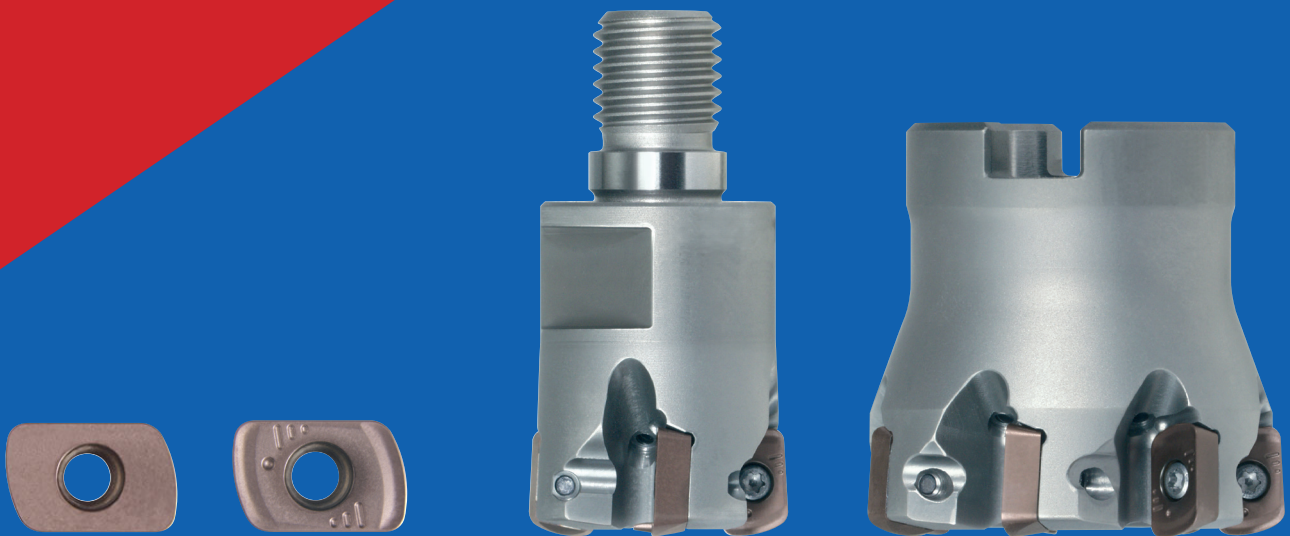


Turbo Metric Series

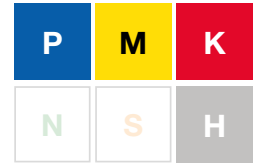
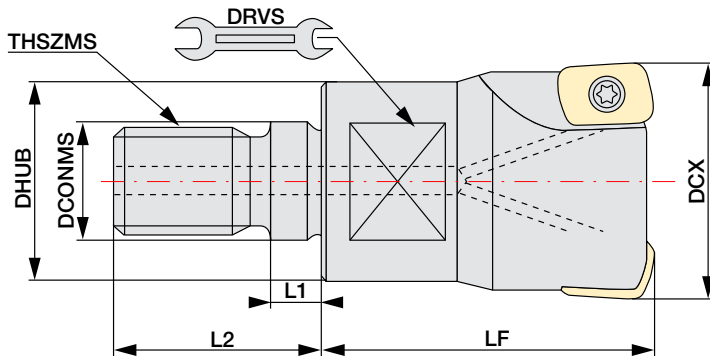
# ***ASR PICO MAXI***

**High Feed Cutting (HFC) & High Hardness Cutting (HHC)**



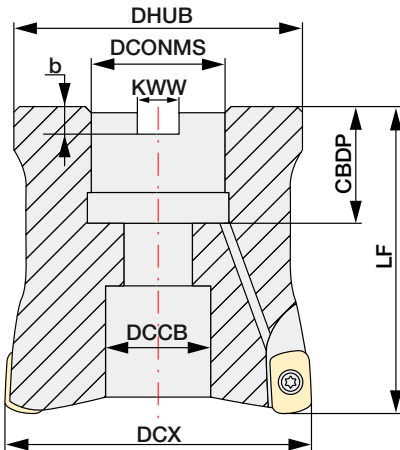
**MOLDINO Tool Engineering Europe GmbH**

