

AJX

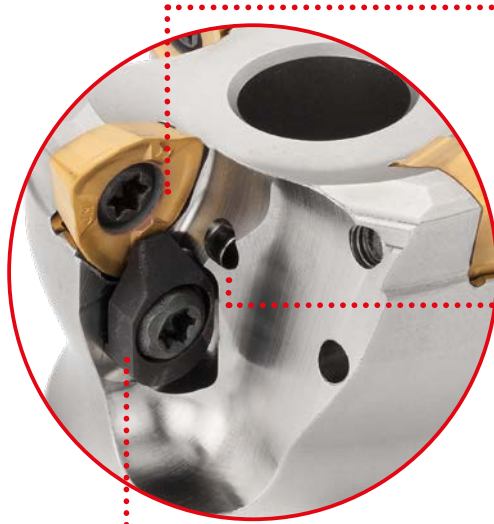
REDUCE COSTS OVER A WIDE RANGE OF APPLICATIONS
WITH ULTRA HIGH FEED MILLING



AJX

HIGH FEED MILLING CUTTER

HARD WEARING CUTTER BODY



COST-EFFECTIVE INSERT

Specially designed triangular style insert geometry for efficient milling.

WITH COOLANT HOLES AS STANDARD

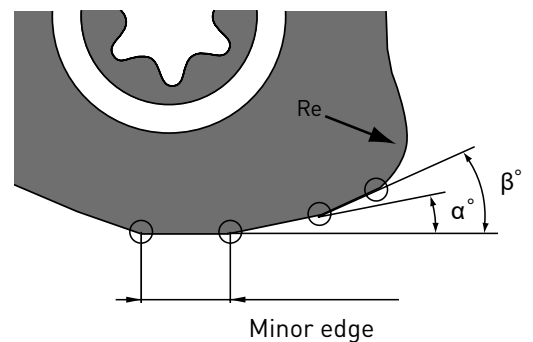
All AJX bodies are supplied with through coolant holes for cutting edge cooling, lubrication and for smooth chip discharge.

HIGH RIGIDITY CLAMPING

Insert clamp bridges are standard (except AJX 06 and 08). Rigid insert clamping enables stable and reliable cutting.

ULTRA HIGH FEED CUTTING

By using a double phased straight cutting edge to form the lead angle α and β with a minor edge, AJX can achieve an ultra high feed rate of up to 1.5 mm/tooth for the ultimate in rough machining efficiency.



MV1000 SERIES

COATED CARBIDE GRADE FOR MILLING

ADVANCED WEAR RESISTANCE

By adopting the newly developed Al-Rich coating technology, the (Al,Ti)N with a high Al content ratio displays very high hardness. This greatly improves oxidation and wear resistance.

ADVANCED THERMAL SHOCK RESISTANCE

The extreme heat resistance of this new series achieves amazing stability, not only during dry cutting, but also when wet cutting where inserts are usually prone to thermal cracking.



Graphical representation

EXCELLENT WELDING RESISTANCE

Smooth surface.

OUTSTANDING WEAR RESISTANCE

Newly developed Al-Rich coating.

EXCELLENT CHIPPING RESISTANCE FOR STABLE MACHINING

Newly developed bonding layer.

FRACTURE RESISTANCE FOR THE ULTIMATE STABILITY

Exclusive cemented carbide substrate.

MV1020

This grade has advanced wear and thermal shock resistance and also achieves stable cutting at unprecedented cutting speeds, especially when machining steel and ductile cast iron, thus greatly reducing work time.

MV1030

The new Al-Rich coating also provides excellent wear resistance. An unprecedented performance against sudden breakage was also realised especially during problematic wet cutting and when machining stainless steels.



Material	ISO	CVD
P Steel	P10	MV1020
	P20	
	P30	
	P40	
		MV1030

Material	ISO	CVD
M Stainless steel	M10	MV1030
	M20	
	M30	
	M40	

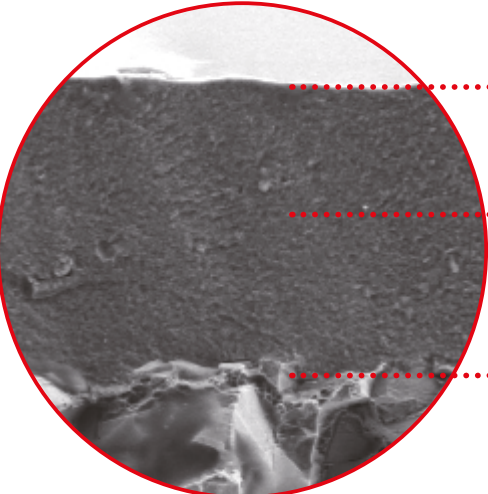
Material	ISO	CVD
K Cast iron	K10	MV1020
	K20	
	K30	
	K40	
		MV1030

1. Dry cutting is recommended for machining stainless steel with MV1030.

MP9140

PVD COATED GRADE FOR DIFFICULT-TO-CUT-MATERIALS

FEATURES OF THE COATING SURFACE



- The smooth coating surface provides excellent welding resistance.
- The high Al-rich ALTiN coating succeeds in dramatically improving wear and heat resistance.
- Special cemented carbide substrate with improved fracture resistance.



