

SCREW-IN TOOLS

**Inch Size
Added**

Easy to use screw-in heads for die and mold machining.


















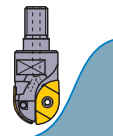


SCREW-IN TOOLS

Features

Screw-in tools can be used for a wide variety of machining applications.

■ Screw-in Head

Product Name	Application	Feature
APX3000 / 4000 	<ul style="list-style-type: none"> ●Shoulder Milling ●Copy Milling ●Face Milling 	<ul style="list-style-type: none"> ●11°, 15° positive, low cutting force insert. ●High accuracy, high quality vertical wall. ●With through coolant holes.
AQX 	<ul style="list-style-type: none"> ●Pocket Milling ●Copy Milling ●Drilling ●Shoulder Milling ●Face Milling 	<ul style="list-style-type: none"> ●The center bottom cutting edge enables drilling without previously formed hole. ●High rigidity body design. ●With through coolant holes.
ASX400 	<ul style="list-style-type: none"> ●Shoulder Milling ●Face Milling 	<ul style="list-style-type: none"> ●Precise but inexpensive molded type 20° positive inserts. ●Economical 4 cutting edge inserts. ●Curved cutting edge and high rigidity holder. ●With through coolant holes.
AJX 	<ul style="list-style-type: none"> ●Pocket Milling ●Face Milling 	<ul style="list-style-type: none"> ●High rigidity double clamp structure. ●Suitable for high feed cutting. ●13°, 15° positive insert. ●Special insert design with 3 cutting edges. ●With through coolant holes.
ARP 	<ul style="list-style-type: none"> ●Slot Milling ●Shoulder Milling ●Contour Milling ●Corner Radius Milling ●Copy Milling ●Face Milling 	<ul style="list-style-type: none"> ●Precision M-class 15° positive insert. ●Effective for various machining applications. ●Air / coolant through.

Product Name	Application	Feature
ARX 	<ul style="list-style-type: none"> ●Slot Milling ●Corner Radius Milling ●Copy Milling ●Face Milling 	<ul style="list-style-type: none"> ●15° positive, close tolerance M-class insert. ●Effective for various machining applications. ●With through coolant holes.
SRF 	<ul style="list-style-type: none"> ●Radius Milling ●Copy Milling 	<ul style="list-style-type: none"> ●S-shaped cutting edges provide sharpness similar to that of solid end mills. ●Highly accurate ball/corner radius tolerance allows for high precision finishing.
SRM2 	<ul style="list-style-type: none"> ●Curved Face Milling ●Copy Milling ●Contour Milling 	<ul style="list-style-type: none"> ●Suitable for roughing to semi-finishing of small and medium molds. ●Low resistance chipbreaker. ●High rigidity body design. ●With through coolant holes.
PMC 		<ul style="list-style-type: none"> ●1 directional cutting with large overhang. ●Unique shape of curved edge gives high rigidity and low resistance.

■ Screw-in Holders

Straight Shank

Steel shank type : General machining
 Carbide shank type : High rigidity applications



BT30 / 40 Arbor

Integral tool for a shorter overhang!



HSK63A Arbor

Effective when used on high speed, low rigidity machining centers!



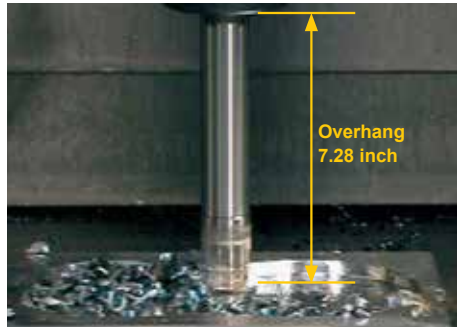
Cutting Performance

■ Carbide Shank Holder

Possible to machine with overhangs of up to 6xD (standard type: 2xD)

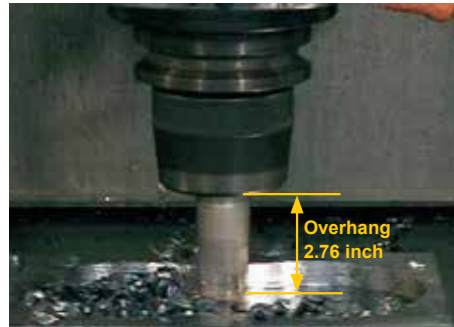
<Screw-in Tool>

Carbide Shank : SC32M16S280LW
Screw-in Head : AJX12R322AM1645



<Standard Arbor>

Arbor : BT50 milling chuck
Holder : AJX12R322SA32S



<Cutting Conditions>

Workpiece : AISI 4140
Insert : JDMW12420ZDSR-FT (VP15TF)
Cutting speed : 490 SFM
Feed rate : 157 inch/min
Feed per tooth : .052-.094 IPT
Depth of cut : .079 inch (Axial)
1.260 inch (Radial)
Cutting mode : Dry cutting

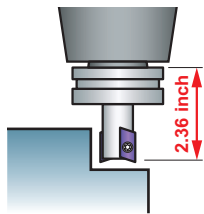
* The overhang length differs depending the tool and cutting conditions.

■ BT Shank Arbor

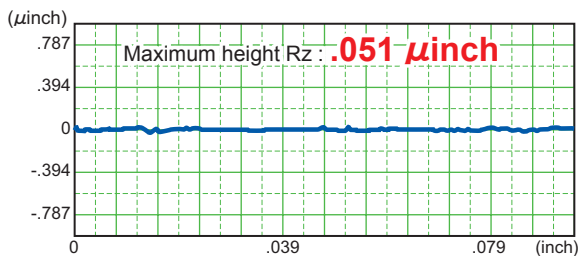
Compact size enables high quality machining!

<Screw-in Tool>

BT Arbor : SC20M10S10-BT30
Screw-in Head : APX3000R203M10A30

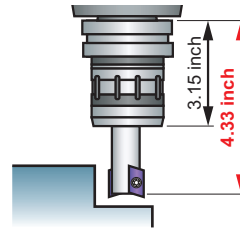


Roughness curve

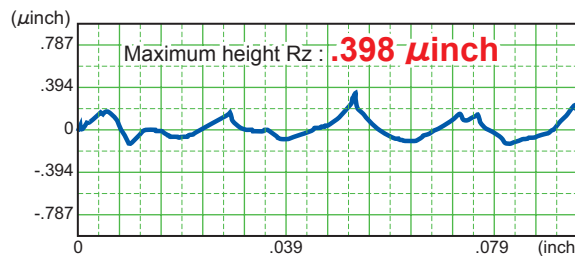


<Standard Arbor>

Arbor : BT30 milling chuck
Holder : APX3000R203SA20SA



Roughness curve

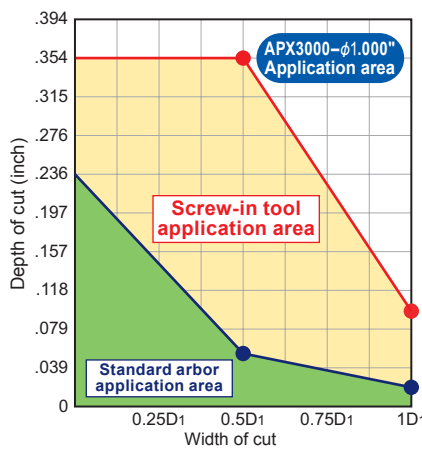
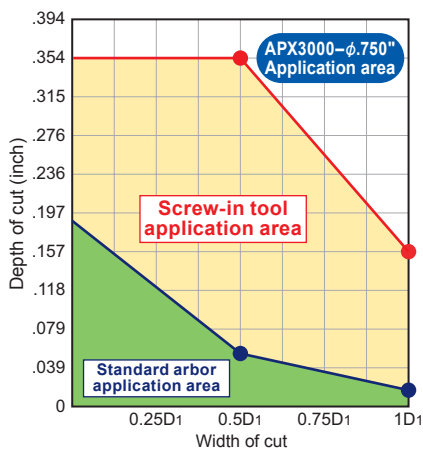


<Cutting Conditions>

Workpiece : AISI 1055
Insert : AOMT123608PEER-M (VP15TF)
Cutting speed : 525 SFM
Feed rate : 30.1 inch/min
Feed per tooth : .004 IPT

Depth of cut : .236 inch (Axial)
.394 inch (Radial)
Cutting mode : Dry cutting

A wide application range

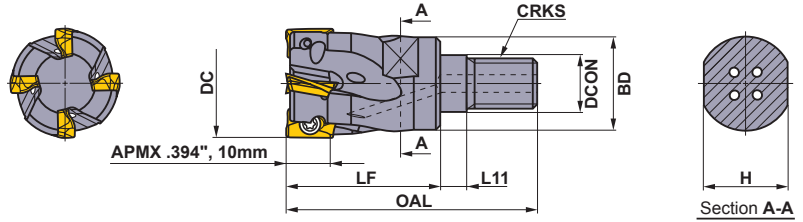


<Cutting Conditions>

Workpiece : AISI 1055
Cutting speed : 525 SFM
Feed per tooth : .004 IPT
Cutting mode : Dry cutting
D1 : Cutting edge diameter

SCREW-IN TOOLS

APX3000



With Air / coolant through.

Right hand tool holder only.

DC	Order Number	Stock	Number of Teeth	Dimensions (inch)							*3 WT	*1 			
				LF	OAL	DCON	BD	L11	H	CRKS*2					
.625	APX3000UR102AM08A30	●	2	1.181	1.890	.335	.512	.236	.394	M8	.2	TPS25	TIP07F	MK1KS	AO-T1236
.750	APX3000UR122AM10A30	●	2	1.181	1.929	.413	.709	.236	.551	M10	.2	TPS25	TIP07F	MK1KS	AO-T1236
.750	APX3000UR123AM10A30	●	3	1.181	1.929	.413	.709	.236	.551	M10	.2	TPS25	TIP07F	MK1KS	AO-T1236
.875	APX3000UR142AM10A30	●	2	1.181	1.929	.413	.709	.236	.551	M10	.2	TPS25-1	TIP07F	MK1KS	AO-T1236
.875	APX3000UR143AM10A30	●	3	1.181	1.929	.413	.709	.236	.551	M10	.2	TPS25-1	TIP07F	MK1KS	AO-T1236
1.000	APX3000UR163AM12A35	●	3	1.378	2.244	.492	.827	.236	.748	M12	.4	TPS25-1	TIP07F	MK1KS	AO-T1236
1.000	APX3000UR164AM12A35	●	4	1.378	2.244	.492	.827	.236	.748	M12	.4	TPS25-1	TIP07F	MK1KS	AO-T1236
1.125	APX3000UR184AM12A35	●	4	1.378	2.244	.492	.827	.236	.748	M12	.4	TPS25-1	TIP07F	MK1KS	AO-T1236
1.250	APX3000UR205AM16A40	●	5	1.575	2.480	.669	1.142	.236	.945	M16	.7	TPS25-1	TIP07F	MK1KS	AO-T1236
1.375	APX3000UR225AM16A40	●	5	1.575	2.480	.669	1.142	.236	.945	M16	.7	TPS25-1	TIP07F	MK1KS	AO-T1236

*1 Clamp Torque (lbf-in) : TPS25=8.9, TPS25-1=8.9

*2 Clamp Torque of the Head (lbf-ft) : M8=17.1, M10=33.8, M12=59.2, M16=66.7

*3 WT : Mass (lbs)

METRIC Standard

With Air / coolant through.

