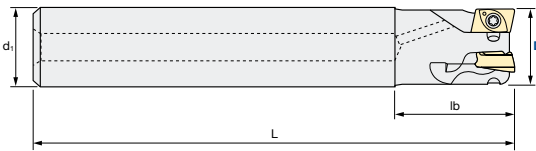
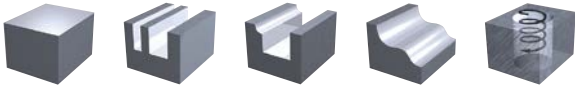


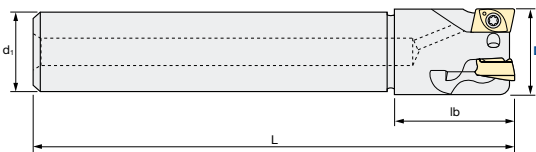


ASM | Shank Type (Short/Long)

Q max High Efficient	Jet Air Hole	▽ Roughing	▽▽ Semi-Finishing	▽▽▽ Finishing	HRC 50	No. of Teeth 1 ~ 5
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Standard type



Undercut type

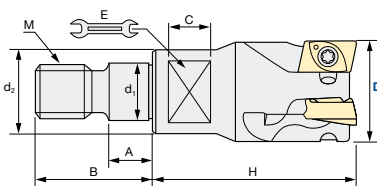
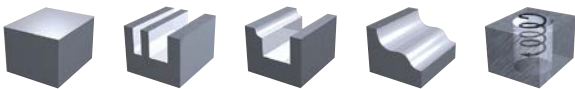


Diameter Holder only [mm]	Fastening Torque [Nm]
-0.1/-0.2 mm	0.5 Nm

Shank Type		ID Code	Item Code	Flutes	D	L	lb	d ₁	Shape	Inserts
Short	FH116	ASM-0708S10R-1	1	8	75	16	10	Standard type	JDMT0702..R EDMT070220R (-T)	
	FH117	ASM-0710S10R-2	2	10	80	20	12			
	FH118	ASM-0712S12R-3	3	12				Undercut type		
	FH119	ASM-0714S12R-3	4	14						
	FH120	ASM-0716S16R-4	4	16	90	25	16	Standard type		
	FH121	ASM-0717S16R-4	4	17	115	20	16	Undercut type		
	FH122	ASM-0720S20R-5	5	20	105	25	20	Standard type		
FH123	ASM-0721S20R-5	5	21	140	20	20	Undercut type			
Long	FH124	ASML-0716S16R-4	4	16	115	50	16	Standard type		
	FH125	ASML-0720S20R-5	5	20	140	60	20			

ASM | Modular

Q max High Efficient	Jet Air Hole	▽ Roughing	▽▽ Semi-Finishing	▽▽▽ Finishing	HRC 50	No. of Teeth 1 ~ 8
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Diameter Holder only [mm]	Fastening Torque [Nm]
-0.1/-0.2 mm	0.5 Nm

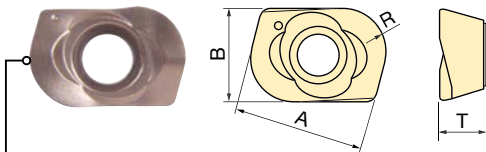
Modular Type		ID Code	Item Code	Flutes	D	H	d ₁	M	d ₂	A	B	C	E	Airhole	Inserts
FH126	ASMM-0708R-1	1	8	20	6.5	M6	9.8	5.5	14.5	5	7	-	JDMT0702..R EDMT070220R (-T)		
FH127	ASMM-0710R-2	2	10												
FH128	ASMM-0712R-3	3	12												
FH129	ASMM-0716R-4	4	16	25	8.5	M8	12.8	5.5	17	8	10				
FH130	ASMM-0720R-5	5	20	10.5	M10	17.8	5.5	19	15	15					
FH135	ASMM-0725R-6	6	25	30	12.5	M12	20.8	6	23	12	22	•			
FH136	ASMM-0732R-8	8	32											17	M16

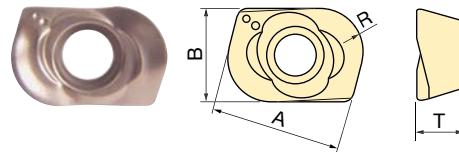
D10–D32 with Airhole

Cutting Conditions | Schnittwerte | Condizioni di taglio | Condiciones de Corte | Conditions de coupe | Valores de corte:

EDMT: D 8 (Z1) – D 32 (Z8); Page 5

JDMT: D 8 (Z1) – D 32 (Z8); Page 6–7

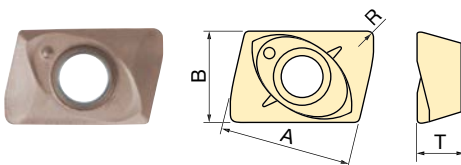
INSERTS ASM/AHU | Mini
EDMT070220R - T Standard Type

