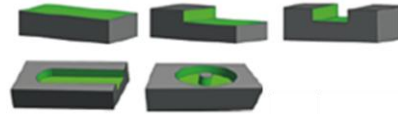


● LOGU 03 FEED MILL



4 CORNER HI FEED INSERT

Particularly suitable for High Feed Machining

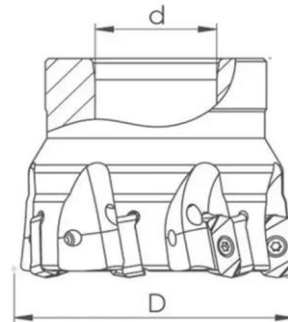
Low cutting forces Excellent chip evacuation

Low chipping tendency Minimum Diameter 16mm



● END MILL

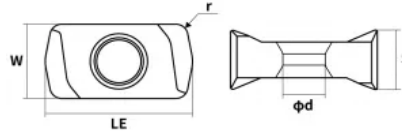
ITEM DESCRIPTION	dc	L1	L	D	Z	SCREW
XN03-C16-16-150L-2T	16	35	150	16	2	M3.0*10
XN03-C16-16-200L-2T	16	35	200	16	2	M3.0*10
XN03-C20-20-150L-3T	20	40	150	20	3	M3.0*10
XN03-C20-20-200L-3T	20	40	200	20	3	M3.0*10
XN03-C25-25-150L-4T	25	40	150	25	4	M3.0*10
XN03-C25-25-200L-4T	25	40	200	25	4	M3.0*10
XN03-C32-32-150L-5T	32	45	150	32	5	M3.0*10
XN03-C32-32-200L-5T	32	45	200	32	5	M3.0*10



● SHELL MILL CUTTER

ITEM DESCRIPTION	D	d	Z	insert	SCREW	KEY
XN03-40-22-6T	40	22	6	LNMU03	M3.0*10	8IP
XN03-50-22-8T	50	22	8	LNMU03	M3.0*10	8IP
XN03R-63-22-10T	63	22	10	LNMU03	M3.0*10	8IP
XN03R-80-27-12T	80	27	12	LNMU03	M3.0*10	8IP

● Insert

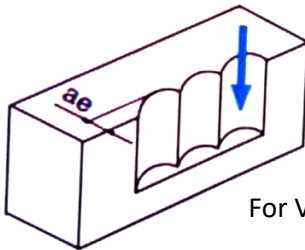


ITEM DESCRIPTION	AP	R	W	S	AS1007	AS9030	AS7020
LOGU030310	1	1	6	4.3	●	●	●

● Technical Guide

● Vertical Milling (Plunging)

Available For Vertical Milling (Plunging)

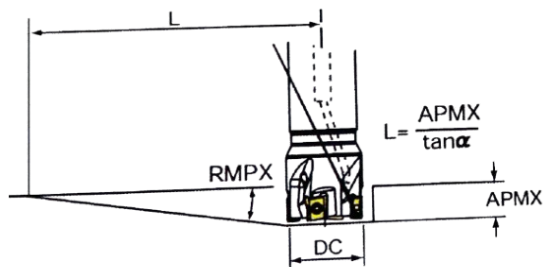


Insert Description	Max. Width Of Cut (ae)
LOGU	3.5 MM

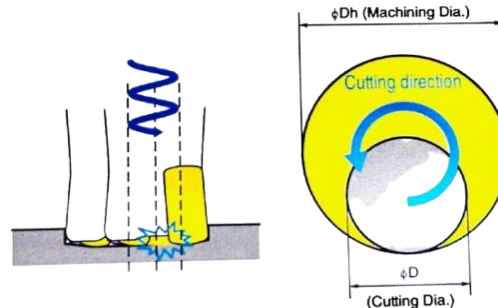
For Vertical Milling (Plunging), Reduce Feed Rate to $fz=0.2\text{mm/t}$ or less

● Technical Guide

● Ramping

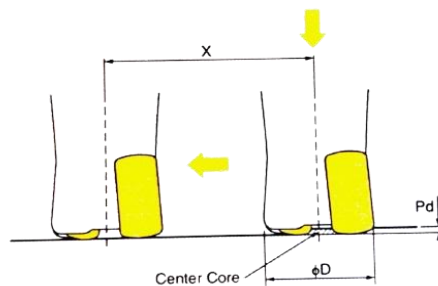


● Helical Milling



LOGU 0303						
Cutter Dia	16	20	25	32	40	50
Max.Ramp Angle	2.8°	1.7°	1.2°	0.8°	0.5°	0.4°
Hole Dia	24-30	32-38	42-48	56-62	72-78	92-98

● Drilling Guideline



LOGU 0303						
Cutter Dia	16	20	25	32	40	50
Max. Cutting Depth Pd	1	1	1	1	1	1
Min.Cutting Lanth X for Flat Bottom Surface	7	11	16	23	31	41

*When traversing directly after drilling, set the table feed at up to 25% of the recommended cutting conditions.

*When drilling, reduce feed rate per revolution to under $f=0.2\text{mm/rev}$

LOGU 0303□□

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	1	80-220	1.0-2.0
		AS1007			
		AS7020			
M	Staniless Steel Austenite,Ferrite,Martensite	AS9030	1	60-150	0.8-0.2
		AS1007			
		AS7020			
K	Cast Iron (Grey,Nodular,Ductile)	AS9030	1	100-250	1.0-3.0
		AS1007			
		AS7020			
S	High Tempeature Alloys (Ti,Ee,Ni & Co Based)	AS9030	1	40-80	0.6-1.5
		AS1007			
		AS7020			
H	Hardened Steel	AS7020	1	30-80	0.6-1