

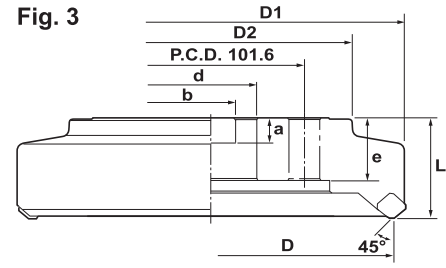
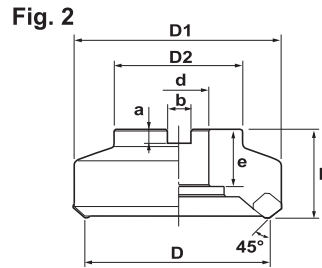
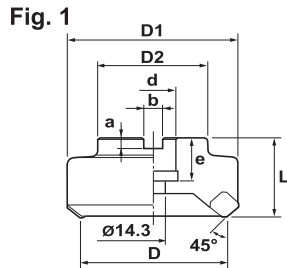
Feathermill - Tough

METRIC

FACE MILL HSG45-5000 Type

- High positive cutter with fixed insert pocket offers heavy duty cutting with stability.
- High axial rake angle and wide chip pocket create excellent chip ejection.

Entering Angle : 45°	A.R. : +30°
	R.R. : -2°
Max. D.O.C.	5mm

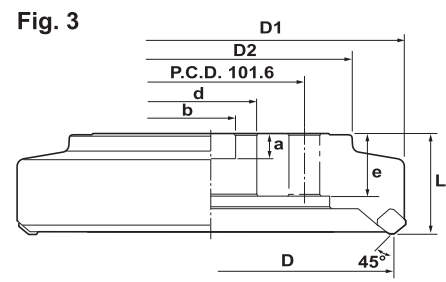
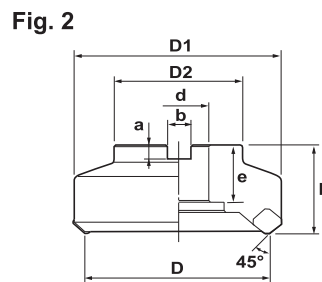
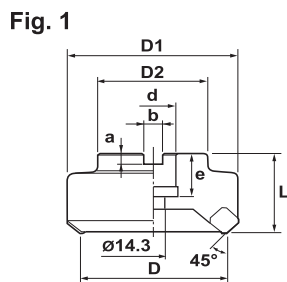


Specifications

CATALOG NUMBER	STK	DIMENSIONS								FIG.	INSERT	Q	PARTS		
		D	D1	L	d	D2	a	b	e				Screw	Wrench	Wedge
HSG45-5080R	•	80	93	44	25.4	60	6	9.5	24	1	SGHN1504AZN-44 SGHN1504AZR-F1 SGLN1504AZN-44 SGLN1504AZR5	4	LS-180	T-27	80808-5
HSG45-5100R	•	100	113	50	31.75	70	8	12.7	32	2		5			
HSG45-5125R	•	125	138	54	38.1	80	10	15.9	36	2		6			
HSG45-5160R	•	160	173	56	50.8	100	11	19	37	2		8			
HSG45-5200R	•	200	213	56	47.625	154	14.3	25.4	34.5	3		10			
HSG45-5250R	•	250	263	56	47.625	154	14.3	25.4	34.5	3		12			

Note: All cutters are supplied without inserts.

FACE MILL HSG45-5000RS Type (with Shim)



Specifications

CATALOG NUMBER	STK	DIMENSIONS								FIG.	INSERT	Q	PARTS		
		D	D1	L	d	D2	a	b	e				Wrench	Screw (Wedge) (Shim)	Wedge/ Shim
HSG45-5080RS	•	80	93	44	25.4	60	6	9.5	24	1	SGHN1504AZN-44 SGHN1504AZR-F1 SGLN1504AZN-44	4	T-27	LS-180 LS-140	DX-80808 ST451R
HSG45-5100RS	•	100	113	50	31.75	70	8	12.7	32	2		5			
HSG45-5125RS	•	125	138	54	38.1	80	10	15.9	36	2		6			
HSG45-5160RS	•	160	173	56	50.8	100	11	19	37	2		8			
HSG45-5200RS	•	200	213	56	47.625	154	14.3	25.4	34.5	3		10			
HSG45-5250RS	•	250	263	56	47.625	154	14.3	25.4	34.5	3		12			

Note: All cutters are supplied without inserts.



