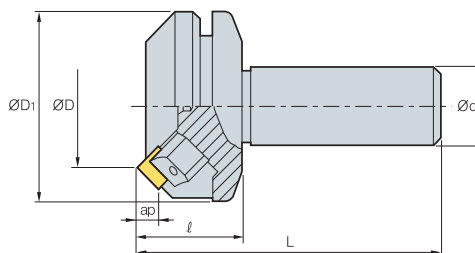


ADS4000



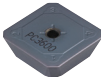
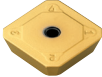
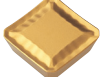
AA
45°

• AR: 15°
• RR: -3°

(mm)

Designation			ØD	ØD ₁	Ød	ℓ	L	ap	 kg
ADS	4050R/L	3	50	75	32	40	120	6.5	1.8
	4050R/L-S42	3	50	75	42	40	120	6.5	2.2
	4063R/L	4	63	87	32	40	120	6.5	2.3
	4063R/L-S42	4	63	87	42	40	120	6.5	2.7

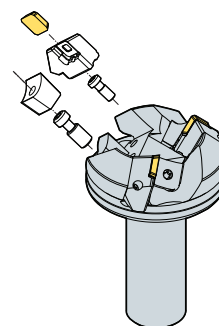
Available inserts

SDCN		SDKN-MU		SDKN-SU		SDKR-MX					
											
Designation		Cermet	Coated						Uncoated	page	
		CN2000 CN30	NCM325 NCM335 NC5330	NCM535 NCM545	PC3600 PC3700	PC6510 PC9530	PC9540 PC5300	PC5400	ST30A G10 H01		
SDCN	42M									●	E17
	42M-G									●	
	42MT	● ●	●						●		
	42MT-RH										
	42MT-S20					●					
	1203AEEN										
	1203AEEN-RH										
	1203AESN										
1203AESN-RH											
SDKN	1203AESN-MU				●						E18
	1203AESN-SU				● ●		● ●				
SDKR	1203AESN-MX										E18
	1203AETN-MX										
	1203AEN-MX		●								

Recommended cutting condition

Workpiece	Cutting condition		Grades
	vc (m/min)	fz (mm/t)	
P	190~320	0.05~0.20	NCM325 PC3600 ST30A
	161~270	0.05~0.20	
	80~140	0.05~0.20	
M	90~150	0.05~0.20	PC9530
K	140~230	0.05~0.30	PC6510 G10
	50~90	0.05~0.30	

Assembling



Parts

Specification					
Ø50-Ø63	LASS4R/L	WASR/L	WTX0817	LTX0512	TW25

Available inserts E17, E18