



METRIC

Finish Jet Mill

FACE MILL

FJM Type

- For super finishing, using a combination of 2 finishing inserts & 2 roughing inserts, giving a stable finishing quality
- Higher feed speed can be achieved by using 4 effective finishing cartridges with a_p of $<0.1\text{mm}$



Fig.1

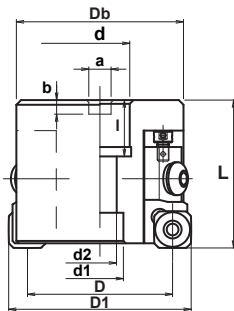


Fig.2

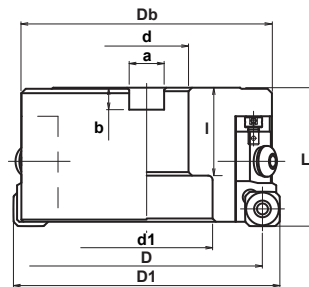
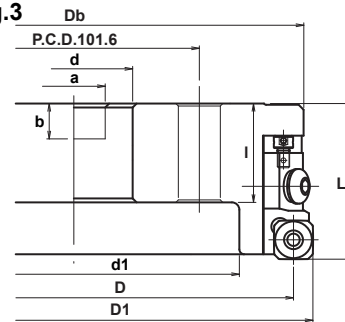


Fig.3



Specifications

CATALOG NUMBER	STK	DIMENSIONS										FIG.	PARTS			
		D1	D	Db	L	d	d1	d2	a	b	l		Insert Cartridge	Insert Screw	Cartridge Parts: Bolt Bolt Ring Adjustable Rest Button	Wrenches
FJM-4080R	•	80	65	71	63	25.4	20	14.3	9.5	6	24	1	SDHW1504ADFN-* (2) SSFDR15-15F (2) SPHW1203ZPTR (2) SSFPR15-12R (2) DSW-4510H	BBH-825 SBZ-8 ADS-513	A-20 (80-200Ø) A-20L (250Ø) LW-050 AD-2080	
FJM-4080R-27	•	80	65	71	63	27	20	14.3	12.4	7	22	1				
FJM-4100R	•	100	85	90	63	31.75	26	17	12.7	8	32	1				
FJM-4100R-32	•	100	85	90	63	32	26	17	14.4	8	32	1				
FJM-4125R	•	125	110	114	63	38.1	60	-	15.9	10	40	2				
FJM-4125R-40	•	125	110	114	63	40	60	-	16.4	9	40	2				
FJM-4160R	•	160	145	148	63	50.8	75	-	19	11	40	2				
FJM-4160R-40	•	160	145	148	63	40	75	-	16.4	9	40	2				
FJM-4200R	•	200	185	186	63	47.625	134	-	25.4	14.3	40	3				
FJM-4200R-60	•	200	185	186	63	60	134	-	25.7	14	40	3				
FJM-4250R	•	250	235	237	63	47.625	182	-	25.4	14.3	40	3				
FJM-4250R-60	•	250	235	237	63	60	182	-	25.7	14	40	3				

Note: All cutters are supplied without inserts.

INSERT

Fig. 1

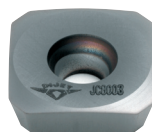
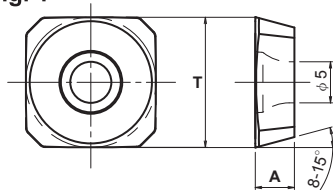


Fig. 2

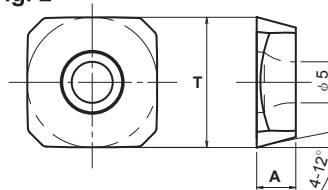
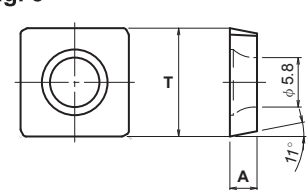


Fig. 3



Specifications



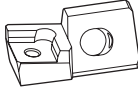
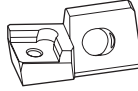
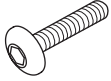
CATALOG NUMBER	DIMENSIONS		IC TOLERANCE	FIG.	COATED		UNCOATED
	A	T			JC8003	JC8015	CX75
SDHW1504ADFN-W1	15.826	4.76	H	1	•		
SDHW1504ADFN-W2	15.82	4.76	H	2			•
SPHW1203ZPTR	12.7	3.18	H	3		•	


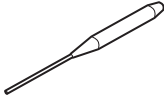

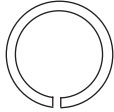
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Parts

INSERT SCREW	INSERT WRENCH	FINISHING CARTRIDGE	ROUGHING CARTRIDGE	CARTRIDGE BOLT
				
DSW-4510H	A-20 (Ø80 ~ Ø00) A-20L (Ø250)	SSFDR15-15F	SSFPR15-12R	BBH-825

CARTRIDGE BOLT WRENCH	ADJUSTABLE REST BUTTON WRENCH	ADJUSTABLE REST BUTTON	BOLT RING
			
LW-050	AD-2080	ADS-513	SBZ-8

Recommended Cutting Data (when using 2 finishing & 2 roughing cartridges)

	WORK MATERIALS	HB	INSERT GRADE		Vc (m/min)	f (mm/rev)	MAX ap (mm)
			FINISH	ROUGH			
P	Low Carbon Steel (S20C, SS400)	180 ~ 280	CX75	JC8015	250 ~ 300	4 ~ 5	0.3mm
	Medium Carbon Steel (S50C)	180 ~ 280	CX75	JC8015	200 ~ 250	4 ~ 5	0.3mm
	Alloy Steel, Tool & Die Steel (SCM440, SKD11)	180 ~ 280	CX75	JC8015	100 ~ 150	4 ~ 5	0.3mm
M	Stainless Steel (SUS304, 316)	~ 270	JC8003	JC8015	200 ~ 250	4 ~ 5	0.3mm
K	Gray Cast Iron (FC250)	200 ~ 250	JC8003	JC8015	130 ~ 200	4 ~ 6	0.3mm
	Nodular Cast Iron (FCD450)	180 ~ 250	JC8003	JC8015	130 ~ 200	4 ~ 6	0.3mm

Recommended Cutting Data (when using 4 finishing cartridges)

	WORK MATERIALS	HB	INSERT GRADE	Vc (m/min)	f (mm/rev)	MAX ap (mm)
P	Low Carbon Steel (S20C, SS400)	180 ~ 280	CX75	250 ~ 300	8 ~ 10	0.1mm
	Medium Carbon Steel (S50C)	180 ~ 280	CX75	200 ~ 250	8 ~ 10	0.1mm
	Alloy Steel, Tool & Die Steel (SCM440, SKD11)	180 ~ 280	CX75	100 ~ 150	8 ~ 10	0.1mm
M	Stainless Steel (SUS304, 316)	~ 270	JC8003	200 ~ 250	8 ~ 10	0.1mm
K	Gray Cast Iron (FC250)	200 ~ 250	JC8003	130 ~ 200	8 ~ 12	0.1mm
	Nodular Cast Iron (FCD450)	180 ~ 250	JC8003	130 ~ 200	8 ~ 12	0.1mm