

# Finish Jet Mill FJM type



● Super Finishing Milling Application

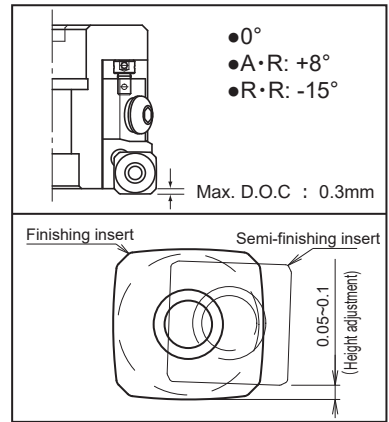
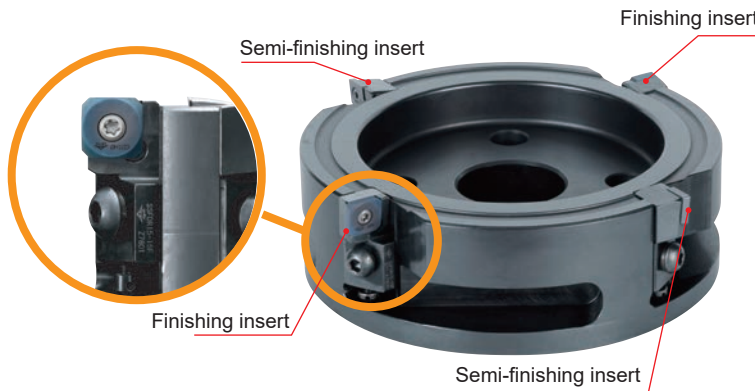


Fig.1

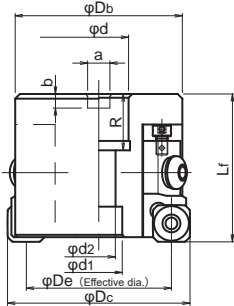


Fig.2

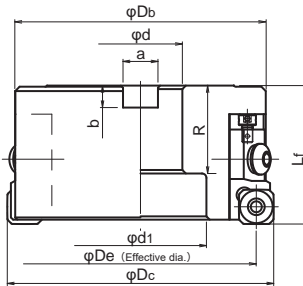
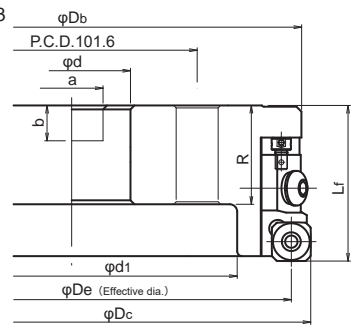


Fig.3



■ BODY

Cat. No.	Stock	No. of Inserts	Dimensions (mm)									Weight(kg)	Fig.	
			φDc	φDe (Eff. Dia)	φDb	Lf	φd	φd1	φd2	a	b			R
FJM-4080R-27	<input type="checkbox"/>	2 Finishing & 2 Semi-finishing inserts	80	65	71	63	27	20	14.3	12.4	7	22	1.7	1
FJM-4100R-32	<input type="checkbox"/>		100	85	90	63	32	26	17	14.4	8	32	2.7	1
FJM-4125R-40	<input type="checkbox"/>		125	110	114	63	40	60	-	16.4	9	40	3.9	2
FJM-4160R-40	<input type="checkbox"/>		160	145	148	63	40	75	-	16.4	9	40	6.1	2
FJM-4200R-60	<input type="checkbox"/>		200	185	186	63	60	134	-	25.7	14	40	8.6	3
FJM-4250R-60	<input type="checkbox"/>		250	235	237	63	60	182	-	25.7	14	40	14.8	3

Note ) All cutters are supplied without inserts or wrenches.

