

MHD Helical Endmill

No. of inserts to be installed in the Plus Mill

Description	No. of Insert	No. of Flute	NDK 09 type		FPMTO9 Type	RPMTO10 Type
			Without notch	With notch		
Separate Type						
MHD 32-S32-SA	10	2	-	5	5	-
32-S32-4RSA				4	4	2
Base Unit						
MHD 32-S32-A	2	2	-	1	1	-
Front Piece						
MHD 32-F	4	2	-	2	2	-
32-4RF				1	1	2
Integral Type						
MHD 20S-S20-C	3	1	3	-	-	-
25-S25-C	8	2	-	4	4	-
32-S32-C	10	2	-	5	5	-
MHD 20-S20-4RC	3	1	2	-	-	1
25S-S25-4RC	4	1	-	-	-	2
32-S32-5RC	10	2	-	4	4	-

Description		No. of Insert	No. of Flute	NDMM12 type		RPMT10 Type	RPMT12 Type		
				With notch					
				N2	N3				
Separate Type	MHD 40-S32-SA 40-S40-SA 40-S42-SA 50-S42-SA	10	2	5	5	-	-		
	MHD 63-FMA-SA 80-FMA-SA 100-FMA-SA	21 27 40	3 3 4	7 9 20	14 18 20				
	MHD 63-BT50-SA 80-BT50-SA 100-BT50-SA	21 27 40	3 3 4	7 9 20	14 18 20				
	MHD 40-S32-5RSA 40-S42-5RSA 50-S42-6RSA	10	2	4	4	2	-		
	MHD 40-S42-SB 50-S42-SB	10	2	5	5	-	2		
Base Unit	MHD 40-S32-A 40-S40-A 40-S42-A 50-S42-A	2	2	1	1	-	-		
	MHD 63-FMA-A 80-FMA-A 100-FMA-A	9 16	3 4	3 8	6 6				
	MHD 63-BT50-A 80-BT50-A 100-BT50-A	9 16	3 4	3 8	6 8				
	MHD 40-S42-B 50-S42-B	6	2	3	3				
	Front Piece	MHD 40-F 50-F 63-F 80-F 100-F	4 6 9 12	2 3 4	2 2 3 6	2 4 6 6	-	-	
MHD 40-5RF 50-6RF		4	2	1	1	2 -			- 2
Integral Type		MHD 40-S42-C 50-S42-C	10	2	5	5	-	-	
		MHD 40-S42-5RC 50-S42-6RC	10	2	4	4	2 -	- 2	

Caution at installing Notched Insert

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

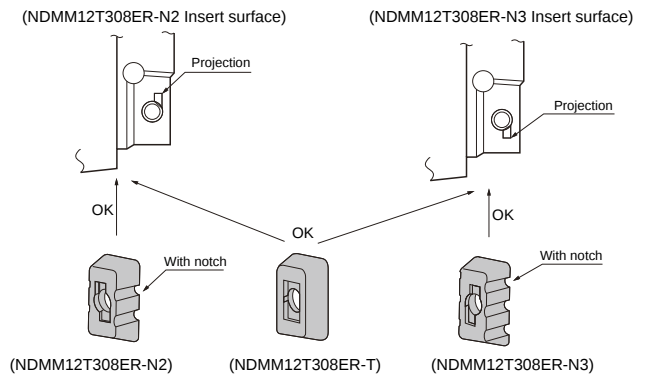
Description of Notched Insert	Applicable Toolholder
	In case of having insert installation mark
NDKT 090304ER-N1 / N2	MHD25,32
NDMM 12T308ER-N2 / N3	MHD40,50,63,80,100

In case of "having insert installation mark"

Caution during insert installation

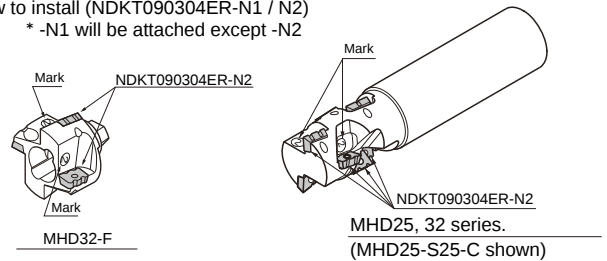
- 1) NDMM12T308ER-N2 or -3 in the insert pocket with projection (only MHD40 / 50)
- 2) NDKT090304ER-N2 in the insert pocket marked ②
- 3) NDKT090304ER-N3 in the insert pocket marked ③

1. How to install (MHD40, 50)

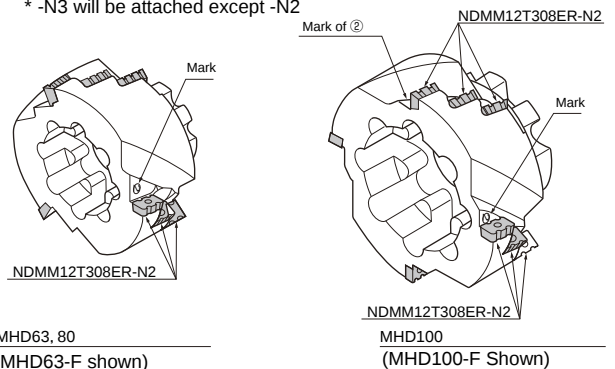


2. How to install (MHD25, 32, 63, 80, 100)

- How to install (NDKT090304ER-N1 / N2)
* -N1 will be attached except -N2



- How to install (NDMM12T308ER-N2 / N3)
* -N3 will be attached except -N2



Notched Insert Benefits

Notched Insert shows not only lowering cutting resistance but also great effect of chattering reduction by good approach to workpieces.

