Clamp Torque (lbf-in) : RS4015T=29, RS5020T=44, RS6025T=66, RS8030T=88

● : Inventory maintained. ★ : Inventory maintained in Japan.
<2 inserts in one case>

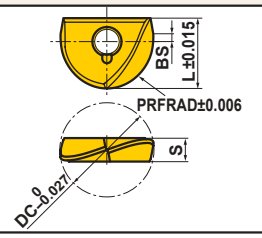
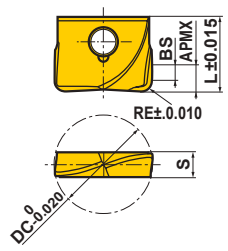
INSERTS

Shape	Order Number	Coated			Dimensions (inch)							Geometry
		MP8010	EP6120	VP15TF	DC	PRFRAD	RE	L	BS	S	APMX	
	SRFT0625	●	●	●	.625	.3125	—	.472	.039	.158	—	
	SRFT0750	●	●	●	.750	.3750	—	.591	.039	.197	—	
	SRFT1000	●	●	●	1.000	.5000	—	.728	.039	.236	—	
	SRFT1250	●	●	●	1.250	.6250	—	.925	.039	.276	—	

(Note) For the recomemded cutting conditions, refer to the general catalogue or B066A Tool News.

■ = MIRACLE SIGMA

METRIC Standard

Shape	Order Number	Coated			Dimensions (mm)							Geometry
		MP8010	EP6120	VP15TF	DC	PRFRAD	RE	L	BS	S	APMX	
	SRFT16	★	★	★	16	8 (.3150")	—	12	1	4	—	
	SRFT20	★	★	★	20	10 (.3937")	—	15	1	5	—	
	SRFT25	★	★	★	25	12.5 (.4921")	—	18.5	1	6	—	
	SRFT30	★	★	★	30	15 (.5906")	—	22.5	1	7	—	
	SRFT32	★	★	★	32	16 (.6299")	—	23.5	1	7	—	
	SUFT16R05	★		★	16	—	0.5 (.0197")	12	1.6	4	2.1	
	SUFT16R10	★		★	16	—	1 (.0394")	12	1.6	4	2.6	
	SUFT16R15	★		★	16	—	1.5 (.0591")	12	1.6	4	3.1	
	SUFT16R20	★		★	16	—	2 (.0787")	12	1.6	4	3.6	
	SUFT16R30	★		★	16	—	3 (.1181")	12	1.6	4	4.6	
	SUFT20R05	★		★	20	—	0.5 (.0197")	15	2	5	2.5	
	SUFT20R10	★		★	20	—	1 (.0394")	15	2	5	3	
	SUFT20R15	★		★	20	—	1.5 (.0591")	15	2	5	3.5	
	SUFT20R20	★		★	20	—	2 (.0787")	15	2	5	4	
	SUFT20R30	★		★	20	—	3 (.1181")	15	2	5	5	
	SUFT25R05	★		★	25	—	0.5 (.0197")	18.5	2.5	6	3	
	SUFT25R10	★		★	25	—	1 (.0394")	18.5	2.5	6	3.5	
	SUFT25R20	★		★	25	—	2 (.0787")	18.5	2.5	6	4.5	
	SUFT25R30	★		★	25	—	3 (.1181")	18.5	2.5	6	5.5	
	SUFT30R05	★		★	30	—	0.5 (.0197")	22.5	3	7	3.5	
	SUFT30R10	★		★	30	—	1 (.0394")	22.5	3	7	4	
	SUFT30R20	★		★	30	—	2 (.0787")	22.5	3	7	5	
	SUFT30R30	★		★	30	—	3 (.1181")	22.5	3	7	6	
	SUFT32R05	★		★	32	—	0.5 (.0197")	23.5	3.2	7	3.7	
	SUFT32R10	★		★	32	—	1 (.0394")	23.5	3.2	7	4.2	
	SUFT32R20	★		★	32	—	2 (.0787")	23.5	3.2	7	5.2	

(Note) For the recomemded cutting conditions, refer to the general catalogue or B066A Tool News.