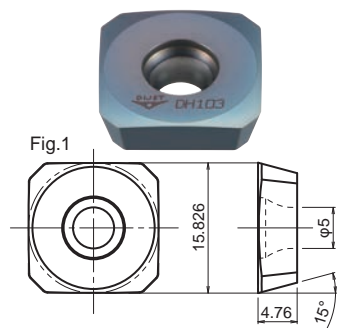
Recommended cutting conditions page 3

## Finish Jet Mill

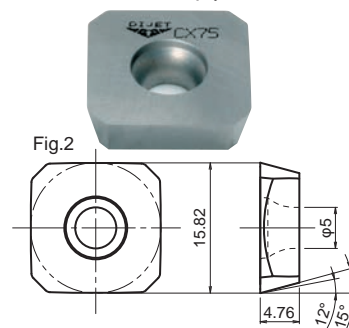
FJM type

## ■ INSERTS

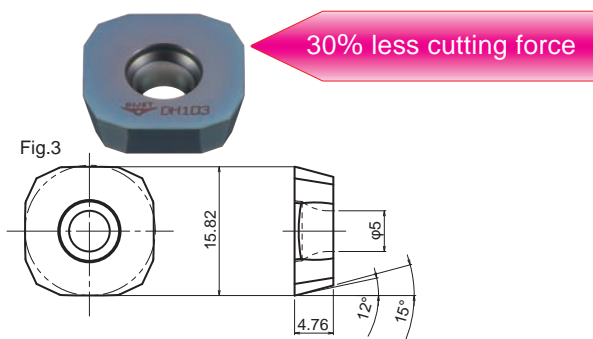
SDHW1504ADFN-W1



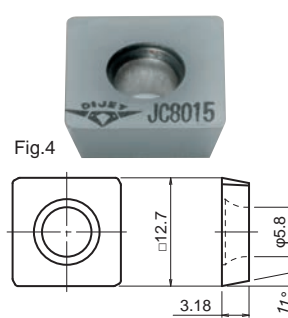
SDHW1504ADE (F) N-W2



SDHW1504ADEN-F1





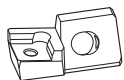
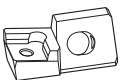


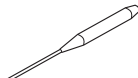


SPHW1203ZPTR



Cat. No.	PVD coated		Cermet	Tolerance	Fig.	Application
	DH103	JC8015	CX75			
SDHW1504ADFN-W1 (finishing insert)	●			H	1	Cast iron, Cast steel
SDHW1504ADFN-W2 (finishing insert)			●	H	2	Carbon steel, Alloy steel
SDHW1504ADEN-W2 (finishing insert)	□			H	2	Mold steel, Die steel
SDHW1504ADEN-F1 (finishing insert for low rigid work)	□		□	H	3	DH103...Cast iron, Cast steel CX75...Carbon steel, Alloy steel
SPHW1203ZPTR (Semi-finishing insert)		□		H	4	

Note) 4 inserts per case, but in case of "SPHW1203ZPTR": 10 pcs per case.

## ■ PARTS (FJM type)

Clamp screw	Wrench	Cartridge for finishing insert	Cartridge for semi-finishing insert	Set bolt for cartridge
 Recommended torque 6.0N·m				
DSW-4510H	A-20 (φ80~φ200) A-20L (φ250)	SSFDR15-15F	SSFPR15-12R	BBH-825
Wrench for cartridge	Wrench for axial adjust screw	Axial adjust screw	Spring washer	
				
LW-050	AD-2080	ADS-513	SBZ-8	

● : Standard stock items □ : Stock in Japan ○ : Soon to be deleted

## Finish Jet Mill

FJM type

## ■ RECOMMENDED CUTTING CONDITIONS

	Work Materials	Inserts	Insert Grades	Vc (m/min)	f (mm/rev)	ap (mm)	ae (mm)
P	Low carbon & Mild steel S20C, SS400 ≤255HB	SDHW1504ADFN-W2 (SDHW1504ADEN-F1)	CX75	250~300	4~5	≤0.3mm	≤0.8De
	Medium carbon S50C ≤255HB	SDHW1504ADFN-W2 (SDHW1504ADEN-F1)	CX75	200~250	4~5	≤0.3mm	≤0.8De
	Alloy & Die steel SCM440, SKD11 ≤255HB	SDHW1504ADFN-W2 (SDHW1504ADEN-F1)	CX75	100~150	4~5	≤0.3mm	≤0.8De
M	Stainless steel SUS304, 316 ≤250HB	SDHW1504ADEN-W2 (SDHW1504ADEN-F1)	DH103	80~120	2~4	≤0.2mm	≤0.8De
K	Gray cast iron FC250, FC300 ≤300HB	SDHW1504ADFN-W1 (SDHW1504ADEN-F1)	DH103	130~200	4~6	≤0.3mm	≤0.8De
	Nodular cast iron FCD500, FCD700 ≤300HB	SDHW1504ADFN-W1 (SDHW1504ADEN-F1)	DH103	110~180	4~6	≤0.3mm	≤0.8De
H	Mold steel HPM7, PX5, NAK80, P20 30 - 40HRC	SDHW1504ADEN-W2 (SDHW1504ADEN-F1)	DH103	100~140	2~4	≤0.2mm	≤0.8De
	Hardened die steel SKD61, DAC, DHA 40 - 50HRC	SDHW1504ADEN-W2 (SDHW1504ADEN-F1)	DH103	40~60	0.3~0.7	≤0.1mm	≤0.7De

Vc : Cutting speed, f : Feedrate, ap : Depth of cut, ae : Width of cut

Note) 1. In Case of stainless steel, recommended wet cutting.

2. Recommend to use-F1 type insert for low rigid work.