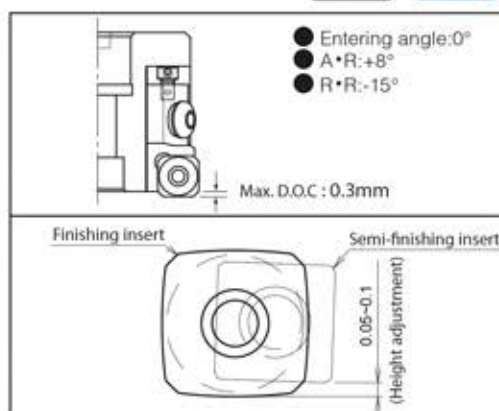


Finish Jet Mill

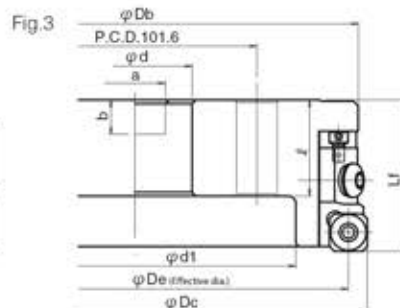
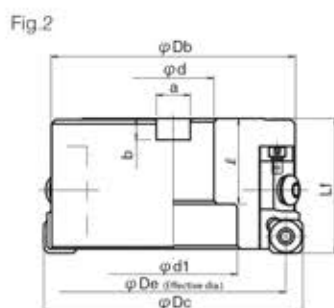
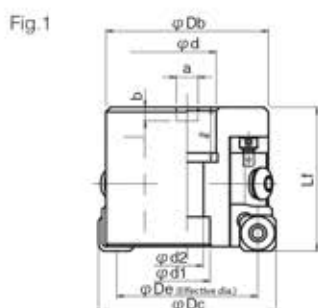
FJM TYPE

● Super Finishing Milling Application

1. The combination of 2 finishing cartridges and 2 semi-finishing cartridges gives stable finishing quality of unreliable removal stock on cast iron and cast steel.
2. Maximum $a_p=0.3\text{mm}$ (3 times larger than competitor's a_p) Consolidate to one process of semi-finishing and super-finishing
3. Two semi-finishing inserts protect the finishing inserts and also achieve longer tool life with reducing cutting force.
4. Easy to adjust the face runoff by adjusting the cartridges.
5. JC8003 for cast iron and stainless steel, Cermet grade CX75 for general steels.



■ BODY



Cat. No.	Stock	No. of Inserts	Dimensions (mm)										Weight (kg)	Fig.
			φDc	φDe (Eff. dia)	Db	Lf	φd	φd1	φd2	a	b	ℓ		
FJM-4080R-27	●	2 Finishing & 2 Semi-finishing inserts	80	65	71	63	27	20	14.3	12.4	7	22	1.7	1
FJM-4100R-32	●		100	85	90	63	32	26	17	14.4	8	32	2.7	1
FJM-4125R-40	●		125	110	114	63	40	60	—	16.4	9	40	3.9	2
FJM-4160R-40	●		160	145	148	63	40	75	—	16.4	9	40	6.1	2
FJM-4200R-60	●		200	185	186	63	60	134	—	25.7	14	40	8.6	3
FJM-4250R-60	□		250	235	237	63	60	182	—	25.7	14	40	14.8	3

Note) 1. All cutter bodies are supplied without inserts.