## ASR Pico Maxi Line-Up



Diameter Holder only	CAM Radius	Fastening Torque
-0.1 / -0.2 mm	3 mm	2.0 Nm

ID Code	Item Code	NOF	Size (mm)							THSZMS	Inner Cooling	Inserts
			DCX	LF	DCONMS	DHUB	L1	L2	DRVS			
FH180	ASRM-3020R-2-M10	2	20	30	10.5	18	5.5	19	15	M10	Yes	EPNW08T3TN-10 EPMT08T3TN-10
FH181	ASRM-3025R-3-M12	3	25	35	12.5	21	5.5	22	17	M12	Yes	
FH173	ASRM-3032R-4-M16	4	32	40	17	29	6	23	22	M16	Yes	
FH174	ASRM-3035R-4-M16	4	35	40	17	29	6	23	22	M16	Yes	
FH175	ASRM-3042R-6-M16	6	42	40	17	29	6	23	22	M16	Yes	



Diameter Holder only	CAM Radius	Fastening Torque
-0.1 / -0.2 mm	3 mm	2.0 Nm

ID Code	Item Code	NOF	Size (mm)									Inner Coolant	Inserts
			DCX	LF	DCONMS	DCCB	TDZ	DHUB	KWW	b	CBDP		
FH167	ASRB-3042RM-6-16	6	42	40	16	13.5	8	35	8.4	5.6	19	Yes	EPNW08T3TN-10 EPMT08T3TN-10
FH274	ASRB-3050RM-7-22	7	50	50	22	17	10	40	10.4	6.3	20	Yes	
FH168	ASRB-3052RM-7-22	7	52	50	22	17	10	40	10.4	6.3	20	Yes	
FH169	ASRB-3052RM-7-27	7	52	50	27	20	12	45	12.4	7	22	Yes	
FH275	ASRB-3063RM-8-27	8	63	50	27	20	12	60	12.4	7	22	Yes	
FH170	ASRB-3066RM-8-27	8	66	50	27	20	12	60	12.4	7	22	Yes	
FH171	ASRB-3080RM-9-27	9	80	70	27	20	12	60	12.4	7	22	Yes	
FH172	ASRB-3100RM-10-32	10	100	70	32	26	16	70	14.4	8	25.5	Yes	

