

**Indexable
Milling**
+Modular Series

AHU High-Feed **Ultra** End Mill
AHUM High-Feed **Ultra** End Mill **Modular Type**
AHUB High-Feed **Ultra** Bore Type
D 16 ~ D 63 · High Feed Cutting

FW Fine Wall Finishing
Improved wall surface accuracy



Available Coatings:

SD-DLC-Coating
JS-Coating
JM-Coating
PTH-Coating
TB-Coating
JP-Coating



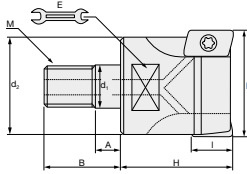
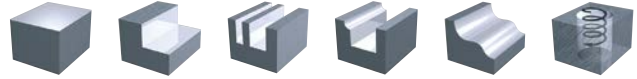
Indexable Milling Tools

AHUM | High-Feed Ultra End Mill Modular

Q max
High Efficient

▽
Roughing

No. of Teeth
2-5



Tolerance Dia.:	Tolerance CR:	Torque on screw:
-0.05/ -0.2 mm	+0.08/ -0.08 mm	1.3 Nm

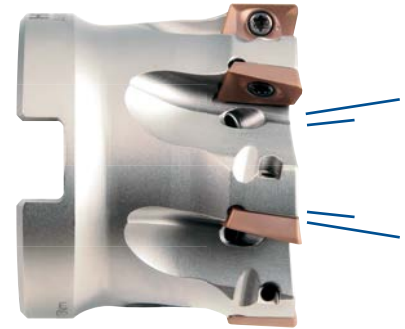
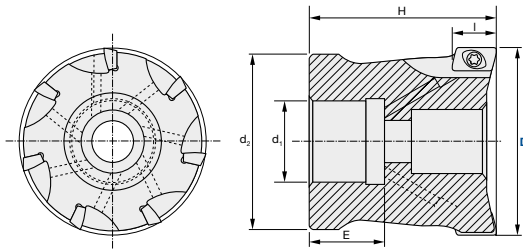
Modular Type												
ID Code	Item Code	Flutes	D	l	H	d ₁	M	d ₂	A	B	E	Inserts
FH 525	AHUM-1016R-2	2	16	9	25	8.5	M8	13	5.5	16	10	JDMT-1003-R../-FW JDET-1003-R../-FA
FH 526	AHUM-1020R-3	3	20		30	10.5	M10	18		18	15	
FH 527	AHUM-1025R-4	4	25		35	12.5	M12	21		20	17	
FH 528	AHUM-1032R-5	5	32		40	17	M16	29	6	22	22	

AHUB | High-Feed Ultra Bore Type

Q max
High Efficient

▽
Roughing

No. of Teeth
6-8



Tolerance Dia.:	Tolerance CR:	Torque on screw:
-0.05/ -0.2 mm	+0.08/ -0.08 mm	1.3 Nm

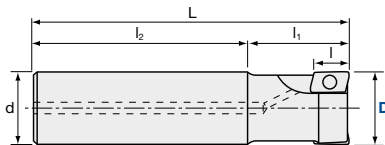
Bore Type										
ID Code	Item Code	Flutes	D	l	H	d ₁	d ₂	E	Inserts	
FH 534	AHUB-1040RM-6	6	40	9	40	16	32	19	JDMT-1003-R../-FW JDET-1003-R../-FA	
FH 535	AHUB-1050RM-7	7	50			22	47	20		
FH 536	AHUB-1063RM-8	8	63							

AHU | High-Feed Ultra End Mill

Q max
High Efficient

▽
Roughing

No. of Teeth
2-5



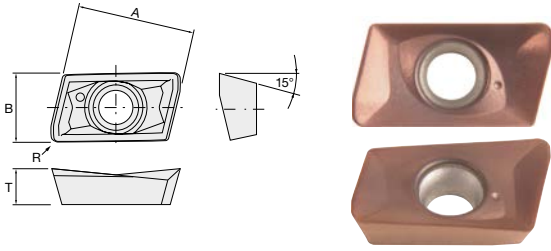
Tolerance Dia.:	Tolerance CR:	Torque on screw:
-0.05/ -0.2 mm	+0.08/ -0.08 mm	1.3 Nm

Shank Type										
ID Code	Item Code	Flutes	D	l	l ₁	l ₂	L	d	Inserts	
FH 506	AHU-1016R-2	2	16	9	30	70	100	16	JDMT-1003-R../-FW JDET-1003-R../-FA	
FH 507	AHU-1020R-3	3	20			80	110	20		
FH 508	AHU-1025R-4	4	25		35	85	120	25		
FH 509	AHU-1032R-5	5	32		45		130	32		

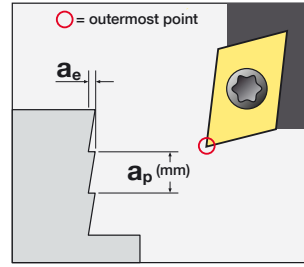
ASC | Carbide Shanks for Modular Mills & AS | Steel Shanks for Modular Mills: page 4

