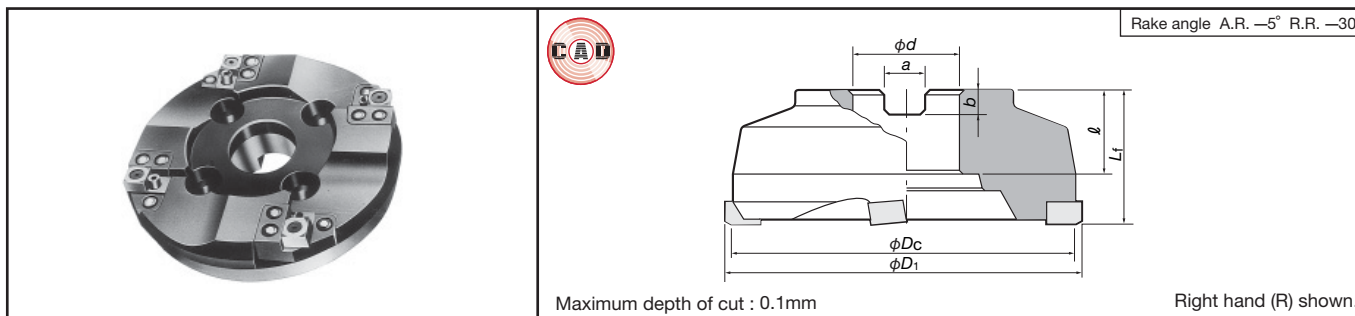


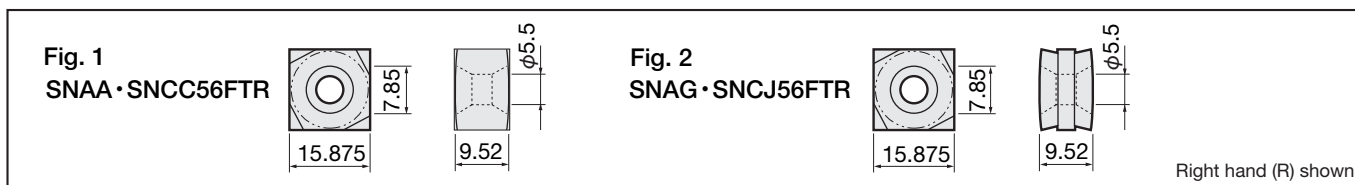


For precision finishing of steels and cast irons



Cat. No.	Stock		No. of inserts	Dimensions (mm)						Weight (kg)	Mounting details			
	R	L		ϕD_c	ϕD_1	ϕd	ℓ	L_f	b			a		
MS04R/L			2	100	105	31.75	32	55	8	12.7	3	9-144B		
MS05R/L				125	130	38.1			10	15.9	4			
MS06R/L				150	155	50.8			11	19	5			
MS08R/L			4	200	205	47.625	38	60	14	25.4	8.5	9-144C		
MS10R/L				250	255						14		25.4	14
MS12R/L				300	305						23			9-144D

Inserts



Cat. No. (Inch system)	ISO Cat. No. (Metric system)	Accuracy	Cutting edge length (mm)	Grades		Figure
				Cermet	Uncoated	
SNAA56FTR	SNAC1509PNTR	A	7.80	X407	TU10	Fig. 1
SNAG56FTR	SNAJ1509PNTR					
SNCC56FTR	SNCC1509PNTR	C	7.80			Fig. 1
SNCJ56FTR	SNCJ1509PNTR					

Packed : 4pcs.

Replacement parts

MS04R/L-MS06R/L	MS08R/L-MS12R/L (Locator type)	No.	Parts	Part Cat. No.		
				MS04R/L	MS05R/L, MS06R/L	MS08R/L-MS12R/L
		①	Locator	—	—	LMS56R/L
		②	Clamping screw	CST-5	CST-5	CST-5
		③	Pin	SP-8	SP-8	SP-8
		④	Locator fixing screw	—	—	CM6 × 25, CM6 × 16
		⑤	Washer	—	—	VA6
		⑥	Protector	PMS4R/L	PMS5R/L	PMS5R/L
		—	Wrench	T-25D	T-25D	T-25D

Standard cutting conditions

Work materials	Insert grade	Cutting speed v_c (m/min)	Feed per tooth f_z (mm/tooth)	Depth of cut a_p (mm)
Mild steels	X407	260~300	< 6	< 0.1
Carbon steels				
Alloy steels				
Die steels				
Cast irons	TU10	100~150	< 6	< 0.1
Carbon steels (> 40HRC)	X407	150~200	< 3	< 0.05

- No. of revolutions (min⁻¹) = Cutting speed × 1000 ÷ 3.14 ÷ Cutter diameter
- Table feed (mm/min) = No. of revolutions × Feed per tooth × No. of inserts

● : Stocked in Japan.