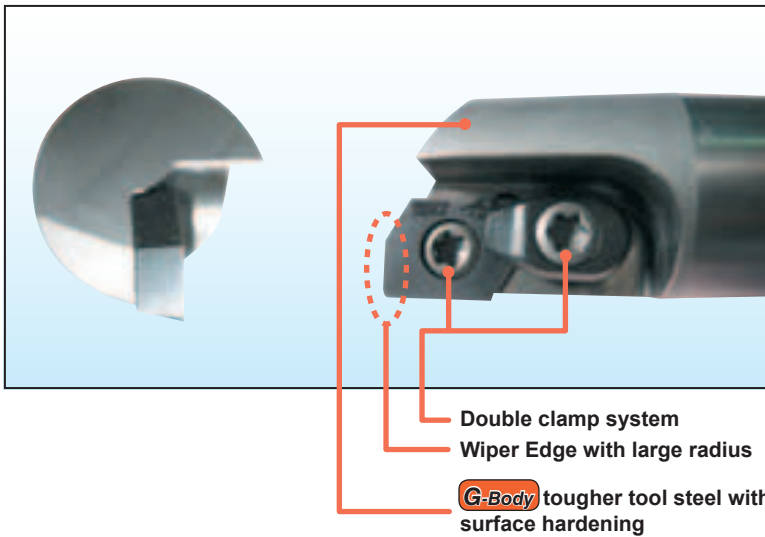


Finish-One

Finishing Indexable End Mill

Features:

- Can attain 1µm or less surface finish on 2D work.
- Finish achieved using wiper edge with large radius.
- No tool deflection occurs due to single cutting edge design.
- Insert available in DV coated and cermet.

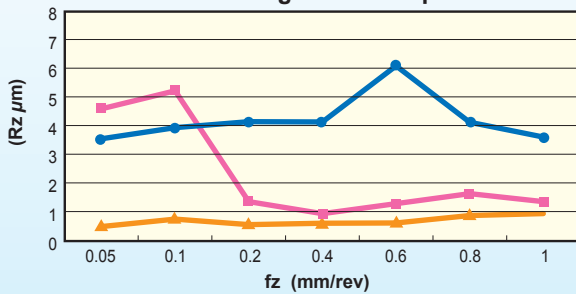


PERFORMANCE RESULTS

Material: Carbon Steel (C50)
(200-250HB)
Tool: T-FON1200 (Ø20mm)
Insert: LDGW120308

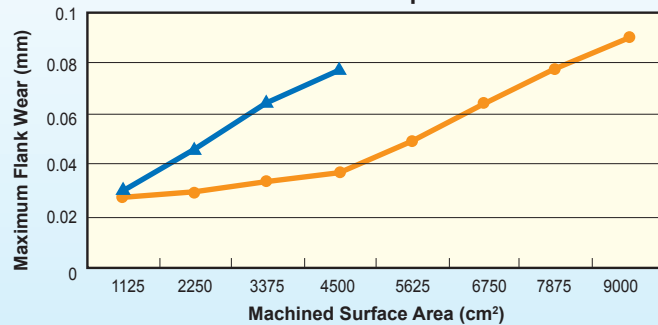
Running Parameters:
 $n=4775 \text{ min}^{-1}$
 $a_p=0.1 \text{ mm}$
 $a_e=10 \text{ mm}$

Surface Roughness Comparison



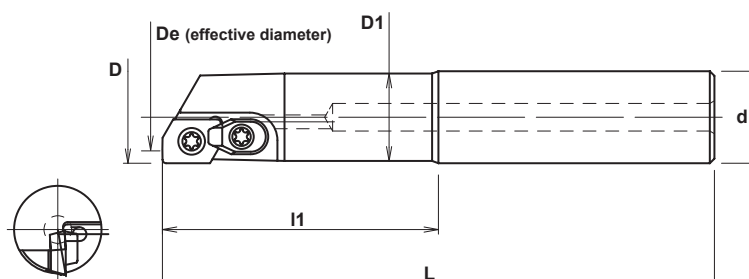
● RNM-200-R10 JC8015
■ T-FON1200 JC8003
▲ T-FON1200 CX75

Tool Life Comparison

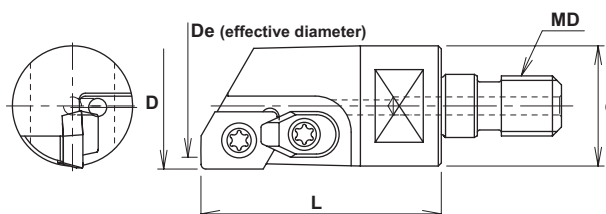


● T-FON1200 CX75
▲ RNM-200-R10 JC8015

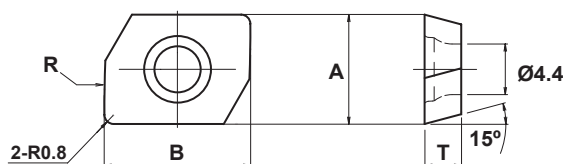
Finish-One Indexable End Mill

METRIC
T-FON type
G-Body

Specifications

CATALOG NUMBER	STK	DIMENSIONS						INSERT	Q	PARTS		
		D	De	D1	L	I1	d			Screw	Wrench	Clamp
T-FON1160	■	16	12.5	15	110	60	16	LDGW120308	1	CSW-406H	A-15	DCM-18
T-FON1200	■	20	16.5	19	120	60	20	LDGW120308	1	CSW-408H	A-15	DCM-18