■ = MIRACLE SIGMA

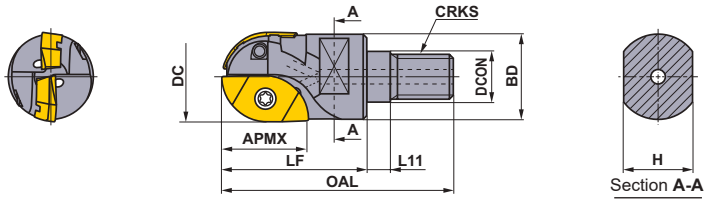
SCREW-IN TOOLS

SRM2

P M K N S H

● Standard Type





With Air / coolant through.

Right hand tool holder only.

DC	Order Number	Stock	Dimensions (inch)								WT *2
			RE	LF	OAL	DCON	BD	L11	H	CRKS*1	
.750	**SRM212AM10S35**	●	.375	1.378	2.126	.413	.701	.236	.551	M10	.2
1.000	**SRM216AM12S40**	●	.500	1.575	2.441	.492	.933	.236	.748	M12	.4
1.250	**SRM220AM16S45**	●	.625	1.772	2.677	.669	1.169	.236	.945	M16	.4

*1 Clamp Torque of the Head (lbf-ft) : M10=33.8, M12=59.2, M16=66.7
*2 WT : Mass (lbs)

SPARE PARTS

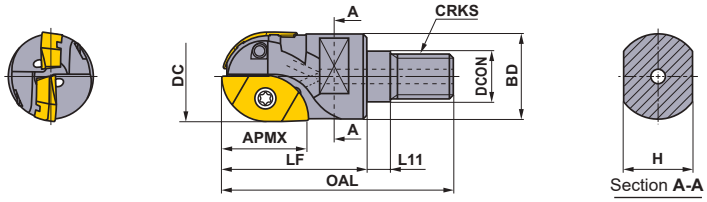
DC	Order Number	Stock	 *1 Insert Screw Inner,Outer	 *1 Insert Screw Peripheral	 Insert Wrench	 Insert Wrench	 Insert Inner	 Insert Outer	 Insert Peripheral
.750	**SRM212AM10S35**	●	TS32	—	①TKY08D	—	SRM212C	SRM212E	—
1.000	**SRM216AM12S40**	●	TS43	TS25	②TKY15T	—	SRM216C	SRM216E	—
1.250	**SRM220AM16S45**	●	TS55	TS43	②TKY25T	TKY15F	SRM220C	SRM216E	—

*1 Clamp Torque (lbf-in) : TS32=8.9, TS43=31, TS55=66

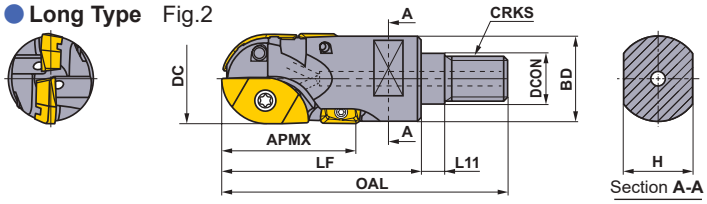
● : Inventory maintained. ★ : Inventory maintained in Japan.
<10 inserts in one case>



● **Standard Type** Fig.1



● **Long Type** Fig.2



METRIC Standard

With Air / coolant through.

Right hand tool holder only.

