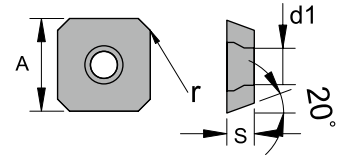


CASE Face Milling

Insert Specifications

Insert	Dimensions (mm)			
	A	S	r	d1
SEKT1204	12.7	4.76	0.8	5.5
SEKW1204				
SEET1204				



Insert Order Code

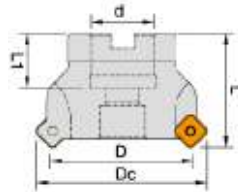
Insert	Order No.	Designation	Working Material					
			P	M	K	N	S	H
	ISEKT1204AFENMF32HS	SEKT1204AFEN-MF-CX32HS	●	●	●		○	○
	ISEKT1204AFENMF33TS	SEKT1204AFEN-MF-CX33TS	●	●	●		●	●
	ISEKT1204AFTNRG32HS	SEKT1204AFTN-RG-CX32HS	●	●	●		○	○
	ISEKT1204AFTNRG33TS	SEKT1204AFTN-RG-CX33TS	●	●	●		●	●
	ISEKT1204AFTNRG43TS	SEKT1204AFTN-RG-CX43TS	●	●	●		●	
	ISEKW1204AFEN32HS	SEKW1204AFEN-CX32HS	●	●	●		○	○
	ISEKW1204AFEN33TS	SEKW1204AFEN-CX33TS	●	●	●		●	●
	ISEKW1204AFSNF32HS	SEKW1204AFSN-F-CX32HS	●	●	●		○	○
	ISEKW1204AFSNF33TS	SEKW1204AFSN-F-CX33TS	●	●	●		●	●
	ISEKW1204AFTN32HS	SEKW1204AFTN-CX32HS	●	●	●		○	○
	ISEKW1204AFTN33TS	SEKW1204AFTN-CX33TS	●	●	●		●	●
	ISEET1204AFFNAL10	SEET1204AFFN-AL-CX10				●		
	ISEET1204AFFNFG22HS	SEET1204AFFN-FG-CX22HS	●	●	●		○	●

CASE Face Milling

Recommended Cutting Conditions

Working Material	Vc	fz	ap
Carbon Steel / Alloy Steel	120 ~ 250	0.10 ~ 0.30	0.3 ~ 5.5
Stainless Steel	100 ~ 180	0.08 ~ 0.25	0.3 ~ 3.0
Cast Iron	120 ~ 250	0.10 ~ 0.30	0.3 ~ 5.0
Aluminum Alloy	300 ~ 1000	0.10 ~ 0.40	0.3 ~ 5.5
High Temperature Alloy	40 ~ 100	0.08 ~ 0.25	0.3 ~ 3.0
Hardened Steel	50 ~ 100	0.08 ~ 0.25	0.3 ~ 3.0

CASEF - Milling tools



Order No.	D	L	L1	d	Dc	T	Inserts	Screw	Wrench	Stock
ICASEF204050220	50	40	20	22	64	4	SEKT1204 or SEKW1204 or SEET1204	ITS5006	ITK20	●
ICASEF205063220	63	45	21	22	77	5				●
ICASEF205063250	63	45	21	25.4	77	5				○
ICASEF206080270	80	50	26	27	94	6				●
ICASEF206080310	80	50	26	31.75	94	6				○
ICASEF206100310	100	32	32	31.75	114	6				○
ICASEF206100320	100	32	32	32	114	6				○

● stock ○ by inquiry