

MTE90-SF



Shouldering



Slotting



Facing

MTE90-SF Face Mill (Adjustable insert height)

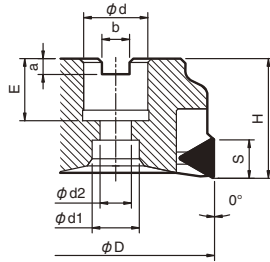
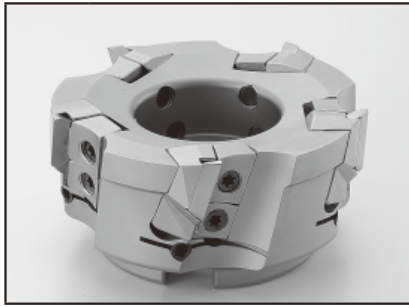


Fig.1

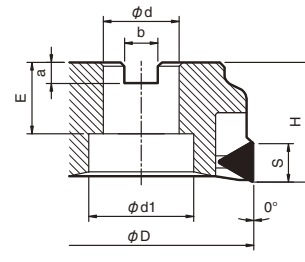


Fig.2

Toolholder Dimensions

Description		Std.	No. of Insert	Dimension (mm)									Rake Angle (°)		Drawing	Weight (kg)
				øD	ød	ød1	ød2	H	E	a	b	S	A.R.	R.R.		
Metric	MTE 90080R-4T-M-SF	●	4	80	27	20	13	50	24	7	12.4	17	+17°	+3°	Fig.1	1.0
	90100R-5T-M-SF	●	5	100	32	45	-		32	8	14.4			+4°	Fig.2	1.5
	90125R-6T-M-SF	●	6	125	40	55	-	63	30	9	16.4			+5°	Fig.2	3.0
Bore Dia. Inch spec	MTE 90080R-4T-SF	○	4	80	25.4	20	13	50	26	6	9.5	17	+17°	+3°	Fig.1	1.0
	90100R-5T-SF	○	5	100	31.75	45	-		32	8	12.7			+4°	Fig.2	1.5
	90125R-6T-SF	○	6	125	38.1	55	-	63	38	10	15.9			+5°	Fig.2	3.0

Spare Parts

Description	① Cartridge	② Clamp	③ Clamp	④ Clamp Screw	⑤ Adjustment Screw	⑥ Wrench	⑦ Wrench
MTE 90000R-OT-M-SF	LTE490SR	C91R (for Insert)	C92R (for Cartridge)	W8X16	SV-60136R	TTC-25	LW-4 (For adjustment screw)
MTE 90000R-OT-SF							

• Mounting bolts (HH12X35M) are included in MTE90080R-4T-SF and MTE90080R-4T-M-SF

Recommended Cutting Conditions

Workpiece Material	fz (mm/t)	Recommended Insert Grade (Cutting Speed Vc : m/min)												
		Cermet			PVD Coated Carbide						Carbide		PCD	
		TN60	TN100M	TC60	PR630	PR730	PR830	PR660	PR1025	PR905	PW30	KW10	KPD001	KPD010
Stainless Steel	~0.20		☆ 120~200	☆ 120~200	☆ 120~200	☆ 120~200	☆ 120~200	☆ 100~200	★ 100~200		☆ 80~120			
Carbon Steel	~0.25	☆ 150~220	★ 120~200	☆ 120~200	☆ 120~200	☆ 120~200	★ 120~200	☆ 100~180	☆ 100~180		☆ 80~150			
Alloy Steel	~0.25	☆ 120~200	★ 100~180	☆ 100~180	☆ 100~180	☆ 100~180	★ 100~180	☆ 100~150			☆ 80~150			
Mold Steel	~0.20	☆ 120~200	★ 100~180	☆ 100~180	☆ 80~150	☆ 80~150	★ 80~150	☆ 80~130			☆ 80~150			
Cast Iron	~0.25								★ 100~200		☆ 80~150			
Non-ferrous Metals	~0.20										★ 100~300	★ 300~800	☆ 300~800	

★: 1st Recommendation ☆: 2nd Recommendation

How to Adjust Cutting Edge height

For adjustment method of edge height, see page [M29](#).

M



Milling