JL CHIPBREAKER

Grade	Features
MP9140	Focus on fracture resistance
MP9130	Standard grade
MP9120	Focus on wear resistance

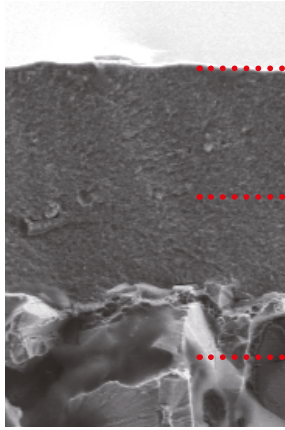
APPLICATION RANGE

P	PVD	M	CVD	PVD	K	CVD	PVD	S	PVD	H	PVD
P10		M10			K10			S10		H10	
P20	MP6120	M20	MC7020	MP7130	K20	FH7020	VP15TF	S20	MP9120	H20	VP15TF
P30	VP15TF	M30		VP15TF	K30			S30	VP15TF	H30	
P40	MP6130	M40		MP7140	K40			S40	MP9130	H40	
P50	VP30RT	M50		VP30RT	K50			S50	MP9140	H50	

INSERT GRADES FOR A WIDE RANGE OF MATERIALS

MP9140

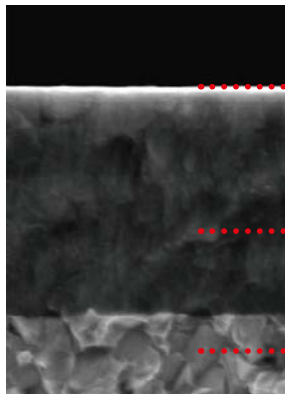
PVD coated grade for difficult-to-cut-materials.



- The smooth coating surface provides excellent welding resistance.
- The high Al-rich AlTiN coating succeeds in dramatically improving wear and heat resistance.
- Special cemented carbide substrate with improved fracture resistance.

MP6100/MP7100

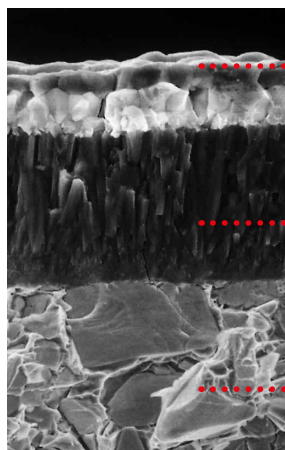
PVD coatings have properties such as toughness, low coefficient of friction and excellent welding, wear and heat resistance.



- Excellent welding resistance due to a low coefficient of friction.
- PVD accumulated coating.
- Special cemented carbide substrate.

FH7020

CVD coated grade for long tool life and high resistance to thermal cracking.

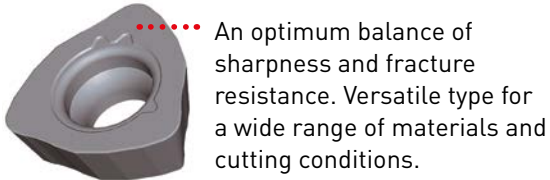


- Vapor deposited by the newly developed even coating technology, the surface texture of the special titanium compound layers is very smooth and chemically stable. It enables a reliable cutting performance without chipping.
- Flat alumina (fine grained aluminium oxide with a smooth surface) is used as the outer layer. It has superior strength at high temperatures and prevents crater wear usually associated with high speed cutting.
- The newly developed cemented carbide base metal has improved resistance to heat-cracking and fracturing.

CHIPBREAKER RECOMMENDATION

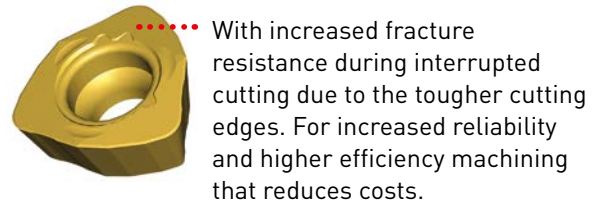
GENERAL USE TYPE

First recommended chipbreaker for general cutting.



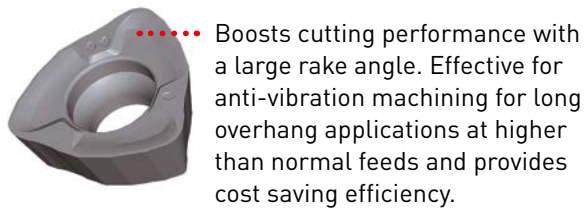
STRONG CUTTING EDGE TYPE

Stability even when machining interrupted workpiece surfaces.



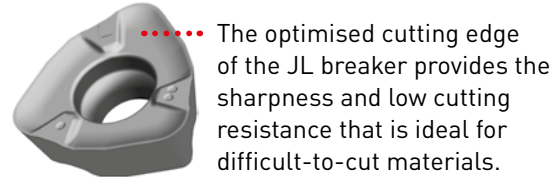
SHARP CUTTING EDGE TYPE

Suitable for use on BT40 and HSK63 machines.



