

Shouldering

Slotting

Facing

MSR-BT50

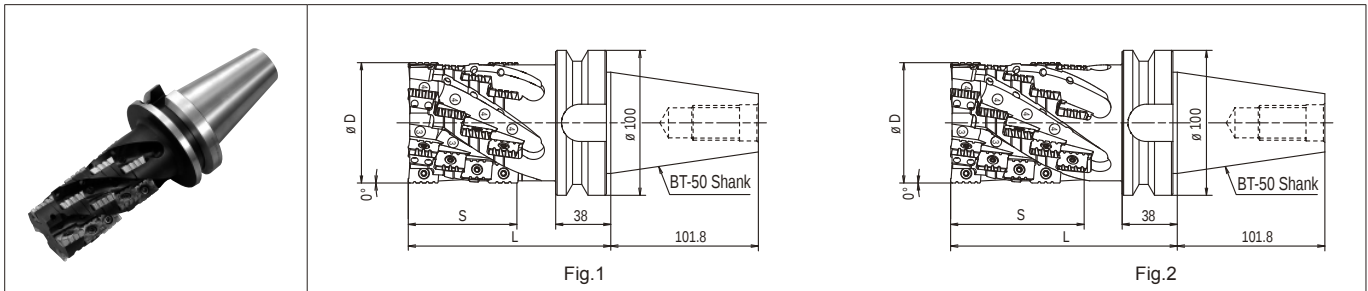


Fig.1

Fig.2

Toolholder Dimensions (BT50 Integral Arbor type)

Description	Std.	No. of Insert	No. of Flute	No. of Stage	Dimension (mm)			Rake Angle (°)		Drawing	Weight (kg)	Spare Parts					
					øD	L	S	A.R.	R.R.			Clamp Screw	Wrench	Shim	Clamp Screw	Wrench	Anti-seize Compound
																	
MSR 063R-BT50-4	○	16	4	4	63	160	90	+9°	-5°	Fig.1	5.7	SB-60120TR	TT-25L	-	-	-	MP-1
063R-BT50-5	○	20	4	5	180	111	Fig.2			6.2							
080R-BT50-4	○	16	4	4	80	160	90			Fig.1	6.9						
080R-BT50-5	○	20	4	5	180	111	Fig.2			7.4							
100R-BT50-4	○	24	6	4	100	160	90			Fig.1	9.6						
100R-BT50-5	○	30	6	5	180	111	Fig.2			10.5							
												for Insert Clamp		for Shim Clamp			

● Shim is not available for MSR063R (Dia. D=63).

● It is not recommended using only top edge part (ap = 30mm) for 4 stages / 5 stages type. If ap is small, use previous page's 1 stage type or 2 stages type.

● Deep grooving is not recommended for this cutter.

Applicable Inserts

Description	Applicable Inserts M17			
MSR 063R...	APMT 250608ER-NB3 APMT 250616ER-NB3 APMT 250640ER-NB3	APMT 250608ER-NB4 APMT 250616ER-NB4 APMT 250640ER-NB4	APMT 250616ER-NB3P	APMT 250616ER-NB4P
080R...				
100R...				
125R...				
160R...				
200R...				
250R...				

Caution of installing Notched Insert

"When installing Notched Insert, it is important to install it in the correct position. If it is installed in incorrect position, the tool cannot machine the workpiece and it may damage the toolholder body."

For MSR Type, Notched Insert location indicator is marked at Insert installed area.

Please be minded followings when you install Inserts to toolholders.

Indication is marked near the Insert pocket for MSR type.

1) ③ is for AP□□□□□□□□ER-NB3

2) ④ is for AP□□□□□□□□ER-NB4

(No. of Inserts - Example)

Description	Number of Insert	No. of Flute	No. of Inserts	
			With Notch	
			NB3	NB4
MSR 100R-1	6	6	3	3
100R-2	12		6	6
100R-4	24		12	12

Caution when installing the Insert with Corner-R(r_c) 4.0

- When installing the insert with corner-radius 4.0mm, additional processing to the body is needed. Apply additional processing to the body corner according to the chart.

Insert Corner-R(r_c)	Additional Processing Dimension to Body Corner
4.0	R2.0

*Round- shaped additional processing is recommended.
When applying chamfer shaped additional processing, do not cut away too much.

