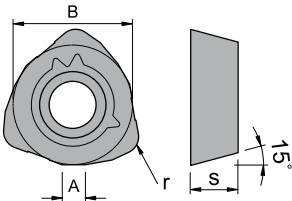


Insert Specifications

Insert	Dimensions (mm)				
	A	B	S	r	d1
JDMW1204	2.5	12.0	4.76	2.0	4.75
JDMW1405	2.8	14.0	5.56	2.0	5.75

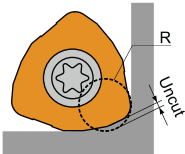


Insert Order Code

Insert	Order No. 訂購編碼	Designation	Working Material					
			P	M	K	N	S	H
	IJDMW120420SRG22HS	JDMW120420ZDSR-RG-CX22HS	●	○	●		○	●
	IJDMW120420SRG32HS	JDMW120420ZDSR-RG-CX32HS	●	●	●		○	○
	IJDMW120420SRG43TS	JDMW120420ZDSR-RG-CX43TS	●	●	●		●	
	IJDMW140520SRG32HS	JDMW140520ZDSR-RG-CX32HS	●	●	●		○	○

Corner R Programming

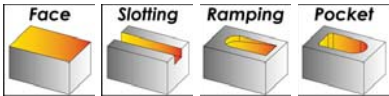
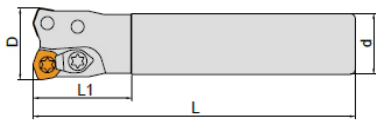
Designation	Approx. R (mm)	
	Input. R	Uncut
JDMW1204	3.0	0.63
JDMW1405	3.0	0.64



Recommended Cutting Conditions

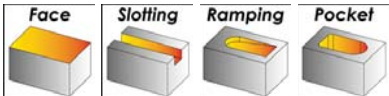
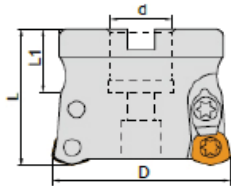
Working Material	for JDMW1204			for JDMW1405		
	Vc	fz	ap	Vc	fz	ap
Carbon Steel (HB85-225)	120 ~ 250	0.8 ~ 1.3	0.3 ~ 1.5	120 ~ 250	0.8 ~ 1.8	0.5 ~ 2.0
Stainless 300 Series	100 ~ 180	0.6 ~ 1.0	0.3 ~ 1.0	100 ~ 180	0.6 ~ 1.2	0.5 ~ 1.5
Cast Iron (HB140-220)	120 ~ 250	0.8 ~ 1.3	0.3 ~ 1.5	120 ~ 250	0.8 ~ 1.8	0.5 ~ 2.0
High temp. & Titanium alloy	40 ~ 100	0.5 ~ 1.0	0.3 ~ 1.0	40 ~ 100	0.5 ~ 1.2	0.5 ~ 1.5
Hardened steel	50 ~ 100	0.5 ~ 1.0	0.3 ~ 1.0	50 ~ 100	0.5 ~ 1.2	0.5 ~ 1.5

CAJXE - Milling tools



Order No. 訂購編碼	D	L1	L	d	T	Inserts	Screw	Wrench	Clamp	Clamp Screw
ICAJXE202032150	32	35	150	32	2	JDMW1204	ITS4008	ITK15	IAS04	IAJ4012

CAJXF - Milling tools



Order No. 訂購編碼	D	L1	L	d	T	Inserts	Screw	Wrench	Clamp	Clamp Screw
ICAJXF204050220	50	23	45	22	4	JDMW1204	ITS4008	ITK15	IAS04	IAJ4012
ICAJXF205063220	63	23	45	22	5					
ICAJXF206080270	80	26	55	27	6					
ICAJXF403063220	63	23	50	22	4	JDMW1405	ITS5001	ITK20	IAS05	IAJ5014
ICAJXF404080270	80	26	55	27	5					
ICAJXF405100320	100	32	55	32	6					