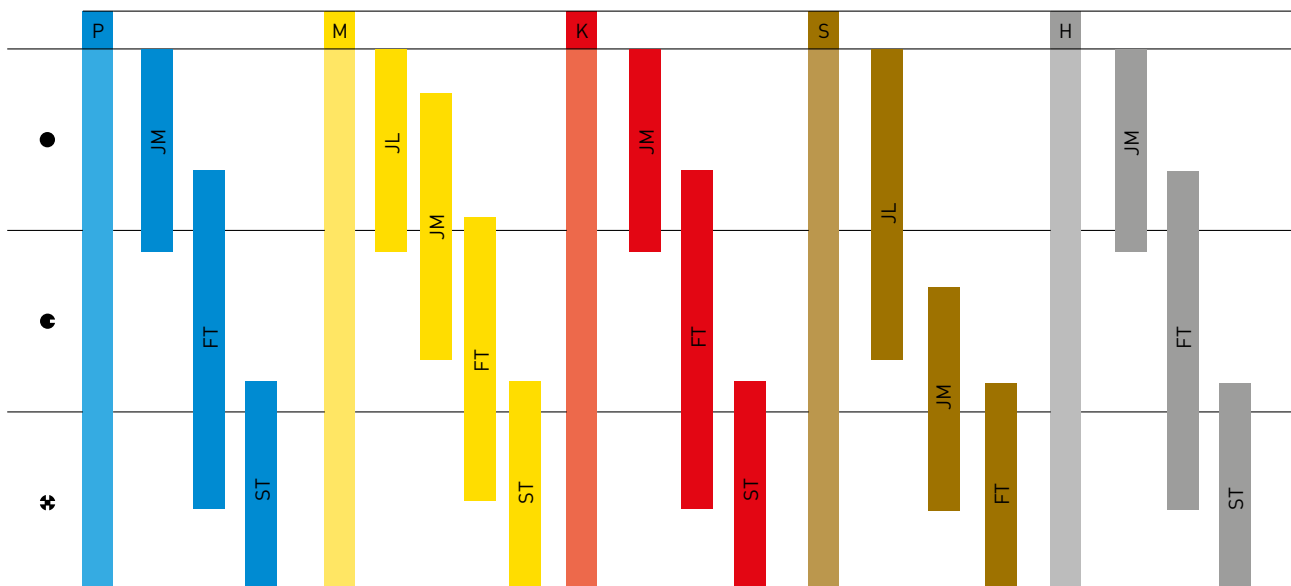
SHARP CUTTING EDGE TYPE

Optimised for difficult-to-cut materials.



APPLICATION OF CHIPBREAKERS

Cutting conditions: ●: Stable cutting ●: General cutting ✖: Unstable cutting



AJX



MULTI FUNCTIONAL MILLING

P M K S H



AJX09

GAMP : +8°
GAMF : -6°

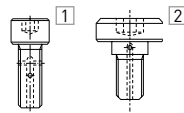
AJX12

GAMP : +8°
GAMF : -5° - -6°

AJX14

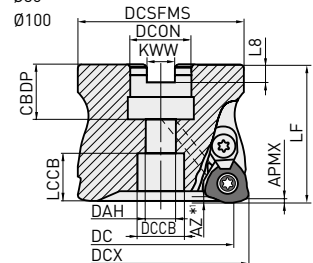
GAMP : +8°
GAMF : -3°

DCX	Set bolt	Geometry
Ø 63 [22]	HSC10030H	1
Ø 63 [27], Ø66, Ø80	HSC12035H	
Ø 100	HSC16040H	
Ø 125, Ø160	MBA20040H	2



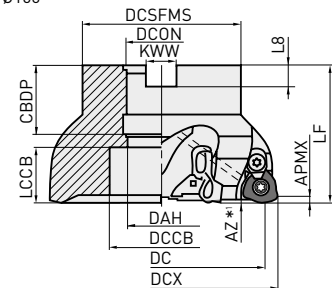
1

Ø50 Ø66
Ø52 Ø80
Ø63 Ø100



2

Ø125
Ø160



Right hand tool holder only.

ARBOR TYPE

Order number	Stock	APMX	DC	DCON	DCX	LF	RMPX	AZ	WT	ZEFP	Type	
AJX12-050A03R	●	2	38.3	22	50	50	2°	1.5	0.4	3	1	JDM1204
AJX12-050A04R	●	2	38.3	22	50	50	2°	1.5	0.4	4	1	
AJX09-050A05R	●	2	40.0	22	50	50	1.1°	1	0.5	5	1	JDM09T3
AJX12-052A03R	★	2	40.3	22	52	50	2.1°	1.5	0.4	3	1	JDM1204
AJX12-052A04R	●	2	40.3	22	52	50	2.1°	1.5	0.4	4	1	
AJX09-052A05R	●	2	42	22	52	50	1°	1	0.4	5	1	JDM09T3
AJX14-063A03R	★	2	51.1	22	63	50	2.8°	2	0.7	3	1	JDM1405
AJX14-063X03R	●	2	51.1	27	63	50	2.8	2	0.6	3	1	
AJX14-063A04R	●	2	51.1	22	63	50	2.8°	2	0.7	4	1	
AJX14-063X04R	●	2	51.1	27	63	50	2.8	2	0.6	4	1	JDM1204
AJX12-063A05R	●	2	51.3	22	63	50	1.5°	1.5	0.7	5	1	
AJX12-063X05R	●	2	51.3	27	63	50	1.5	1.5	0.6	5	1	JDM1405
AJX14-066A03R	★	2	54.1	22	66	50	2.3°	2	0.7	3	1	
AJX14-066X03R	●	2	54.1	27	66	50	2.6	2	0.6	3	1	
AJX14-066A04R	●	2	54.1	22	66	50	2.3°	2	0.7	4	1	
AJX14-066X04R	●	2	54.1	27	66	50	2.6	2	0.6	4	1	JDM1204
AJX12-066A05R	●	2	54.3	22	66	50	1.4°	1.5	0.8	5	1	
AJX12-066X05R	●	2	54.3	27	66	50	1.4	1.5	0.7	5	1	JDM1405
AJX14-080A04R	★	2	68.1	27	80	50	1.8°	2	1.2	4	1	
AJX14-080A05R	●	2	68.1	27	80	50	1.8°	2	1.2	5	1	JDM1204
AJX12-080A06R	●	2	68.3	27	80	50	1.1°	1.5	1.2	6	1	

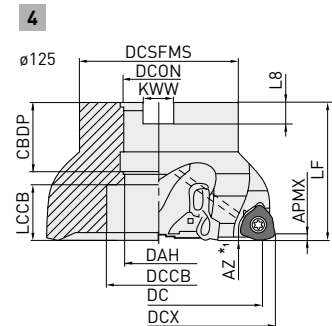
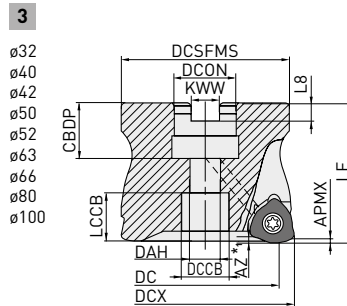
AJX – ARBOR TYPE