 Insert with 2.0 mm corner R for low-depth, high-feed-rate cutting ($a_{p\ max} = 0.3\ mm$)

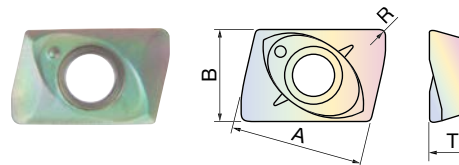
EDMT070220R Low-force breaker type

 Insert with 2.0 mm corner R for low-depth, high-feed-rate cutting ($a_{p\ max} = 0.3\ mm$)

ID Code	Item Code	Tolerance Class	Grade			Size				Shape
			JM4060	JP4020	JX1020	A	B	R	T	
WF663	EDMT070220R	M			•	6.4	4.3	2	2.5	Low-force type
WF664	EDMT070220R-T				•					Standard type
WF709	EDMT070220R-T		•	•						Standard type
WF710	EDMT070220R-T		•							Standard type
WF711	EDMT070220R		•	•						Standard type
WF712	EDMT070220R		•							Low-force type

← Soft Target Hardness of Workpiece Hard →

JM4060	JM Coating
JP4020	JP Coating
JX1020	PVD Coating/Dry Cutting

JDMT07020..R

 Insert with 5 mm flute length for shoulder cutting ($a_{p\ max} = 5.0\ mm$)

