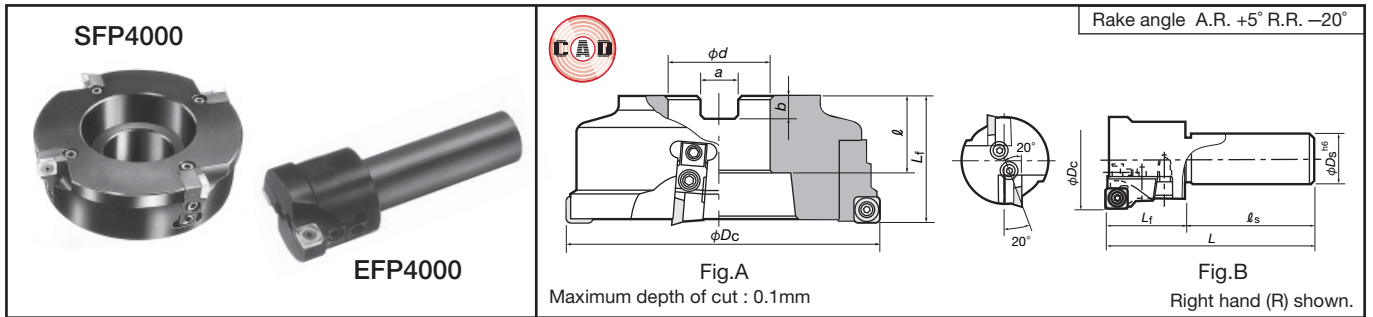


For precision finishing of general steels, cast irons and stainless steels



SFP4000 (Fig. A)

Cat. No.	Stock		No. of inserts	Dimensions (mm)						Weight (kg)	Mounting details
	R	L		ϕD_c	ϕd	ℓ	L_f	b	a		
SFP4004R/L	●		2	100	31.75	32	63	8	12.7	2.3	9-144(A)
SFP4005R/L	●			125	38.1			10	15.9		
SFP4006R/L	●		4	160	50.8	38	63	11	19.0	5.8	9-144(B)
SFP4008R/L	●			200	47.625			14	25.4		
SFP4010R/L			6	250		8	315				
SFP4012R/L			8	315						9-144(D)	

EFP4000 (Fig. B, shank-type spec)

Cat. No.	Stock		No. of inserts	Dimensions (mm)				
	R	L		ϕD_c	L_f	ℓ_s	L	ϕD_s
EFP4050R	●		1	50	40	80	120	32
EFP4063R	●		2	63	50			

Note: EFP4063R is applied with front edge adjusting mechanism. But EFP4050R is not.

Inserts

Cat. No.	ISO Cat. No.	Accuracy	Honing	Cermet	Uncoated
				N308	TH10
SPHA435FNW	SPHB120420FN-W	H	Without	●	●

Replacement parts

No.	Parts	Part Cat. No.		
		SFP4000	EFP4050R	EFP4063R
①	Locator	LW400R/L	LW402R	LW400R
②	Locator adjusting wedge	FW-305	—	FW-305
③	Insert fixing screw	CSTA-5S	CSTA-5S	CSTA-5S
④	Locator fixing screw	CM5 × 0.8 × 16	CM5 × 0.8 × 16	CM5 × 0.8 × 16
⑤	Hex. socket-head screw	CM5 × 0.8 × 8	—	CM5 × 0.8 × 8
⑥	Washer	(JIS) L5	—	(JIS) L5
⑦	Wedge-locking screw	FDS-8S	—	FDS-8S
—	Spring washer	(JIS) 5S	—	(JIS) 5S
—	T-handle wrench	P-4	—	P-4
—	Wrench	T-15D	T-15D	T-15D

Standard cutting conditions

Work materials	Insert grade	Cutting speed v_c (m/min)	Feed per revolution f (mm/rev)		Depth of cut a_p (mm)
			SFP	EFP	
Mild steels	N308	180~250	< 6	< 4	< 0.1
Carbon steels		150~200			
Alloy steels					
Stainless steels	N308	160~200	< 4	< 3	< 0.1
Cast irons	TH10	100~150	< 5	< 3	< 0.2
Nonferrous metals	TH10	200~500	< 6	< 4	< 0.1

Note: Under above conditions, attainable surface roughness is 3 to 4 μm R_z for steels and 6~12 μm R_z for cast irons.

- No. of revolutions (min^{-1}) = Cutting speed \times 1000 \div 3.14 \div Cutter diameter
- Table feed (mm/min) = No. of revolutions \times Feed per tooth \times No. of inserts

● : Stocked in Japan.