

Ultra High Feed Chamfer Mill

C-CUTTER mini

Indexable Inserts

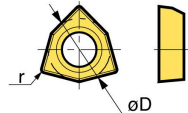


Fig. 1

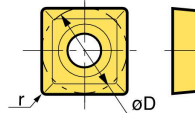


Fig. 2

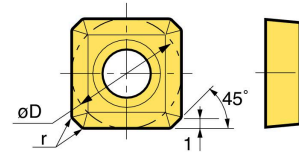
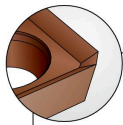


Fig. 3

The suffix **SE** designates a sharp cutting edge version.

Fig.	Insert Model	øD	Nose R	P	M	K	N	Insert Clamping Screw Set
				ACP300	ACP200	DS20		
1	CM0402	3.97	0.2	○	—	—	—	S2SS-T6
2	CM0502	5	0.2	—	○	○	—	S2TS-T6
	CM0502SE			○	○	—		
3	CM10C1	10	0.2	—	○	○	—	S4S-T15
	CM10C1SE			—	○	—		

1. Inserts are available in packet of 10pcs. Please specify model number and grade. (ie: CM0502-ACP200)
2. It is recommended to regularly replace clamping screws and wrench to ensure the correct clamping force is maintained.



Sharp cutting edge insert

Sharp cutting edge minimises the generation of burrs. This is especially beneficial when cutting stainless and mild steel materials.

Anti-seizure Lubricant



5g contained

Model **BN-5**

Recommended cutting condition

A (Standard conditions)

Work Material	Insert Grade	Cutting Speed Vc (m/min)	Feed rate f (mm/tooth)		Coolant
			Chamfering	Face Milling (CM10 insert only)	
General steel, Alloy steel, High-alloy steel	ACP200	100 – 350	0.05 – 0.4	0.05 – 0.2	Dry
Prehardened steel (Less than HRC40)		60 – 100	0.05 – 0.1	0.05 – 0.1	Wet
Stainless steel	ACP300	100 – 250	0.08 – 0.3	0.08 – 0.2	Dry/Wet
Cast iron	DS20, ACP300	100 – 350	0.1 – 0.5	0.05 – 0.25	Dry
Aluminum, Non-ferrous		100 – 800	0.1 – 0.5	0.05 – 0.3	Dry/Wet

1. The table is just a reference to determine cutting conditions. It should be adjusted according to the condition of the machine tool and workpiece.
2. Wet cutting is recommended to obtain the good surface quality.
3. In case built-up edge occurs when cutting aluminum and stainless steel, use soluble oil.

B (For long models of "bolt hole & starting hole for tapping type".)

Work Material	Insert Grade	Cutting Speed Vc (m/min)	Feed rate f (mm/tooth)	Coolant
General steel, Alloy steel, High-alloy steel	ACP200	20 – 100	0.03 – 0.12	Wet
Cast iron		50 – 160	0.05 – 0.20	Dry
Aluminum, Non-ferrous	ACP300	30 – 100	0.03 – 0.12	Wet

1. The table is just a reference to determine cutting conditions. It should be adjusted according to the condition of the machine tool and workpiece.
2. For stainless steel and hardened steel, shorter models are recommended.