

FACE MILLING

<CUTTING FOR DIFFICULT-TO-CUT MATERIALS>



Finishing



Roughing



SG20

Light Alloy	Cast Iron	Carbon Steel Alloy Steel	Stainless Steel	Hardened Steel

Fig.1
ø80
ø100

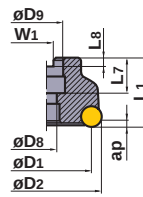


Fig.2
ø125

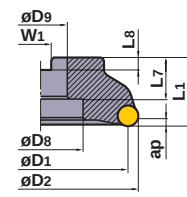
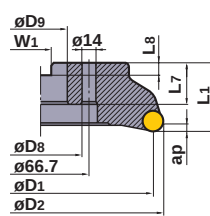


Fig.3
ø160



- 30° positive insert.
- High rake angle.
- Round shape insert with a strong cutting edge.
- Suitable for difficult-to-cut materials.

A.R: +24° T: +23° (CH=45°)
R.R: +9°

Right hand tool holder only.

Order Number	Stock	Number of Teeth	Dimensions (mm)								Mass (kg)	Max. Depth of Cut (mm)	Type (Fig.)
	R		D1	D2	L1	D9	L7	D8	W1	L8			
SG20-080A04R	●	4	80	101.2	50	27	22	13.5	12.4	7	1.5	8	1
-100A05R	●	5	100	121.4	50	32	25	17.5	14.4	8	2.9	8	1
-125B06R	●	6	125	146.4	63	40	32	56	16.4	9	3.8	8	2
-160C08R	●	8	160	181.4	63	40	28	56	16.4	9	6.1	8	3

INSERTS

Order Number	Class	Coated		Carbide		Geometry
		F7030	VP15TF	UP20M	UTi20T	
RGEN2004M0EN	E	★				
2004M0SN	E	●	●	●	●	

RECOMMENDED CUTTING CONDITIONS

Work Material	Hardness	Grade	Cutting Speed (m/min)	Feed per Tooth (mm/tooth)	Max. Depth of Cut (mm)
P Carbon Steel Alloy Steel	≤180HB	F7030 NX2525	300 (200—360)	0.35 (0.2—0.5)	4.5
		UTi20T	240 (170—290)	0.25 (0.2—0.3)	4.5
	280—350HB	UTi20T	140 (100—170)	0.15 (0.1—0.2)	4.5
M Stainless Steel	≤200HB	UTi20T	200 (140—240)	0.2 (0.1—0.3)	3
K Cast Iron	Tensile Strength ≤350MPa	HTi10	200 (140—240)	0.4 (0.3—0.5)	4.5
H Hardened Steel	40—60HRC	UTi20T	80 (50—100)	0.2 (0.1—0.3)	2

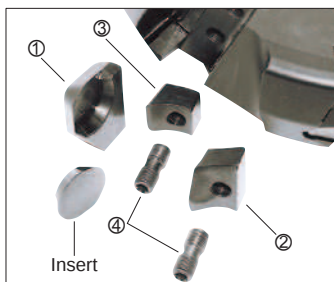
● Revolution (min⁻¹)=(1000×Cutting Speed)÷(3.14×øD1)

● Table Feed (mm/min)=Feed per Tooth×Number of Teeth×Cutter Revolution

SPARE PARTS

Tool Holder Number	①	②	③	④	*
	Locator	Wedge-T	Wedge-S	Clamp Screw	Wrench
SG20 Type	SPSG20R	CWSG20TR	CWSG20SN	LS15T	TKY25T

* Clamp Torque (N • m) : LS15T=8.5



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

SPARE PARTS > M001
TECHNICAL DATA > N001

K021