

ROTATING TOOLS

MAXIMUM ALLOWABLE REVOLUTIONS FOR CUTTERS

Diameter (mm)	ASX445		AHX640W		ASX400		AXD4000		AXD7000	
	Max. Allowable Revolution (min ⁻¹)	Clamp Torque (N • m)	Max. Allowable Revolution (min ⁻¹)	Clamp Torque (N • m)	Max. Allowable Revolution (min ⁻¹)	Clamp Torque (N • m)	Max. Allowable Revolution (min ⁻¹)	Clamp Torque (N • m)	Max. Allowable Revolution (min ⁻¹)	Clamp Torque (N • m)
25	—	—	—	—	—	—	49000	1.5	—	—
32	—	—	—	—	—	—	48000	1.5	41000	3.5
40	—	—	—	—	—	—	41000	1.5	36000	3.5
50	18000	3.5	—	—	18000	3.5	35000	1.5	30000	3.5
63	16000	3.5	—	—	16000	3.5	30000	1.5	25000	3.5
80	14000	3.5	8900	6	14000	3.5	27000	1.5	23000	3.5
100	13000	3.5	7800	6	13000	3.5	23000	1.5	19000	3.5
125	12000	3.5	6600	6	12000	3.5	20000	1.5	16000	3.5
160	10000	3.5	5300	6	10000	3.5	—	—	—	—
200	9000	3.5	4100	6	9000	3.5	—	—	—	—
250	8000	3.5	2900	6	8000	3.5	—	—	—	—
315	6500	3.5	1700	6	—	—	—	—	—	—

Diameter (mm)	SG20	
	Max. Allowable Revolution (min ⁻¹)	Clamp Torque (N • m)
20	—	—
25	—	—
32	—	—
35	—	—
40	—	—
50	—	—
63	—	—
80	8200	8
100	7000	8
125	6100	8
160	5300	8

(Note) All values shown on this chart are based on the insert being properly seated in the pocket and the screws clamped to the recommended torque values.