Note: All cutters are supplied without inserts.
Modular Head
G-Body

Specifications

CATALOG NUMBER	STK	DIMENSIONS					INSERT	PARTS		
		D	De	L	d	MD		Screw	Wrench	Clamp
MFO-170-M8	•	17	13.5	40	16	M8	LDGW120308	CSW-406H	A-15	DCM-18
MFO-210-M10	•	21	17.5	40	20	M10	LDGW120308	CSW-408H	A-15	DCM-18

Note: All cutters are supplied without inserts.
Inserts

Specifications

CATALOG NUMBER	IC TOLERANCE	DIMENSIONS			PVD COATED	CERMET
		A	B	T	JC8003	CX75
LDGW120308	G	9.525	12.7	3.18	•	■


METRIC

Finish -One Indexable End Mill

CARBIDE SHANK HOLDER



Fig. 1

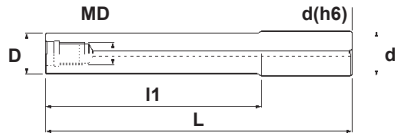
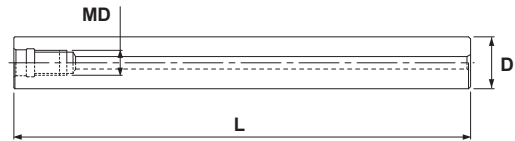
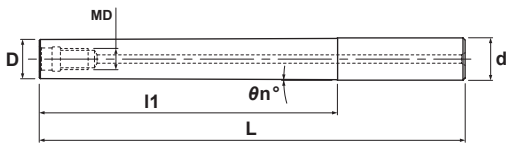


Fig. 2



Specifications

CATALOG NUMBER	STK	DIMENSIONS					FIG.
		D	I1	L	d	MD	
MSN-M8-20-S16C	•	15.5	20	75	16	M8	1
MSN-M8-40-S16C	•	15.5	40	95	16	M8	1
MSN-M8-80-S16C	•	15.5	80	135	16	M8	1
MSN-M8-120-S16C	•	15.5	120	175	16	M8	1
MSN-M10-20-S20C	•	19.5	20	80	20	M10	1
MSN-M10-40-S20C	•	19.5	40	100	20	M10	1
MSN-M10-40T-S20C	•	18.5	40	100	20	M10	2
MSN-M10-70-S20C	•	19.5	70	130	20	M10	1
MSN-M10-90-S20C	•	19.5	90	150	20	M10	1
MSN-M10-90T-S20C	•	18.5	90	150	20	M10	2
MSN-M10-140-S20C	•	19.5	140	200	20	M10	1
MSN-M10-140T-S20C	•	18.5	140	200	20	M10	2

Specifications - Straight

CATALOG NUMBER	STK	DIMENSIONS		
		L	d	MD
MSN-M8-97S-S15C	•	97	15	M8
MSN-M8-147S-S15C	•	147	15	M8
MSN-M8-107S-S16C	•	107	16	M8
MSN-M8-157S-S16C	•	157	16	M8
MSN-M10-130S-S18C	•	130	18	M10
MSN-M10-190S-S18C	•	190	18	M10
MSN-M10-130S-S20C	•	130	20	M10
MSN-M10-190S-S20C	•	190	20	M10
MSN-M10-250S-S20C	•	250	20	M10

Recommended Cutting Data

Work Materials	Insert Grade	Diameter							
		16mm (17mm Modular Head)				20mm (21mm Modular Head)			
		Vc (m/min)	fz (mm/rev)	ap (mm)	ae (mm)	Vc (m/min)	fz (mm/rev)	ap (mm)	ae (mm)
Carbon Steel (C50, C55) up to 250HB	CX75 (JC8003)	200~300	0.3~0.6	0.05~0.1	8~11	200~300	0.3~0.6	0.05~0.1	10~14
Mold Steel (1.2311, P20) 30-43HRC	JC8003 (CX75)	100~250	0.2~0.6	0.05~0.1	8~11	100~250	0.2~0.6	0.05~0.1	10~14
Cast Iron, Nodular Iron (GG, GGG) up to 300HB	JC8003	300~400	0.3~0.6	0.1~0.2	8~11	300~400	0.3~0.6	0.1~0.2	10~14

NOTE: 1. Continuous stroke processing is recommended to avoid vibration when tool is entering or exiting work material.

2. In case of chattering, coarse surface or steps, recommended to reduce cutting speed & maintain feed rate.

3. Figures should be adjusted according to the machine rigidity or work rigidity.

See Page A-177 for **G-Body** steel holder

See Pages A-175 thru A-177 for weights & coolant hole sizes