

Cutting Edge Length of Plus Mill

Base Unit	No. of Flute	No. of Insert	Plus Mill ⚙️ M67~M69			Radius Plus Mill ⚙️ M133, M134				
			Front Piece (Both Middle and End)		Clamp Bolt	Front Piece (Middle)		Radius Front Piece (End)		Clamp Bolt
			Description	No. of pos		Description	No. of pos	Description	No. of pos	
MHD32-S32-A	2	6	MHD32-F	1	HH8X35	MHD32-F	0	MHD32-4RF	1	HH8X35
		10		2	HH8X50		1		1	HH8X50
		14		3	HH8X70		2		1	HH8X65
MHD40-S32-A (MHD40-S32-B) MHD40-S40-A MHD40-S42-A (MHD40-S42-B)	2	6	MHD40-F	1	HH8X40	MHD40-F	0	MHD40-5RF	1	HH8X35
		10		2	HH8X65		1		1	HH8X55
		14		3	HH8X85		2		1	HH8X80
		18		4	HH8X110		3		1	HH8X100
MHD50-S42-A (MHD50-S42-B)	2	6	MHD50-F	1	HH12X40	MHD50-F	0	MHD50-6RF	1	HH12X40
		10		2	HH12X65		1		1	HH12X55
		14		3	HH12X85		2		1	HH12X80
		18		4	HH12X110		3		1	HH12X100
		22		5	HH12X130		4		1	HH12X120
		26		6	HH12X150		5		1	HH12X140
MHD63-FMA-A	3	9	MHD63-F	0	HH16X45	-	-	-	-	-
		15		1	HH16X65					
		21		2	HH16X90					
		27		3	HH16X110					
MHD80-FMA-A	3	9	MHD80-F	0	HH20X40	-	-	-	-	-
		18		1	HH20X75					
		27		2	HH20X110					
		36		3	HH20X140					
MHD100-FMA-A	3	16	MHD100-F	0	HH24X40	-	-	-	-	-
		28		1	HH24X75					
		40		2	HH24X110					
		52		3	HH24X140					
MHD63-BT50-A	3	15	MHD63-F	1	HH16X45	-	-	-	-	-
		21		2	HH16X65					
		27		3	HH16X90					
		33		4	HH16X110					
MHD80-BT50-A	3	18	MHD80-F	1	HH20X55	-	-	-	-	-
		27		2	HH20X90					
		36		3	HH20X120					
		45		4	HH20X150					
MHD100-BT50-A	4	28	MHD100-F	1	HH24X60	-	-	-	-	-
		40		2	HH24X90					
		52		3	HH24X120					
		64		4	HH24X150					

• Dimension in () is for Base Unit B.

• Clamp Bolt Description (HH ○○ X □□): ○○ ...indicates screw standard (M ○○), □□ ...indicates bolt's nominal length (mm).

• Clamp Bolt Descriptions are common to both Base Unit A and B.

- Difference of Cutting Edge Length between Radius Plus Mill and Plus Mill
As shown in Fig.1, the edge length of front piece in Radius Plus Mill (t2) and the edge length of front piece in Plus Mill (t1) are different.

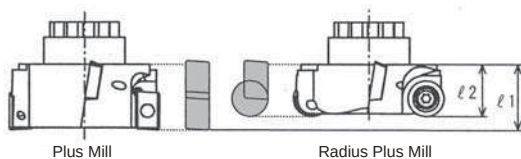


Fig.1

For Radius Plus Mill and Plus Mill, the number of Front Piece required varies depending on the ap.

- Difference of Clamp Bolt Length in the Front Piece
Radius Plus Mill's inserts protrude from the bottom of the body for the function of ramping or helical milling, as well as the difference of Front Piece Length. For this reason, the Radius Plus Mill's clamp bolt length in the front piece is shorter than that of Plus Mill. (Fig.2)

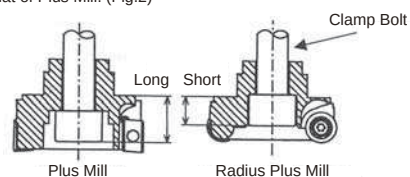


Fig.2

When using Radius Plus Mill's front piece, be careful for the difference of clamp bolt length as mentioned above.

If the length of clamp bolt is too long, the front piece will not be secured even when the bolt is tightened. Make sure to check the length of clamp bolt for installation of the front piece to avoid troubles such as tool damages.

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Milling