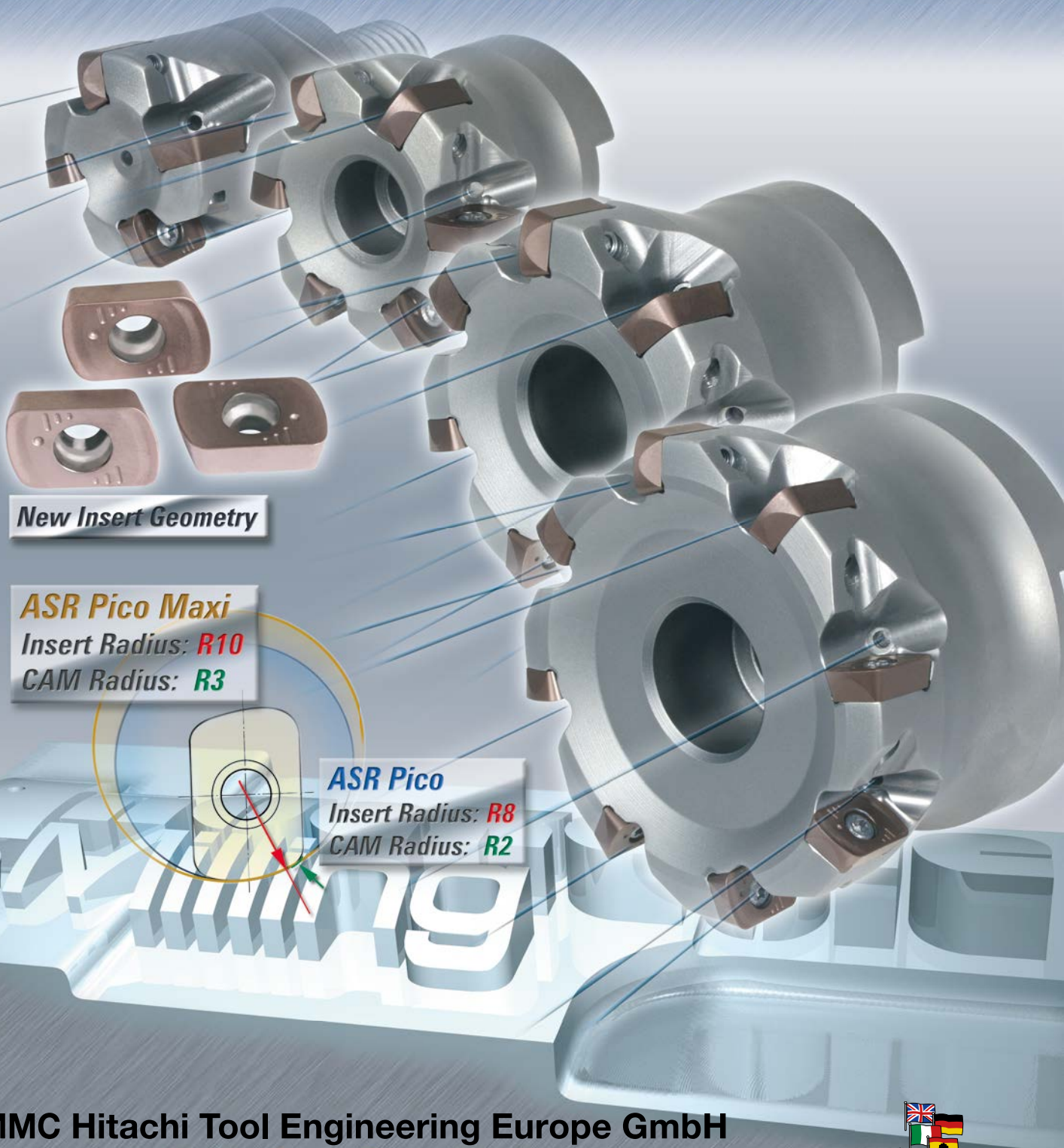


ASR Pico Maxi Turbo Metric Series

D 20 ~ D 100 · High Feed Cutting (HFC)

High Hardness Cutting (HHC)