Order number	Stock	APMX	DC	DCON	DCX	LF	RMPX	AZ	WT	ZEFP	Type	
AJX14-100A05R	●	2	88.1	32	100	63	1.2°	2	2.4	5	1	JDM○1405
AJX14-100A06R	●	2	88.1	32	100	63	1.2°	2	2.4	6	1	
AJX12-100A07R	●	2	88.3	32	100	63	0.8°	1.5	2.6	7	1	JDM○1204
AJX14-125B05R	★	2	113.2	40	125	63	0.8°	2	3.3	5	2	JDM○1405
AJX14-125B07R	●	2	113.2	40	125	63	0.8°	2	3.3	7	2	
AJX14-160B06R	★	2	148.2	40	160	63	0.5°	2	5	6	2	
AJX14-160B08R	★	2	148.2	40	160	63	0.5°	2	5	8	2	

1. Please refer to page 19, for maximum depth of cut (APMX) and maximum plunging depth (AZ).

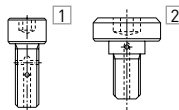


ARBOR TYPE – ULTRA FINE PITCH



Right hand tool holder only.

DCX	Set bolt	Geometry
Ø32, Ø40, Ø42	HSC08025H	1
Ø50, Ø52, Ø63 Ø66 (DCON=22)	HSC10030H	
Ø63 Ø66 (DCON=27), Ø80	HSC12035H	
Ø 100	HSC16040H	
Ø 125, Ø160	MBA20040H	2



Order number	Stock	APMX	DC	DCON	DCX	LF	RMPX	AZ	WT	ZEFP	Type	
AJX06-032A05R	●	1	24.9	16	32	40	0.5°	0.3	0.1	5	3	JOM○06T2
AJX06-032A06R	●	1	24.9	16	32	40	0.5°	0.3	0.1	6	3	JOM○06T2
AJX08-040A06R	●	1.5	31.4	16	40	40	1°	0.5	0.2	6	3	JOM○0803
AJX08-042A06R	●	1.5	33.4	16	42	40	0.9°	0.5	0.2	6	3	JOM○0803
AJX09-050A06R	●	2	39.3	22	50	50	1.1°	1	0.4	6	3	JDM○09T3
AJX08-050A07R	●	1.5	41.4	22	50	50	0.7°	0.5	0.4	7	3	JOM○0803
AJX09-052A06R	●	2	41.9	22	52	50	1°	1	0.4	6	3	JDM○09T3
AJX08-052A07R	●	1.5	43.4	22	52	50	0.7°	0.5	0.5	7	3	JOM○0803
AJX12-063A06R	●	2	51.3	22	63	50	1.5°	1.5	0.7	6	3	JDM○1204
AJX09-063A07R	●	2	52.9	22	63	50	0.8°	1	0.7	7	3	JDM○09T3
AJX12-063X06R	●	2	51.3	27	63	50	1.5°	1.5	0.6	6	3	JDM○1204
AJX09-063X07R	●	2	52.9	27	63	50	0.8°	1	0.7	7	3	JDM○09T3
AJX12-066A06R	●	2	54.3	22	66	50	1.4°	1.5	0.7	6	3	JDM○1204
AJX09-066A07R	●	2	55.9	22	66	50	0.8°	1	0.8	7	3	JDM○09T3
AJX12-066X06R	●	2	54.3	27	66	50	1.4°	1.5	0.7	6	3	JDM○1204
AJX09-066X07R	●	2	55.9	27	66	50	0.8°	1	0.8	7	3	JDM○09T3
AJX12-080A08R	●	2	68.3	27	80	50	1.1°	1.5	1.1	8	3	JDM○1204
AJX12-100A09R	●	2	88.3	32	100	63	0.8°	1.5	2.5	9	3	JDM○1204
AJX14-125B09R	●	2	113.2	40	125	63	0.8°	2	3.0	9	4	JDM○1405

AJX – ARBOR TYPE

MOUNTING DIMENSIONS

Order number	CBDP	DAH	DCCB	DCON	DCSFMS	DCX	KWW	LCCB	L8	Type
AJX12-050A03R	20	11	17	22	47	50	10.4	17.28	6.3	1
AJX12-050A04R	20	11	17	22	47	50	10.4	17.28	6.3	1
AJX09-050A05R	20	11	17	22	47	50	10.4	17.31	6.3	1
AJX12-052A03R	20	11	17	22	47	52	10.4	17.28	6.3	1
AJX12-052A04R	20	11	17	22	47	52	10.4	17.28	6.3	1
AJX09-052A05R	20	11	17	22	47	52	10.4	17.31	6.3	1
AJX14-063A03R	20	11	17	22	60	63	10.4	17.16	6.3	1
AJX14-063A04R	20	11	17	22	60	63	10.4	17.16	6.3	1
AJX12-063A05R	20	11	17	22	60	63	10.4	17.28	6.3	1
AJX14-066A03R	20	11	17	22	60	66	10.4	17.16	6.3	1
AJX14-066A04R	20	11	17	22	60	66	10.4	17.16	6.3	1
AJX12-066A05R	20	11	17	22	60	66	10.4	17.28	6.3	1
AJX09-063X	23	13	20	27	60	63	12.4	16.3	7.0	3
AJX12-063X	23	13	20	27	60	63	12.4	16.3	7.0	3
AJX14-063X	23	13	20	27	60	63	12.4	16.3	7.0	1
AJX09-066X	23	13	20	27	60	66	12.4	16.3	7.0	3
AJX12-066X	23	13	20	27	60	66	12.4	16.3	7.0	1, 3
AJX14-066X	23	13	20	27	60	66	12.4	16.2	7.0	1
AJX14-080A04R	23	13	19	27	76	80	12.4	16.16	7	1
AJX14-080A05R	23	13	19	27	76	80	12.4	16.16	7	1
AJX12-080A06R	23	13	19	27	76	80	12.4	16.28	7	1
AJX14-100A05R	26	17	26	32	96	100	14.4	26.16	8	1
AJX14-100A06R	26	17	26	32	96	100	14.4	26.16	8	1
AJX12-100A07R	26	17	26	32	96	100	14.4	26.28	8	1
AJX14-125B05R	40	—	56	40	100	125	16.4	22.14	9	2
AJX14-125B07R	40	—	56	40	100	125	16.4	22.14	9	2
AJX14-160B06R	40	—	56	40	100	160	16.4	22.14	9	2
AJX14-160B08R	40	—	56	40	100	160	16.4	22.14	9	2

