

To use the cutter safely and not to decrease its performance,  
Please observe the following steps and each standard values.

## Instruction manual for AHX640S Multi corner insert type milling cutter for general purpose

### 1. Feature of the product

#### a. Double positive cutting edge

Although the insert is negative typed, we succeeded to make double positive cutting edge. It shows the excellent sharpness.  
(When MK,MP breaker is installed.)

#### b. Heptagonal indexable insert

The insert is heptagonal so it has total of 14 corners that is very economical for using.

### 2.Setting instruction for placing and removing the insert

#### a. Cleaning

Please clean up the insert and the insert pocket carefully with air blowing or a brush.

#### b. Clamping

Press firmly down the insert and tighten the screw by attached torques wrench (Fig. A).

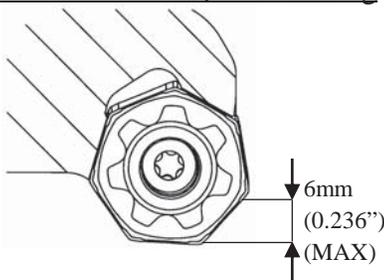
- Prescribed tightening torque value 5.0N·m (3.70ft·lb)
- Please insert the torques wrench firmly to the bottom of the torques pitch.
- Please use anti-seize lubricant, preventing the screw from seizing.
- Ensure there is no space between the insert and the insert seat.

### 3.Attaching the tool to an arbor

Before attaching the tool, ensure all locating faces are cleaned and are free of any obstructions.

### 4. Limited values

#### a. Maximum depth of cutting



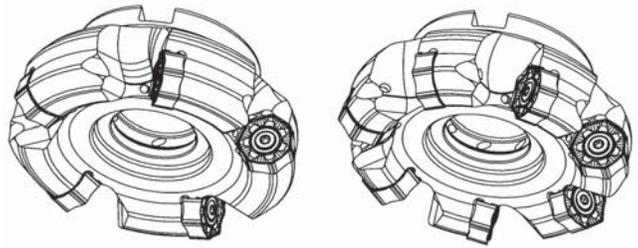
#### b. Maximum allowable spindle speed

|                                    |                  |                  |                   |                   |                   |                   |
|------------------------------------|------------------|------------------|-------------------|-------------------|-------------------|-------------------|
| Cutter Dia. (mm)                   | φ63<br>(φ3.150") | φ80<br>(φ3.150") | φ100<br>(φ3.937") | φ125<br>(φ4.921") | φ160<br>(φ6.299") | φ200<br>(φ7.874") |
| Spindle speed (min <sup>-1</sup> ) | 12,000           | 10,000           | 8,700             | 7,500             | 6,100             | 5,100             |
| Cutter Dia. (inch)                 | φ2.5"<br>(φ63.5) | φ3"<br>(φ76.2)   | φ4"<br>(φ101.6)   | φ5"<br>(φ127)     | φ6"<br>(φ152.4)   | φ8"<br>(φ203.2)   |
| Spindle speed (min <sup>-1</sup> ) | 11,800           | 10,000           | 8,600             | 7,300             | 6,400             | 5,000             |

### 5.Table of the combination of the wiper insert

Please use WNEU2006ZEN7C-WK with NNMU200608ZEN-MK or NNMU200608ZEN-HK for finishing cast iron. Don't use WNEU2006ZEN7C-WK with NNMU200708ZEN-MP. If you use this combination, the performance will be inferior and insert break may occur.

| Breaker kind | WK (Wiper insert) |
|--------------|-------------------|
| MP           | NG                |
| MK, HK       | OK                |



attached component

| insert screw   | wrench  |
|--|---|
|  |  |
| CS5015060T   | TKY20T  |

Please use original parts.

If other parts are used, the performance will be inferior and the safety can not be assured.

Fig. A