New Insert Geometry

ASR Pico Maxi
Insert Radius: **R10**
CAM Radius: **R3**

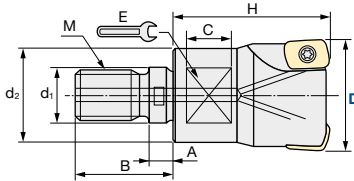
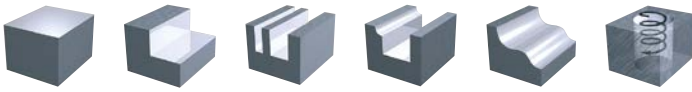
ASR Pico
Insert Radius: **R8**
CAM Radius: **R2**



Indexable Milling Tools

ASRM | Pico Maxi – Turbo Metric Series – Modular Type

Q max High Efficient	Jet Air Hole	▽ Roughing	▽▽ Semi-Finishing	HRC 62	No. of Teeth 2~6
--------------------------------	------------------------	----------------------	-----------------------------	------------------	----------------------------



Tolerance Dia.:	CAM Radius:	Torque on screw:
-0.1/-0.2	3 mm	2.0 Nm

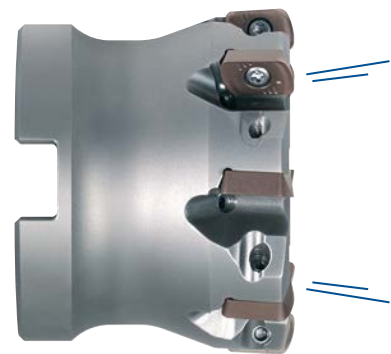
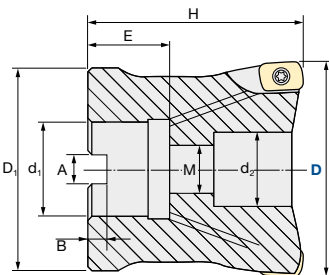
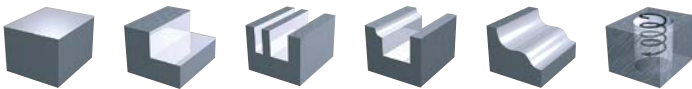
Modular Type													Inserts
ID Code	Item Code	Flutes	D	H	d ₁	M	d ₂	A	B	C	E		
FH180	ASRM-3020R-2-M10	2	20	30	10.5	M10	18	5.5	19	10	15	EPNW08T3TN-10 EPMT08T3TN-10	
FH181	ASRM-3025R-3-M12	3	25	35	12.5	M12	21	5.5	22	10	17		
FH173	ASRM-3032R-4-M16	4	32	40	17	M16	29	6	23	12	22		
FH174	ASRM-3035R-4-M16		35										
FH175	ASRM-3042R-6-M16	6	42										

Wrench Size

ASC | Carbide Shanks for Modular Mills & AS | Steel Shanks for Modular Mills: page 8

ASRB | Pico Maxi – Turbo Metric Series – Bore Type

Q max High Efficient	Jet Air Hole	▽ Roughing	▽▽ Semi-Finishing	HRC 62	No. of Teeth 6~10
--------------------------------	------------------------	----------------------	-----------------------------	------------------	-----------------------------



Tolerance Dia.:	CAM Radius:	Torque on screw:
-0.1/-0.2	3 mm	2.0 Nm

Bore Type													Inserts
ID Code	Item Code	Flutes	D	H	d ₁	d ₂	M	D ₁	A	B	E		
FH167	ASRB-3042RM-6-16	6	42	40	16	13.5	8	35	8.4	5.6	19	EPNW08T3TN-10 EPMT08T3TN-10	
FH168	ASRB-3052RM-7-22	7	52	50	22	17	10	40	10.4	6.3	20		
FH169	ASRB-3052RM-7-27												45
FH170	ASRB-3066RM-8-27	8	66	70	27	20	12	60	12.4	7	22		
FH171	ASRB-3080RM-9-27	9	80										
FH172	ASRB-3100RM-10-32	10	100		32	26	16	70	14.4	8	25.5		

For more Details about ASR Pico and EPNW06...-8 Inserts please see our brochure No. 320.5 ASR Pico