DC	Order Number	Stock	Dimensions (mm)								WT *2	Type (Fig.)
			RE	LF	OAL	DCON	BD	L11	H	CRKS*1		
16	**SRM2160AM08S30**	★	8	30	48	8.5	14.6	6	10	M8	0.1	1
20	**SRM2200AM10L45**	★	10	45	64	10.5	18.6	6	14	M10	0.2	2
20	**SRM2200AM10S35**	★	10	35	54	10.5	18.6	6	14	M10	0.1	1
25	**SRM2250AM12L55**	★	12.5	55	77	12.5	23.5	6	19	M12	0.3	2
25	**SRM2250AM12S40**	★	12.5	40	62	12.5	23.5	6	19	M12	0.2	1
30	**SRM2300AM16L60**	★	15	60	83	17	28.3	6	24	M16	0.3	2
30	**SRM2300AM16S45**	★	15	45	68	17	28.3	6	24	M16	0.2	1
32	**SRM2320AM16L60**	★	16	60	83	17	29	6	24	M16	0.3	2
32	**SRM2320AM16S45**	★	16	45	68	17	30	6	24	M16	0.2	1

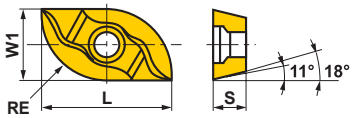
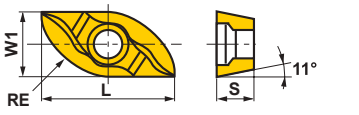
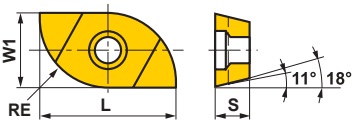
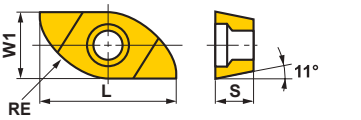
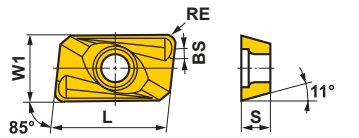
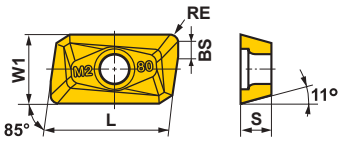
*1 Clamp Torque of the Head (lbf-ft) : M8=17.1, M10=33.8, M12=59.2, M16=66.7
*2 WT : Mass (kg)

SPARE PARTS

DC	Order Number	Stock	 *1	 *1					
			Insert Screw Inner,Outer	Insert Screw Peripheral	Insert Wrench	Insert Wrench	Insert Inner	Insert Outer	Insert Peripheral
16	**SRM2160AM08S30**	★	TS25H	—	TKY08D	—	SR○16C	SR○16E	—
20	**SRM2200AM10L45**	★	TS32	TS25	TKY08D	—	SR○20C	SR○20E	APMT1135
20	**SRM2200AM10S35**	★	TS32	—	TKY08D	—	SR○20C	SR○20E	—
25	**SRM2250AM12L55**	★	TS43	TS25	TKY15T	TKY08F	SR○25C	SR○25E	APMT1135
25	**SRM2250AM12S40**	★	TS43	TS25	TKY15T	—	SR○25C	SR○25E	—
30	**SRM2300AM16L60**	★	TS55	TS43	TKY25T	TKY15F	SR○30C	SR○30E	APMT1604
30	**SRM2300AM16S45**	★	TS55	—	TKY15T	TKY08F	SR○30C	SR○30E	—
32	**SRM2320AM16L60**	★	TS55	TS43	TKY25T	TKY15F	SR○32C	SR○32E	APMT1604
32	**SRM2320AM16S45**	★	TS55	TS43	TKY25T	TKY15F	SR○32C	SR○32E	—