2. Please refer page C258 for recommended cutting conditions.

Finish Jet Mill

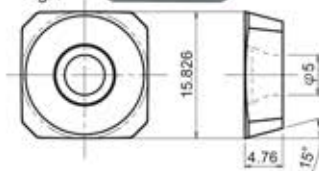
FJM_{TYPE}

■ INSERTS

SDHW1504ADFN-W1



Fig.1



SDHW1 504ADE(F)N-W2



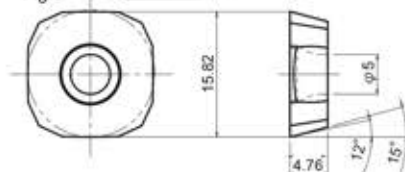
Fig.2



SDHW1504ADEN-F1



Fig.3



SPHW1203ZPTR



Fig.4






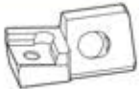





Cat. No.	PVD coated		Cermet	Tolerance	Fig.	Application
	DH103	JC8015	CX75			
SDHW1504ADFN-W1 (finishing insert)	●			H	1	Cast iron•Cast steel
SDHW1504ADFN-W2 (finishing insert)			●	H	2	Carbon steel•Alloy steel
SDHW1504ADEN-W2 (finishing insert)	●			H	2	Mold steel•Die steel
SDHW1504ADEN-F1 (finishing insert for low rigid work)	●		●	H	3	DH103...(Cast iron•Cast steel) CX75...(Carbon steel•Alloy steel)
SPHW1203ZPTR (Semi-finishing insert)		●		H	4	

4 inserts per case, but in case of SPHW1203ZPTR: 10 piece per case.

Finish Jet Mill

FJM^{TYPE}

PARTS

Clamp screw	Wrench	Cartridge for finishing insert	Cartridge for semi-finishing insert	Set bolt for cartridge
				
Recommended torque 6.0N·m				
DSW-4510H	A-20 (φ80~φ200) A-20L (φ250)	SSFDR15-15F	SSFPR15-12R	BBH-825
Wrench for cartridge	Wrench for axial adjust screw	Axial adjust screw	Spring washer	
				
LW-050	AD-2080	ADS-513	SBZ-8	

RECOMMENDED CUTTING CONDITIONS

	Work Materials	Inserts	Insert Grades	Vc (m/min)	f (mm/rev)	ap (mm)	ae (mm)
P	Low carbon & Mild steel S20C, SS400 (C20) Below 255HB	SDHW1504ADFN-W2 (SDHW1504ADEN-F1)	CX75	250~300	4~5	up to 0.3mm	up to 0.8De
	Medium carbon steel S50C (C50) Below 255HB	SDHW1504ADFN-W2 (SDHW1504ADEN-F1)	CX75	200~250	4~5	up to 0.3mm	up to 0.8De
	Alloy & Die steel SCM440, SKD11 (1.7223, 1.2379) Below 255HB	SDHW1504ADFN-W2 (SDHW1504ADEN-F1)	CX75	100~150	4~5	up to 0.3mm	up to 0.8De
M	Stainless steel SUS304, 316 Below 250HB	SDHW1504ADFN-W2 (SDHW1504ADEN-F1)	JC8003	80~120	2~4	up to 0.2mm	up to 0.8De
K	Grey cast iron FC250, FC300 (GG25, GG30) Below 300HB	SDHW1504ADFN-W2 (SDHW1504ADEN-F1)	JC8003	130~200	4~6	up to 0.3mm	up to 0.8De
	Nodular cast iron FCD500, FCD700 (GGG50, GGG70) Below 300HB	SDHW1504ADFN-W2 (SDHW1504ADEN-F1)	JC8003	110~180	4~6	up to 0.3mm	up to 0.8De
H	Mold steel HPM7, PX5, NAK80, P20 (1.2311, P20) Below 30~40HRC	SDHW1504ADFN-W2 (SDHW1504ADEN-F1)	JC8003	100~140	2~4	up to 0.2mm	up to 0.8De
	Hardened die steel SKD61, DAC, DHA (1.2311, P20) Below 40~55HRC	SDHW1504ADFN-W2 (SDHW1504ADEN-F1)	JC8003	40~60	0.3~0.7	up to 0.1mm	up to 0.7De

Vc: Cutting speed, f: Feedrate, ap: Depth of cut, ae: Width of cut

Note) 1. In case of stainless steel, recommend wet cutting.
2. Recommend to use-F1 type insert for low rigid work.