

Advanced Engineering

Indexable
Milling
+Modular Series

MMC Hitachi Tool

No. 324.4

ASM/AHU Mini

Shank & Modular Types

Indexable Side-Milling and High Feed End Mill

Available Grades:

JP-Coating

JM-Coating

JX-Coating

PTH-Coating

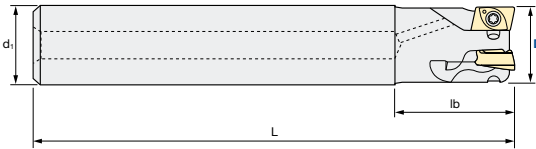
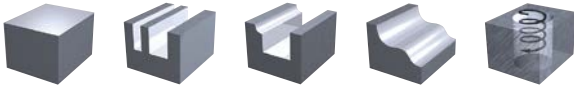
SD-DLC-Coating

MMC Hitachi Tool Engineering Europe GmbH
www.high-speed-cutting.com

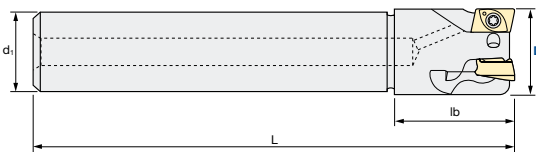
Indexable Milling Tools

ASM | Shank Type (Short/Long)

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



Standard type



Undercut type

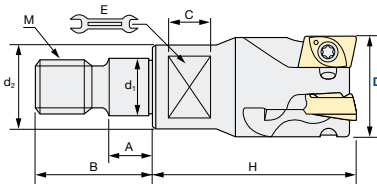
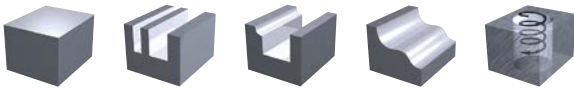


Tolerance D:	Maximum torque on screw:
-0.1 / -0.2	0.5 Nm

Shank Type		ID Code	Item Code	Flutes	D	L	lb	d ₁	Shape	Inserts
Short	FH116	ASM-0708S10R-1	1	8	75	16	10	10	Standard type	JDMT0702..R EDMT070220R (-T)
	FH117	ASM-0710S10R-2	2	10	80	20	12		Undercut type	
	FH118	ASM-0712S12R-3	3	12						
	FH119	ASM-0714S12R-3	3	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	JDMT0702..R EDMT070220R (-T)	
	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
--------------------------------	------------------------	----------------------	-----------------------------	-------------------------	------------------	------------------------------



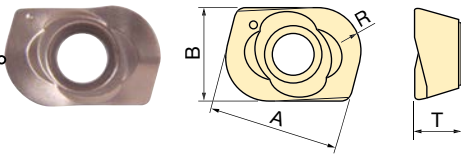
D 16 - 32 with Airhole	Tolerance D:	Maximum torque on screw:
	-0.1 / -0.2	0.5 Nm

Modular Type		ID Code	Item Code	Flutes	D	H	d ₁	M	d ₂	A	B	C	E	Inserts
Without Airhole	FH126	ASMM-0708R-1	1	8	20	6.5	M6	12.8	9.8	5.5	14.5	5	7	JDMT0702..R EDMT070220R (-T)
	FH127	ASMM-0710R-2	2	10					9.4					
	FH128	ASMM-0712R-3	3	12					9.8					
With Airhole	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							
	FH135	ASMM-0725R-6	6	25	30	12.5	M12	20.8	6	23	12	22		
	FH136	ASMM-0732R-8	8	32									17	

Indexable Milling Tools

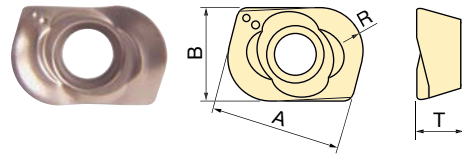
INSERTS ASM/AHU | Mini

EDMT070220R - **T** Standard Type



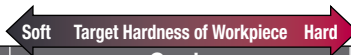
Insert with 2.0mm corner R for low-depth, high-feed-rate cutting ($a_{p\max} = 0.3\text{mm}$)