*1 Clamp Torque (lbf-in) : TS25H=8.9, TS25=8.9, TS32=8.9, TS43=31, TS55=66

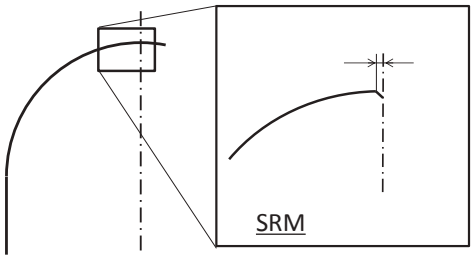
INSERTS

Type	Shape	Order Number	Class	Coated			Dimensions (inch)					Geometry
				MP6120	MP9120	VP15TF	RE	L	W1	S	BS	
Inner		**SRM210C-M**	M	●	●	●	.313	.630	.323	.138	—	
		SRM**212C-M**	M	●	●	●	.375	.748	.385	.169	—	
		SRM**216C-M**	M	●	●	●	.500	.945	.512	.216	—	
		SRM**220C-M**	M	●	●	●	.625	1.102	.638	.275	—	
Outer		**SRM210E-M**	M	●	●	●	.313	.531	.258	.138	—	
		SRM**212E-M**	M	●	●	●	.375	.610	.315	.169	—	
		SRM**216E-M**	M	●	●	●	.500	.807	.409	.216	—	
		SRM**220E-M**	M	●	●	●	.625	.964	.520	.275	—	
Inner	Strong Cutting Edge Type 	**SRM212C**	M	●	●	●	.375	.748	.385	.169	—	
		SRM**216C**	M	●	●	●	.500	.945	.512	.216	—	
		SRM**220C**	M	●	●	●	.625	1.102	.638	.275	—	
Outer	Strong Cutting Edge Type 	**SRM212E**	M	●	●	●	.375	.610	.315	.169	—	
		SRM**216E**	M	●	●	●	.500	.807	.409	.216	—	
		SRM**220E**	M	●	●	●	.625	.964	.520	.275	—	
Peripheral	Strong Cutting Edge Type 	**APMT1135PDER-H2**	M			●	.031	.433	.250	.138	.047	
		APMT**1604PDER-H2**	M			●	.031	.650	.375	.187	.055	
	Low Resistance Type 	**APMT1135PDER-M2**	M			●	.031	.433	.250	.138	.047	
		APMT**1604PDER-M2**	M			●	.031	.650	.375	.187	.055	

(Note) The **M** type breaker (APMT....PDER-M2) is the first recommendation for its excellent cutting performance.
Please use **H** type breakers (APMT....PDER-H2) due to cutting edge strength.

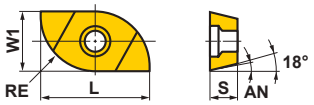
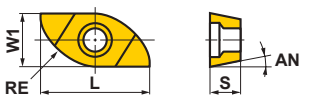
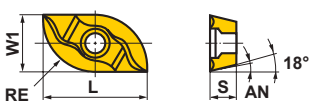
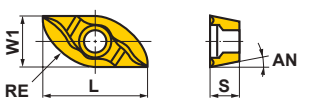
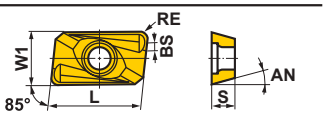
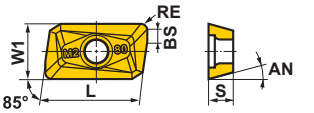
■ = MIRACLE SIGMA

(Note) SRM tooling is designed for rough machining applications. *Programming Note: If you choose to use SRM tooling for semi-finishing applications, care must be taken when setting the tool height. The SRM insert includes a chamfer flat at the tip as illustrated. To assist with SRM programming needs, please download our CAD data from our web site; http://www.mitsubishicarbide.com/



● : Inventory maintained. ★ : Inventory maintained in Japan.
<10 inserts in one case>