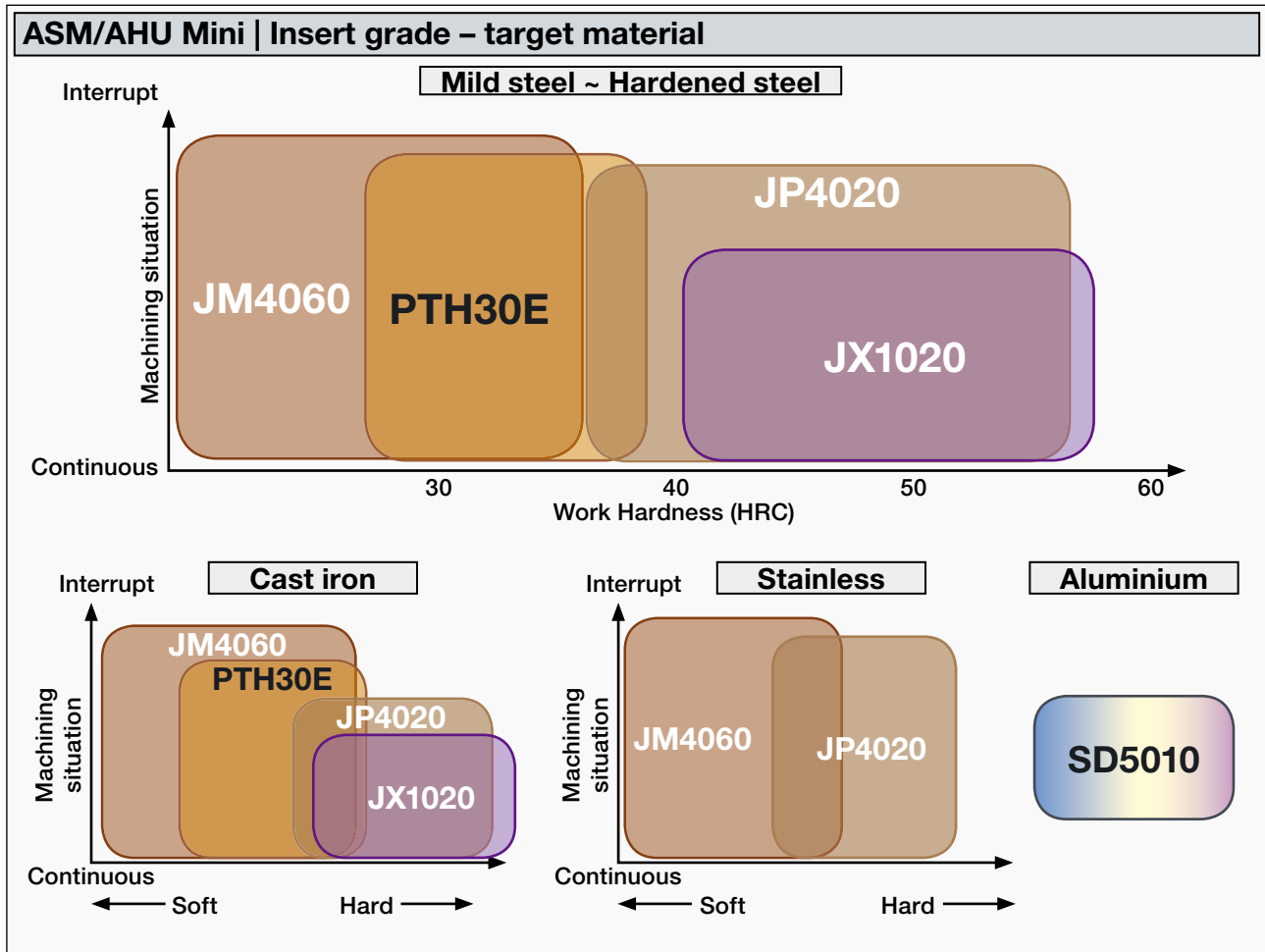
JDMT07020..R DLC Coated

 Insert with 5 mm flute length for shoulder cutting ($a_{p\ max} = 5.0\ mm$)

ID Code	Item Code	Tolerance Class	Corner-R	Grade					Size					
				SD5010	JM4060	PTH30E	JP4020	JX1020	A	B	R	T		
WF665	JDMT070202R	M	0.2			•			6.4	4.3	0.2	2.45		
WF666	JDMT070202R			•	•									
WF671	JDMT070202R						•							
WF667	JDMT070204R		0.4			•							0.4	
WF668	JDMT070204R			•	•									
WF672	JDMT070204R						•							
WF669	JDMT070208R		0.8			•					0.8			
WF670	JDMT070208R			•	•									
WF673	JDMT070208R						•							
WF689	JDMT070202R		0.2	0.2		•					0.2			
WF690	JDMT070202R						•							
WF691	JDMT070204R				0.4	0.4						•		0.4
WF692	JDMT070204R						•	•						
WF693	JDMT070208R												•	
WF694	JDMT070208R				0.8	0.8		•						0.8
			•											

← Soft Target Hardness of Workpiece Hard →

SD5010	DLC Coating
JM4060	JM Coating
PTH30E	TH Coating
JP4020	JP Coating
JX1020	PVD Coating/Dry Cutting

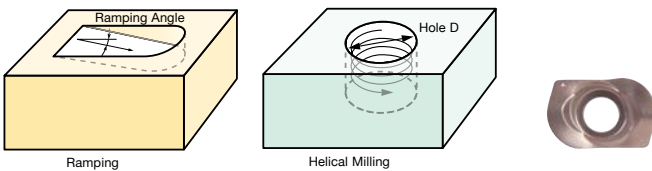
Parts	Clamp Screw ID-Code	Item-Code	Wrench ID-Code	Item-Code
	ET052	240-140	ET053	106-T6



ASM/AHU | Mini | Recommended Cutting Conditions for EDMT Inserts

PLEASE NOTE:	1. The use of a machining centre and toolholder with highest precision, concentricity and rigidity	2. All components – including machine and controller – are of the latest technology	
The values in these tables are only recommended under the following conditions:			

Ramping with EDMT-type inserts

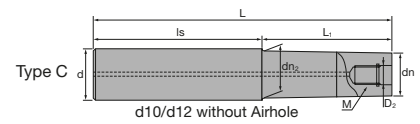
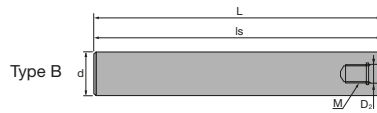
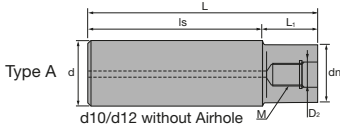


Insert	Cutting edge D (mm)	D 8	D 10	D 12	D 16	D 20	D 25	D 32
EDMT	Ramping Angle °	6.4	6.6	4.1	2.2	1.4	1	0.8
	Helical Milling / Hole Dia. (mm)	10 ~ 15	13 ~ 19	17 ~ 23	25 ~ 31	33 ~ 39	43 ~ 49	57 ~ 63

- | | |
|--|--|
| <p>1. The ramp angle should be set within the ranges listed above. Use at ramp angles of 0.5° is recommended.</p> <p>2. For hole diameters outside the ranges listed above, a pilot hole should be drilled before milling.</p> | <p>1. Der Rampenfräswinkel sollte innerhalb der oben aufgelisteten Bereiche sein. Empfohlen wird ein Winkel von 0,5°.</p> <p>2. Für Bohrungen mit einem größeren Durchmesser als oben aufgeführt sollte vor dem Helikalfräsen eine Startbohrung durchgeführt werden.</p> |
|--|--|