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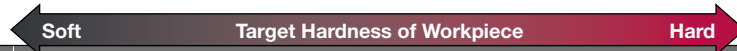
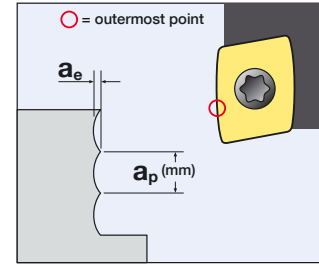
INSERTS | Improved cutting surface



Conventional (JDMT.....R)

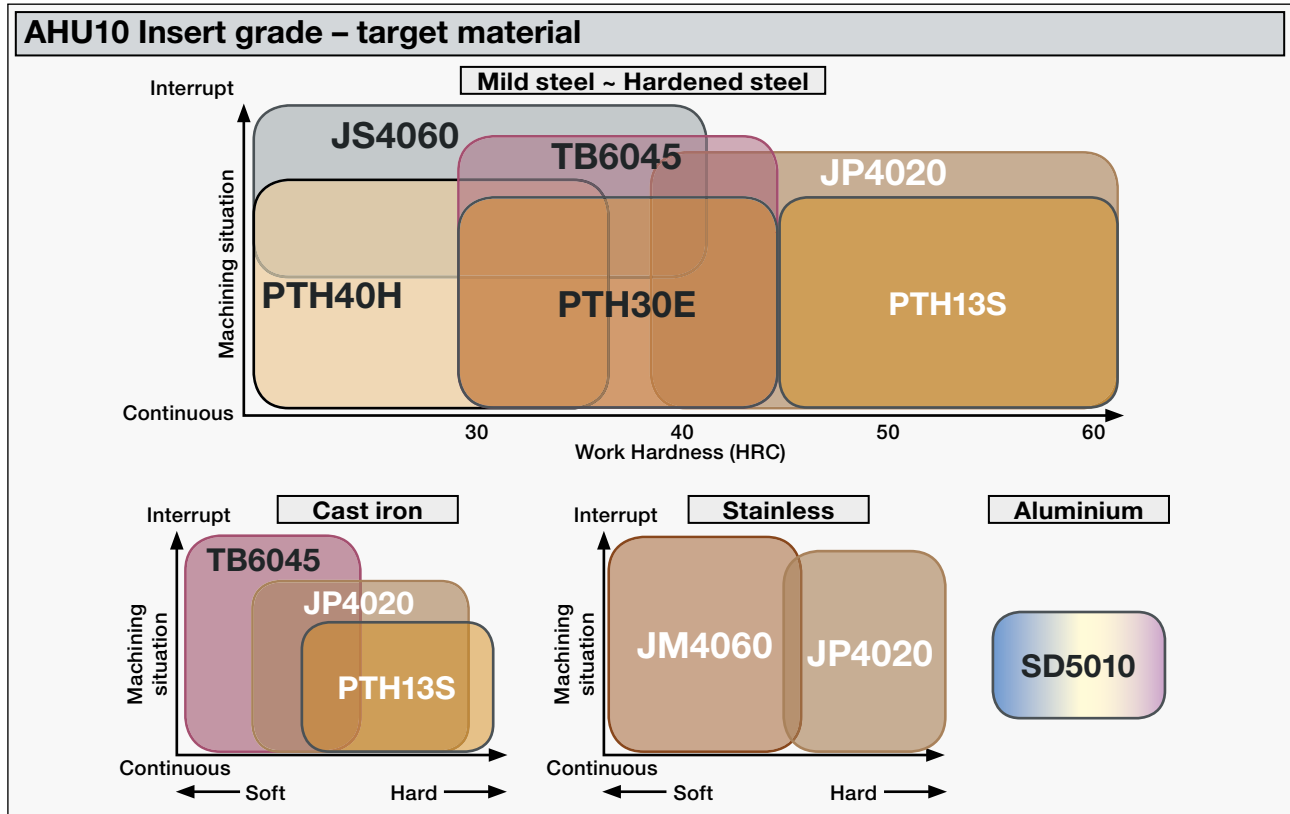


Fine Wall type **JDMT.....R-FW**



Inserts	Tolerance Class	Corner-R	Grade							Size (mm)			
			SD5010	JM4060	JS4060	PTH40H	PTH30E	TB6045	PTH13S	JP4020	A	B	T
Item Code			ID-Code										
JDMT-1003-R04	M	0.4					WF633	WF634	WF637		11	6.1	3.5
JDMT-1003-R04-FW		0.4-FW		WF696						WF695			
JDMT-1003-R08		0.8		WF702	WF701	WF636	WF631	WF635	WF638	WF700			
JDMT-1003-R08-FW		0.8-FW		WF699	WF698					WF697			
JDMT-1003-R20		2.0		WF705	WF704		WF632			WF703			
JDET-1003-R04-FA	E	0.4-FA	WF706										