METRIC Standard

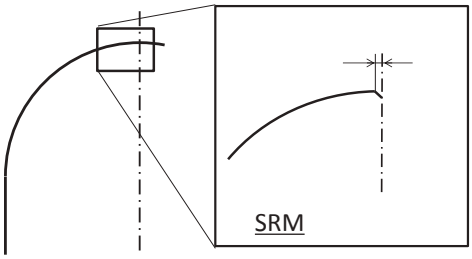
Type	Shape	Order Number	Class	Coated				Dimensions (mm)						Geometry
				F7030	MP6120	MP9120	VP15TF	RE	L	W1	S	BS	AN	
Inner	Strong Cutting Edge Type 	SRG16C	G		★	★	★	8	16	8.2	3.5	–	11°	
		SRG20C	G		★	★	★	10	19	10.2	4.6	–	10°	
		SRG25C	G		★	★	★	12.5	24	12.8	5.5	–	10°	
		SRG30C	G		★	★	★	15	28	15.3	7	–	10°	
		SRG32C	G		★	★	★	16	28	16.3	7	–	10°	
Outer	Strong Cutting Edge Type 	SRG16E	G		★	★	★	8	13.5	6.7	3.5	–	11°	
		SRG20E	G		★	★	★	10	15.5	8.5	4.6	–	9°	
		SRG25E	G		★	★	★	12.5	20.5	10.2	5.5	–	9°	
		SRG30E	G		★	★	★	15	25.2	12.2	7	–	9°	
		SRG32E	G		★	★	★	16	26.1	13.1	7	–	9°	
Inner	Low Resistance Type 	SRM16C-M	M		★	★	★	8	16	8.2	3.5	–	11°	
		SRM20C-M	M		★	★	★	10	19	10.2	4.6	–	10°	
		SRM25C-M	M		★	★	★	12.5	24	12.8	5.5	–	10°	
		SRM30C-M	M		★	★	★	15	28	15.3	7	–	10°	
		SRM32C-M	M		★	★	★	16	28	16.3	7	–	10°	
Outer	Low Resistance Type 	SRM16E-M	M		★	★	★	8	13.5	6.7	3.5	–	11°	
		SRM20E-M	M		★	★	★	10	15.5	8.5	4.6	–	9°	
		SRM25E-M	M		★	★	★	12.5	20.5	10.2	5.5	–	9°	
		SRM30E-M	M		★	★	★	15	25.2	12.2	7	–	9°	
		SRM32E-M	M		★	★	★	16	26.1	13.1	7	–	9°	
* Peripheral	Strong Cutting Edge Type 	APMT1135PDER-H2	M	●			●	0.8	11	6.35	3.5	1.2	11°	
		APMT1604PDER-H2	M	●			●	0.8	16.5	9.525	4.76	1.4	11°	
	Low Resistance Type 	APMT1135PDER-M2	M	●			●	0.8	11	6.35	3.5	1.2	11°	
		APMT1604PDER-M2	M	●			●	0.8	16.5	9.525	4.76	1.4	11°	

(Low-resistance inner or outer inserts are precision M class type.)

= MIRACLE SIGMA

* Selection guide for peripheral cutting edges : The first recommendation is the super sharp M breaker (APMT....PDER-M2).
When cutting edge strength is particularly important, use the H breaker (APMT....PDER-H2).

(Note) SRM tooling is designed for rough machining applications.
*Programming Note: If you choose to use SRM tooling for semi-finishing applications, care must be taken when setting the tool height. The SRM insert includes a chamfer flat at the tip as illustrated. To assist with SRM programming needs, please download our CAD data from our web site; http://www.mitsubishicarbide.com/

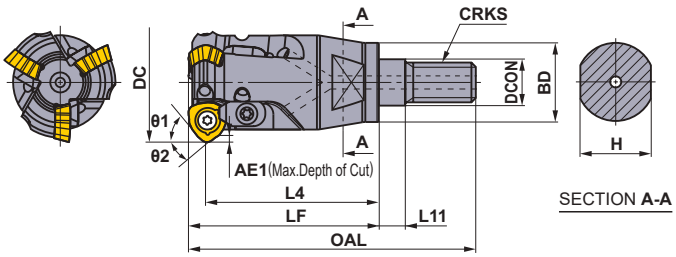


SCREW-IN TOOLS

PMC

P | M | K | N | S | H





METRIC Standard

With Air / coolant through.

Right hand tool holder only.