SPARE PARTS

Tool holder					
	Clamp screw	Clamp bridge	Clamp bridge screw	Spring	Wrench
AJX09	TS351	AMS3	AJS3010T10	ASS2	TKY10D
AJX12	TS43	AMS4	AJS4012T15	ASS2	TKY15T
AJX14	TS54	AMS5	AJS5014T25	ASS3	TKY25T

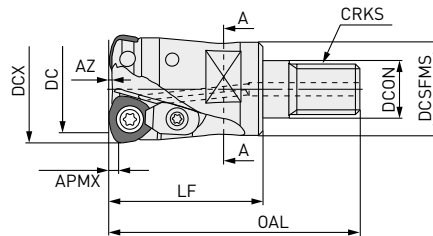
1. Clamp torque (N • m) : **TS351=2.5. TS43=3.5. TS54=7.5. AJS3010T10=2.5. AJS4012T15=3.5. AJS5014T25=7.5**

AJX



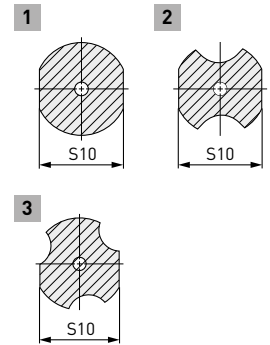
MULTI FUNCTIONAL MILLING

P M K S H



Right hand tool holder only.

A-A



SCREW-IN-TYPE

Order number	Stock	APMX	DC	DCON	DCX	LF	OAL	RMPX	AZ	WT	ZEFP	Type	
AJX06R162AM08	●	1	8.9	8.5	16	25	43	3°	0.3	0.1	2	2	JOM06 T2ZZoR -o
AJX06R172AM08	●	1	9.9	8.5	17	25	43	2.5°	0.3	0.1	2	2	
AJX06R203AM10	●	1	12.9	10.5	20	28	47	1.5°	0.3	0.1	3	3	
AJX06R223AM10	●	1	14.9	10.5	22	28	47	1°	0.3	0.1	3	3	
AJX06R254AM1235	●	1	17.9	12.5	25	35	57	0.8°	0.3	0.1	4	1	JOM06T2
AJX06R284AM1235	●	1	20.9	12.5	28	35	57	0.7°	0.3	0.1	4	1	JOM06T2
AJX08R202AM10	●	1.5	11.4	10.5	20	28	47	3.5°	0.5	0.1	2	2	JOM080 3ZZoR -o
AJX08R222AM10	●	1.5	13.4	10.5	22	28	47	3°	0.5	0.1	2	2	
AJX08R253AM12	●	1.5	16.4	12.5	25	36	58	2°	0.5	0.1	3	1	
AJX08R283AM12	●	1.5	19.4	12.5	28	36	58	1.7°	0.5	0.1	3	1	
AJX08R324AM1645	●	1.5	23.4	17.0	32	45	68	1.4°	0.5	0.2	4	1	JOM0803
AJX08R354AM1645	●	1.5	26.4	17.0	35	45	68	1.2°	0.5	0.2	4	1	JOM0803
AJX08R406AM1645	●	1.5	31.4	17.0	40	45	68	1°	0.5	0.3	6	1	JOM0803
AJX09R252AM12	●	2	14.9	12.5	25	36	58	4°	1	0.2	2	2	JDM09T 3ZDOR -o
AJX09R282AM12	●	2	17.9	12.5	28	36	58	3°	1	0.2	2	2	
AJX09R303AM16	●	2	20.0	17	30	47	70	2.7°	1	0.2	3	1	
AJX09R323AM16	●	2	21.9	17	32	47	70	2.5°	1	0.2	3	1	
AJX09R353AM16	●	2	24.9	17	35	47	70	2°	1	0.2	3	1	JDM 1204 ZDOR -o
AJX09R404AM16	●	2	29.9	17	40	60	83	1.5°	1	0.2	4	1	
AJX12R302AM16	●	2	18.3	17	30	47	70	4.5°	1.5	0.3	2	2	
AJX12R322AM16	●	2	20.3	17	32	47	70	4°	1.5	0.3	2	2	
AJX12R352AM16	●	2	23.3	17	35	47	70	3.5°	1.5	0.3	2	2	JDM 1204 ZDOR -o
AJX12R403AM16	●	2	28.3	17	40	60	83	3°	1.5	0.3	3	2	

