Advanced Engineering

MMC Hitachi Tool

No. 320.5

Indexable Milling +Modular Series

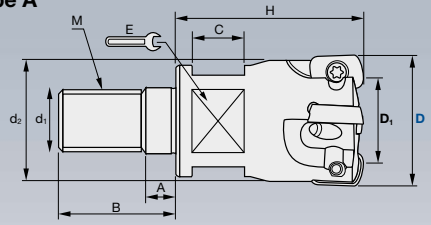
ASR Pico Turbo Metric Series

High Feed Cutting (HFC) & High Hardness Cutting (HHC)

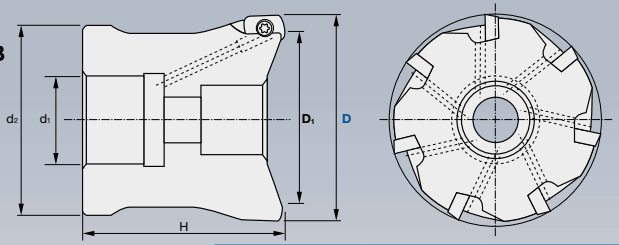
D 16 mm ~ D 66 mm

Q max	Jet	▽	HRC	No. of Teeth
High Efficient	Air Hole	Roughing	60	2 ~ 8

Type A



Type B



Tolerance Dia.:	CAM Radius:	Torque on screw:
0/-0.2 mm	2 mm	1.3 Nm

	ID Code	Item Code	Flutes	D	D_1	H	d_1	M	d_2	A	B	C	E	Inserts
Type A	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		15	
	FH 531	**ASRM-2025R-4**	4	25	15.2	35	12.5	M12	21	7	22		17	
	FH 532	**ASRM-2032R-5**	5	32	22.2	40	17	M16	29		23	12	22	
	FH 533	**ASRM-2040R-6**	6	40	30.2									
Type B	FH 537	**ASR-2042RM-6**		42	32.2		16	–	32	–	–	–	–	
	FH 538	**ASR-2052RM-7**	7	52	42.2	50	22		47					
	FH 539	**ASR-2066RM-8**	8	66	56.2		27		60					

One Insert-size for all diameters D 16 mm ~ D 66 mm

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

+ Special Insert: Low Force Type

MMC Hitachi Tool Engineering Europe GmbH

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

Soft ← Target Hardness of Workpiece → Hard

Inserts	Grade								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					Fig.2
EPMT0603TN-8			WF207							
EPMT0603TN-8	WF232									
EPMT0603TN-8		WF233								
EPMT0603TN-8								WF234		
EPMT0603EN-8LF*		WF231								Fig.3

* LF = Low Force

CAM Radius

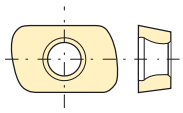


Fig.1: EPNW Standard Shape

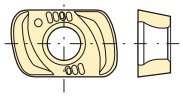


Fig.2: EPMT with Breaker

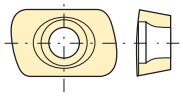


Fig. 3: EPMT-LF Spiral shape
(low cutting force)

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 4

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

Item Info: Grades & Insert Shape

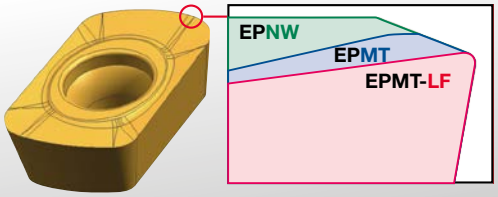
GX2140: CVD coating for heavy roughing of mild steel (≤35HRC)
Smooth surface of coating: Better adhesion resistance
Thicker Al2O3 layer: Better heat resistance
Nano-Ti(C.N): Better wear resistance
Tougher substrate: Better crack resistance