EDMT070220R Low-force breaker type



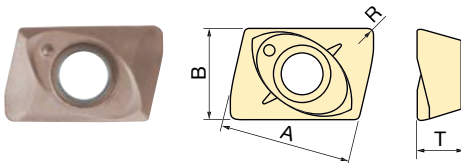
Insert with 2.0mm corner R for low-depth, high-feed-rate cutting ($a_{p\max} = 0.3\text{mm}$)

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		•	•						
WF710	EDMT070220R-T		•							
WF711	EDMT070220R		•							
WF712	EDMT070220R		•							



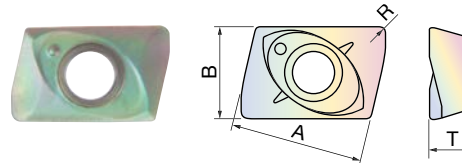
JM4060 JM Coating
JP4020 JP Coating
JX1020 PVD Coating/Dry Cutting

JDMT07020..R



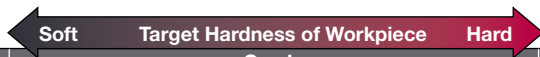
Insert with 5 mm flute length for shoulder cutting ($a_{p\max} = 5.0\text{mm}$)

JDMT07020..R DLC Coated



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

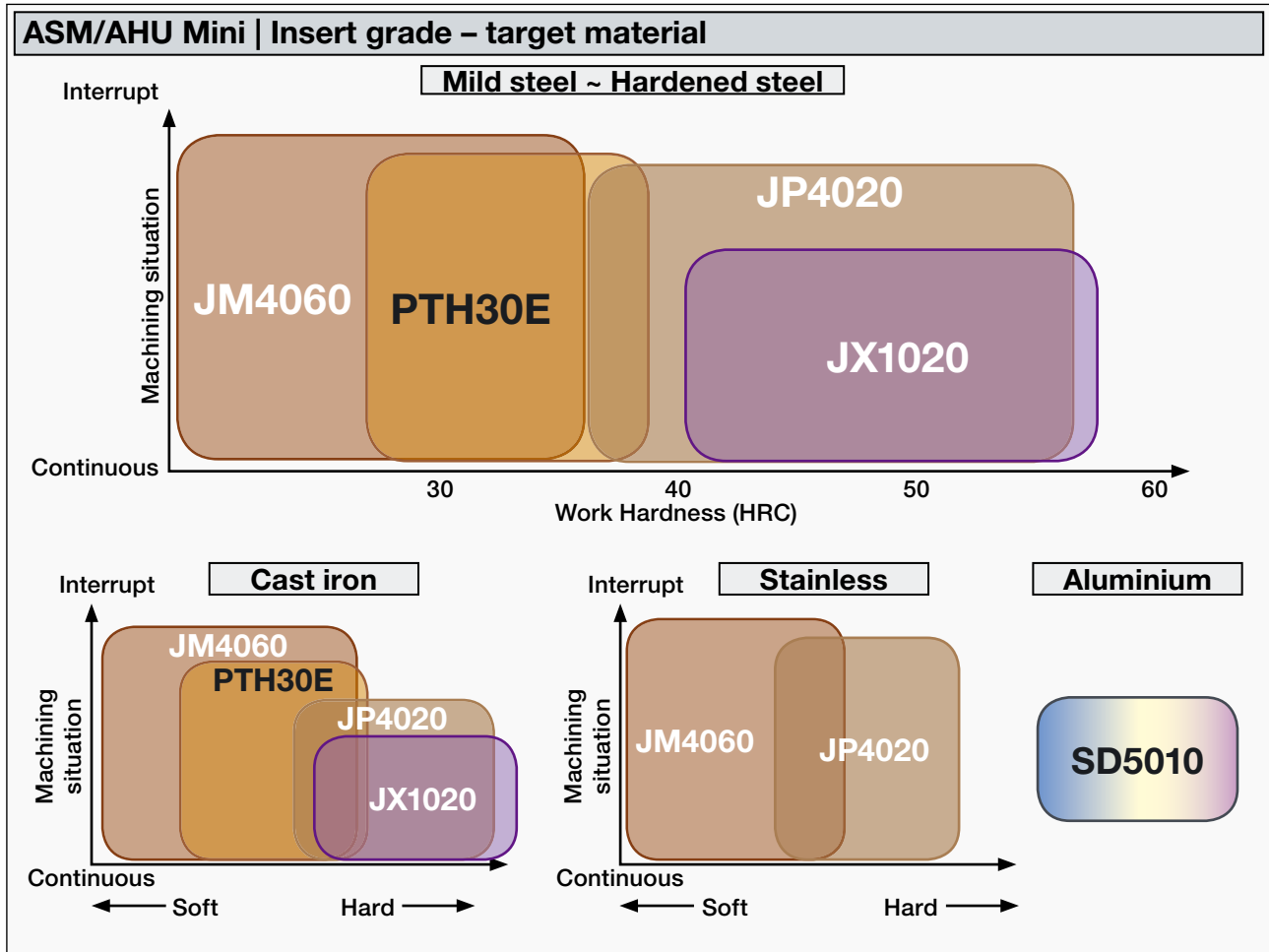
ID Code	Item Code	Tolerance Class	Corner-R	Grade					Size						
				SD5010	JM4060	PTH30E	JP4020	JX1020	A	B	R	T			
WF665	JDMT070202R	M	0.2			•			6.4	4.3	0.2	2.45			
WF666	JDMT070202R			•											
WF671	JDMT070202R			•											
WF667	JDMT070204R		0.4			•							0.4		
WF668	JDMT070204R			•										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

