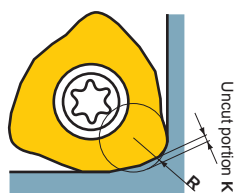


	$\phi 30 - 35$			$\phi 40$ ($\phi 32$ Shank)			$\phi 40$ ($\phi 42$ Shank)			$\phi 50/\phi 63$ (Shank type)			$\phi 50/\phi 63$ (Arbor type)			$\phi 80 - 160$ (Arbor type)		
	Over-hang (mm)	Axial Depth of Cut (mm)	Feed per Tooth (mm/tooth)	Over-hang (mm)	Axial Depth of Cut (mm)	Feed per Tooth (mm/tooth)	Over-hang (mm)	Axial Depth of Cut (mm)	Feed per Tooth (mm/tooth)	Over-hang (mm)	Axial Depth of Cut (mm)	Feed per Tooth (mm/tooth)	Over-hang (mm)	Axial Depth of Cut (mm)	Feed per Tooth (mm/tooth)	Over-hang (mm)	Axial Depth of Cut (mm)	Feed per Tooth (mm/tooth)
	180	1.2	1.2	180	1.2	1.2	180	1.2	1.3	180	1.4	1.3	150	1.5	1.3	170	1.5	1.3
	230	1.0	1.0	240	1.0	1.0	240	1.0	1.1	240	1.2	1.1	250	1.3	1.1	300	1.3	1.1
	290	0.8	0.8	300	0.8	0.8	300	0.8	0.9	—	—	—	350	1.1	0.9	450	1.0	0.8
	180	1.2	1.2	180	1.2	1.2	180	1.2	1.3	180	1.4	1.3	150	1.5	1.3	170	1.5	1.3
	230	1.0	1.0	240	1.0	1.0	240	1.0	1.1	240	1.2	1.1	250	1.3	1.1	300	1.3	1.1
	290	0.8	0.8	300	0.8	0.8	300	0.8	0.9	—	—	—	350	1.1	0.9	450	1.0	0.8
	180	1.2	1.6	180	1.2	1.6	180	1.2	1.7	180	1.4	1.7	150	1.5	1.7	170	1.5	1.7
	230	1.0	1.4	240	1.0	1.4	240	1.0	1.5	240	1.2	1.5	250	1.3	1.5	300	1.3	1.5
	290	0.8	1.2	300	0.8	1.2	300	0.8	1.3	—	—	—	350	1.1	1.3	450	1.0	1.2
	180	1.0	1.4	180	1.0	1.4	180	1.0	1.5	180	1.2	1.5	150	1.3	1.5	170	1.3	1.5
	230	0.8	1.2	240	0.8	1.2	240	0.8	1.3	240	1.0	1.3	250	1.1	1.3	300	1.1	1.3
	290	0.6	1.0	300	0.6	1.0	300	0.6	1.1	—	—	—	350	0.9	1.1	450	0.8	1.0
	180	0.6	1.0	180	0.6	1.0	180	0.6	1.1	180	0.8	1.1	150	0.9	1.1	170	0.9	1.1
	230	0.5	0.8	240	0.5	0.8	240	0.5	0.9	240	0.6	0.9	250	0.7	0.9	300	0.7	0.9
	290	0.4	0.6	300	0.4	0.6	300	0.4	0.7	—	—	—	—	—	—	—	—	—

NOTE FOR PROGRAMMING

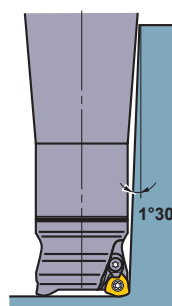


When using **AJX**, please programme as an R3 radius cutter. The approximate uncut portions for the programme are as follows.

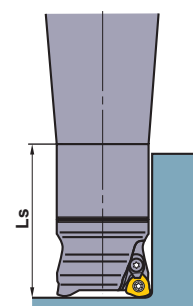
Insert	Approx. R(mm)	Uncut portion K(mm)
JOM06T215ZZSR-00	2.0	0.33
JOM080320ZZSR-00	2.5	0.46
JDM09T320ZDSR-00	3.0	0.47
JDM120420ZDSR-00	3.0	0.63
JDM140520ZDSR-00	3.0	0.64

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

EFFECTIVE USE



The tapered body of the special arbor for the **AJX** enables machining without touching a finished wall with a 1°30' draft angle.



Vertical wall machining is possible within the range of L_s .