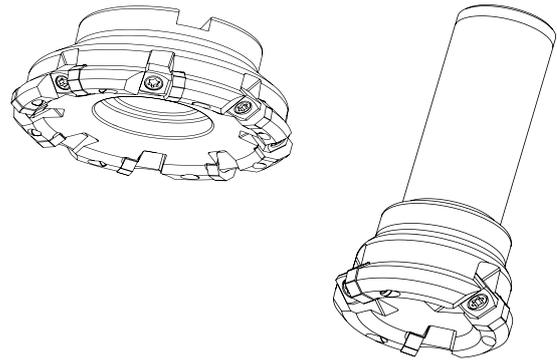


Instruction manual for AOX445

High efficient face milling cutter for cast iron

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

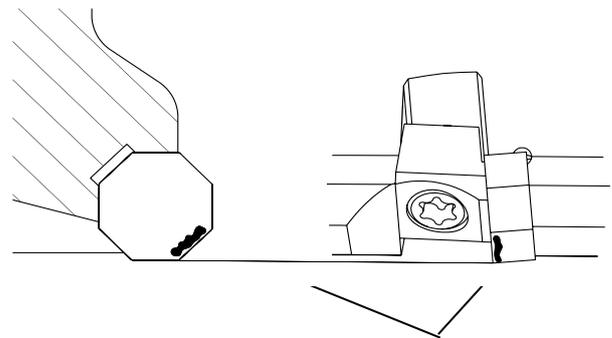


1. Feature of product

- a. It is very thrifty for an CBN solid octagonal insert with 16 corners' cutting edge.
(in case of depth of cut : under 3mm)
- b. It is very wide application, rough to semi-finishing cutting.

2. Setting instruction for placing and removing the insert

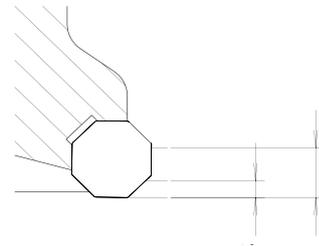
- a. Cleaning
Please clean up carefully the insert and the insert pocket before clamping
If you remained anything on the insert, insert might be broken
- b. Clamping
Press firmly down the insert and tighten the screw by attached torques wrench
Prescribed tightening torque value
8.0N·m (5.9ft·ld)



Please remove something when you change the corner of insert

3. Limited values

- ①Maximum depth of cutting
 - a. Use 8 corners : Maximum depth of cut is under 8mm
 - b. Use 16 corners : Maximum depth of cut is under 3mm



Cutter dia (mm)	φ 50	φ 63	φ 80	φ 100	φ 125	φ 160	φ 200
Maximum allowable spindle speed (min ⁻¹)	13000	12000	11000	9300	8300	7200	6400

4. Recommended cutting condition

Work material		tensile strength	Grad	Cutting speed (m/min)	Feed per tooth (mm/tooth)
K	Cast Iron	≤200MPa	BC5030	1000 (800-1500)	0.1 (0.05-0.15)
		250-350 MPa			

5. Spare parts

wedge	clamp screw	wrench
CWAOX445N	LS15T	TKY25T