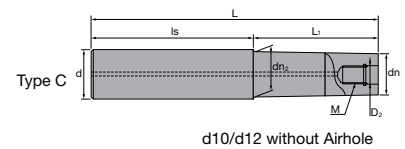
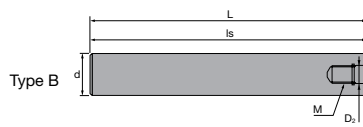
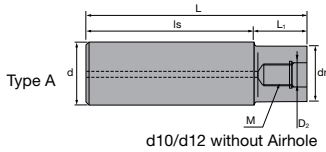


SD5010 DLC Coating
JM4060 JM Coating
PTH30E TH Coating
JP4020 JP Coating
JX1020 PVD Coating/Dry Cutting

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

Indexable Milling Tools





ASC | Carbide Shanks for Modular Mills



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

- UK SUPER Lock milling chucks or shrink-fit holders can be used.
- DE SUPER Lock Aufnahmen oder Schrumpffutter können verwendet werden.
- IT Possono essere utilizzati mandrini a forte serraggio SUPER Lock.

- ES Aptos para amarrar en portapinzas SUPER Lock.
- FR Les attachements SUPER Lock peuvent être utilisés.
- PT Cones hidráulicos de grande aperto e aperto térmico podem ser usados.

AS | Steel Shanks for Modular Mills



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

- UK SUPER Lock milling chucks can be used.
- DE SUPER Lock Aufnahmen können verwendet werden.
- IT Possono essere utilizzati mandrini a forte serraggio SUPER Lock.

- ES Aptos para amarrar en portapinzas SUPER Lock.
- FR Les attachements SUPER Lock peuvent être utilisés.
- PT Cones hidráulicos de grande aperto e aperto térmico podem ser usados.

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

Always up to date: Please check our P50 QuickFinder

www.mmc-hitachitool-eu.com/quickfinder

MMC Hitachi Tool Engineering Europe GmbH

Itterpark 12 · 40724 Hilden · Germany · Phone +49 (0) 21 03-24 82-0 · Fax +49 (0) 21 03-24 82-30
 E-Mail info@mmc-hitachitool-eu.com · Internet www.mmc-hitachitool-eu.com
 © 2015 by MMC Hitachi Tool Engineering Europe GmbH · 4th Edition · Printed in Germany