DC	Order Number	Stock	Number of Teeth	Dimensions (mm)							*3 WT	*1 			
				LF	OAL	DCON	BD	L11	H	CRKS*2					
16	APX3000R162M08A30	★	2	30	48	8.5	48	6	10	M8	0.1	TPS25	TIP07F	MK1KS	AO-T1236
18	APX3000R182M08A30	★	2	30	48	8.5	48	6	10	M8	0.1	TPS25	TIP07F	MK1KS	AO-T1236
20	APX3000R203M10A30	★	3	30	49	10.5	49	6	14	M10	0.1	TPS25	TIP07F	MK1KS	AO-T1236
22	APX3000R223M10A30	★	3	30	49	10.5	49	6	14	M10	0.1	TPS25-1	TIP07F	MK1KS	AO-T1236
25	APX3000R254M12A35	★	4	35	57	12.5	57	6	19	M12	0.2	TPS25-1	TIP07F	MK1KS	AO-T1236
28	APX3000R284M12A35	★	4	35	57	12.5	57	6	19	M12	0.2	TPS25-1	TIP07F	MK1KS	AO-T1236
30	APX3000R304M16A40	★	4	40	63	17	63	6	24	M16	0.3	TPS25-1	TIP07F	MK1KS	AO-T1236
32	APX3000R325M16A40	★	5	40	63	17	63	6	24	M16	0.3	TPS25-1	TIP07F	MK1KS	AO-T1236
35	APX3000R355M16A40	★	5	40	63	17	63	6	24	M16	0.3	TPS25-1	TIP07F	MK1KS	AO-T1236
40	APX3000R406M16A40	★	6	40	63	17	63	6	24	M16	0.3	TPS25-1	TIP07F	MK1KS	AO-T1236

*1 Clamp Torque (lbf-in) : TPS25=8.9, TPS25-1=8.9


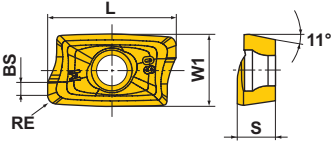

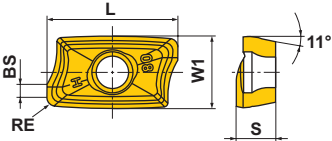

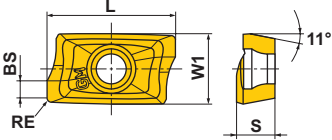
*2 Clamp Torque of the Head (lbf-ft) : M8=17.1, M10=33.8, M12=59.2, M16=66.7

*3 WT : Mass (kg)

● : Inventory maintained. ★ : Inventory maintained in Japan.

<10 inserts in one case>

INSERTS

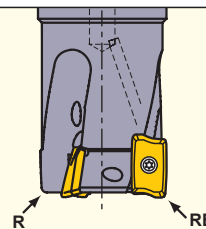
Work Material	P	Steel																	Cutting Conditions (Guide) : ● : Stable Cutting ● : General Cutting ✦ : Unstable Cutting Honing : E : Round F : Sharp
	M	Stainless Steel																	
	K	Cast Iron																	
Shape	Order Number	Class	Honing	Coated							Carbide	Dimensions (inch)					Geometry		
				MC5020	MP6120	MP6130	MP7130	MP9120	MP9130	VP15TF	VP20RT	TF15	L	W1	S	BS		RE	
General M Breaker 	AOMT123602PEER-M	M	E	●	●	●	●	●	●	●			.472	.260	.142	.071	.008		
	AOMT123604PEER-M	M	E	●	●	●	●	●	●	●			.472	.260	.142	.063	.016		
	AOMT123608PEER-M	M	E	●	●	●	●	●	●	●			.472	.260	.142	.047	.031		
	AOMT123610PEER-M	M	E	●	●	●	●	●	★	★			.472	.260	.142	.039	.039		
	AOMT123612PEER-M	M	E	●	●	●	●	●	●	●			.472	.260	.142	.031	.047		
	AOMT123616PEER-M	M	E	●	●	●	●	●	●	●			.472	.260	.142	.016	.063		
	AOMT123620PEER-M	M	E	●	●	●	●	●	●	●			.472	.260	.142	.016	.079		
Strong Cutting Edge Type H Breaker 	AOMT123604PEER-H	M	E	●	●	●	●	●	●	●			.472	.260	.142	.063	.016		
	AOMT123608PEER-H	M	E	●	●	●	●	●	●	●			.472	.260	.142	.047	.031		
	AOMT123616PEER-H	M	E	●	●	●	●	●	●	●			.472	.260	.142	.016	.063		
For Machining of Aluminium Alloys GM Breaker 	AOGT123602PEFR-GM	G	F								●		.472	.260	.142	.071	.008		
	AOGT123604PEFR-GM	G	F								●		.472	.260	.142	.063	.016		
	AOGT123608PEFR-GM	G	F								●		.472	.260	.142	.047	.031		

(Note) For the recommended cutting conditions, refer to the general catalogue or B055A Tool News.



NOTE ON USE OF INSERTS WITH LARGE CORNER RADII

When using inserts with corner radius $RE \geq R.094"$, please machine the holder with a radius form as shown on the right table.



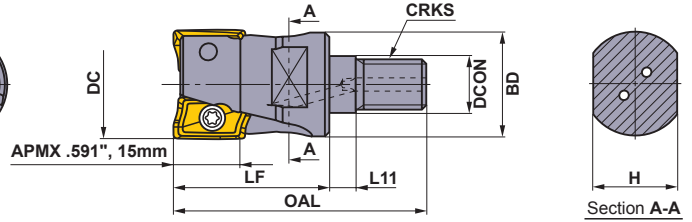
RE	R
.094"	.106" (B-Holder)
.118"	
.125"	

R : Holder end radius
RE : Insert corner radius

Or B-Holders are available as non stock, produced to order only.
 "Order numbers"; Please add "B" to the end of the order number of A-Holders.
 Ex) APX3000R162M08A30 → APX3000R162M08A30B

SCREW-IN TOOLS

APX4000



With Air / coolant through.

DC	Order Number	Stock	Number of Teeth	Dimensions (inch)							WT ^{*3}	Insert Screw ^{*1}	Wrench	Anti-seize Lubricant	Insert
				LF	OAL	DCON	BD	L11	H	CRKS ^{*2}					
1.000	APX4000UR162AM12A35	●	2	1.378	2.244	.492	.925	.236	.748	M12	.4	TPS4	TIP15W	MK1KS	AO-T1848
1.125	APX4000UR182AM12A35	●	2	1.378	2.244	.492	.925	.236	.748	M12	.4	TPS4	TIP15W	MK1KS	AO-T1848
1.250	APX4000UR203AM16A40	●	3	1.575	2.480	.669	1.122	.236	.945	M16	.7	TPS4	TIP15W	MK1KS	AO-T1848
1.375	APX4000UR223AM16A40	●	3	1.575	2.480	.669	1.122	.236	.945	M16	.7	TPS4	TIP15W	MK1KS	AO-T1848

*1 Clamp Torque (lbf-in) : TPS4=31, TPS43=31

*2 Clamp Torque of the Head (lbf-ft) : M12=59.2, M16=66.7

*3 WT : Mass (lbs)

METRIC Standard

With Air / coolant through.

DC	Order Number	Stock	Number of Teeth	Dimensions (mm)							WT ^{*3}	Insert Screw ^{*1}	Wrench	Anti-seize Lubricant	Insert
				LF	OAL	DCON	BD	L11	H	CRKS ^{*2}					
25	APX4000R252M12A35	★	2	35	57	12.5	23.5	6	19	M12	0.2	TPS4	TIP15W	MK1KS	AO-T1848
28	APX4000R282M12A35	★	2	35	57	12.5	23.5	6	19	M12	0.2	TPS4	TIP15W	MK1KS	AO-T1848
32	APX4000R322M16A40	★	2	40	63	17	28.5	6	24	M16	0.3	TPS4	TIP15W	MK1KS	AO-T1848
32	APX4000R323M16A40	★	3	40	63	17	28.5	6	24	M16	0.3	TPS4	TIP15W	MK1KS	AO-T1848
35	APX4000R352M16A40	★	2	40	63	17	28.5	6	24	M16	0.3	TPS4	TIP15W	MK1KS	AO-T1848
35	APX4000R353M16A40	★	3	40	63	17	28.5	6	24	M16	0.3	TPS4	TIP15W	MK1KS	AO-T1848
40	APX4000R403M16A40	★	3	40	63	17	28.5	6	24	M16	0.3	TPS43	TIP15W	MK1KS	AO-T1848
40	APX4000R404M16A40	★	4	40	63	17	28.5	6	24	M16	0.3	TPS43	TIP15W	MK1KS	AO-T1848

*1 Clamp Torque (N · m) : TPS4=31, TPS43=31

*2 Clamp Torque of the Head (N · m) : M12=59.2, M16=66.7

*3 WT : Mass (kg)

INSERTS

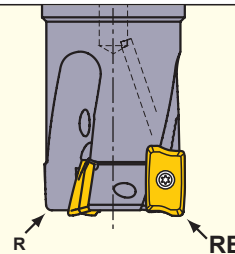
Work Material	P	Steel													Cutting Conditions (Guide) : ● : Stable Cutting ● : General Cutting ✦ : Unstable Cutting Honing : E : Round F : Sharp		
	M	Stainless Steel															
Shape	K	Cast Iron													Geometry 		
	S	Heat-resistant Alloy, Titanium Alloy															
	H	Hardened Steel															
Coated	Order Number	Class	Honing	MC5020	MP6120	MP6130	MP7130	MP9120	MP9130	VP15TF	VP20RT	Dimensions (inch)					
				L	W1	S	BS	RE	Geometry								
General M Breaker 	AOMT184804PEER-M	M	E	●	●	●	●	●	●	●	●	.709	.354	.189	.071	.016	
	AOMT184808PEER-M	M	E	●	●	●	●	●	●	●	●	.709	.354	.189	.055	.031	
	AOMT184810PEER-M	M	E	●	●	●	●	●	●	★	●	.709	.354	.189	.039	.039	
	AOMT184812PEER-M	M	E	●	●	●	●	●	●	●	●	.709	.354	.189	.031	.047	
	AOMT184816PEER-M	M	E	●	●	●	●	●	●	●	●	.709	.354	.189	.016	.063	
	AOMT184820PEER-M	M	E	●	●	●	●	●	●	●	★	●	.709	.354	.189	.016	
Strong Cutting Edge Type H Breaker 	AOMT184804PEER-H	M	E	●	●	●	●	●	●	●	●	.709	.354	.189	.071	.016	
	AOMT184808PEER-H	M	E	●	●	●	●	●	●	●	●	.709	.354	.189	.055	.031	
	AOMT184816PEER-H	M	E	●	●	●	●	●	●	●	●	.709	.354	.189	.016	.063	

(Note) For the recommended cutting conditions, refer to the general catalogue or B055A Tool News.



