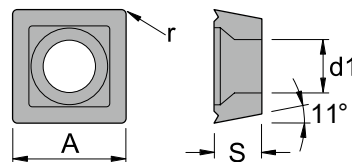


CASP Shoulder Milling

### Insert Specifications

Insert	Dimensions (mm)			
	A	S	r	d1
SPMG050204	5.00	2.38	0.4	2.30
SPMG060204	6.00	2.38	0.4	2.65
SPMG07T308	7.94	3.97	0.8	2.85
SPMG090408	9.80	4.3	0.8	4.05
SPMG110408	11.50	4.8	0.8	4.45



### Insert Order Code

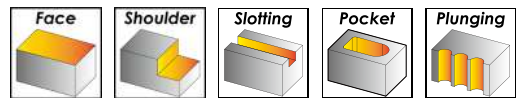
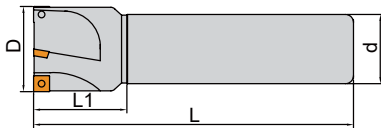
Insert	Order No.	Designation	Working Material					
			P	M	K	N	S	H
	ISPMG050204MG32HS	SPMG050204-MG-CX32HS	●	●	●		○	○
	ISPMG050204MG33TS	SPMG050204-MG-CX33TS	●	●	●		●	●
	ISPMG050204MG43TS	SPMG050204-MG-CX43TS	●	●	●		●	
	ISPMG060204MG32HS	SPMG060204-MG-CX32HS	●	●	●		○	○
	ISPMG060204MG33TS	SPMG060204-MG-CX33TS	●	●	●		●	●
	ISPMG060204MG43TS	SPMG060204-MG-CX43TS	●	●	●		●	
	ISPMG07T308MG32HS	SPMG07T308-MG-CX32HS	●	●	●		○	○
	ISPMG07T308MG33TS	SPMG07T308-MG-CX33TS	●	●	●		●	●
	ISPMG07T308MG43TS	SPMG07T308-MG-CX43TS	●	●	●		●	
	ISPMG090408MG32HS	SPMG090408-MG-CX32HS	●	●	●		○	○
	ISPMG090408MG33TS	SPMG090408-MG-CX33TS	●	●	●		●	●
	ISPMG090408MG43TS	SPMG090408-MG-CX43TS	●	●	●		●	
	ISPMG090408RG32HS	SPMG090408-RG-CX32HS	●	●	●		○	○
	ISPMG090408RG33TS	SPMG090408-RG-CX33TS	●	●	●		●	●
	ISPMG090408RG43TS	SPMG090408-RG-CX43TS	●	●	●		●	
	ISPMG110408MG32HS	SPMG110408-MG-CX32HS	●	●	●		○	○
	ISPMG110408MG33TS	SPMG110408-MG-CX33TS	●	●	●		●	●
	ISPMG110408MG43TS	SPMG110408-MG-CX43TS	●	●	●		●	
	ISPMG110408RG32HS	SPMG110408-RG-CX32HS	●	●	●		○	○
	ISPMG110408RG33TS	SPMG110408-RG-CX33TS	●	●	●		●	●
	ISPMG110408RG43TS	SPMG110408-RG-CX43TS	●	●	●		●	

CASP Shoulder Milling

### Recommended Cutting Conditions

Working Material	SPMG050204 & SPMG060204			SPMT07T308 & SPMG090408		
	Vc	fz	ap	Vc	fz	ap
Carbon Steel / Alloy Steel	120 ~ 250	0.10 ~ 0.22	0.3 ~ 3.0	120 ~ 250	0.10 ~ 0.22	0.5 ~ 6.0
Stainless Steel	100 ~ 180	0.08 ~ 0.18	0.3 ~ 2.0	100 ~ 180	0.08 ~ 0.18	0.5 ~ 4.0
Cast Iron	120 ~ 250	0.10 ~ 0.22	0.3 ~ 3.0	120 ~ 250	0.10 ~ 0.22	0.5 ~ 6.0
High Temperature Alloy	40 ~ 100	0.07 ~ 0.14	0.3 ~ 2.0	40 ~ 100	0.07 ~ 0.14	0.5 ~ 4.0
Hardened Steel	50 ~ 100	0.07 ~ 0.15	0.3 ~ 2.0	50 ~ 100	0.07 ~ 0.15	0.5 ~ 4.0

### CASPE - Milling tools



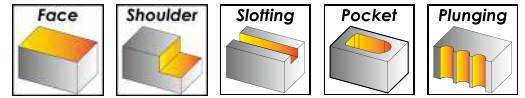
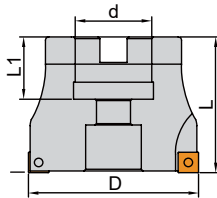
Order No.	D	L1	L	d	T	Inserts	Screw	Wrench	Stock
ICASPE502012100	12	20	100	12	2	SPMG0502	ITS2003	ITK06	●
ICASPE502013100	13	20	100	12	2				○
ICASPE502014100	14	20	100	12	2				○
ICASPE502015100	15	20	100	12	2				○
ICASPE602016120	16	25	120	16	2	SPMG0602	ITS2205	ITK06	●
ICASPE603020120	20	30	120	20	3				●
ICASPE603025120	25	30	120	25	3				●
ICASPE604030120	30	30	120	25	4				●
ICASPE605032120	32	30	120	25	5				●
ICASPE703025150	25	35	150	25	3	SPMG07T3	ITS3504	ITK15	●
ICASPE703030150	30	35	150	25	3				○
ICASPE704030150	30	40	150	32	4				○
ICASPE704032150	32	40	150	32	4				●

● stock ○ by inquiry

Customize available.

CASP Shoulder Milling

CASPF - Milling tools



Order No.	D	L1	L	d	T	Inserts	Screw	Wrench	Stock
ICASPF607050220	50	20	45	22	7	SPMG0602	ITS2205	ITK06	●
ICASPF607050250	50	20	45	25.4	7				○
ICASPF609063220	63	20	45	22	9				●
ICASPF609063250	63	20	45	25.4	9				●
ICASPF611080270	80	23	50	27	11				○
ICASPF611080250	80	23	50	25.4	11				●
ICASPF905050220	50	20	45	22	5	SPMG0904	ITS3504	ITK15	●
ICASPF905050250	50	20	45	25.4	5				○
ICASPF906063220	63	20	45	22	6				●
ICASPF906063250	63	20	45	25.4	6				○
ICASPF907080270	80	23	50	27	7				●
ICASPF907080250	80	23	50	25.4	7				○

● stock ○ by inquiry

Customize available.