Mehr Details über ASR Pico und EPNW06...-8 Schneidplatten finden Sie in unserem Prospekt No. 320.5 ASR Pico

Per maggiori dettagli relative a ASR Pico ed inserti EPNW06...-8 fare riferimento al nostro catalogo No. 320.5 ASR Pico

Para una información más detallada acerca del ASR Pico y las placas EPNW06...-8 ver nuestro catálogo ASR Pico No. 320.5

Pour plus de détails concernant notre ASR Pico et les EPNW06...-8 référez-vous à notre brochure N° 320.5 ASR Pico

Para mais detalhes sobre a ASR Pico e plaquetas EPNW06...-8 consulte nosso folheto N° 320.5 ASR Pico



Indexable Milling Tools

INSERTS ASRM/ASRB | Pico Maxi – Turbo Metric Series – Modular/Bore Type

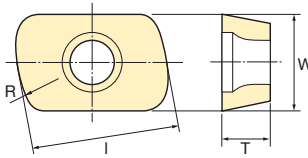


Fig.1: EPNW Standard Shape

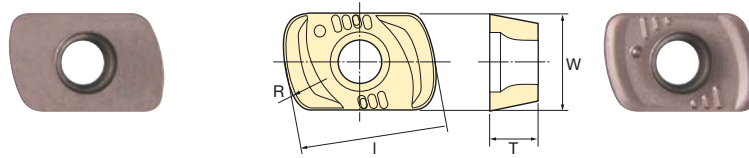
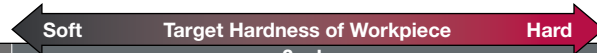
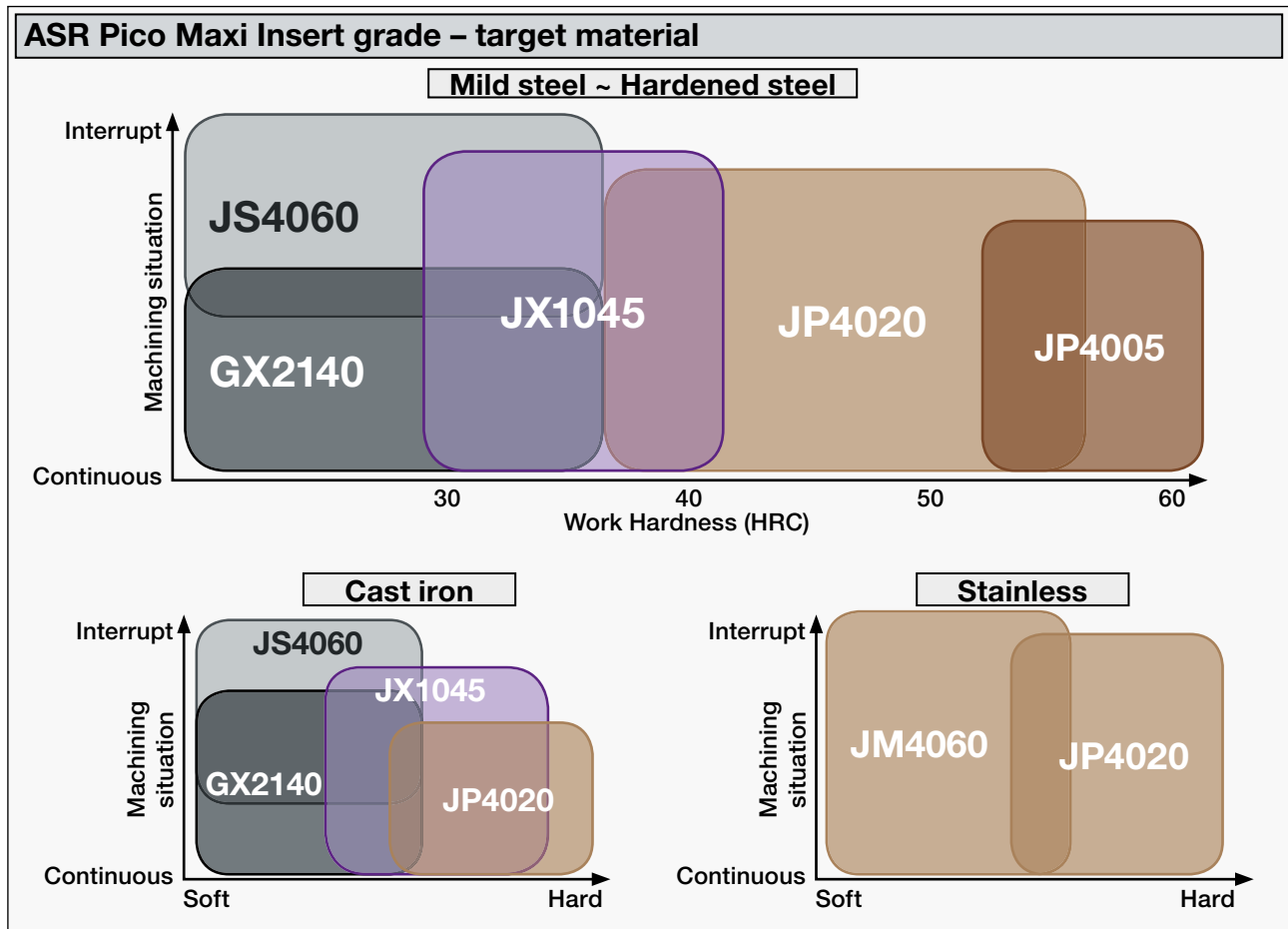


