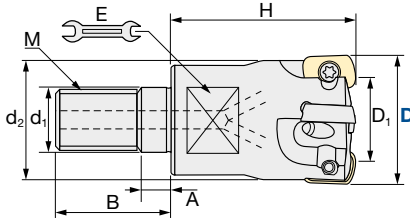
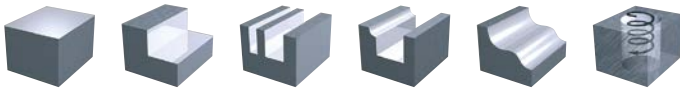


ASR | Pico – Turbo Metric Series – Modular Type

Q max High Efficient	Jet Air Hole	▽ Roughing	HRC 60	No. of Teeth 2 ~ 6
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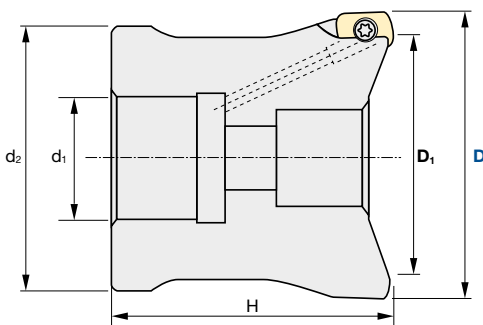
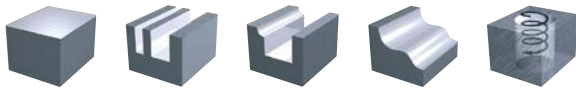
Diameter Holder only [mm]	CAM Radius:	Fastening Torque [Nm]
0/-0.2mm	2.0mm	1.1 Nm

Modular Type													Inserts
ID Code	Item Code	Flutes	D	D ₁	H	d ₁	M	d ₂	A	B	C	E	
FH 529	ASRM-2016R-2	2	16	6.2	25	8.5	M8	13	5.5	17	10	10	EPNW0603TN-8 EPMT0603TN-8 EPMT0603EN-8LF
FH 530	ASRM-2020R-3	3	20	10.2	30	10.5	M10	18	6	19	10	15	
FH 531	ASRM-2025R-4	4	25	15.2	35	12.5	M12	21	7	22	10	17	
FH 532	ASRM-2032R-5	5	32	22.2	40	17	M16	29	7	23	12	22	
FH 533	ASRM-2040R-6	6	40	30.2	40	17	M16	29	7	23	12	22	

ASC | Carbide Shanks for Modular Mills & AS | Steel Shanks for Modular Mills: page 7

ASR | Pico – Turbo Metric Series – Bore Type

Q max High Efficient	Jet Air Hole	▽ Roughing	HRC 60	No. of Teeth 6 ~ 8
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Diameter Holder only [mm]	CAM Radius:	Fastening Torque [Nm]
0/-0.2mm	2.0mm	1.1 Nm

Bore Type									
ID Code	Item Code	Flutes	D	D ₁	H	d ₁	d ₂	Inserts	
FH 537	ASR-2042RM-6	6	42	32.2	40	16	32	EPNW0603TN-8	
FH 538	ASR-2052RM-7	7	52	42.2	50	22	47	EPMT0603TN-8	
FH 539	ASR-2066RM-8	8	66	56.2	50	27	60	EPMT0603EN-8LF	

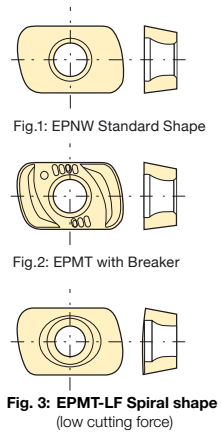
Cutting Conditions | Schnittwerte | Condizioni di taglio | Condiciones de Corte | Conditions de coupe | Valores de corte:

D 16 (Z2) – D 66 (Z8): Page 4–5



ASR | Pico – Turbo Metric Series – Inserts

Inserts	Target Hardness of Workpiece								R	Insert Shape
	GX2140	JM4060	JS4060	TB6045	JP4020	TB6020	TB6005	JP4005		
Item Code	ID Code									
EPNW0603TN-8	WF235								2	Fig.1
EPNW0603TN-8		WF236								
EPNW0603TN-8								WF237		
EPNW0603TN-8							WF641			
EPNW0603TN-8						WF642				
EPNW0603TN-8				WF643						
EPNW0603TN-8					WF208					
EPNW0603TN-8			WF209							
EPMT0603TN-8					WF206					
EPMT0603TN-8			WF207							
EPMT0603TN-8	WF232									
EPMT0603TN-8		WF233								
EPMT0603TN-8							WF234			
EPMT0603EN-8LF*		WF231							Fig.3	



* LF = Low Force

CAM Radius →

GX2140	CVD · For heavy roughing of mild steels Recommended for dry cutting
JM4060	PVD · For stainless steels & carbon steels < 35HRC
JS4060	PVD · For carbon steels < 35HRC
TB6045	PVD · General steels for 30–40 HRC / Recommended for dry cutting

JP4020	PVD · For pre-hardened steels 40–55 HRC
TB 6020 - 6005	PVD · Hybrid Coating
JP4005	PVD · For hardened steels > 50 HRC

Grades Overview: Page 6

Item Info: Grades & Insert Shape

GX2140: CVD coating for heavy roughing of mild steel (≤35HRC)
Smooth surface of coating: Better adhesion resistance
Thicker Al₂O₃ layer: Better heat resistance
Nano-Ti(C.N): Better wear resistance
Tougher substrate: Better crack resistance