# ASR Pico Maxi Inserts

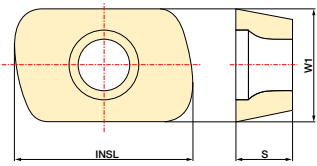


Fig.1

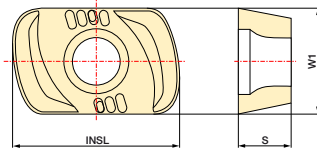


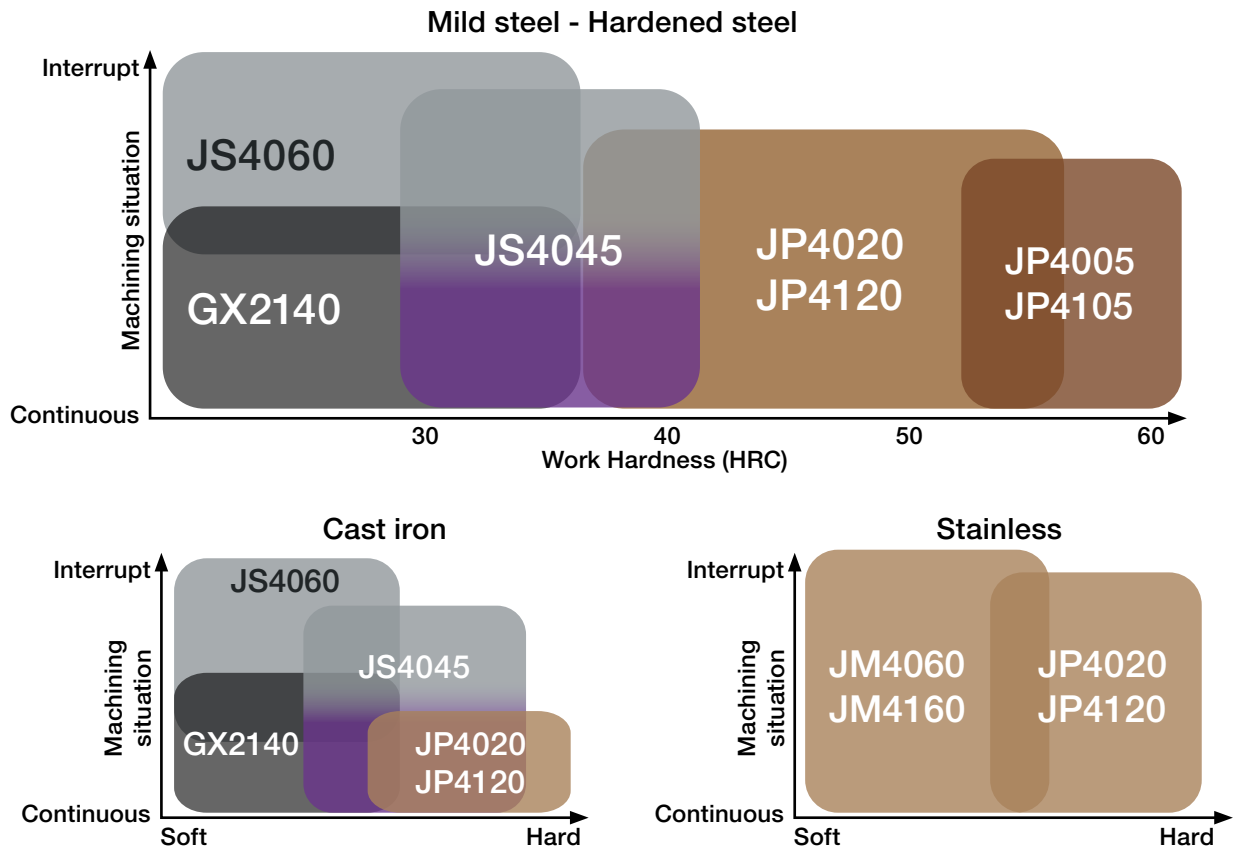
Fig.2

Item Code	Tolerance Class	Grade									Size (mm)				Shape
		GX2140	JM4060	JM4160*	JS4060	JS4045	JP4020	JP4120*	JP4005	JP4105*	R	INSL	S	W1	
EPNW-08T3TN-10	N	WF243	-	-	WF204	WF373	WF203	WF919	WF342	WF920	10	12.648	3.97	8.25	Fig. 1
EPMT-08T3TN-10	M	WF242	WF343	WF921	WF201	WF372	WF200	WF918	-	-					Fig. 2

\*Note: New insert grade

- GX2140 CVD - For heavy roughing of mild steels | Recommended for dry cutting
- JM4060 / JM4160 PVD - For stainless steels
- JS4060 / JS4045 PVD - General grade for 30-40 HRC | Recommended for dry cutting
- JP4020 / JP4120 PVD - For pre-hardened steels 40-55 HRC
- JP4005 / JP4105 PVD - For hardened steels > 50 HRC

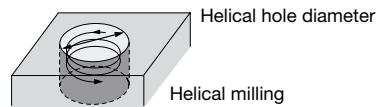
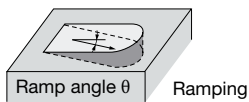
## ASR Pico Maxi Grade Table - Target Material



## ASR Pico Maxi Parts

Type	Cutter Body	Clamp Screw		Wrench	
		ID Code	Item Code	ID Code	Item Code
Modular	ASRM-3020R-2-M10 – ASRM-3042R-6-M16	ET152	265-141	ET011	104-T10
Bore Type	ASRB-3042RM-6-16 – ASRB-3100RM-10-32				

## ASR Pico Maxi Ramping and helical milling



Tool diameter DCX (mm)	32	35	42	52	66	80	100
Maximum ramp angle °	4.5°	3.5°	2.5°	1.5°	1°	0.5°	0.5°
Helical Milling / Hole Dia. (mm)	50-62	56-68	70-82	90-102	118-130	146-158	186-198

## ASR Pico Maxi General technical information

ISO 513 Symbol	Description	Examples
<b>P</b>	Non-alloy steel, low alloy steel, high alloy steel, ferritic/martensitic stainless steel, tool steel	1.2343 / X38CrMoV5-1; 1.2738 / 40CrMnNiMo8; 1.0503 / C45; 1.0570 / ST52-3; 1.1730 / C45W; 1.7131 / 16MnCr5; 1.7225 / 42CrMo4; 1.3343 / HS6-5-2; 1.0511 / C40; 1.2312 / 40CrMnMoS8-6; 1.2311 / 40CrMnMo7; 1.2344 / X40CrMoV5-1; 1.2767 / X45NiCrMo4; 1.2083 / X42Cr13; 1.2085 / X33CrS16; 1.2714 / 55NiCrMoV7; 1.2842 / 90MnCrV8;
<b>M</b>	Austenitic stainless steel	1.4301 / X5CrNi18-9; 1.4401 / X5CrNiMo17-12-2; 1.4404 / X2CrNiMo17-13-2; 1.4828 / X15CrNiSi20 12
<b>K</b>	Grey cast iron (GG), nodular cast iron (GGG), malleable cast iron	0.6025 / GG-25; GGG-40.3; 0.8155 / GTS-55-04
<b>N</b>	Aluminum wrought all, copper alloy, aluminum-cast, alloyed, non-metallic	2.0060 / E-Cu57; 2.0321 / CuZn37; 3.0255 / Al99.5; 3.5103 / MgSE3Zn27r1
<b>S</b>	High temperature alloys, titanium and Ti alloys	1.4864 / X12NiCrSi36 16; 2.4856 / NiCr22Mo9Nb; 1.4977 / X40CoCrNi20 20; 2.4669 / NiCr15Fe7TiAl
<b>H</b>	Hardened steel, chilled cast iron, cast iron	