NOTE ON USE OF INSERTS WITH LARGE CORNER RADII

When using inserts with corner radius $RE \geq R$.125", please machine the holder with a radius form as shown on the right table.



RE	R
.125"	.098"
.157"	B-Holders
.197"	.197"
.250"	C-Holders

R : Holder end radius
RE : Insert corner radius

Or additional B-Holders and C-Holders are available as non stock, produced to order only.
 "Order numbers"; Please replace the last letter "A" of A-Holders to "B" or "C".
 In case of screw-in holders, please add "B" or "C" to the end of the order number of A-Holders.
 Ex) APX4000R08007C~~A~~→APX4000R08007C~~C~~
 APX4000R252M12A35→APX4000R252M12A35~~C~~

SCREW-IN TOOLS

AQX

P

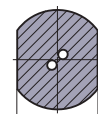
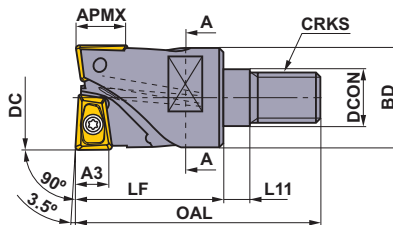
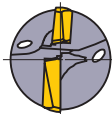
M

K

N

S

H



Section A-A

METRIC Standard

With Air / coolant through.

Right hand tool holder only.

DC	Order Number	Stock	Number of Teeth	Dimensions (mm)									*5 WT	*3 		
				LF	OAL	DCON	BD	L11	H	CRKS ^{*4}	A3 ^{*1}	APMX ^{*2}				
16	AQXR162M08A30	★	2	30	48	8.5	14.7	6	10	M8	4.5	7.4	0.1	TS2A	⌀TKY06F	QO○T0830R
17	AQXF172M08A30	★	2	30	48	8.5	14.5	6	10	M8	4.5	7.4	0.1	TS2A	⌀TKY06F	QO○T0830R
20	AQXR202M10A30	★	2	30	49	10.5	18.6	6	14	M10	6	9.2	0.2	TS25	⌀TKY08F	QO○T1035R
21	AQXF212M10A30	★	2	30	49	10.5	18.5	6	14	M10	6	9.2	0.2	TS25	⌀TKY08F	QO○T1035R
25	AQXR252M12A35	★	2	35	57	12.5	23.5	6	19	M12	7.5	11.5	0.2	TS33	⌀TKY08D	QO○T1342R
26	AQXF262M12A35	★	2	35	57	12.5	23.5	6	19	M12	7.5	11.5	0.2	TS33	⌀TKY08D	QO○T1342R
32	AQXR322M16A40	★	2	40	63	17	28.5	6	24	M16	9.5	14.5	0.3	TS407	⌀TKY15D	QO○T1651R
33	AQXF332M16A40	★	2	40	63	17	28.5	6	24	M16	9.5	14.5	0.3	TS407	⌀TKY15D	QO○T1651R
35	AQXR352M16A40	★	2	40	63	17	28.5	6	24	M16	11	16	0.3	TS407	⌀TKY15D	QO○T1856R
40	AQXF402M16A45	★	2	45	68	17	28.5	6	24	M16	12	18	0.3	TS55	⌀TKY25D	QO○T2062R

*1 Dimension A3 represents the depth of cut when the cutting edge consists of 2 inserts.


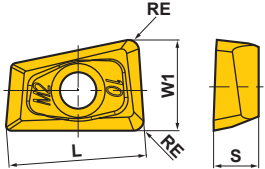

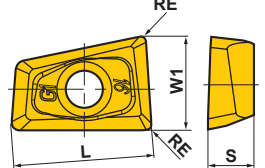
*2 APMX: Maximum depth of cut.

*3 Clamp Torque (lbf-in) : TS2A=5.3, TS25=8.9, TS33=8.9, TS407=31, TS55=66

*4 Clamp Torque of the Head (lbf-ft) : M8=17.1, M10=33.8, M12=59.2, M16=66.7

*5 WT : Mass (kg)

INSERTS

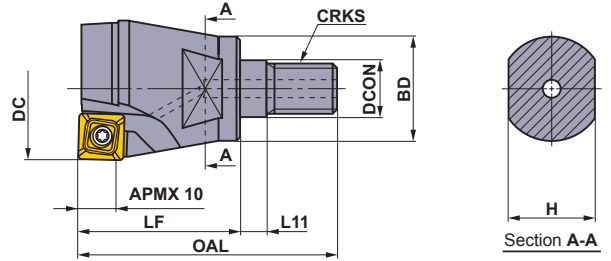
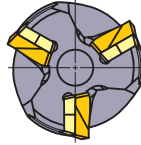
Shape	Order Number	End Mill Dia.	Class	Honing	Coated		Carbide	Dimensions (mm)				Geometry
					VP15TF	VP30RT	HT110	L	W1	S	RE	
M breaker 	QOMT0830R-M2	φ 16,17	M	E	●	●		8.4	5.5	3	0.8	
	QOMT1035R-M2	φ 20,21	M	E	★	★		10.6	7	3.5	0.8	
	QOMT1342R-M2	φ 25,26	M	E	★	★		13.1	8.7	4.2	0.8	
	QOMT1651R-M2	φ 32,33	M	E	●	●		16.5	11	5.1	0.8	
	QOMT1856R-M2	φ 35	M	E	★	★		18	12	5.6	0.8	
	QOMT2062R-M2	φ 40	M	E	★	★		20.4	13.6	6.2	0.8	
G breaker 	QOGT0830R-G1	φ 16,17	G	F*	★		●	8.4	5.5	3	0.4	
	QOGT1035R-G1	φ 20,21	G	F*	★		★	10.6	7	3.5	0.4	
	QOGT1342R-G1	φ 25,26	G	F*	★		★	13.1	8.7	4.2	0.4	
	QOGT1651R-G1	φ 32,33	G	F*	★		●	16.5	11	5.1	0.4	
	QOGT1856R-G1	φ 35	G	F*	★		★	18	12	5.6	0.4	
	QOGT2062R-G1	φ 40	G	F*	★		★	20.4	13.6	6.2	0.4	

*Grade VP15TF has "E" honing.

(Note) For the recommended cutting conditions, refer to the general catalogue or B021A Tool News.

SCREW-IN TOOLS

ASX400



METRIC Standard

With Air / coolant through.

Right hand tool holder only.

DC	Order Number	Stock	Number of Teeth	Dimensions (mm)							*3 WT	*1 Insert Screw	*1 Insert Wrench	Shim	*1 Shim Screw	*1 Shim Wrench
				LF	OAL	DCON	BD	L11	H	CRKS						
32	ASX400R322AM1640	★	2	40	63	17	29	6	24	M16	0.3	TPS35	TIP15T	—	WCS503507H	HKY35R
40	ASX400R403AM1645	★	3	45	68	17	29	6	24	M16	0.3	TPS35	TIP15T	STASX400N	WCS503507H	HKY35R

*1 Clamp Torque (lbf-in) : WCS503507H=44, TPS35=31

*2 Clamp Torque of the Head (lbf-ft) : M16=66.7

*3 WT : Mass (kg)

INSERTS

Application	Shape	Order Number	Class	Honing	Coated											Cermets	Carbide	Dimensions (inch)				Geometry	
					F7010	F7030	MC5020	MP6120	MP6130	MP7130	MP7140	MP9120	MP9130	VP15TF	VP30RT			NX4545	IC	S	BS		RE
																		HT10					
Work Material	P	Steel			●	●		●	●												Cutting Conditions : ● : Stable Cutting ● : General Cutting ✦ : Unstable Cutting Honing : E : Round F : Sharp T : Chamfer		
	M	Stainless Steel			●	●		●	●														
	K	Cast Iron						●	●														
	N	Non-ferrous Metal																					
	S	Heat-resistant Alloy, Titanium Alloy																					
H	Hardened Steel																						
Finish—Light Cutting	JL Breaker	SOET12T308PEER-JL	E	E		●		●	●	●	●	●	●	●	●				.500	.156	.055	.031	
Light—Rough Cutting	JM Breaker	SOMT12T308PEER-JM	M	E	●	●		●	●	●	●	●	●	●	●				.500	.156	.055	.031	
Medium—Heavy Cutting	JH Breaker	SOMT12T308PEER-JH	M	E	●	●		●	●	●	●	●	●	●	●				.500	.156	.055	.031	
Heavy/Interrupted Cutting	FT Breaker	SOMT12T320PEER-FT	M	E		●	●				●	●	●						.500	.156	.055	.079	
For Aluminium Alloy	JP Breaker	SOGT12T308PEFR-JP	G	F															.500	.156	.055	.031	

(Note) For the recommended cutting conditions, refer to the general catalogue or B023A Tool News.



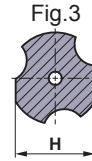
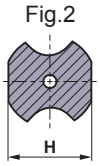
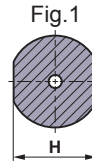
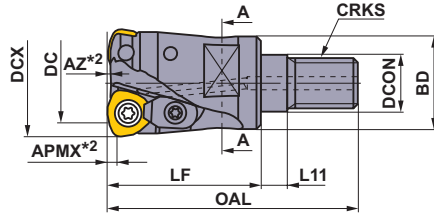
WIPER INSERTS

Shape	Order Number	Class	Honing	Carbide	Cermets	Dimensions (inch)					Geometry
				HT105T	NX2525	L	W1	S	BS	RE	
	WOEW12T308PEER8C	E	E	●		.492	.520	.156	.315	.031	
	WOEW 12T308PETR8C	E	T		●	.492	.520	.156	.315	.031	

(Note) For the recommended cutting conditions, refer to the general catalogue or B023A Tool News.

SCREW-IN TOOLS

AJX



Section A-A

Air / coolant through.

Right hand tool holder only.

