



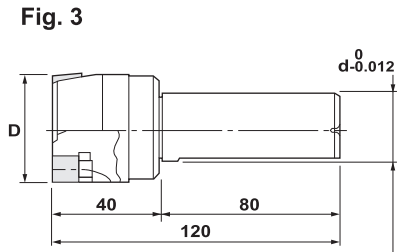
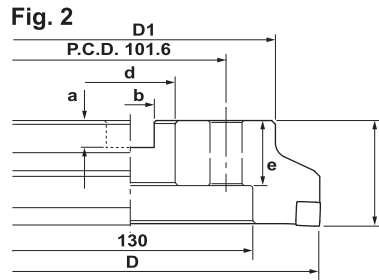
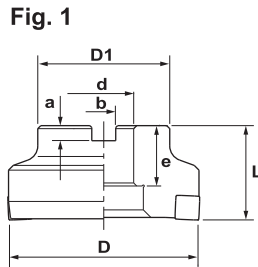
METRIC

High Rake Cutter

FACE MILL HR2L Type

- Positive High-Rake Cutter for milling aluminum & other non-ferrous materials with low cutting resistance.

Entering Angle : 2°25'	A.R. : +10° ~ +15°
	R.R. : +7° ~ +12°
Max. D.O.C.	9mm

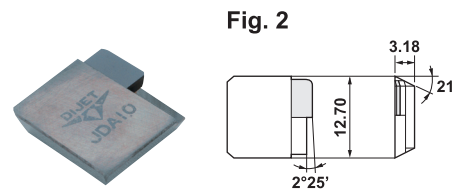
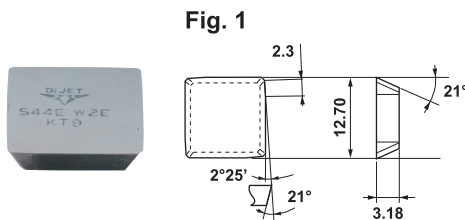


Specifications

CATALOG NUMBER	STK	DIMENSIONS							FIG.	INSERT	Q	PARTS		
		D	D1	L	d	a	b	e				Wrench	Wedge / Screw	Rest Button / Screw
HR2L-4080R-06	•	80	60	44	25.4	6	9.5	24	1	S44E-W2E	6	A-030	60705-1 LS-101	RB-14 LS-113
HR2L-4100R-08	•	100	70	50	31.75	8	12.7	32	1		8			
HR2L-4125R-08	•	125	85	54	38.1	10	15.9	36	1		8			
HR2L-4160R-12	•	160	100	56	50.8	11	19	37	1		12			
HR2L-4200R-16	•	200	154	56	47.625	14.3	25.4	34.5	2		16			
HR2L-4250R-16		250	154	56	47.625	14.3	25.4	34.5	2		16			
HR2L-4300R-16		300	154	56	47.625	14.3	25.4	34.5	2		16			
HR2L-2030S32	•	50	-	-	32	-	-	-	3		3			

Note: All cutters are supplied without inserts.

INSERTS



Specifications - Metric

CATALOG NUMBER	DIMENSIONS		FIG.	UNCOATED	UNCOATED - PCD
	IC	T		KT9	JDA10
S44E-W2E	12.7	3.18	1	•	
JDA-S44E-W2E (Wiper)	12.7	3.18	2		•

Recommended Cutting Data

WORK MATERIALS		INSERT GRADE	Vc (m/min)	fz (mm/tooth)
Pure Aluminum (99% ~)		KT9	500 - 1500	0.10 - 0.30
Aluminum Alloys	Forging	Non-heat treated	KT9	500 - 1500
		Heat treated	KT9	300 - 1000
	Casting	Si<13%	KT9	300 - 800
		Si≥13%	KT9	250 - 600