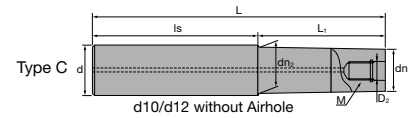
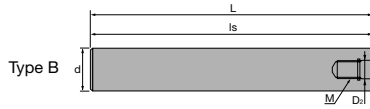
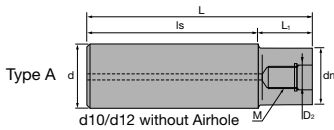
- SD5010** PVD · DLC coated grade for Aluminium
- PTH30E** PVD · General steels for 30–40 HRC
- JM4060** PVD · For stainless steels & carbon steels < 35HRC
- TB6045** PVD · General steels for 30–40 HRC / Recommended for dry cutting
- JS4060** PVD · For carbon steels < 35HRC
- PTH13S** PVD · For pre-hardened steels 40–55 HRC
- PTH40H** PVD · For carbon steels < 35HRCA
- JP4020** PVD · For pre-hardened steels 40–55 HRC



Clamp Screw		Wrench	
ID Code	Item-Code	ID Code	Item-Code
ET175	250-141	ET013	104-T8

Indexable Milling Tools

ASC | Carbide Shanks for Modular Mills

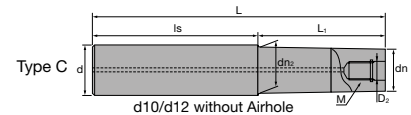
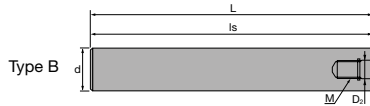
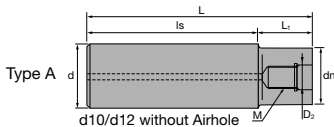


		Carbide Shank																		
		ID Code	Item Code	D ₂	M	L	L ₁	Is	dn	dn ₂	d	Type								
Without Airhole	FH137	ASC10-6.5-74-24	6.5	M6	74	24	50	9.3	-	10	10	A								
	FH254	ASC10-6.5-84-34											84	34						
	FH255	ASC10-6.5-114-24											114	24	90					
	FH138	ASC10-6.5-114-49												49	65					
	FH139	ASC12-6.5-74-24											74	24	50	11	11.5	12	12	C
	FH256	ASC12-6.5-94-44											94	44	50					
	FH257	ASC12-6.5-129-24											129	24	105					
	FH140	ASC12-6.5-129-64												64	65					
With Airhole	FH141	ASC16-8.5-95-30	8.5	M8	95	30	65	14.5	15.5	16	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	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			20	C							
	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	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	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	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.

Indexable Milling Tools

AHUM | High-Feed Ultra End Mill Modular

- For further information about Modular Chucks please see our brochure *Indexable Modular Series No. 328.2*
- Weitere Informationen über Modulare Werkzeugaufnahmen finden Sie in unserem Prospekt *Indexable Modular Series No. 328.2*
- Per maggiori informazioni riguardanti la gamma dei mandrini avvitabili consultate il catalogo *Indexable Modular Series No. 328.2*
- Para obtener más información sobre conos modulares consulte nuestro folleto *Indexable Modular Series No. 328.2*
- Pour de plus amples informations concernant les attachements modulaires, voyez SVP notre brochure *Indexable Modular Series No. 328.2*
- Para mais informações sobre Cones Modulares consulte o nosso folheto *Indexable Modular Series No. 328.2*



Ramping / Helical Milling



Ramping

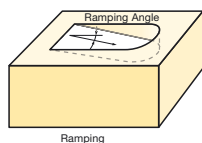
Ramping is possible please use the following data for direct milling without pre-drilling any starter holes.

Fräsoptionen über Rampe

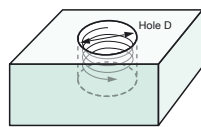
Für Fräsoptionen über Rampe nutzen Sie bitte die nachfolgend abgebildeten Schnittwerte für die direkte Bearbeitung ohne Startlochbohrung.

Lavorazioni in rampa

È possibile lavorare in rampa senza alcun preforo. Usate per questa lavorazione i seguenti dati.



Ramping



Helical Milling

Rampa

El mecanizado en rampa es posible. Por favor, utilizar las condiciones siguientes para mecanizado directo sin pretaladrado.

Usinage de rampes

Cette application est possible, utilisez, les données suivantes pour un fraisage direct, sans avant trou.

Rampa

A fresagem em rampa é possível. Por favor utilizar as condições seguintes em maquinação directa sem pré-furo.

Tool Diameter D mm	D 16	D 20	D 25	D 32	D 40	D 50	D 63
Max Ramp Angle°	4°	3°	2.5°	2°	1.5°	1°	1°
Hole D (mm)	21~29	29~37	39~47	53~61	68~80	85~100	107~126

Always up to date: Please check our P50 QuickFinder



Product Range

Solid Carbide End Mills



Indexable Milling Tools



WHNSB Drills



Milling Chucks



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