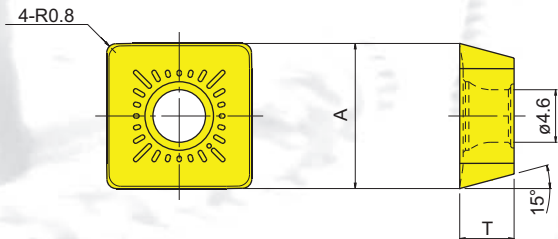


“Mighty Blader”





MIG Inserts

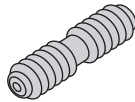
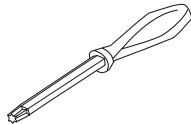


Cat.No.	Coated		Dimensions (mm)			
	JC8015	JC5040	A	T		
SDMT1204PDER	●	●	12.7	4.76		

● New product on request

Parts

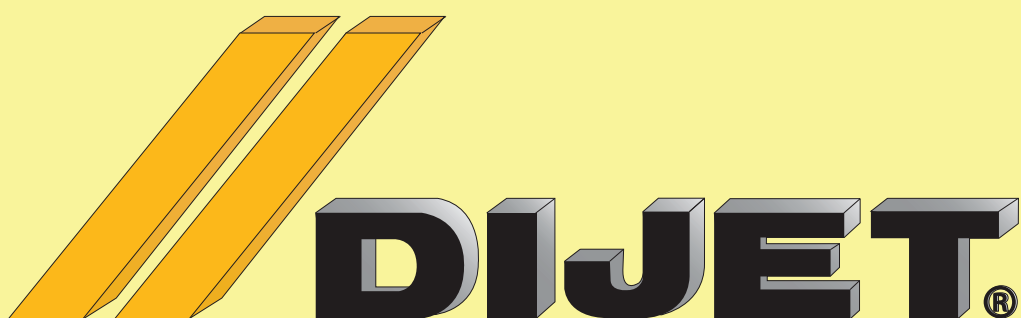
Clamp screw / Torque	Seat	Seat bolt	Rest button
			
ESW-412 (3.1 N-m)	BSV43S-1	M4 x 0.7 x 10	RB-14

Wedge screw	Wrench
	
LS-113	A-I5SD

Recommended Cutting Conditions for Mighty Blader

Material group	Hardness (HB)	Typical groups	Grade	Cutting speed Vc (m/min)	feed fz (mm/th)
Low carbon steel	125 - 180	C15, ST137, 1.0401	JC5040	100 ~ 250	01 ~ 0.2
Low alloy steel	170 - 220	CK45, 1.1231, 16MnCr5	JC5040	100 ~ 250	01 ~ 0.2
High alloy steel	200 - 260	X20Cr13, 1.4923	JC5040	80 ~ 200	01 ~ 0.2
Tool & Die steel	280 - 370	1.2379, 1.2311	JC5040	80 ~ 180	01 ~ 0.2
Stainless steel	150 - 270	1.4404, 316, 321	JC5040	100 ~ 250	01 ~ 0.2
Grey cast iron	200 - 250	GG25, GRADE220	JC5040	100 ~ 250	01 ~ 0.2
S.G. iron	180 - 250	GGG60, SNG600/3	JC5040	100 ~ 250	01 ~ 0.2

TOOLING BY



“ ISO & Dijet Milling Inserts ”

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