DCX	Order Number	Stock	Number of Teeth	Dimensions (inch)								WT ^{*3}	Type (Fig.)
				DC	LF	OAL	DCON	BD	L11	H	CRKS ^{*1}		
.625	AJXU06R102AM0830	●	2	.346	1.181	1.890	.335	.512	.236	.394	M8	.2	1
.750	AJXU08R122AM1030	●	2	.417	1.181	1.929	.413	.709	.236	.551	M10	.2	2
.750	AJXU06R123AM1030	●	3	.472	1.181	1.929	.413	.709	.236	.551	M10	.2	3
.875	AJXU08R142AM1030	●	2	.535	1.181	1.929	.413	.709	.236	.551	M10	.2	2
.875	AJXU06R143AM1030	●	3	.595	1.181	1.929	.413	.709	.236	.551	M10	.2	3
1.000	AJXU09R162AM1235	●	2	.602	1.378	2.244	.492	.827	.236	.748	M12	.4	2
1.000	AJXU08R163AM1235	●	3	.661	1.378	2.244	.492	.827	.236	.748	M12	.2	1
1.125	AJXU09R182AM1235	●	2	.728	1.378	2.244	.492	.827	.236	.748	M12	.4	2
1.125	AJXU08R183AM1235	●	3	.784	1.378	2.244	.492	.827	.236	.748	M12	.2	1
1.250	AJXU09R203AM1645	●	3	.854	1.772	2.677	.669	1.142	.236	.945	M16	.4	1
1.375	AJXU09R223AM1645	●	3	.976	1.772	2.677	.669	1.142	.236	.945	M16	.4	1

*1 Clamp Torque of the Head (lbf-ft) : M8=17.1, M10=33.8, M12=59.2, M16=66.7

*2 Refer to page 13 for the max. depth of cut (APMX), and maximum drilling depth (AZ)

*3 WT : Mass (lbs)

SPARE PARTS

DCX	Order Number	*1			*1		
		Insert Screw	Insert Wrench	Clamp Bridge	Clamp Bridge Screw	Spring	Insert
.625	AJXU06R102AM0830	TS25	①TKY08F	—	—	—	JOM [○] 06
.750	AJXU08R122AM1030	TS33	①TKY08D	—	—	—	JOM [○] 08
.750	AJXU06R123AM1030	TS25	①TKY08F	—	—	—	JOM [○] 06
.875	AJXU08R142AM1030	TS33	①TKY08D	—	—	—	JOM [○] 08
.875	AJXU06R143AM1030	TS25	①TKY08F	—	—	—	JOM [○] 06
1.000	AJXU09R162AM1235	TS351	②TKY10D	AMS3	AJS3010T10	ASS2	JDM [○] 09
1.000	AJXU08R163AM1235	TS33	①TKY08D	—	—	—	JOM [○] 08
1.125	AJXU09R182AM1235	TS351	②TKY10D	AMS3	AJS3010T10	ASS2	JDM [○] 09
1.125	AJXU08R183AM1235	TS33	①TKY08D	—	—	—	JOM [○] 08
1.250	AJXU09R203AM1645	TS351	②TKY10D	AMS3	AJS3010T10	ASS2	JDM [○] 09
1.375	AJXU09R223AM1645	TS351	②TKY10D	AMS3	AJS3010T10	ASS2	JDM [○] 09

*1 Clamp Torque (lbf-in) : TS25=8.9, TS33=8.9, TS351=22, TS407=31, TS43=31, AJS3010T10=22, AJS4012T15=31

● : Inventory maintained. ★ : Inventory maintained in Japan.

<10 inserts in one case>

METRIC Standard







With Air / coolant through.

DCX	Order Number	Stock	Number of Teeth	Dimensions (mm)								WT ^{*2}	Type (Fig.)
				DC	LF	OAL	DCON	BD	L11	H	CRKS ^{*1}		
16	AJX06R162AM0830	★	2	8.9	30	48	8.5	13	6	10	M8	0.1	1
17	AJX06R172AM0830	★	2	9.9	30	48	8.5	13	6	10	M8	0.1	1
20	AJX08R202AM1030	★	2	11.4	30	49	10.5	18	6	14	M10	0.1	2
20	AJX06R203AM1030	★	3	12.9	30	49	10.5	18	6	14	M10	0.1	3
22	AJX08R222AM1030	★	2	13.4	30	49	10.5	18	6	14	M10	0.1	2
22	AJX06R223AM1030	★	3	14.9	30	49	10.5	18	6	14	M10	0.1	3
25	AJX09R252AM1235	★	2	14.9	35	57	12.5	21	6	19	M12	0.2	2
25	AJX08R253AM1235	★	3	16.4	35	57	12.5	21	6	19	M12	0.1	1
28	AJX09R282AM1235	★	2	17.9	35	57	12.5	21	6	19	M12	0.2	2
30	AJX12R302AM1645	★	2	18.3	45	68	17	29	6	24	M16	0.3	2
28	AJX08R283AM1235	★	3	19.4	35	57	12.5	21	6	19	M12	0.1	1
30	AJX09R303AM1645	★	3	20.0	45	68	17	29	6	24	M16	0.2	1
32	AJX12R322AM1645	★	2	20.3	45	68	17	29	6	24	M16	0.3	2
32	AJX09R323AM1645	★	3	21.9	45	68	17	29	6	24	M16	0.2	1
35	AJX12R352AM1645	★	2	23.3	45	68	17	29	6	24	M16	0.3	2
35	AJX09R353AM1645	★	3	24.9	45	68	17	29	6	24	M16	0.2	1
40	AJX12R403AM1645	★	3	28.3	45	68	17	29	6	24	M16	0.3	2
40	AJX09R404AM1645	★	4	29.9	45	68	17	29	6	24	M16	0.2	1

*1 Clamp Torque of the Head (lbf-ft) : M8=17.1, M10=33.8, M12=59.2, M16=66.7

*2 WT : Mass (kg)

SPARE PARTS

DCX	Order Number	 *1			 *1		
		Insert Screw	Insert Wrench	Clamp Bridge	Clamp Bridge Screw	Spring	Insert
16	AJX06R162AM0830	TS25	①TKY08F	—	—	—	JOM06
17	AJX06R172AM0830	TS25	①TKY08F	—	—	—	JOM06
20	AJX08R202AM1030	TS33	①TKY08D	—	—	—	JOM08
20	AJX06R203AM1030	TS25	①TKY08F	—	—	—	JOM06
22	AJX08R222AM1030	TS33	①TKY08D	—	—	—	JOM08
22	AJX06R223AM1030	TS25	①TKY08F	—	—	—	JOM06
25	AJX09R252AM1235	TS351	②TKY10D	AMS3	AJS3010T10	ASS2	JOM09
25	AJX08R253AM1235	TS33	①TKY08D	—	—	—	JOM08
28	AJX09R282AM1235	TS351	②TKY10D	AMS3	AJS3010T10	ASS2	JOM09
30	AJX12R302AM1645	TS407	②TKY15D	AMS4	AJS4012T15	ASS2	JOM12
28	AJX08R283AM1235	TS33	①TKY08D	—	—	—	JOM08
30	AJX09R303AM1645	TS351	②TKY10D	AMS3	AJS3010T10	ASS2	JOM09
32	AJX12R322AM1645	TS43	②TKY15D	AMS4	AJS4012T15	ASS2	JOM12
32	AJX09R323AM1645	TS351	②TKY10D	AMS3	AJS3010T10	ASS2	JOM09
35	AJX12R352AM1645	TS43	②TKY15D	AMS4	AJS4012T15	ASS2	JOM12
35	AJX09R353AM1645	TS351	②TKY10D	AMS3	AJS3010T10	ASS2	JOM09
40	AJX12R403AM1645	TS43	②TKY15D	AMS4	AJS4012T15	ASS2	JOM12
40	AJX09R404AM1645	TS351	②TKY10D	AMS3	AJS3010T10	ASS2	JOM09

*1 Clamp Torque (lbf-in) : TS25=8.9, TS33=8.9, TS351=22, TS407=31, TS43=31, AJS3010T10=22, AJS4012T15=31

SCREW-IN TOOLS

INSERTS

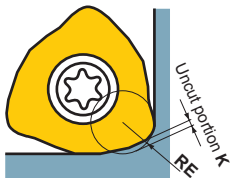
Work Material	P	Steel	●	●	●	●	●	●	●	●	●	●	●	Cutting Conditions : ● : Stable Cutting ● : General Cutting ✖ : Unstable Cutting						
	M	Stainless Steel	●	●	●	●	●	●	●	●	●	●	●							
Shape	K	Cast Iron	●	●	●	●	●	●	●	●	●	●	●	Coated	Dimensions (inch)					Geometry
	S	Heat-resistant Alloy, Titanium Alloy	●	●	●	●	●	●	●	●	●	●	●		AN	IC	S	BS	RE	
H	Hardened Materials	●	●	●	●	●	●	●	●	●	●	●	●	AN	IC	S	BS	RE		
	Order Number	Class	FHT020	MP6120	MP6130	MP7130	MP7140	MP9120	MP9130	VP15TF	VP30RT	AN	IC	S	BS	RE	Geometry			
	JOMW06T215ZZSR-FT	M	●	●	●	●	●	●	●	●	●	13°	.250	.109	.047	.059				
	JOMW080320ZZSR-FT	M	●	●	●	●	●	●	●	●	●	13°	.315	.125	.055	.079				
	JDMW09T320ZDSR-FT	M	●	●	●	●	●	●	●	●	●	15°	.375	.156	.071	.079				
	JDMW120420ZDSR-FT	M	●	●	●	●	●	●	●	●	●	15°	.472	.187	.098	.079				
Strong Cutting Edge	JDMT120420ZDSR-ST	M	●	●	●	●	●	●	●	●	●	15°	.472	.187	.098	.079				
	JOMT06T216ZZER-JL	M				●	●	●	●			13°	.250	.109	.047	.071				
	JOMT080322ZZER-JL	M				●	●	●	●			13°	.315	.125	.055	.102				
	JDMT09T323ZDER-JL	M				●	●	●	●			15°	.375	.156	.071	.091				
	JDMT120423ZDER-JL	M				●	●	●	●			15°	.472	.187	.098	.091				
Lower Cutting Resistance	JOMT06T215ZZSR-JM	M	●	●	●	●	●	●	●	●	●	13°	.250	.109	.047	.059				
	JOMT080320ZZSR-JM	M	●	●	●	●	●	●	●	●	●	13°	.315	.125	.055	.079				
	JDMT09T320ZDSR-JM	M	●	●	●	●	●	●	●	●	●	15°	.375	.156	.071	.079				
	JDMT120420ZDSR-JM	M	●	●	●	●	●	●	●	●	●	15°	.472	.187	.098	.079				

(Note) For the recommended cutting conditions, refer to the general catalogue or B028A Tool News.

(Note) Setting heights for ST chipbreaker and the other chipbreakers differ slightly.
If an ST type chipbreaker is used, please check the tool length offset height.



NOTE FOR PROGRAMMING



When using the **AJX**, please program the approximate radius as indicated.
The approximate uncut portions for the program are as follows.

Holder Type	Insert size	Breaker	Approx. RE(inch)	Uncut portion K(inch)	APMX	AZ	
AJXU06	AJX06	JOM06	FT/JM/ST	.079	.013	.039	.012
		JL	.098	.013	.024	.012	
AJXU08	AJX08	JOM08	FT/JM/ST	.098	.018	.059	.020
		JL	.079	.016	.035	.020	
AJXU09	AJX09	JDM09	FT/JM/ST	.118	.019	.079	.039
		JL	.118	.018	.047	.039	
—	AJX12	JDM12	FT/JM/ST	.118	.025	.079	.059
		JL	.118	.021	.047	.059	

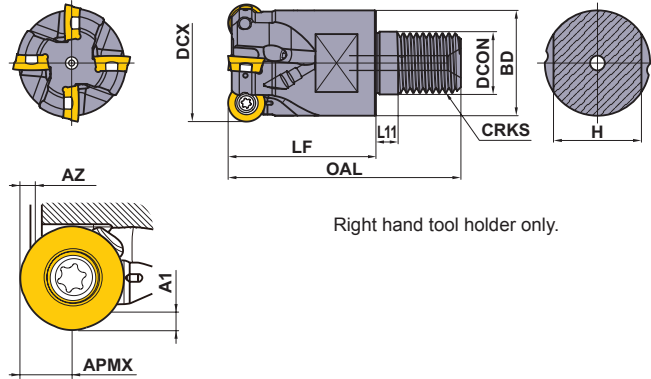
(Note) The uncut portion may change slightly depending on cutting conditions.