AJX – SCREW-IN-TYPE

MOUNTING DIMENSIONS

Order number	CRKS	S10	DCON	DCSFMS	DCX	Type
AJX06R162AM08	M8	10	8.5	13	16	2
AJX06R172AM08	M8	10	8.5	13	17	2
AJX06R203AM10	M10	15	10.5	18	20	3
AJX06R223AM10	M10	15	10.5	18	22	3
AJX06R254AM1235	M12	19	12.5	23.5	25	1
AJX06R284AM1235	M12	19	12.5	23.5	28	1
AJX08R202AM10	M10	15	10.5	18	20	2
AJX08R222AM10	M10	15	10.5	18	22	2
AJX08R253AM12	M12	17	12.5	21	25	1
AJX08R283AM12	M12	17	12.5	21	28	1
AJX08R324AM1645	M16	24	17	29	32	1
AJX08R354AM1645	M16	24	17	29	35	1
AJX08R406AM1645	M16	24	17	29	40	1
AJX09R252AM12	M12	17	12.5	21	25	2
AJX09R282AM12	M12	17	12.5	21	28	2
AJX09R303AM16	M16	22	17	29	30	1
AJX09R323AM16	M16	22	17	29	32	1
AJX09R353AM16	M16	22	17	29	35	1
AJX09R404AM16	M16	22	17	29	40	1
AJX12R302AM16	M16	22	17	29	30	2
AJX12R322AM16	M16	22	17	29	32	2
AJX12R352AM16	M16	22	17	29	35	2
AJX12R403AM16	M16	22	17	29	40	2

SPARE PARTS

Tool holder					
	Clamp screw	Clamp bridge	Clamp bridge screw	Spring	Wrench
AJX06	TS25	—	—	—	TKY08F
AJX08	TS33	—	—	—	TKY08D
AJX09	TS351	AMS3	AJS3010T10	ASS2	TKY10D
AJX12R302AM16	TS407	AMS4	AJS4012T15	ASS2	TKY15D
AJX12	TS43	AMS4	AJS4012T15	ASS2	TKY15D

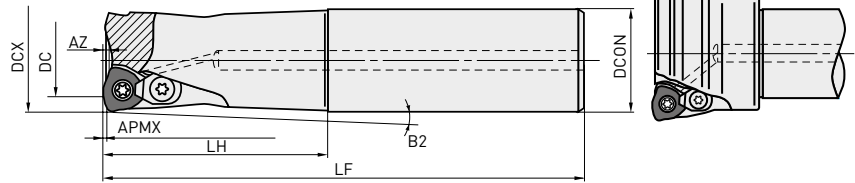
1. Clamp torque (N • m) : TS25=1.0. TS33=1.0. TS351=2.5. TS407=3.5. TS43=3.5. AJS3010T10=2.5. AJS4012T15=3.5

AJX



MULTI FUNCTIONAL MILLING

P M K S H



Right hand tool holder only.

STRAIGHT SHANK TYPE

Order number	Stock	APMX	DC	DCON	DCX	LF	LH	B2	RMPX	AZ	ZEFP	
AJX06R162SA16ES	●	1	8.9	16	16	70	20	3.5°	3°	0.3	2	
AJX06R172SA16ES	●	1	9.9	16	17	70	20	—	2.5°	0.3	2	
AJX06R162SA16S	●	1	8.9	16	16	110	30	2.25°	3°	0.3	2	
AJX06R172SA16S	●	1	9.9	16	17	110	20	—	2.5°	0.3	2	
AJX06R203SA20S	●	1	12.9	20	20	130	50	1.31°	1.5°	0.3	3	
AJX06R223SA20S	●	1	14.9	20	22	130	30	—	1°	0.3	3	
AJX06R254SA25S	●	1	17.9	25	25	140	60	1.11	0.8°	0.3	4	
AJX06R284SA25S	●	1	20.9	25	28	140	40	—	0.7°	0.3	4	
AJX06R325SA32S	●	1	24.9	32	32	150	70	0.94	0.5°	0.3	5	
AJX06R326SA32S	●	1	24.9	32	32	150	70	0.94	0.5°	0.3	6	
AJX06R162SA16L	●	1	8.9	16	16	150	70	0.93°	3°	0.3	2	
AJX06R172SA16L	●	1	9.9	16	17	150	20	—	2.5°	0.3	2	
AJX06R203SA20L	●	1	12.9	20	20	180	100	0.64°	1.5°	0.3	3	
AJX06R223SA20L	●	1	14.9	20	22	180	30	—	1°	0.3	3	
AJX06R254SA25L	●	1	17.9	25	25	200	120	0.54	0.8°	0.3	4	
AJX06R284SA25L	●	1	20.9	25	28	200	40	—	0.7°	0.3	4	
AJX06R325SA32L	●	1	24.9	32	32	200	120	0.54	0.5°	0.3	5	
AJX06R162SA16EL	★	1	8.9	16	16	200	100	0.64°	3°	0.3	2	
AJX06R172SA16EL	★	1	9.9	16	17	200	20	—	2.5°	0.3	2	
AJX08R202SA20S	●	1.5	11.4	20	20	130	50	1.34°	3.5°	0.5	2	
AJX08R222SA20S	●	1.5	13.4	20	22	130	30	—	3°	0.5	2	
AJX08R253SA25S	●	1.5	16.4	25	25	140	60	1.1°	2°	0.5	3	
AJX08R283SA25S	●	1.5	19.4	25	28	140	40	—	1.7°	0.5	3	
AJX08R324SA32S	●	1.5	23.4	32	32	150	70	0.95	1.4°	0.5	4	
AJX08R406SA32S	●	1.5	31.4	32	40	150	50	—	1°	0.5	6	
AJX08R202SA20L	●	1.5	11.4	20	20	180	100	0.65°	3.5°	0.5	2	
AJX08R222SA20L	●	1.5	13.4	20	22	180	30	—	3°	0.5	2	
AJX08R253SA25L	●	1.5	16.4	25	25	200	120	0.54°	2°	0.5	3	
AJX08R283SA25L	●	1.5	19.4	25	28	200	40	—	1.7°	0.5	3	
AJX08R324SA32L	●	1.5	23.4	32	32	200	120	0.55	1.4°	0.5	4	
AJX08R406SA32L	●	1.5	31.4	32	40	250	50	—	1°	0.5	6	
AJX08R202SA20EL	★	1.5	11.4	20	20	250	130	0.5°	3.5°	0.5	2	
AJX08R222SA20EL	★	1.5	13.4	20	22	250	30	—	3°	0.5	2	