JM4060: For stainless steel
Advanced PVD technology makes higher adherence

- best form for stainless steel
- better wear & chipping resistance

Combination with tougher substrate makes

- higher heat resistance
- better chipping resistance

JP4005: For high-hardened material (≥50HRC)
Ultra micro grain & higher-adhesive coating

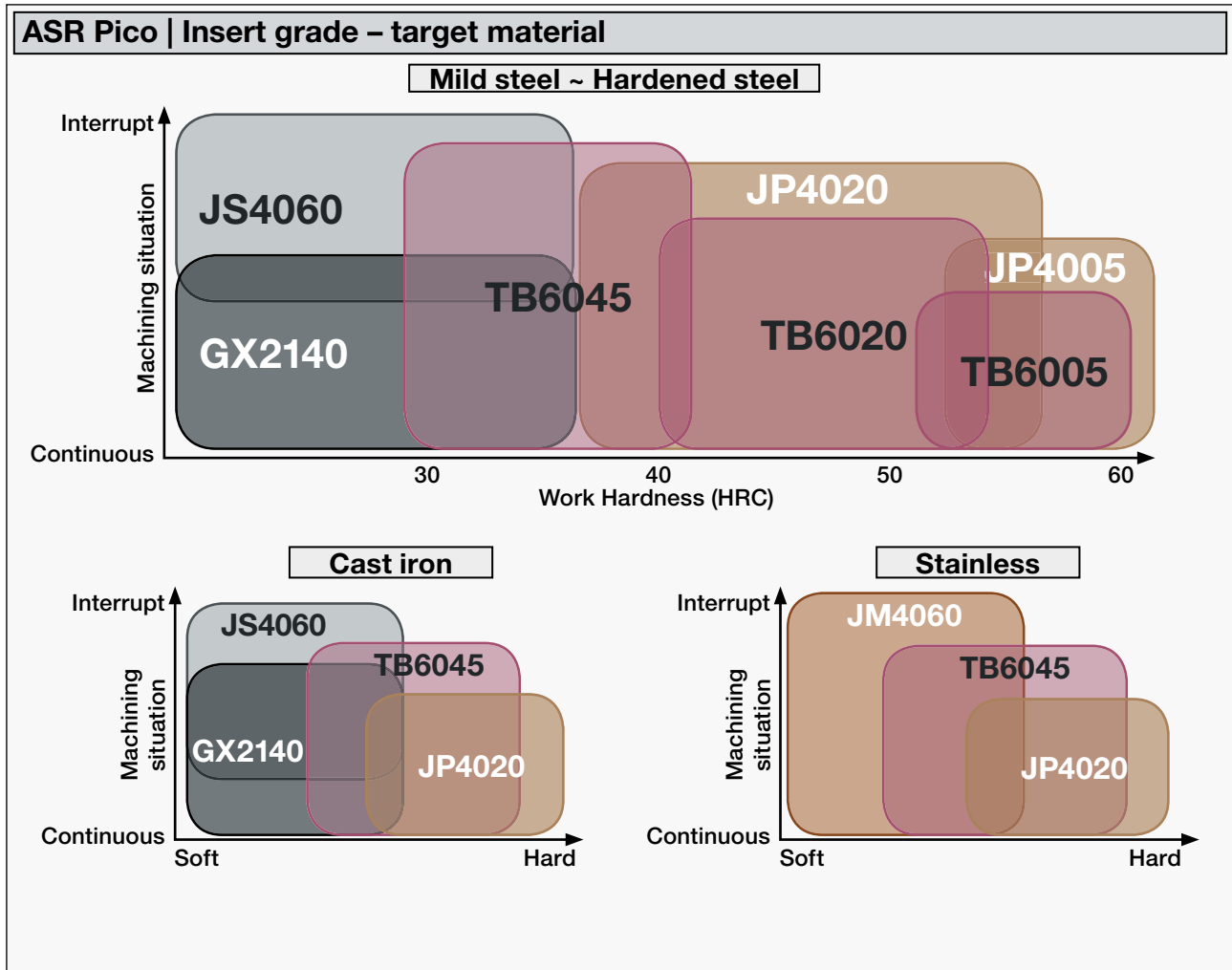
PICO LF Type (Fig. 3) Low Force

- sharper than standard chip breaker
- better for sticky material

Parts	Clamp Screw		Wrench	
	ID-Code	Item-Code	ID-Code	Item-Code
	ET175	250-141(A)	ET13	104-T8

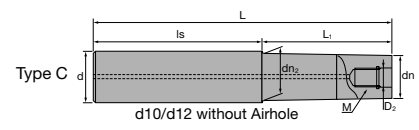
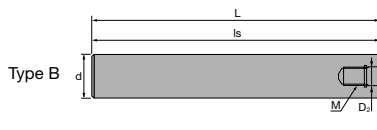
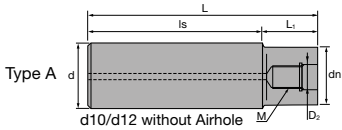


ASR | Pico – Turbo Metric Series – Modular/Bore Type





ASC | Carbide Shanks for Modular Mills



		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		
	FH144	ASC20-10.5-220-50				220	50	170					18	-		
	FH262	ASC20-10.5-220-120Z				220	120	100					18.5	19.5		
	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	65	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*