METRIC

Feathermill - Tough

FACE MILL HSG45-5000RS-F Type

- High positive cutter with fixed insert pocket and shim offers heavy duty cutting with stability.
- High axial rake angle and wide chip pocket create excellent chip ejection.

Entering Angle : 45°	A.R. : +30°
	R.R. : -2°
Max. D.O.C.	5mm

Other Face Mills



Fig. 1

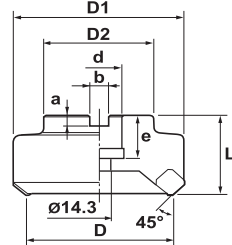


Fig. 2

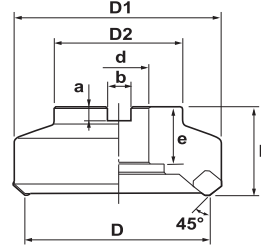
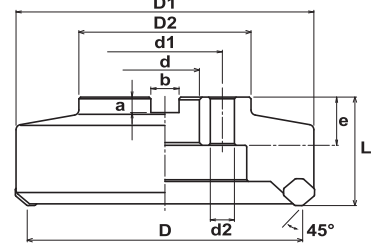


Fig. 3



Specifications

CATALOG NUMBER	STK	DIMENSIONS										FIG.	INSERT	Q	PARTS		
		D	D1	L	d	D2	d1	d2	a	b	e				Wrench	Screw (Wedge) (Shim)	Wedge/Shim
HSG45-5080-27RS-F	•	80	93	50	27	60	-	-	7	12.4	22	1	SGHN1504AZN-44 SGHN1504AZR-F1 SGLN1504AZN-44 SGLN1504AZR5	4	T-27	LS-180 LS-140	DX-80808 ST451R
HSG45-5100-32RS-F	•	100	113	50	32	70	-	-	8	14.4	32	2		5			DX-80808 ST452R
HSG45-5125-32RS-F	•	125	138	63	40	85	-	-	9	16.4	35	2		6			DX-80808 ST452R
HSG45-5160-40RS-F	•	160	173	63	40	100	66.7	14	9	16.4	28	3		8			DX-80808 ST452R
HSG45-5200-60RS-F	•	200	213	63	60	154	101.6	18	14	25.7	32	3		10			DX-80808 ST451R
HSG45-5250-60RS-F	•	250	263	63	60	154	101.6	18	14	25.7	32	3		12			DX-80808 ST451R

Note: All cutters are supplied without inserts.

INSERTS

Fig. 1

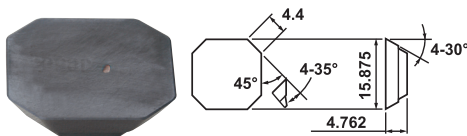


Fig. 2

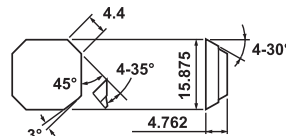


Fig. 3

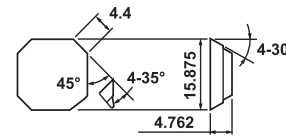
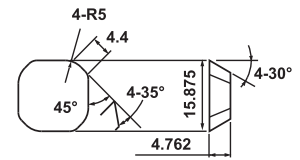


Fig. 4



Specifications - Metric

CATALOG NUMBER	DIMENSIONS			FIG.	COATED				CERMET	UNCOATED
	IC	T	IC TOLERANCE		JC5030	JC610	JC5040	JC730U	CX90	KT9
SGHN1504AZN-44	15.875	4.762	H	1	•	•	•	•	•	•
SGHN1504AZR-F1	15.875	4.762	H	2	•	•			•	
SGLN1504AZN-44	15.875	4.762	L	3	•					
SGLN1504AZR5	15.875	4.762	L	4			•			

Recommended Cutting Data

WORK MATERIALS	INSERT GRADE	Vc (m/min)	fz (mm/tooth)
Carbon Steel & Alloy Steel (180-280HB)	JC5030, JC5040, JC730U, CX90	180 - 300	0.2 - 0.5
Stainless Steel (~270HB)	JC5040, JC730U, CX90	120 - 220	0.2 - 0.3
Cast Iron (200-250HB)	JC610	150 - 250	0.2 - 0.4
Aluminum Alloy	KT9	300 - 800	0.2 - 0.5