● : Inventory maintained. ★ : Inventory maintained in Japan.
<10 inserts in one case>

SCREW-IN TOOLS

ARP

P M K N S H



Right hand tool holder only.

With Air / coolant through. GAMP:+4°
GAMF:-6°--7°

DCX	Order Number	Stock	Number of Teeth	Dimensions (inch)								WT ^{*2}	APMX	A1	AZ
				RE (APMX)	LF	OAL	DCON	BD	L11	H	CRKS ^{*1}				
NEW 1.000	ARP5UPR1603AM1235	●	3	.197	1.378	2.244	.492	.925	.236	.748	M12	.198	.197	—	.016
NEW 1.250	ARP5UPR2004AM1640	●	4	.197	1.575	2.480	.669	1.122	.236	.945	M16	.397	.197	.039	.026
NEW 1.250	ARP6UPR2003AM1640	●	3	.236	1.575	2.480	.669	1.122	.236	.945	M16	.375	.236	.039	.024
NEW 1.500	ARP6UPR2404AM1640	●	4	.236	1.575	2.480	.669	1.122	.236	.945	M16	.441	.236	.098	.045

*1 Clamp Torque of the Head (lbf-ft) : M12=59.2, M16=66.7

*2 WT : Mass (lbs)

SPARE PARTS

DCX	Order Number	*1			
1.000	ARP5UPR1603AM1235	TPS351B	TIP10D	MK1KS	RPOT1040
1.250	ARP5UPR2004AM1640	TPS351B	TIP10D	MK1KS	RPOT1040
1.250	ARP6UPR2003AM1640	TPS4	TIP15D	MK1KS	RPOT1248
1.500	ARP6UPR2404AM1640	TPS4	TIP15D	MK1KS	RPOT1248

*1 Clamp Torque (lbf-in) : TPS351B = 22, TPS4 = 31

	≤140PSI (≤5.3gal/min)	←Standard→ (140PSI-720PSI)	≥720PSI (≥7.9gal/min)	≥1000PSI (≥13.2gal/min)
Nozzle Dia.	ø.024"	ø.031"	ø.047"	ø.063"
Order Number	HSD04004H06	HSD04004H08	HSD04004H12	HSD04004H16

Select and use alternate nozzles from below list depending on coolant pressure.

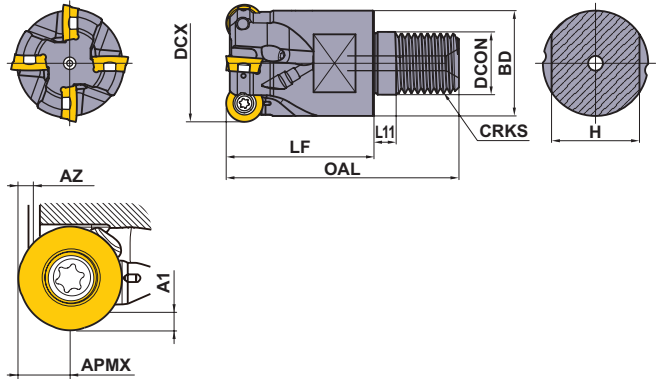
Clamp Torque (lbf-in) : HSD0400H=13

The part number for a plug screw without a through nozzle is HSS04004.

SCREW-IN TOOLS

ARP

P M K N S H



METRIC Standard

With Air / coolant through.

GAMP: +4°
GAMF: -6° - -7°

Right hand tool holder only.

DCX	Order Number	Stock	Number of Teeth	Dimensions (mm)								WT ^{*2}	APMX	A1	AZ
				RE (APMX)	LF	OAL	DCON	BD	L11	H	CRKS ^{*1}				
25	ARP5PR2502AM1235	★	2	5	35	57	12.5	23.5	6	19	M12	0.1	5	—	0.4
25	ARP5PR2503AM1235	★	3	5	35	57	12.5	23.5	6	19	M12	0.09	5	1	0.65
32	ARP5PR3203AM1640	★	3	5	40	63	17	28.5	6	24	M16	0.16	5	—	0.4
32	ARP5PR3204AM1640	★	4	5	40	63	17	28.5	6	24	M16	0.15	5	1	0.65
32	ARP6PR3202AM1640	★	2	6	40	63	17	28.5	6	24	M16	0.18	6	1	0.6
32	ARP6PR3203AM1640	★	3	6	40	63	17	28.5	6	24	M16	0.17	6	2.5	1.15
40	ARP6PR4003AM1640	★	3	6	40	63	17	28.5	6	24	M16	0.2	6	1	0.6
40	ARP6PR4004AM1640	★	4	6	40	63	17	28.5	6	24	M16	0.2	6	2.5	1.15

*1 Clamp Torque of the Head (lbf-ft) : M12=59.2, M16=66.7

*2 WT : Mass (kg)


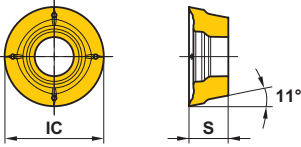
SPARE PARTS

DCX	Order Number	Stock	*1		
			Insert Screw	Wrench	Insert
25	ARP5PR2502AM1235	★	TPS351B	TIP10D	RPOT1040
25	ARP5PR2503AM1235	★	TPS351B	TIP10D	RPOT1040
32	ARP5PR3203AM1640	★	TPS351B	TIP10D	RPOT1040
32	ARP5PR3204AM1640	★	TPS351B	TIP10D	RPOT1040
32	ARP6PR3202AM1640	★	TPS4	TIP15D	RPOT1248
32	ARP6PR3203AM1640	★	TPS4	TIP15D	RPOT1248
40	ARP6PR4003AM1640	★	TPS4	TIP15D	RPOT1248
40	ARP6PR4004AM1640	★	TPS4	TIP15D	RPOT1248

*1 Clamp Torque (lbf-in) : TPS351B = 22, TPS4 = 31

● : Inventory maintained. ★ : Inventory maintained in Japan.
<10 inserts in one case>

INSERTS

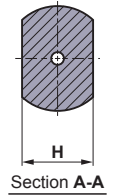
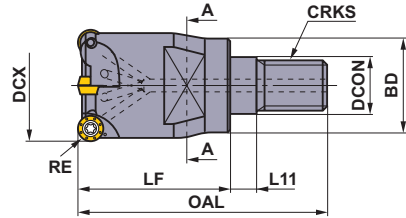
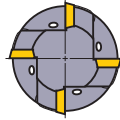
Work Material	P	Steel								Cutting Conditions (Guide) : ● : Stable Cutting ● : General Cutting ✖ : Unstable Cutting Honing : E : Round				
	M	Stainless Steel	●	●										
Shape	K	Cast Iron								Dimensions (mm) IC S Geometry				
	N	Non-ferrous Metal												
	S	Heat-resistant Alloy, Titanium Alloy			✖									
Order Number	H	Hardened Steel												
	Class		Honing	Coated			Cermet	Carbide	Dimensions (mm)		Geometry			
MC7020	MP7130	MP9130					IC	S						
	Ground	RPHT1040M0E4-L	H	E	●	●	●				10	3.97		
		RPHT1040M0E4-M	H	E	●	●	●					10		3.97
		RPHT1040M0E4-R	H	E	●	●	●					10		3.97
		RPHT1248M0E4-L	H	E	●	●	●					12		4.76
		RPHT1248M0E4-M	H	E	●	●	●					12		4.76
		RPHT1248M0E4-R	H	E	●	●	●					12		4.76
	Sintered	RPMT1040M0E4-L	M	E	●	●	●					10		3.97
		RPMT1040M0E4-M	M	E	●	●	●					10		3.97
		RPMT1040M0E4-R	M	E	●	●	●					10		3.97
		RPMT1248M0E4-L	M	E	●	●	●					12		4.76
		RPMT1248M0E4-M	M	E	●	●	●					12		4.76
		RPMT1248M0E4-R	M	E	●	●	●					12		4.76

(Note) For the recommended cutting conditions, refer to the B222A Tool News.

SCREW-IN TOOLS

ARX

- P
M
K
N
S
H



METRIC Standard

With Air / coolant through.

Right hand tool holder only.

DCX	Order Number	Stock	Number of Teeth	Dimensions (mm)								*3 WT	*1 		
				RE	LF	OAL	DCON	BD	L11	H	CRKS				
16	ARX25R163M08A30	★	3	2.5	30	48	8.5	14.7	6	10	M8	0.1	TPS20	TIP06F	RDMW0517
16	ARX30R163M08A30	★	3	3	30	48	8.5	14.6	6	10	M8	0.1	TPS22	TIP07FS	RDMW0620
17	ARX25R173M08A30	★	3	2.5	30	48	8.5	14.5	6	10	M8	0.1	TPS20	TIP06F	RDMW0517
17	ARX30R173M08A30	★	3	3	30	48	8.5	14.5	6	10	M8	0.1	TPS22	TIP07FS	RDMW0620
20	ARX25R204M10A30	★	4	2.5	30	49	10.5	18.6	6	14	M10	0.2	TPS20	TIP06F	RDMW0517
20	ARX30R203M10A30	★	3	3	30	49	10.5	18.5	6	14	M10	0.2	TPS22	TIP07FS	RDMW0620
22	ARX25R224M10A30	★	4	2.5	30	49	10.5	18.5	6	14	M10	0.2	TPS20	TIP06F	RDMW0517
22	ARX30R224M10A30	★	4	3	30	49	10.5	18.5	6	14	M10	0.2	TPS22	TIP07FS	RDMW0620
25	ARX25R255M12A35	★	5	2.5	35	57	12.5	23.6	6	19	M12	0.2	TPS20	TIP06F	RDMW0517
25	ARX30R254M12A35	★	4	3	35	57	12.5	23.4	6	19	M12	0.2	TPS22	TIP07FS	RDMW0620

*1 Clamp Torque (lbf-in) : TPS20=5.3, TPS22=5.3

*2 Clamp Torque of the Head (lbf-ft) : M8=17.1, M10=33.8, M12=59.2

*3 WT : Mass (kg)

INSERTS

Shape	Order Number	Coated		Dimensions (mm)		Geometry
		VP15TF	MP8010	IC	S	
	RDMW0517M0E	★	★	5.0	1.70	
	RDMW0620M0E	★	★	6.0	1.99	
	RDMW0724M0E	★	★	7.0	2.38	

(Note) For the recommended cutting conditions, refer to the general catalogue or B066A Tool News.

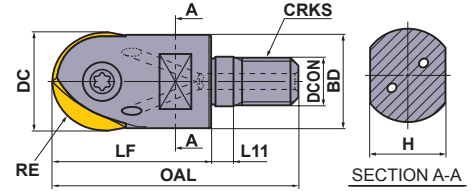
● : Inventory maintained. ★ : Inventory maintained in Japan.

