

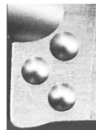
● Number of Inserts Installed

Description	No. of Flute	No. of Insert	No. of Inserts Installed			
			BDMT11T308ER-		BDMT170408ER-	
						
MECH 025-025-11-4-2T	2	8	4	4		
032-032-11-5-2T		10	5	5		
032-032-11-5-4T		20	10	10		
040-032-11-6-4T	4	24	12	12		
040-S42-11-6-4T						
050-S42-11-7-4T		28	14	14		
050-W40-11-7-4T	6	42	21	21		
050-S42-11-7-6T						
050-W40-11-7-6T						
MECH 040-032-17-4-2T	2	8			4	4
040-S42-17-4-2T						
050-S42-17-5-4T		20			10	10
050-W40-17-5-4T	4					
MECH 040R-11-4-4T-M	4	16	8	8		
050R-11-5-6T-M	6	30	15	15		
MECH 050R-17-2-4T-M	4	8			4	4
050R-17-4-4T-M	4	16			8	8
063R-17-3-4T-M	4	12			6	6
080R-17-4-6T-M	6	24			12	12
100R-17-4-6T-M	6	24			12	12
MECH 063R-17-3-4T	4	12			6	6
080R-17-4-6T	6	24			12	12
100R-17-4-6T	6	24			12	12
MECH 040R11-6-4T-SK40	4	24	12	12		
MECH 050R11-8-4T-BT50	4	32	16	16		
050R11-8-4T-SK50						
MECH 050R17-7-4T-BT50	4	28			14	14
050R17-7-4T-SK50						
063R17-7-4T-BT50						
080R17-7-4T-BT50						
MECH 100R17-7-6T-BT50	6	42			21	21

● Precautions when installing inserts with notched.

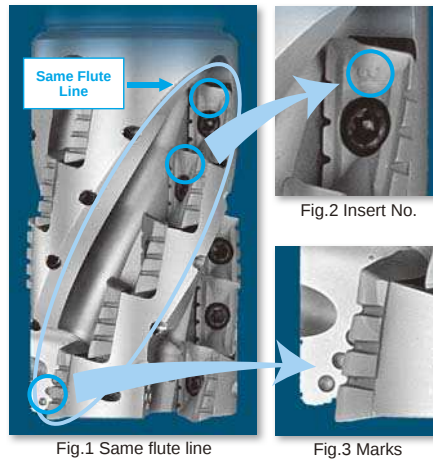
1. Install notched inserts by matching the insert with the number of marks on the holder body.

<Insert Number and Holder Marks>

Insert Size	11 type		17 type	
Insert No.	2	3	3	4
Marks				

*Using the cutter with the inserts installed incorrectly will damage the holder.

2. When installing notched inserts in flute line, ensure that the number on the insert is the same as the insert in first stage. See Fig.1, 2 and 3.

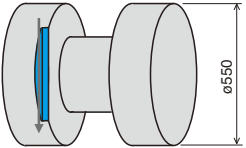


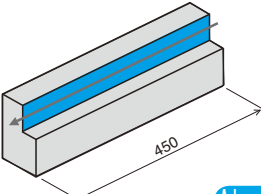
M



Milling

■ Case studies (Achievement of productivity improvement and machining time reduction)

C45 (S45C)	
• Ship parts • $V_c=150\text{m/min}$ ($n=955\text{min}^{-1}$) • $a_p \times a_e=70\text{mm} \times 10\text{mm}$ • $f_z=0.2\text{mm/t}$ ($V_f=764\text{mm/min}$) • Dry • MECH050-S42-17-5-4T • 4 Flutes • BDMT170408ER-N3 • BDMT170408ER-N4	 PR830 Advancing Productivity 4.6 times!
MECH	Chip removal Q=534cc/min.
Competitor A	Chip removal Q=115cc/min.
Comp. A removed 115cc of chips per minute. In contrast, MECH removed 534cc per minute. Machining productivity improved to 4.6 times.	
(Evaluation by the user)	

St42-2 (SS400)	
• Plate • $V_c=150\text{m/min}$ ($n=955\text{min}^{-1}$) • $a_p \times a_e=70\text{mm} \times 10\text{mm}$ • $f_z=0.2\text{mm/t}$ ($V_f=760\text{mm/min}$) • Dry • MECH050-S42-17-5-4T • 4 flute lines • BDMT170408ER-N3 • BDMT170408ER-N4	 PR830 Advancing Productivity 3.1 times!
MECH	Chip removal Q=532cc/min.
Competitor B	Chip removal Q=170cc/min.
Comp. B removed 170cc of chips per minute. In contrast, MECH removed 532cc per minute. Machining productivity improved to 3.1 times and finished wall condition was excellent.	
(Evaluation by the user)	