

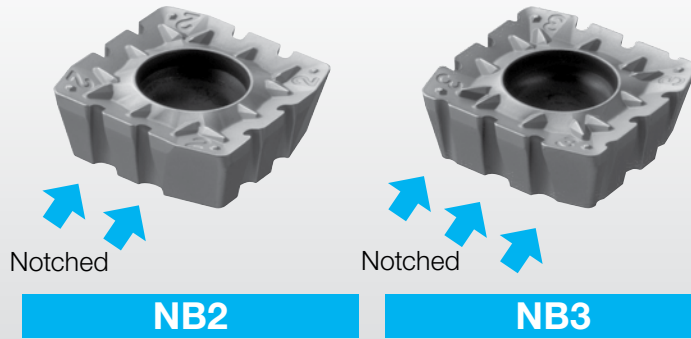
# MSRS15 HEAVY MILLING FACE MILL



Facing

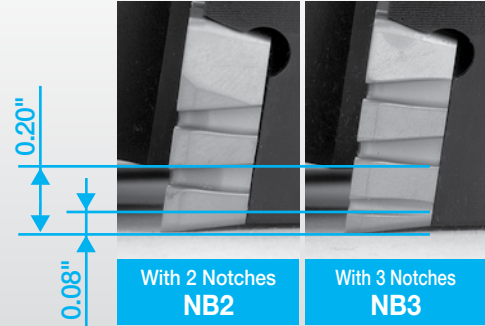
## Notched Inserts Reduce Cutting Forces and Chattering to Enable Efficient Machining

### Notched Inserts



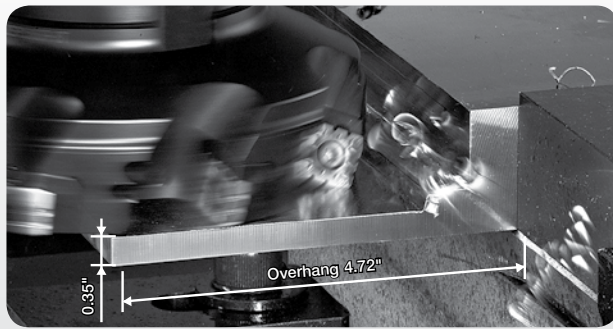
### Notch effect

The effects of the notch can be seen at more than 0.20" of vertical axial D.O.C. (effects for NB3 appears from at least 0.08" or more)



## Designed to Suppress Chattering by Reducing Cutting Forces

### Possible to cut thin-plate workpieces

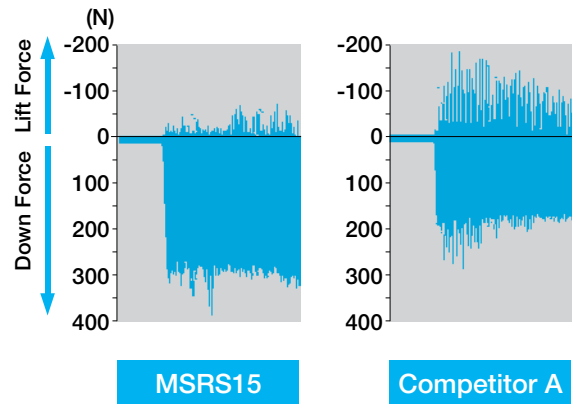


### MSRS15160R-8T

Workpiece Material: 1050 Steel  
 $V_c = 675 \text{ sfm}$  ( $n = 398 \text{ RPM}$ )  
 $f_z = 0.006 \text{ ipt}$  ( $V_f = 18.78 \text{ ipm}$ ), D.O.C.  $\times a_e = 0.24" \times 3.94"$   
 (Cutting of unsupported overhang from a thickness of 0.600"-0.350")

### Comparison of cutting force (radial force)

MSRS suppresses chattering by generating less "lifting force" during cutting.



## Features of Toolholder

### Coarse Pitch

Designed with Large Chip Pockets  
 Good Chip Evacuation

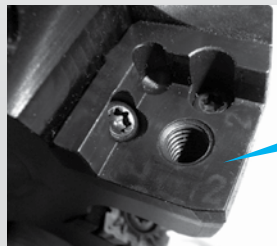
### Fine Pitch

Higher Productivity Due to Close Pitch Design

Designed with Cartridges  
 Prevents Damage to Base Body

Applicable Insert Number  
 (Notch Number)

### Insert Replacement Identification



Insert number is transcribed as a result of the cutting tool load.

\* Depending on the cutting conditions, marks may not be transcribed.

GRADES	A
LINEUP / INSERTS	B
45° / 70° LEAD	C
75° LEAD	D
90° LEAD	E
HIGH FEED	F
MULTI-FUNCTION	G
SLOT MILLS	H
RADIUS / BALL-NOSE	J
OTHER APPLICATIONS	K
TOOL HOLDING	O
SPARE PARTS	P
TECHNICAL	R
INDEX	T