ASC | Carbide Shanks for Modular Mills

MMC Hitachi Tool Engineering Europe GmbH



Carbide Shank																
	ID Code	Item Code	D ₂	M	L	L ₁	Is	dn	dn ₂	d	Type					
Without Airhole	FH137	ASC10-6.5-74-24	6.5	M6	74	24	50	9.3	-	10	A					
	FH254	ASC10-6.5-84-34			84	34										
	FH255	ASC10-6.5-114-24			114	24						90				
	FH138	ASC10-6.5-114-49			114	49						65				
	FH139	ASC12-6.5-74-24			74	24	50					11	11.5	12	C	
	FH256	ASC12-6.5-94-44			94	44										
	FH257	ASC12-6.5-129-24			129	24										105
	FH140	ASC12-6.5-129-64			129	64										65
With Airhole	FH141	ASC16-8.5-95-30	8.5	M8	95	30	65	14.5	15.5	16	C					
	FH258	ASC16-8.5-120-55			120	55										
	FH142	ASC16-8.5-140-75			140	75										
	FH260	ASC16-8.5-160-30			160	30										130
	FH259	ASC16-8.5-160-95			160	95						65				
	FH143	ASC20-10.5-120-50	10.5	M10	120	50	70	18	-	20	A					
	FH261	ASC20-10.5-170-90Z			170	90	80	18.5	19.5		C					
	FH144	ASC20-10.5-220-50			220	50	170	18	-		A					
	FH262	ASC20-10.5-220-120Z			220	120	100	18.5	19.5		25	A				
	FH263	ASC20-10.5-270-150Z			270	150	120									
	FH264	ASC20-10.5-270-50Z	270	50	220											
	FH145	ASC25-12.5-145-65	12.5	M12	145	65	80	23	-	25	A					
	FH146	ASC25-12.5-265-65			265		200									
	FH265	ASC25-12.5-215-115			215		115					100				
	FH266	ASC25-12.5-265-145			265	145	120									
	FH268	ASC25-12.5-315-65			315	65	250									
	FH267	ASC25-12.5-315-195			315	195	120									
	FH147	ASC32-17-160-80	17	M16	160	80	80	28	-	32	A					
	FH269	ASC32-17-260-140			260	140	120									
	FH148	ASC32-17-310-80			310	80	230									
FH270	ASC32-17-360-240	360			240	120										

- 🇬🇧 SUPER Lock milling chucks or shrink-fit holders can be used.
- 🇩🇪 SUPER Lock Aufnahmen oder Schrumpffutter können verwendet werden.
- 🇮🇹 Possono essere utilizzati mandrini a forte serraggio SUPER Lock.

- 🇪🇸 Aptos para amarrar en portapinzas SUPER Lock.
- 🇫🇷 Les attachements SUPER Lock peuvent être utilisés.
- 🇵🇹 Cones hidráulicos de grande aperto e aperto térmico podem ser usados.

AS | Steel Shanks for Modular Mills


Steel Shank											
	ID Code	Item Code	D ₂	M	L	L ₁	Is	dn	dn ₂	d	Type
Without Airhole	FH131	AS10-6.5-74-0	6.5	M6	74	-	74	-	-	10	B
	FH132	AS12-6.5-84-4			84	4	80	11	-	12	A
With Airhole	FH133	AS16-8.5-95-15	8.5	M8	95	15	80	14.5	15.5	16	C
	FH134	AS20-10.5-100-20	10.5	M10	100	20		18	-	20	A
	FH271	AS25-12.5-115-35	12.5	M12	115	35		23	23	25	
	FH272	AS32-17-110-30	17	M16	110	30		28	28	32	

- 🇬🇧 SUPER Lock milling chucks can be used.
- 🇩🇪 SUPER Lock Aufnahmen können verwendet werden.
- 🇮🇹 Possono essere utilizzati mandrini a forte serraggio SUPER Lock.

- 🇪🇸 Aptos para amarrar en portapinzas SUPER Lock.
- 🇫🇷 Les attachements SUPER Lock peuvent être utilisés.
- 🇵🇹 Cones hidráulicos de grande aperto e aperto térmico podem ser usados.

🇬🇧 For further information about modular chucks please see our brochure *Indexable Modular Series No. 328*

🇩🇪 Weitere Informationen über modulare Werkzeugaufnahmen finden Sie in unserem Prospekt: *Indexable Modular Series No. 328*

🇪🇸 Para obtener más información sobre conos modulares consulte nuestro folleto *Indexable Modular Series No. 328*

🇮🇹 Per maggiori informazioni riguardanti la gamma dei mandrini avvitali consultate il catalogo *Indexable Modular Series No. 328*

🇫🇷 Pour de plus amples informations concernant les attachements modulaires, voyez SVP notre brochure *Indexable Modular Series No. 328*

🇵🇹 Para mais informações sobre Conos Modulares consulte o nosso folheto *Indexable Modular Series No. 328*



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