DC	Order Number	Stock	Number of Teeth	Dimensions (mm)							WT *2	θ1	θ2
				LF	OAL	DCON	BD	L11	H	CRKS*1			
25	PMC08R252AM1035	★	2	39.7	58.7	10.5	18	6	14	M10	0.1	40.5°	35°
32	PMC09R323AM1245	★	3	50.5	72.5	12.5	21	6	19	M12	0.2	40.5°	35°
40	PMC12R403AM1645	★	3	51.4	74.4	17	29	6	24	M16	0.3	42°	35°

*1 Clamp Torque of the Head(lbf-ft) : M10=33.8, M12=59.2, M16=66.7
*2 WT : Mass (kg)

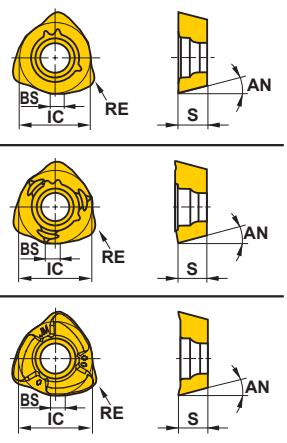
SPARE PARTS

DC	Order Number	Stock	Insert Screw *	Insert Wench	Clamp Bridge	Clamp Bridge Screw *	Clamp Wrench	Anti-seizure Lubricant	Spring	Insert
25	PMC08R252AM1035	★	AJS3010T10	①TKY08D	AMS3	TS33	TKY10R	MK1KS	ASS2	JOM□08
32	PMC09R323AM1245	★	AJS3010T10	②TKY10D	AMS3	TS351	TKY10D	MK1KS	ASS2	JOM□09
40	PMC12R403AM1645	★	AJS4012T15	②TKY15D	AMS4	TS43	TKY15D	MK1KS	ASS2	JOM□12

* Clamp Torque (lbf-in) : TS33=8.9, TS351=22, TS43=31, AJS3010T10=22, AJS4012T15=31

INSERTS

Shape	Order Number	Class	Coated			Dimensions (mm)					PMC holder	Geometry
			FH7020	VP15TF	VP30RT	AN	IC	S	BS	RE		
FT Breaker	JOMW080320ZZSR-FT	M	●	●	●	13°	8	3.18	1.4	2	PMC08R252AM1035	
	JDMW09T320ZDSR-FT	M	●	●	●	15°	9.525	3.97	1.8	2	PMC09R323AM1245	
	JDMW120420ZDSR-FT	M	●	●	●	15°	12	4.76	2.5	2	PMC12R403AM1645	
ST Breaker	JDMT120420ZDSR-ST	M	●	●	●	15°	12	4.76	2.5	2	PMC12R403AM1645	
JM Breaker	JOMT080320ZZSR-JM	M	●	●	●	13°	8	3.18	1.4	2	PMC08R252AM1035	
	JDMT09T320ZDSR-JM	M	●	●	●	15°	9.525	3.97	1.8	2	PMC09R323AM1245	
	JDMT120420ZDSR-JM	M	●	●	●	15°	12	4.76	2.5	2	PMC12R403AM1645	

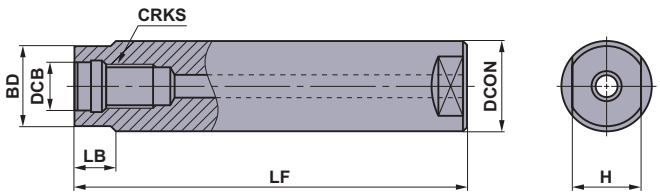


● : Inventory maintained. ★ : Inventory maintained in Japan.

SCREW-IN ARBORS

STRAIGHT SHANK ARBOR





STEEL SHANK TYPE

CRKS	Order Number	Stock	Dimensions (inch)						WT *1
			DCON	LF	DCB	BD	LB	H	
M8	**SCU10M08S100S**	●	.625	3.937	.335	.571	.394	.394	.2
M8	**SCU10M08S200L**	●	.625	7.874	.335	.571	.394	.394	.7
M10	**SCU12M10S120S**	●	.750	4.724	.413	.728	.394	.551	.4
M10	**SCU12M10S220L**	●	.750	8.661	.413	.728	.394	.551	.9
M12	**SCU16M12S125S**	●	1.000	4.921	.492	.925	.394	.748	.9
M12	**SCU16M12S245L**	●	1.000	9.646	.492	.925	.394	.748	2.0
M16	**SCU20M16S140S**	●	1.250	5.512	.669	1.122	.591	.945	1.8
M16	**SCU20M16S280L**	●	1.250	11.024	.669	1.122	.591	.945	3.5