<10 inserts in one case>

SCREW-IN TOOLS

SRF

- P
- M
- K
- N
- S
- H



Ball nose and corner radius
With Air / coolant through.




Right hand tool holder only.

DC	Insert Type	Order Number	Stock	Number of Teeth	Dimensions (inch)								WT
					RE	LF	OAL	DCON	BD	L11	H	CRKS	
.625	SRFT0625	SRFHU10AM0830	●	1	.3125	1.181	1.890	.335	.587	.236	.394	M8	.2
.750	SRFT0750	SRFHU12AM1035	●	1	.3750	1.378	2.126	.413	.724	.236	.551	M10	.2

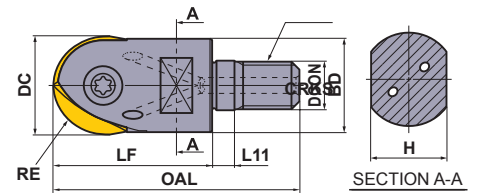
*1 Ball nose type only
*2 WT : Mass (lbs)



SPARE PARTS

Order Number	 *1 Insert Screw	 Insert Wrench	 Anti-seizure Lubricant
SRFHU10AM0830	RS4015T	TKY15T	MK1KS
SRFHU12AM1035	RS5020T	TKY20T	MK1KS

*1 Clamp Torque (lbf-in) : RS4015T=29, RS5020T=44,



METRIC Standard

Ball nose and corner radius type share the same respective holder
With Air/coolant though.

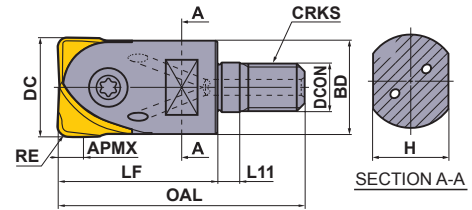
Right hand tool holder only.

DC	Insert Type	Order Number	Stock	Number of Teeth	Dimensions (mm)							WT	
					RE	LF	OAL	DCON	BD	L11	H		CRKS
16	SRFT16	SRFH16AM0830	★	1	8	30	48	8.5	14.9	6	10	M8	0.1
20	SRFT20	SRFH20AM1035	★	1	10	35	54	10.5	18.4	6	14	M10	0.1
25	SRFT25	SRFH25AM1240	★	1	12.5	40	62	12.5	23.5	6	19	M12	0.1
30	SRFT30	SRFH30AM1645	★	1	15	45	68	17	28.1	6	24	M16	0.2
32	SRFT32	SRFH30AM1645	★	1	16	46	69	17	28.1	6	24	M16	0.2

*1 Ball nose type only

*2 WT : Mass (kg)

SCREW-IN TOOLS



METRIC Standard




Ball nose and corner radius shared holder
 The dimensions of the case of using corner radius insert
 With Air/coolant though.

Right hand tool holder only.

DC	Insert Type	Order Number	Stock	Number of Teeth	Dimensions (mm)						WT	
					LF	OAL	DCON	BD	L11	H		CRKS
16	SUFT16R	SRFH16AM0830	★	1	30	48	8.5	14.9	6	10	M8	0.1
20	SUFT20R	SRFH20AM1035	★	1	35	54	10.5	18.4	6	14	M10	0.1
25	SUFT25R	SRFH25AM1240	★	1	40	62	12.5	23.5	6	19	M12	0.1
30	SUFT30R	SRFH30AM1645	★	1	45	68	17	28.1	6	24	M16	0.2
32	SUFT32R	SRFH30AM1645	★	1	46	69	17	28.1	6	24	M16	0.2

*1 WT : Mass (kg)

SPARE PARTS


Order Number	 *1		
	Insert Screw	Insert Wrench	Anti-seizure Lubricant
SRFHU10AM0830	RS4015T	TKY15T	MK1KS
SRFHU12AM1035	RS5020T	TKY20T	MK1KS
SRFH25AM1240	RS6025T	TKY25T	MK1KS
SRFH30AM1645	RS8030T	TKY30T	MK1KS

(Note 1) Fit inserts in the right direction. (Refer to the general catalogue or B065A Tool News)

(Note 2) Inch type insert can not be installed on the metric holder.

*1 Clamp Torque (lbf-in) : RS4015T=29, RS5020T=44, RS6025T=66, RS8030T=88



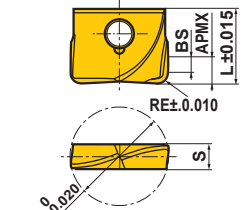
INSERTS

Shape	Order Number	Coated			Dimensions (inch)						Geometry	
		MP8010	EP6120	VP15TF	DC	PRFRAD	RE	L	BS	S		APMX
			SRFT0625	●	●	●	.625	.3125	—	.472		.039
SRFT0750	●	●	●	.750	.3750	—	.591	.039	.197	—		
SRFT1000	●	●	●	1.000	.5000	—	.728	.039	.236	—		
SRFT1250	●	●	●	1.250	.6250	—	.925	.039	.276	—		

(Note) For the recommended cutting conditions, refer to the general catalogue or B066A Tool News.



METRIC Standard

Shape	Order Number	Coated			Dimensions (mm)						Geometry	
		MP8010	EP6120	VP15TF	DC	PRFRAD	RE	L	BS	S		APMX
			SRFT16	★	★	★	16	8 (.3150")	—	12		1
SRFT20	★	★	★	20	10 (.3937")	—	15	1	5	—		
SRFT25	★	★	★	25	12.5 (.4921")	—	18.5	1	6	—		
SRFT30	★	★	★	30	15 (.5906")	—	22.5	1	7	—		
SRFT32	★	★	★	32	16 (.6299")	—	23.5	1	7	—		
	SUFT16R05	★	★	★	16	—	0.5 (.0197")	12	1.6	4	2.1	
SUFT16R10	★	★	★	16	—	1 (.0394")	12	1.6	4	2.6		
SUFT16R15	★	★	★	16	—	1.5 (.0591")	12	1.6	4	3.1		
SUFT16R20	★	★	★	16	—	2 (.0787")	12	1.6	4	3.6		
SUFT16R30	★	★	★	16	—	3 (.1181")	12	1.6	4	4.6		
SUFT20R05	★	★	★	20	—	0.5 (.0197")	15	2	5	2.5		
SUFT20R10	★	★	★	20	—	1 (.0394")	15	2	5	3		
SUFT20R15	★	★	★	20	—	1.5 (.0591")	15	2	5	3.5		
SUFT20R20	★	★	★	20	—	2 (.0787")	15	2	5	4		
SUFT20R30	★	★	★	20	—	3 (.1181")	15	2	5	5		
SUFT25R05	★	★	★	25	—	0.5 (.0197")	18.5	2.5	6	3		
SUFT25R10	★	★	★	25	—	1 (.0394")	18.5	2.5	6	3.5		
SUFT25R20	★	★	★	25	—	2 (.0787")	18.5	2.5	6	4.5		
SUFT25R30	★	★	★	25	—	3 (.1181")	18.5	2.5	6	5.5		
SUFT30R05	★	★	★	30	—	0.5 (.0197")	22.5	3	7	3.5		
SUFT30R10	★	★	★	30	—	1 (.0394")	22.5	3	7	4		
SUFT30R20	★	★	★	30	—	2 (.0787")	22.5	3	7	5		
SUFT30R30	★	★	★	30	—	3 (.1181")	22.5	3	7	6		
SUFT32R05	★	★	★	32	—	0.5 (.0197")	23.5	3.2	7	3.7		
SUFT32R10	★	★	★	32	—	1 (.0394")	23.5	3.2	7	4.2		
SUFT32R20	★	★	★	32	—	2 (.0787")	23.5	3.2	7	5.2		

(Note) For the recommended cutting conditions, refer to the general catalogue or B066A Tool News.

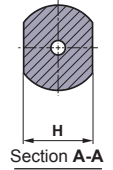
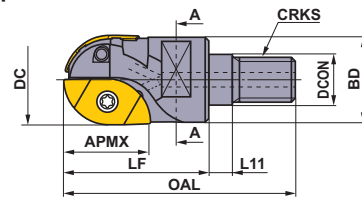


SCREW-IN TOOLS

SRM2

P M K N S H

● Standard Type



With Air / coolant through.








Right hand tool holder only.

DC	Order Number	Stock	Dimensions (inch)								WT ^{*2}
			RE	LF	OAL	DCON	BD	L11	H	CRKS ^{*1}	
.750	SRM212AM10S35	●	.375	1.378	2.126	.413	.701	.236	.551	M10	.2
1.000	SRM216AM12S40	●	.500	1.575	2.441	.492	.933	.236	.748	M12	.4
1.250	SRM220AM16S45	●	.625	1.772	2.677	.669	1.169	.236	.945	M16	.4

*1 Clamp Torque of the Head (lbf-ft) : M10=33.8, M12=59.2, M16=66.7

*2 WT : Mass (lbs)

SPARE PARTS

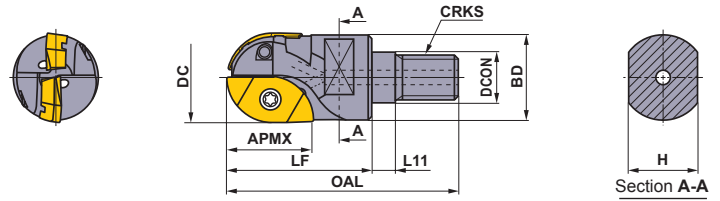
DC	Order Number	Stock	 *1	 *1	 ① ②				
			Insert Screw Inner,Outer	Insert Screw Peripheral	Insert Wrench	Insert Wrench	Insert Inner	Insert Outer	Insert Peripheral
.750	SRM212AM10S35	●	TS32	—	①TKY08D	—	SRM212C	SRM212E	—
1.000	SRM216AM12S40	●	TS43	TS25	②TKY15T	—	SRM216C	SRM216E	—
1.250	SRM220AM16S45	●	TS55	TS43	②TKY25T	TKY15F	SRM220C	SRM216E	—

*1 Clamp Torque (lbf-in) : TS32=8.9, TS43=31, TS55=66

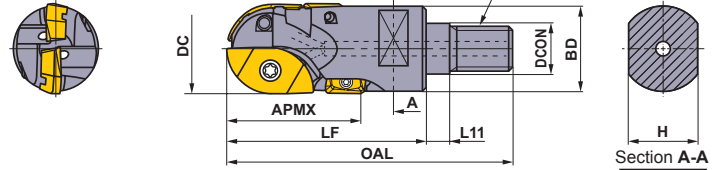
● : Inventory maintained. ★ : Inventory maintained in Japan.
<10 inserts in one case>



● Standard Type Fig.1



● Long Type Fig.2



METRIC Standard

With Air / coolant through.

Right hand tool holder only.