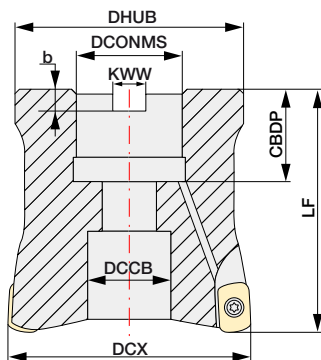
Recommended



Suitable

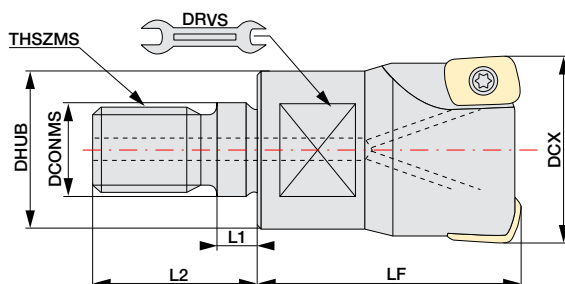


NOT recommended



Drawing Nomenclature

DCX	Cutting Diameter
b	Depth of Keyway
CBDP	Connection Board Depth
DCCB	Counterbore Diameter Connection Bore
DCONMS	Connection Diameter Machine Side
DRVS	Driver Size
DHUB	Hub Diameter
LF	Functional Length
THSZMS	Connection Thread Nominal Size Machine Side
KWW	Keyway Width
L1	Length 1
L2	Length 2



 **Attentions on Safety**

**1. Cautions regarding handling**

- (1) When removing the tool from its case (packaging), be careful that the tool does not pop out or is dropped. Be particularly careful regarding contact with the tool flutes.
- (2) When handling tools with sharp cutting flutes, be careful not to touch the cutting flutes directly with your bare hands.

**2. Cautions regarding mounting**

- (1) Before use, check the outside appearance of the tool for scratches, cracks, etc. and that it is firmly mounted in the collet chuck, etc.
- (2) When preparing for use, be sure that the inserts are firmly mounted in place and that they are firmly mounted on the arbor, etc.
- (3) If abnormal chattering, etc. occurs during use, stop the machine immediately and remove the cause of the chattering.

**3. Cautions during use**

- (1) Before use, confirm the dimensions and direction of rotation of the tool and milling work material.
- (2) The numerical values in the standard cutting conditions table should be used as criteria when starting new work. The cutting conditions should be adjusted as appropriate when the cutting depth is large, the rigidity of the machine being used is low, or according to the conditions of the work material.
- (3) Cutting tools are made of a hard material. During use, they may break and fly off. In addition, cutting chips may also fly off. Since there is a danger of injury to workers, fire, or eye damage from such flying pieces, a safety cover should be attached when work is performed and safety equipment such as safety goggles should be worn to create a safe environment for work.
- (4) There is a risk of fire or inflammation due to sparks, heat due to breakage, and cutting chips. Do not use where there is a risk of fire or explosion. Please caution of fire while using oil base coolant, fire prevention is necessary.
- (5) Do not use the tool for any purpose other than that for which it is intended.

**4. Cautions regarding regrinding**

- (1) If regrinding is not performed at the proper time, there is a risk of the tool breaking. Replace the tool with one in good condition, or perform regrinding.
- (2) Grinding dust will be created when regrinding a tool. When regrinding, be sure to attach a safety cover over the work area and wear safety clothes such as safety goggles, etc.
- (3) This product contains the specified chemical substance cobalt and its inorganic compounds. When performing regrinding or similar processing, be sure to handle the processing in accordance with the local laws and regulations regarding prevention of hazards due to specified chemical substances.

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**Specifications for the products listed in this catalog are subject to change without notice due to replacement or modification.**

**The diagrams and table data are examples of test results and are not guaranteed values.**

**For more details please check our digital tool database**



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