*1 WT : Mass (lbs)

METRIC Standard

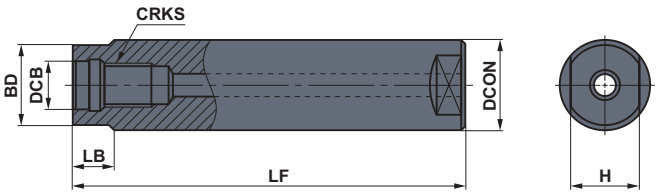
CRKS	Order Number	Stock	Dimensions (mm)						WT *1
			DCON	LF	DCB	BD	LB	H	
M8	**SC16M08S100S**	★	16	100	8.5	14.5	10	10	0.1
M8	**SC16M08S200L**	★	16	200	8.5	14.5	10	10	0.3
M10	**SC20M10S120S**	★	20	120	10.5	18.5	10	14	0.3
M10	**SC20M10S220L**	★	20	220	10.5	18.5	10	14	0.5
M12	**SC25M12S125S**	★	25	125	12.5	23.5	10	19	0.4
M12	**SC25M12S245L**	★	25	245	12.5	23.5	10	19	0.8
M16	**SC32M16S140S**	★	32	140	17	28.5	15	24	0.8
M16	**SC32M16S280L**	★	32	280	17	28.5	15	24	1.6

*1 WT : Mass (kg)

SCREW-IN ARBORS

STRAIGHT SHANK ARBOR





CARBIDE SHANK TYPE

CRKS	Order Number	Stock	Dimensions (inch)						WT *1
			DCON	LF	DCB	BD	LB	H	
M8	**SCU10M08S100SW**	●	.625	3.937	.335	.571	.394	.394	.4
M8	**SCU10M08S200LW**	●	.625	7.874	.335	.571	.394	.394	1.1
M10	**SCU12M10S120SW**	●	.750	4.724	.413	.728	.394	.551	.9
M10	**SCU12M10S220LW**	●	.750	8.661	.413	.728	.394	.551	1.8
M12	**SCU16M12S125SW**	●	1.000	4.921	.492	.925	.394	.748	1.8
M12	**SCU16M12S245LW**	●	1.000	9.646	.492	.925	.394	.748	3.5
M16	**SCU20M16S140SW**	●	1.250	5.512	.669	1.122	.591	.945	3.1
M16	**SCU20M16S280LW**	●	1.250	11.024	1.250	1.122	.591	.945	6.4

*1 WT : Mass (lbs)

METRIC Standard

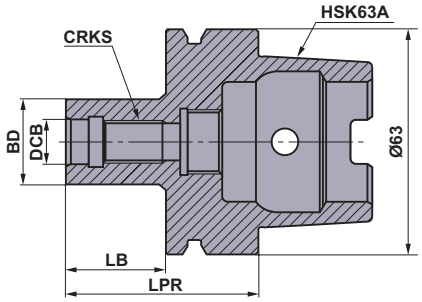
CRKS	Order Number	Stock	Dimensions (mm)						WT *1
			DCON	LF	DCB	BD	LB	H	
M8	**SC16M08S100SW**	★	16	100	8.5	14.5	10	10	0.2
M8	**SC16M08S200LW**	★	16	200	8.5	14.5	10	10	0.5
M10	**SC20M10S120SW**	★	20	120	10.5	18.5	10	14	0.5
M10	**SC20M10S220LW**	★	20	220	10.5	18.5	10	14	0.9
M12	**SC25M12S125SW**	★	25	125	12.5	23.5	10	19	0.8
M12	**SC25M12S245LW**	★	25	245	12.5	23.5	10	19	1.5
M16	**SC32M16S140SW**	★	32	140	17	28.5	15	24	1.4
M16	**SC32M16S280LW**	★	32	280	17	28.5	15	24	2.8

*1 WT : Mass (kg)

● : Inventory maintained. ★ : Inventory maintained in Japan.