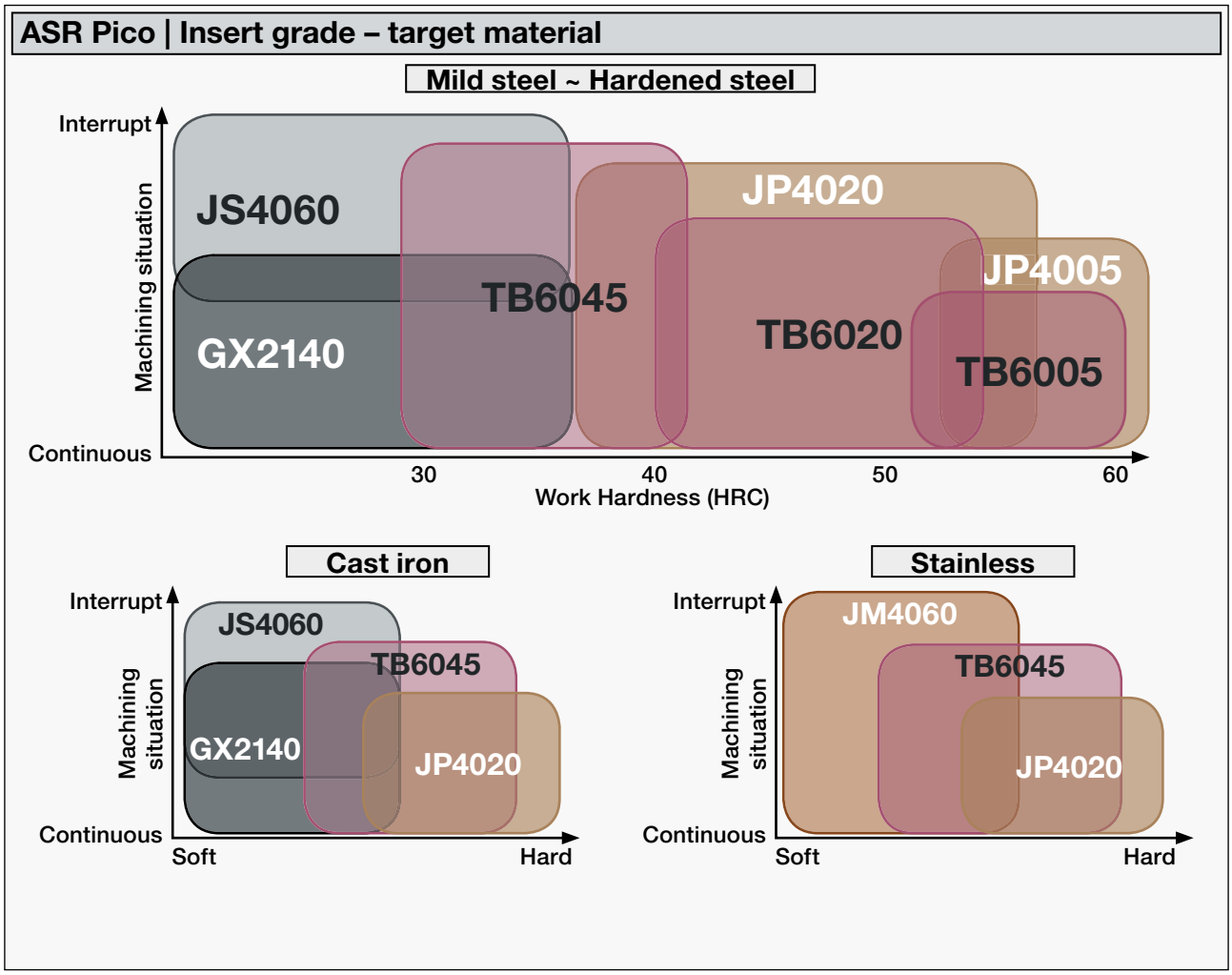
JM4060: For stainless steel
Advanced PVD technology makes higher adherence
- best form for stainless steel
- better wear & chipping resistance

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





Product Range

Solid Carbide End Mills

microEndMill

HD COATING

MINIATURE

CBN Cubic Boron Nitride

Epoch21

3D-Cut

Indexable Milling Tools

Indexable Milling

WHNSB Drills

WHNSB NON STEP BOREA

Milling Chucks

Milling Chucks

P50QF PRODUCTION50® QuickFinder www.mmc-hitachitool-eu.com/quickfinder

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HTT615 1505 ASR-Pico-6.5 BW-DS