JOM006T200
ZZOR-00JOM0080300
ZZOR-00

AJX – STRAIGHT SHANK TYPE

Order number	Stock	APMX	DC	DCON	DCX	LF	LH	B2	RMPX	AZ	ZEFP	
AJX09R252SA25S	●	2	14.9	25	25	140	60	1.1°	4°	1	2	JDM○09T3○○ ZD○R-○○
AJX09R282SA25S	●	2	17.9	25	28	140	40	—	3°	1	2	
AJX09R303SA32S	●	2	20.0	32	30	150	70	1.79°	2.7°	1	3	
AJX09R323SA32S	●	2	21.9	32	32	150	70	0.94°	2.5°	1	3	
AJX09R353SA32S	●	2	24.9	32	35	150	50	—	2°	1	3	
AJX09R404SA32S	●	2	29.9	32	40	150	50	—	1.5°	1	4	
AJX09R252SA25L	●	2	14.9	25	25	200	120	0.54°	4°	1	2	
AJX09R282SA25L	●	2	17.9	25	28	200	40	—	3°	1	2	
AJX09R303SA32L	●	2	20.0	32	30	200	120	1.03°	2.7°	1	3	
AJX09R323SA32L	●	2	21.9	32	32	200	120	0.54°	2.5°	1	3	
AJX09R353SA32L	●	2	24.9	32	35	200	50	—	2°	1	3	
AJX09R404SA32L	●	2	29.9	32	40	250	50	—	1.5°	1	4	
AJX09R252SA25EL	★	2	14.9	25	25	300	180	0.36°	4°	1	2	JDM○1204○○ ZD○R-○○
AJX09R282SA25EL	★	2	17.9	25	28	300	40	—	3°	1	2	
AJX12R302SA32S	●	2	18.3	32	30	150	70	1.82°	4.5°	1.5	2	
AJX12R322SA32S	●	2	20.3	32	32	150	70	0.96°	4°	1.5	2	
AJX12R352SA32S	●	2	23.3	32	35	150	50	—	3.5°	1.5	2	
AJX12R403SA32S	●	2	28.3	32	40	150	50	—	3°	1.5	3	
AJX12R403SA42S	★	2	28.3	42	40	150	70	1.79°	3°	1.5	3	
AJX12R302SA32L	●	2	18.3	32	30	200	120	1.04°	4.5°	1.5	2	
AJX12R322SA32L	●	2	20.3	32	32	200	120	0.55°	4°	1.5	2	
AJX12R352SA32L	●	2	23.3	32	35	200	50	—	3.5°	1.5	2	
AJX12R403SA32L	●	2	28.3	32	40	250	50	—	3°	1.5	3	
AJX12R403SA42L	★	2	28.3	42	40	250	70	1.79°	3°	1.5	3	JDM○1405○○ ZD○R-○
AJX12R302SA32EL	★	2	18.3	32	30	300	180	0.69°	4.5°	1.5	2	
AJX12R322SA32EL	★	2	20.3	32	32	300	180	0.36°	4°	1.5	2	
AJX12R352SA32EL	★	2	23.3	32	35	300	50	—	3.5°	1.5	2	
AJX12R402SA32EL	★	2	28.3	32	40	350	50	—	3°	1.5	2	
AJX12R402SA42EL	★	2	28.3	42	40	350	70	1.79°	3°	1.5	2	
AJX14R503SA42S	★	2	38.2	42	50	150	50	—	4.2°	2	3	
AJX14R503SA42L	★	2	38.1	42	50	250	50	—	4.2°	2	4	
AJX14R634SA42S	★	2	51.1	42	63	150	50	—	2.8°	2	4	
AJX14R634SA42L	★	2	51.1	42	63	250	50	—	2.8°	2	4	

1. Please refer to page 19, for maximum depth of cut (APMX) and maximum plunging depth (AZ).



SPARE PARTS

Tool holder					
	Clamp screw	Clamp bridge	Clamp bridge screw	Spring	Wrench
AJX06	TS25	—	—	—	TKY08F
AJX08	TS33	—	—	—	TKY08D
AJX09	TS351	AMS3	AJS3010T10	ASS2	TKY10D
AJX12R302	TS407	AMS4	AJS4012T15	ASS2	TKY15D
AJX12	TS43	AMS4	AJS4012T15	ASS2	TKY15D
AJX14	TS54	AMS5	AJS5014T25	ASS3	TKY25D

1. Clamp torque (N • m) : **TS25=1.0. TS33=1.0. TS351=2.5. TS407=3.5. TS43=3.5. TS54=7.5. AJS3010T10=2.5. AJS4012T15=3.5. AJS5014T25=7.5**

● : Inventory maintained. ★ : Inventory maintained in Japan.