HSK63A SHANK ARBOR





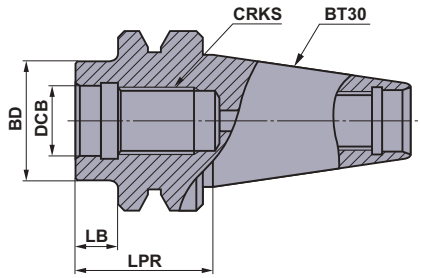
METRIC Standard

CRKS	Order Number	Stock	Dimensions (mm)				WT *1
			DCB	BD	LPR	LB	
M8	**SC16M08S22-HSK63A**	★	8.5	14.5	48	22	0.7
M10	**SC20M10S24-HSK63A**	★	10.5	18.5	50	24	0.7
M12	**SC25M12S27-HSK63A**	★	12.5	23.5	53	27	0.7
M16	**SC32M16S28-HSK63A**	★	17	28.5	54	28	0.8

*1 WT : Mass (kg)

BT30 SHANK ARBOR





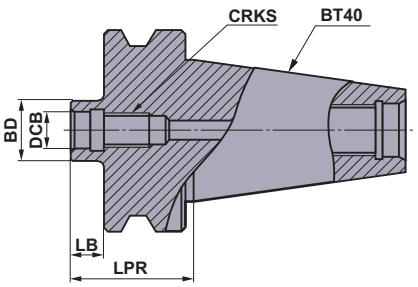
METRIC Standard

CRKS	Order Number	Stock	Dimensions (mm)				WT *1
			DCB	BD	LPR	LB	
M8	**SC16M08S10-BT30**	★	8.5	14.5	32	10	0.4
M10	**SC20M10S10-BT30**	★	10.5	18.5	32	10	0.4
M12	**SC25M12S10-BT30**	★	12.5	23.5	32	10	0.4
M16	**SC32M16S10-BT30**	★	17	28.5	32	10	0.4

*1 WT : Mass (kg)

BT40 SHANK ARBOR





METRIC Standard

CRKS	Order Number	Stock	Dimensions (mm)				WT *1
			DCB	BD	LPR	LB	
M8	**SC16M08S10-BT40**	★	8.5	14.5	37	10	1
M10	**SC20M10S10-BT40**	★	10.5	18.5	37	10	1
M12	**SC25M12S10-BT40**	★	12.5	23.5	37	10	1
M16	**SC32M16S10-BT40**	★	17	28.5	37	10	1

*1 WT : Mass (kg)

HOW TO INSTALL THE SCREW-IN HEAD

①Thoroughly clean the clamp section of the head and the arbor with an air blower or brush before installation.

②Tighten the head at the recommended torque and ensure that there is no gap between the head and arbor.



Screw Size	Recommended Torque (lbf-ft)	Wrench Size	
		(inch)	(mm)
M8	17.1	.394	10
M10	33.8	.551	14
M12	59.2	.748	19
M16	66.7	.945	24

- Cutting tools become extremely hot during cutting. Never touch them with bare hands after operation as this may produce risk of injuries or burns.
- Do not handle the cutting tools with bare hands as this may cause injuries.

Memo

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FOR YOUR SAFETY

- Don't handle inserts and chips without gloves.
- Please machine within the recommended application range and exchange expired tools with new ones in advance of breakage.
- Please use safety covers and wear safety glasses.
- When using compounded cutting oils, please take fire precautions.
- When attaching inserts or spare parts, please use only the correct wrench or driver.
- When using rotating tools, please make a trial run to check run-out, vibration and abnormal sounds etc.

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Tools specifications subject to change without notice.

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