DC	Order Number	Stock	Dimensions (mm)								WT ^{*2}	Type (Fig.)
			RE	LF	OAL	DCON	BD	L11	H	CRKS ^{*1}		
16	SRM2160AM08S30	★	8	30	48	8.5	14.6	6	10	M8	0.1	1
20	SRM2200AM10L45	★	10	45	64	10.5	18.6	6	14	M10	0.2	2
20	SRM2200AM10S35	★	10	35	54	10.5	18.6	6	14	M10	0.1	1
25	SRM2250AM12L55	★	12.5	55	77	12.5	23.5	6	19	M12	0.3	2
25	SRM2250AM12S40	★	12.5	40	62	12.5	23.5	6	19	M12	0.2	1
30	SRM2300AM16L60	★	15	60	83	17	28.3	6	24	M16	0.3	2
30	SRM2300AM16S45	★	15	45	68	17	28.3	6	24	M16	0.2	1
32	SRM2320AM16L60	★	16	60	83	17	29	6	24	M16	0.3	2
32	SRM2320AM16S45	★	16	45	68	17	30	6	24	M16	0.2	1

*1 Clamp Torque of the Head (lbf-ft) : M8=17.1, M10=33.8, M12=59.2, M16=66.7


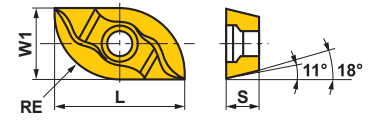

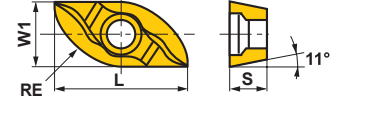

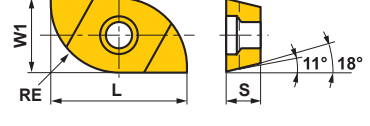

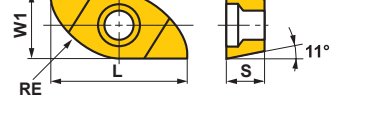

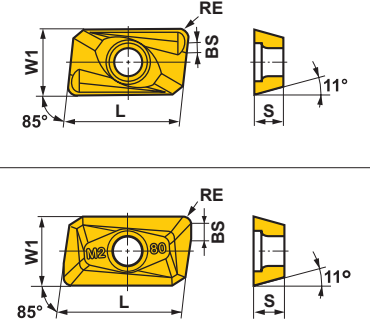

*2 WT : Mass (kg)

SPARE PARTS

DC	Order Number	Stock	*1	*1	① ②				
			Insert Screw Inner,Outer	Insert Screw Peripheral	Insert Wrench	Insert Wrench	Insert Inner	Insert Outer	Insert Peripheral
16	SRM2160AM08S30	★	TS25H	—	TKY08D	—	SR \odot 16C	SR \odot 16E	—
20	SRM2200AM10L45	★	TS32	TS25	TKY08D	—	SR \odot 20C	SR \odot 20E	APMT1135
20	SRM2200AM10S35	★	TS32	—	TKY08D	—	SR \odot 20C	SR \odot 20E	—
25	SRM2250AM12L55	★	TS43	TS25	TKY15T	TKY08F	SR \odot 25C	SR \odot 25E	APMT1135
25	SRM2250AM12S40	★	TS43	TS25	TKY15T	—	SR \odot 25C	SR \odot 25E	—
30	SRM2300AM16L60	★	TS55	TS43	TKY25T	TKY15F	SR \odot 30C	SR \odot 30E	APMT1604
30	SRM2300AM16S45	★	TS55	—	TKY15T	TKY08F	SR \odot 30C	SR \odot 30E	—
32	SRM2320AM16L60	★	TS55	TS43	TKY25T	TKY15F	SR \odot 32C	SR \odot 32E	APMT1604
32	SRM2320AM16S45	★	TS55	TS43	TKY25T	TKY15F	SR \odot 32C	SR \odot 32E	—

*1 Clamp Torque (lbf-in) : TS25H=8.9, TS25=8.9, TS32=8.9, TS43=31, TS55=66

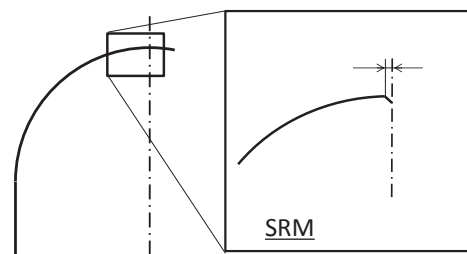
INSERTS

Type	Shape	Order Number	Class	Coated			Dimensions (inch)					Geometry
				MP6120	MP9120	VP15TF	RE	L	W1	S	BS	
Inner		SRM210C-M	M	●	●	●	.313	.630	.323	.138	—	
		SRM212C-M	M	●	●	●	.375	.748	.385	.169	—	
		SRM216C-M	M	●	●	●	.500	.945	.512	.216	—	
		SRM220C-M	M	●	●	●	.625	1.102	.638	.275	—	
Outer		SRM210E-M	M	●	●	●	.313	.531	.258	.138	—	
		SRM212E-M	M	●	●	●	.375	.610	.315	.169	—	
		SRM216E-M	M	●	●	●	.500	.807	.409	.216	—	
		SRM220E-M	M	●	●	●	.625	.964	.520	.275	—	
Inner	Strong Cutting Edge Type 	SRM212C	M	●	●	●	.375	.748	.385	.169	—	
		SRM216C	M	●	●	●	.500	.945	.512	.216	—	
		SRM220C	M	●	●	●	.625	1.102	.638	.275	—	
Outer	Strong Cutting Edge Type 	SRM212E	M	●	●	●	.375	.610	.315	.169	—	
		SRM216E	M	●	●	●	.500	.807	.409	.216	—	
		SRM220E	M	●	●	●	.625	.964	.520	.275	—	
Peripheral	Strong Cutting Edge Type 	APMT1135PDER-H2	M			●	.031	.433	.250	.138	.047	
		APMT1604PDER-H2	M			●	.031	.650	.375	.187	.055	
	Low Resistance Type 	APMT1135PDER-M2	M			●	.031	.433	.250	.138	.047	
		APMT1604PDER-M2	M			●	.031	.650	.375	.187	.055	

(Note) The M type breaker (APMT....PDER-M2) is the first recommendation for its excellent cutting performance. Please use H type breakers (APMT....PDER-H2) due to cutting edge strength.



(Note) SRM tooling is designed for rough machining applications.
*Programming Note: If you choose to use SRM tooling for semi-finishing applications, care must be taken when setting the tool height. The SRM insert includes a chamfer flat at the tip as illustrated. To assist with SRM programming needs, please download our CAD data from our web site; <http://www.mitsubishicarbide.com/>



METRIC Standard

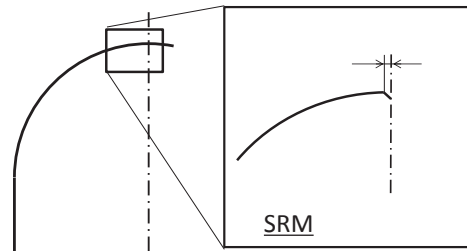
Type	Shape	Order Number	Class	Coated			Dimensions (mm)					Geometry		
				F7030	MP6120	MP9120	VP15TF	RE	L	W1	S		BS	AN
Inner		SRG16C	G	★	★	★	8	16	8.2	3.5	—	11°		
		SRG20C	G	★	★	★	10	19	10.2	4.6	—	10°		
		SRG25C	G	★	★	★	12.5	24	12.8	5.5	—	10°		
		SRG30C	G	★	★	★	15	28	15.3	7	—	10°		
		SRG32C	G	★	★	★	16	28	16.3	7	—	10°		
Outer		SRG16E	G	★	★	★	8	13.5	6.7	3.5	—	11°		
		SRG20E	G	★	★	★	10	15.5	8.5	4.6	—	9°		
		SRG25E	G	★	★	★	12.5	20.5	10.2	5.5	—	9°		
		SRG30E	G	★	★	★	15	25.2	12.2	7	—	9°		
		SRG32E	G	★	★	★	16	26.1	13.1	7	—	9°		
Inner		SRM16C-M	M	★	★	★	8	16	8.2	3.5	—	11°		
		SRM20C-M	M	★	★	★	10	19	10.2	4.6	—	10°		
		SRM25C-M	M	★	★	★	12.5	24	12.8	5.5	—	10°		
		SRM30C-M	M	★	★	★	15	28	15.3	7	—	10°		
		SRM32C-M	M	★	★	★	16	28	16.3	7	—	10°		
Outer		SRM16E-M	M	★	★	★	8	13.5	6.7	3.5	—	11°		
		SRM20E-M	M	★	★	★	10	15.5	8.5	4.6	—	9°		
		SRM25E-M	M	★	★	★	12.5	20.5	10.2	5.5	—	9°		
		SRM30E-M	M	★	★	★	15	25.2	12.2	7	—	9°		
		SRM32E-M	M	★	★	★	16	26.1	13.1	7	—	9°		
* Peripheral		APMT1135PDER-H2	M	●			●	0.8	11	6.35	3.5	1.2	11°	
		APMT1604PDER-H2	M	●			●	0.8	16.5	9.525	4.76	1.4	11°	
Peripheral		APMT1135PDER-M2	M	●			●	0.8	11	6.35	3.5	1.2	11°	
		APMT1604PDER-M2	M	●			●	0.8	16.5	9.525	4.76	1.4	11°	

(Low-resistance inner or outer inserts are precision M class type.)

* Selection guide for peripheral cutting edges : The first recommendation is the super sharp M breaker (APMT...PDER-M2).

When cutting edge strength is particularly important, use the H breaker (APMT...PDER-H2).

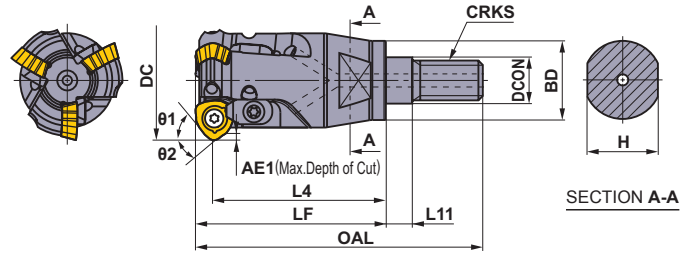
(Note) SRM tooling is designed for rough machining applications.
 *Programming Note: If you choose to use SRM tooling for semi-finishing applications, care must be taken when setting the tool height. The SRM insert includes a chamfer flat at the tip as illustrated. To assist with SRM programming needs, please download our CAD data from our web site; <http://www.mitsubishicarbide.com/>



SCREW-IN TOOLS

PMC

- P M **K** N S H



METRIC Standard

With Air / coolant through.

Right hand tool holder only.

