

MFK CUTTER FOR CAST IRON



MFK

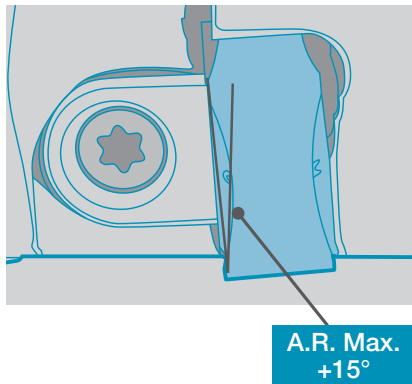
Milling Cutter for Cast Iron

Tough edge with low cutting forces enable stable machining.
Uses 10-edge inserts for economical machining.

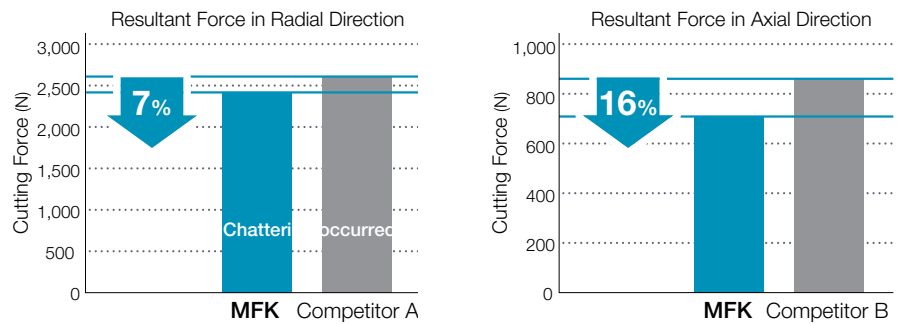
C
45° / 70° LEAD

1 Low Cutting Forces Prevent Chattering

Low Cutting Forces with Helical Cutting Edge Design



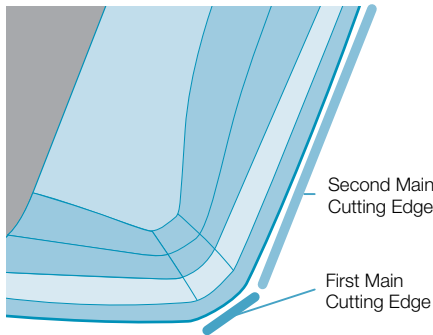
Cutting Force Comparison (Internal Evaluation)



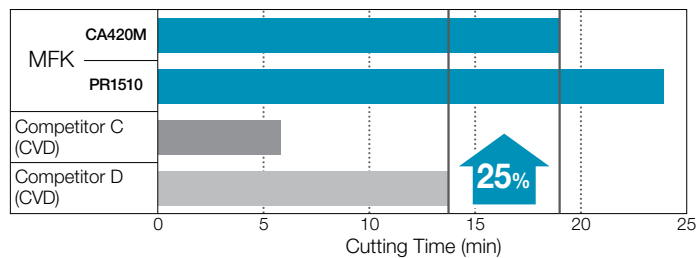
Cutting Conditions: $V_c = 590$ sfm, $f_z = 0.012$ ipt, D.O.C. $\times a_e = 0.118'' \times 2.441''$, Dry Workpiece: Nodular Cast Iron (80-60-03), $\varnothing 5.000''$

2 Tough and Reliable Insert Construction Prevents Fracturing

Tough and Reliable Dual Angle Edge Design

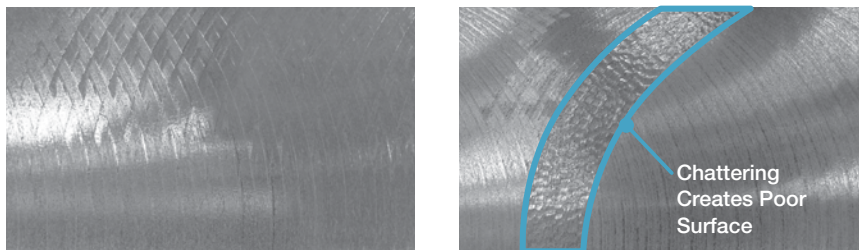


Fracture Resistance Comparison (Internal Evaluation)



Cutting Conditions: $V_c = 980$ sfm, $f_z = 0.020$ ipt, $a_p = 0.079''$, Wet Workpiece: Nodular Cast Iron (65-45-12) with 4 Bores

Surface Finish Comparison (Internal Evaluation)



Cutting Conditions: $V_c = 590$ sfm, $f_z = 0.012$ ipt, $a_p \times a_e = 0.118'' \times 3.071''$, Dry Workpiece: Nodular Cast Iron (80-60-03)

Burr Comparison

Sharp Cutting Prevents Burr Formation

