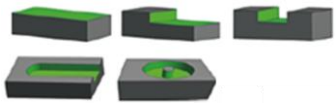
• *LNMU 02 FEED MILL*

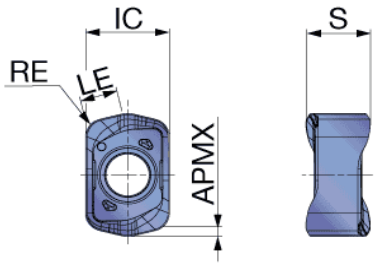


4 CORNER HI FEED INSERT
Particularly suitable for High Feed Machining
Low cutting forces Excellent chip evacuation
Low chipping tendency Minimum Diameter 8mm

• ***END MILL***

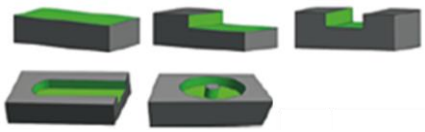
ITEM DESCRIPTION	dc	L1	L	D	Z	SCREW
EXN02-C10-8-150L-1T	8	25	150	10	1	M1.8*6
EXN02-C12-12-150L-2T	12	25	150	12	2	M1.8*6
EXN02-C14-14-150L-3T	14	25	150	14	3	M1.8*6

• Insert



ITEM DESCRIPTION	LE	R	APMX	IC	AS1007	AS9030	AS7020
LNMU 0202 ZE	1.79	0.9	0.5	4	●	●	●

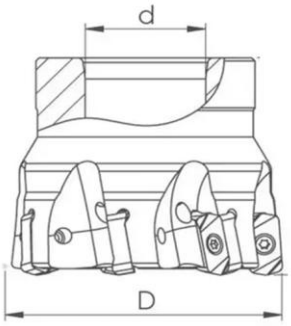
• *LNMU 03 FEED MILL*



4 CORNER HI FEED INSERT
Particularly suitable for High Feed Machining
Low cutting forces Excellent chip evacuation
Low chipping tendency Minimum Diameter 16mm

• END MILL

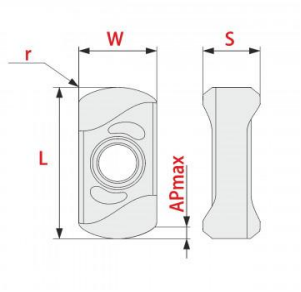
ITEM DESCRIPTION	dc	L1	L	D	Z	SCREW
EXN03-C16-16-150L-2T	16	35	150	16	2	M2.5*8
EXN03-C16-16-200L-2T	16	35	200	16	2	M2.5*8
EXN03-C20-20-150L-3T	20	40	150	20	3	M2.5*8
EXN03-C20-20-200L-3T	20	40	200	20	3	M2.5*8
EXN03-C25-25-150L-4T	25	40	150	25	4	M2.5*8
EXN03-C25-25-200L-4T	25	40	200	25	4	M2.5*8
EXN03-C32-32-150L-5T	32	45	150	32	5	M2.5*8
EXN03-C32-32-200L-5T	32	45	200	32	5	M2.5*8



• SHELL MILL CUTTER

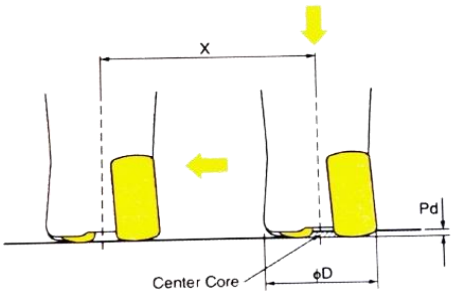
ITEM DESCRIPTION	D	d	Z	insert	SCREW	KEY
EXN03-40-22-6T	40	22	6	LNMU03	M2.5*8	7IP
EXN03-50-22-8T	50	22	8	LNMU03	M2.5*8	7IP
EXN03R-63-22-10T	63	22	10	LNMU03	M2.5*8	7IP
EXN03R-80-27-12T	80	27	12	LNMU03	M2.5*8	7IP

● Insert



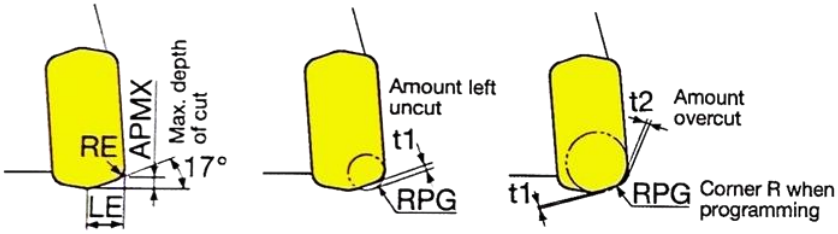
ITEM DESCRIPTION	AP	R	W	S	AS1007	AS9030	AS7020
LNMU 0303 ZE	1	1.2	6	4.3	●	●	●

● Drilling Guideline



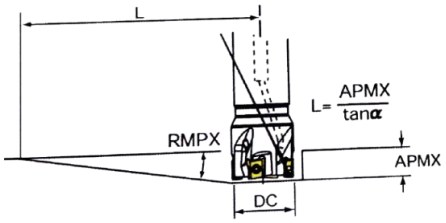
LNMU 0303						
Cutter Dia	16	20	25	32	40	50
Max.Cutting Depth Pd	0.9	0.9	0.9	0.9	0.9	0.9
Min.Cutteing Lenth X for Flat Bottom Surface	12.2	16.2	21.2	28.2	36.2	46.2

● Technical Guide

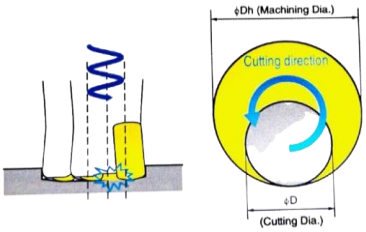


Max.depth of cut APMX (mm)	Corner Radius RE (mm)	LE (mm)	Programming Corner Radius	Ampunt Left Uncut t1 (mm)	Amount Left overcut t2 (mm)
1.0	1.2	3.0	1.0	0.6	-
1.0	1.2	3.0	1.5	0.5	-
1.0	1.2	3.0	2.0	0.25	0.08
1.0	1.2	3.0	2.5	0.14	0.26

● Ramping



● Helical Milling



Cutter Dia	16	18	20	25	32	40	50
Max.Ramp Angle	-	1.7°	1.4°	1°	0.7°	0.5°	0.4°
Hole Dia	-	26-34	30-38	40-48	54-62	70-78	90-98

LNMU 02/03□□

Recommended Cutting Conditions

ISO	Work Material	Grade	Ap (Max)	Cutting Speed Vc (m/min)	Feed Rate fz (mm/t)
P	Steel (Carbon,Alloy,Mold)	AS9030 AS1007 AS7020	1	80-220	1.0-2.0
M	Staniless Steel Austenite,Ferrite,Martensite	AS9030 AS1007 AS7020	1	60-150	0.8-0.2
K	Cast Iron (Grey,Nodular,Ductile)	AS9030 AS1007 AS7020	1	100-250	1.0-3.0
S	High Tempeature Alloys (Ti,Ee,Ni & Co Based)	AS9030 AS1007 AS7020	1	40-80	0.6-1.5
H	Hardened Steel	AS7020	1	30-80	0.6-1