DC	Order Number	Stock	Number of Teeth	Dimensions (mm)							WT	θ1	θ2
				LF	OAL	DCON	BD	L11	H	CRKS*1			
25	PMC08R252AM1035	★	2	39.7	58.7	10.5	18	6	14	M10	0.1	40.5°	35°
32	PMC09R323AM1245	★	3	50.5	72.5	12.5	21	6	19	M12	0.2	40.5°	35°
40	PMC12R403AM1645	★	3	51.4	74.4	17	29	6	24	M16	0.3	42°	35°

*1 Clamp Torque of the Head(lbf-ft) : M10=33.8, M12=59.2, M16=66.7

*2 WT : Mass (kg)

SPARE PARTS

DC	Order Number	Stock										
			Insert Screw	Insert Wench	Clamp Bridge	Clamp Bridge Screw	Clamp Wrench	Anti-seizure Lubricant	Spring	Insert		
25	PMC08R252AM1035	★	AJS3010T10	①TKY08D	AMS3	TS33	TKY10R	MK1KS	ASS2	JOM08		
32	PMC09R323AM1245	★	AJS3010T10	②TKY10D	AMS3	TS351	TKY10D	MK1KS	ASS2	JOM09		
40	PMC12R403AM1645	★	AJS4012T15	②TKY15D	AMS4	TS43	TKY15D	MK1KS	ASS2	JOM12		

* Clamp Torque (lbf-in) : TS33=8.9, TS351=22, TS43=31, AJS3010T10=22, AJS4012T15=31

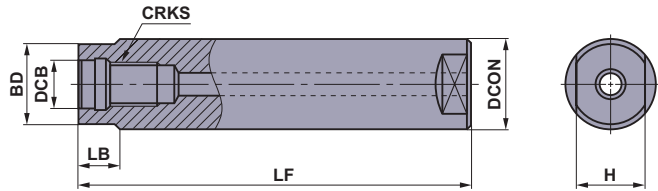
INSERTS

Shape	Order Number	Class	Coated			Dimensions (mm)					PMC holder	Geometry
			FH7020	VP15TF	VP30RT	AN	IC	S	BS	RE		
 FT Breaker	JOMW080320ZZSR-FT	M	●	●	●	13°	8	3.18	1.4	2	PMC08R252AM1035	
	JDMW09T320ZDSR-FT	M	●	●	●	15°	9.525	3.97	1.8	2	PMC09R323AM1245	
	JDMW120420ZDSR-FT	M	●	●	●	15°	12	4.76	2.5	2	PMC12R403AM1645	
 ST Breaker	JDMT120420ZDSR-ST	M	●	●	●	15°	12	4.76	2.5	2	PMC12R403AM1645	
 JM Breaker	JOMT080320ZZSR-JM	M	●	●	●	13°	8	3.18	1.4	2	PMC08R252AM1035	
	JDMT09T320ZDSR-JM	M	●	●	●	15°	9.525	3.97	1.8	2	PMC09R323AM1245	
	JDMT120420ZDSR-JM	M	●	●	●	15°	12	4.76	2.5	2	PMC12R403AM1645	

● : Inventory maintained. ★ : Inventory maintained in Japan.

SCREW-IN ARBORS

STRAIGHT SHANK ARBOR



STEEL SHANK TYPE

CRKS	Order Number	Stock	Dimensions (inch)						WT ^{*1}
			DCON	LF	DCB	BD	LB	H	
M8	SCU10M08S100S	●	.625	3.937	.335	.571	.394	.394	.2
M8	SCU10M08S200L	●	.625	7.874	.335	.571	.394	.394	.7
M10	SCU12M10S120S	●	.750	4.724	.413	.728	.394	.551	.4
M10	SCU12M10S220L	●	.750	8.661	.413	.728	.394	.551	.9
M12	SCU16M12S125S	●	1.000	4.921	.492	.925	.394	.748	.9
M12	SCU16M12S245L	●	1.000	9.646	.492	.925	.394	.748	2.0
M16	SCU20M16S140S	●	1.250	5.512	.669	1.122	.591	.945	1.8
M16	SCU20M16S280L	●	1.250	11.024	.669	1.122	.591	.945	3.5

*1 WT : Mass (lbs)

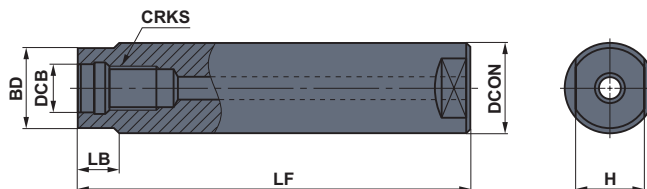
METRIC Standard

CRKS	Order Number	Stock	Dimensions (mm)						WT ^{*1}
			DCON	LF	DCB	BD	LB	H	
M8	SC16M08S100S	★	16	100	8.5	14.5	10	10	0.1
M8	SC16M08S200L	★	16	200	8.5	14.5	10	10	0.3
M10	SC20M10S120S	★	20	120	10.5	18.5	10	14	0.3
M10	SC20M10S220L	★	20	220	10.5	18.5	10	14	0.5
M12	SC25M12S125S	★	25	125	12.5	23.5	10	19	0.4
M12	SC25M12S245L	★	25	245	12.5	23.5	10	19	0.8
M16	SC32M16S140S	★	32	140	17	28.5	15	24	0.8
M16	SC32M16S280L	★	32	280	17	28.5	15	24	1.6

*1 WT : Mass (kg)

SCREW-IN ARBORS

STRAIGHT SHANK ARBOR



CARBIDE SHANK TYPE

CRKS	Order Number	Stock	Dimensions (inch)						WT ^{*1}
			DCON	LF	DCB	BD	LB	H	
M8	SCU10M08S100SW	●	.625	3.937	.335	.571	.394	.394	.4
M8	SCU10M08S200LW	●	.625	7.874	.335	.571	.394	.394	1.1
M10	SCU12M10S120SW	●	.750	4.724	.413	.728	.394	.551	.9
M10	SCU12M10S220LW	●	.750	8.661	.413	.728	.394	.551	1.8
M12	SCU16M12S125SW	●	1.000	4.921	.492	.925	.394	.748	1.8
M12	SCU16M12S245LW	●	1.000	9.646	.492	.925	.394	.748	3.5
M16	SCU20M16S140SW	●	1.250	5.512	.669	1.122	.591	.945	3.1
M16	SCU20M16S280LW	●	1.250	11.024	1.250	1.122	.591	.945	6.4

*1 WT : Mass (lbs)

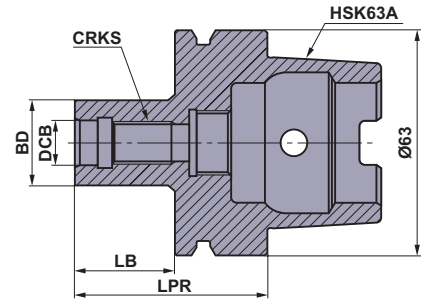
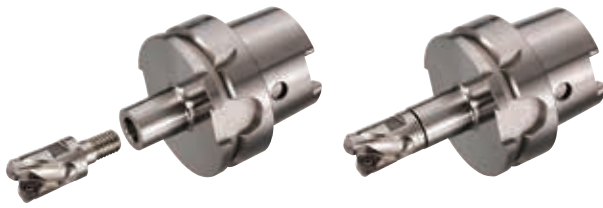
METRIC Standard

CRKS	Order Number	Stock	Dimensions (mm)						WT ^{*1}
			DCON	LF	DCB	BD	LB	H	
M8	SC16M08S100SW	★	16	100	8.5	14.5	10	10	0.2
M8	SC16M08S200LW	★	16	200	8.5	14.5	10	10	0.5
M10	SC20M10S120SW	★	20	120	10.5	18.5	10	14	0.5
M10	SC20M10S220LW	★	20	220	10.5	18.5	10	14	0.9
M12	SC25M12S125SW	★	25	125	12.5	23.5	10	19	0.8
M12	SC25M12S245LW	★	25	245	12.5	23.5	10	19	1.5
M16	SC32M16S140SW	★	32	140	17	28.5	15	24	1.4
M16	SC32M16S280LW	★	32	280	17	28.5	15	24	2.8

*1 WT : Mass (kg)

● : Inventory maintained. ★ : Inventory maintained in Japan.

■ HSK63A SHANK ARBOR

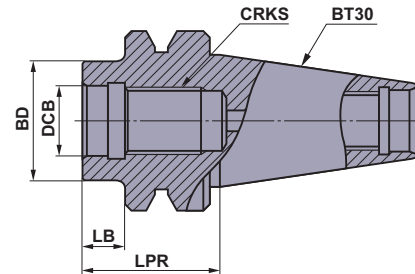


METRIC Standard

CRKS	Order Number	Stock	Dimensions (mm)				WT *1
			DCB	BD	LPR	LB	
M8	SC16M08S22-HSK63A	★	8.5	14.5	48	22	0.7
M10	SC20M10S24-HSK63A	★	10.5	18.5	50	24	0.7
M12	SC25M12S27-HSK63A	★	12.5	23.5	53	27	0.7
M16	SC32M16S28-HSK63A	★	17	28.5	54	28	0.8

*1 WT : Mass (kg)

■ BT30 SHANK ARBOR

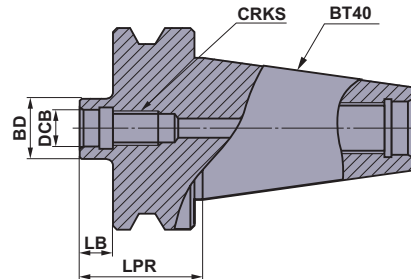


METRIC Standard

CRKS	Order Number	Stock	Dimensions (mm)				WT *1
			DCB	BD	LPR	LB	
M8	SC16M08S10-BT30	★	8.5	14.5	32	10	0.4
M10	SC20M10S10-BT30	★	10.5	18.5	32	10	0.4
M12	SC25M12S10-BT30	★	12.5	23.5	32	10	0.4
M16	SC32M16S10-BT30	★	17	28.5	32	10	0.4

*1 WT : Mass (kg)

■ BT40 SHANK ARBOR



METRIC Standard

CRKS	Order Number	Stock	Dimensions (mm)				WT *1
			DCB	BD	LPR	LB	
M8	SC16M08S10-BT40	★	8.5	14.5	37	10	1
M10	SC20M10S10-BT40	★	10.5	18.5	37	10	1
M12	SC25M12S10-BT40	★	12.5	23.5	37	10	1
M16	SC32M16S10-BT40	★	17	28.5	37	10	1

*1 WT : Mass (kg)

HOW TO INSTALL THE SCREW-IN HEAD

- ① Thoroughly clean the clamp section of the head and the arbor with an air blower or brush before installation.
- ② Tighten the head at the recommended torque and ensure that there is no gap between the head and arbor.



Screw Size	Recommended Torque (lbf-ft)	Wrench Size	
		(inch)	(mm)
M8	17.1	.394	10
M10	33.8	.551	14
M12	59.2	.748	19
M16	66.7	.945	24

- Cutting tools become extremely hot during cutting. Never touch them with bare hands after operation as this may produce risk of injuries or burns.
- Do not handle the cutting tools with bare hands as this may cause injuries.

Avoiding screws/bolts seizing

- In order to avoid screws/bolts seizing, the application of a special lubricant MK1K (separately sold) is recommended when setting inserts on end mills.

For Your Safety

- Don't handle inserts and chips without gloves.
- Please machine within the recommended application range and exchange expired tools with new ones in advance of breakage.
- Please use safety covers and wear safety glasses.
- When using compounded cutting oils, please take fire precautions.
- When attaching inserts or spare parts, please use only the correct wrench or driver.
- When using rotating tools, please make a trial run to check run-out, vibration and abnormal sounds etc.

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