

CR39 90° Shoulder Milling

Single sided, 2 cutting edges



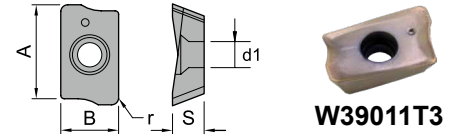
Versatile concept suitable for various applications !

- *Specially designed for productive milling at high temperature alloys.*
- *Finishing and roughing capability in a wide range of operations and materials.*
- *High removal rates can be achieved even at smaller low powered machines.*



Insert Specification

Insert	Dimensions (mm)				
	A	B	S	r	d1
W39011T308	11	6.9	3.59	0.8	2.8
W39011T320	11	6.9	3.59	2.0	2.8



Insert Geometry

Shape	Chipbreaker	Application
	MG	Low cutting force for medium cutting in steel, stainless and cast iron.

Insert Grade

Grade Type	Machining Application	Industry area
CX22HS	<ul style="list-style-type: none"> • Continuous semi-finishing machining • For hardened steel and cast Iron 	<ul style="list-style-type: none"> • Die and mould • Hardened parts
CX32HS	<ul style="list-style-type: none"> • Medium machining • For carbon steel, alloy steel and stainless steel 	<ul style="list-style-type: none"> • Auto parts • Machinery parts
CX43TS	<ul style="list-style-type: none"> • Roughing or interrupted machining • For carbon steel, alloy steel, stainless steel and high temperature alloy. 	<ul style="list-style-type: none"> • Auto parts • Machinery parts • Aircraft parts

※ Different grades for various applications are available to select, please contact us for more information.

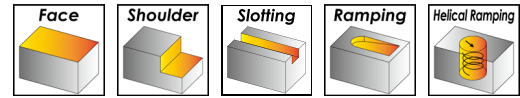
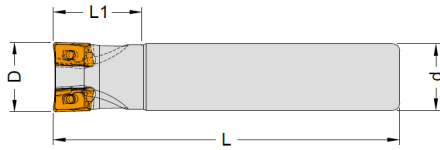
Recommended Cutting Conditions

Working Material	Vc	fz	ap
Carbon Steel (HB85-225)	120 ~ 200	0.10 ~ 0.22	0.5 ~ 7.0
Stainless 300 Series	70 ~ 150	0.08 ~ 0.18	0.5 ~ 4.0
Cast Iron (HB140-220)	120 ~ 220	0.10 ~ 0.22	0.5 ~ 6.0
High temp. & Titanium alloy	40 ~ 80	0.07 ~ 0.14	0.5 ~ 4.0
Hardened steel	50 ~ 100	0.07 ~ 0.15	0.5 ~ 4.0

Order Code

Insert	Order No.	Designation	Working Material					
			P	M	K	N	S	H
	IW39011T308MG22HS	W39011T308-MG-CX22HS	●	○	●		○	●
	IW39011T308MG32HS	W39011T308-MG-CX32HS	●	●	●		○	○
	IW39011T308MG43TS	W39011T308-MG-CX43TS	●	●	●		●	
	IW39011T320MG22HS	W39011T320-MG-CX22HS	●	○	●		○	●
	IW39011T320MG32HS	W39011T320-MG-CX32HS	●	●	●		○	○

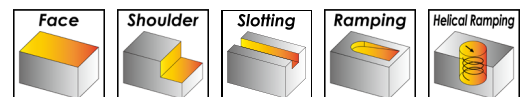
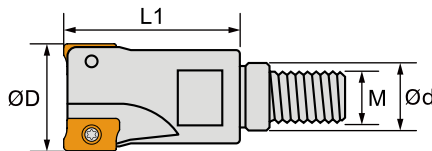
CR39E - Milling tools



Order No.	D	L1	L	d	T	Inserts	Screw	Wrench
ICR39E302016150	16	30	150	16	2	W39011T3	ITS2515	ITK08
ICR39E303025150	25	30	150	25	3			
ICR39E303032150	32	35	150	32	3			

Customize available.

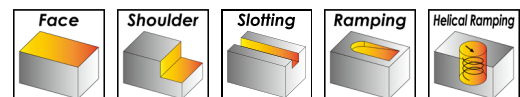
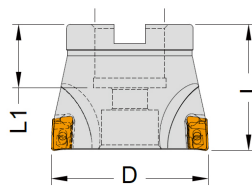
CR39M - Modular tools



Order No.	D	L1	d	M	T	Inserts	Screw	Wrench
ICR39M302016080	16	26	8.5	M8	2	W39011T3	ITS2515	ITK08
ICR39M303020100	20	32	10.5	M10	3			
ICR39M303025120	25	38	12.5	M12	3			
ICR39M303032160	32	41	17	M16	3			

Customize available.

CR39F - Milling tools



Order No.	D	L	d	T	Inserts	Screw	Wrench
ICR39F304050220	50	40	22	4	W39011T3	ITS2515	ITK08
ICR39F305063220	63	40	22	5			
ICR39F308080270	80	50	27	8			

Customize available.

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