Fig.2: EPMT with Breaker

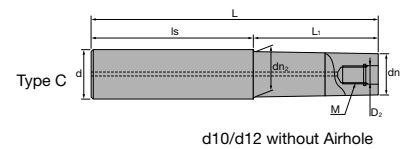
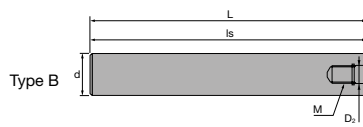
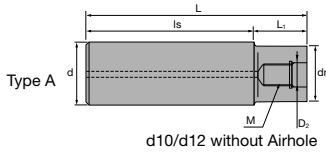


Inserts	Tolerance Class	Grade						Size (mm)				
		GX2140	JM4060	JS4060	JX1045	JP4020	JP4005	R	I	T	W	Shape
EPNW-08T3TN-10	N	WF243		WF204	WF205 ✗	WF203	WF342	10	12.648	3.97	8.25	Fig.1
EPMT-08T3TN-10	M	WF242	WF343	WF201	WF202 ✗	WF200	Fig.2					

- GX2140** CVD · For heavy roughing of mild steels | Recommended for dry cutting
- JM4060** PVD · For stainless steels
- JS4060** PVD · General grade for 30 – 40 HRC | Recommended for dry cutting
- JX1045** ✗ to be replaced by JS4045
- JP4020** PVD · For pre-hardened steels 40 – 55 HRC
- JP4005** PVD · For hardened steels > 50 HRC



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



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	6.5		49	65										
	FH139	12.5		M8	74	24					50	11	11.5	12	C
	FH256	12.5			94	44									
	FH257	12.5			24	105									
	FH140	12.5			129	64					65				
FH141	12.5	95	30		65	14.5	15.5	16	C						
FH258	12.5	120	55												
FH142	12.5	140	75												
FH260	12.5	160	30	130											
With Airhole	FH259	10.5	M10	95	65	65	18	-	20	A					
	FH143	10.5		120	50						70				
	FH261	10.5		170	90	80					18.5	19.5			
	FH144	10.5		220	50	170					18	-			
	FH262	10.5		120	100	18.5					19.5	20	C		
	FH263	10.5		150	120										
	FH264	10.5		270	50	220									
	FH145	12.5		M12	145	65					80	23	-	25	A
	FH146	12.5	265		200										
	FH265	12.5	215		115	100									
	FH266	12.5	265		145	120									
	FH268	12.5	65		250										
	FH267	12.5	315		195	120									
	FH147	17	M16		160	80	80	28	-	32	A				
	FH269	17			260	140									
	FH148	17		310	80	230									
FH270	17	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 avvitalibili 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*

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