1. When using the ST chipbreaker, please check the height setting as it differs from other chipbreakers.

AJX

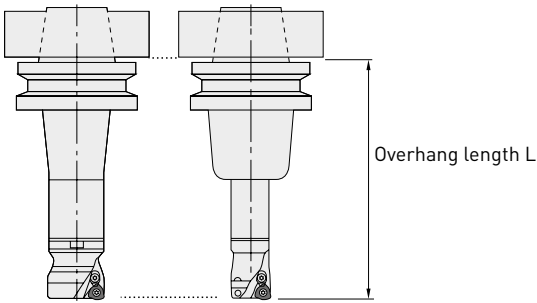
RECOMMENDED CUTTING CONDITIONS

CUTTING SPEED

Material	Properties	Grade	Vc	
P	Mild steel	≤180HB	MV1020	230 (180 – 280)
			FH7020	170 (120–220)
			MV1030	160 (100 – 220)
			MP6120	150 (100–200)
			MP6130	130 (80–180)
			VP30RT	110 (60–160)
	Carbon steel Alloy steel	180–280HB	MV1020	220 (170 – 270)
			MV1030	150 (80 – 220)
			FH7020	150 (100–200)
			MP6120	130 (80–180)
			MP6130	110 (60–160)
			VP30RT	90 (40–140)
	Carbon steel Alloy steel	280–350HB	MV1020	180 (100 – 250)
			MV1030	140 (70 – 210)
			FH7020	130 (80–180)
			MP6120	100 (50–100)
			MP6130	80 (30–130)
			VP30RT	60 (20–110)
	Alloy tool steel	≤350HB (Annealing)	MV1020	180 (100 – 250)
			MV1030	140 (70 – 210)
			FH7020	130 (80–180)
			MP6120	100 (50–150)
			MP6130	80 (30–120)
			VP30RT	60 (20– 90)
	Pre-hardened steel	35–45HRC	MP6120	100 (70–130)
			MP6130	80 (50–110)
			VP30RT	80 (30– 90)
M	Austenitic stainless steel	≤200HB	MV1030	160 (130 – 200)
		>200HB	MV1030	140 (80 – 200)
		≤270HB	MP7130	140 (100–180)
			MP7140	120 (80–160)
	PH stainless steel	<450HB	MV1030	140 (80 – 200)
K	Gray cast iron	≤350MPa	FH7020	150 (100–200)
		≤450MPa	MV1020	210 (160 – 260)
			MV1030	160 (120 – 210)
	Ductile cast iron	≤800MPa	MV1020	190 (140 – 240)
			MV1030	130 (90 – 170)
			VP15TF	120 (80–160)
S	Titanium alloy	—	MP9120	50 (40– 60)
			MP9130	45 (30– 55)
			MP9140	40 (30– 50)
	Heat resistant alloy	≤350 HB	MP9120	30 (20– 40)
			MP9130	25 (20– 35)
			MP9140	20 (15– 30)
H	Hardened steel	40–55HRC	VP15TF	70 (50– 90)

AJX

1 Overhang length L



2 Main spindle revolution n (min^{-1}) = [Recommended cutting speed x 1000] ÷ [Outer tool diameter x 3.14]

3 Table feed rate V_f (mm/min) = $n \times \text{feed per tooth} \times \text{number of teeth}$

4 Recommended width of cut (a_e) is more than 60 % of the cutting edge diameter.

5 The above cutting conditions are guides to cutting on a #50 BT machine. In case of #40 BT and #63 HSK machines, a cutting edge diameter of under 35 mm is recommended. In these cases, also reduce the depth of cut and table feed rate.

6 Use of ST chipbreaker with a tougher cutting edge is recommended for machining parts that require interrupted cutting. First recommended grade for ST chipbreakers is VP30RT, irrespective of the workpiece material.

7 Cutter body with a coarse pitch is recommended for the unstable cutting caused by a long tool overhang.

8 Use the "sharp" JM chipbreaker to lower cutting forces or when long tool overhangs are used.

9 Heavy chips are generated when machining with AJX. To avoid chip jamming related problems, use air blow while machining to discharge chips effectively.

DEPTH OF CUT / FEED PER TOOTH

Material			Properties			DCX=16.17			DCX=20.22			DCX=25.28		
						L	ap	fz	L	ap	fz	L	ap	fz
P	Mild steel	≤180HB	140	0.8	0.8	160	1.0	1.0	170	1.0	1.2			
			180	0.6	0.6	210	0.8	0.8	230	0.8	1.0			
			210	0.4	0.4	240	0.6	0.6	290	0.6	0.8			
	Carbon steel Alloy steel	180–280HB	140	0.8	0.8	160	1.0	1.0	170	1.0	1.2			
			180	0.6	0.6	210	0.8	0.8	230	0.8	1.0			
			210	0.4	0.4	240	0.6	0.6	290	0.6	0.8			
	Carbon steel Alloy steel	280–350HB	140	0.7	0.8	160	0.8	1.0	170	0.8	1.2			
			180	0.5	0.6	210	0.6	0.8	230	0.6	1.0			
			210	0.3	0.4	240	0.4	0.6	290	0.4	0.8			
	Alloy tool steel	≤350 HB	140	0.7	0.8	160	0.8	1.0	170	0.8	1.2			
			180	0.5	0.6	210	0.6	0.8	230	0.6	1.0			
			210	0.3	0.4	240	0.4	0.6	290	0.4	0.8			
Pre-hardened steel	35–45HRC	140	0.7	0.7	160	0.8	0.8	170	0.8	1.0				
		180	0.5	0.5	210	0.6	0.6	230	0.6	0.8				
		210	0.3	0.3	240	0.4	0.4	290	0.4	0.6				
M	Austenitic stainless steel	≤270 HB	140	0.8	0.7	160	1.0	0.8	170	1.0	1.0			
			180	0.6	0.5	210	0.8	0.6	230	0.8	0.8			
			210	0.4	0.3	240	0.6	0.4	290	0.6	0.6			
K	Gray cast iron	≤350 MPa	140	0.8	1.0	160	1.0	1.2	170	1.0	1.4			
			180	0.6	0.8	210	0.8	1.0	230	0.8	1.2			
			210	0.4	0.6	240	0.6	0.8	290	0.6	1.0			
	Ductile cast iron	≤800MPa	140	0.7	0.8	160	0.8	1.0	170	0.8	1.2			
			180	0.5	0.6	210	0.6	0.8	230	0.6	1.0			
			210	0.3	0.4	240	0.4	0.6	290	0.4	0.8			
S	Titanium alloy	—	140	0.6	0.6	160	0.8	0.6	170	1.0	0.6			
	Heat resistant alloy	≤350 HB	180	0.4	0.4	210	0.6	0.4	230	0.8	0.4			
			210	0.3	0.3	240	0.4	0.3	290	0.6	0.3			
H	Hardened steel	40–55HRC	140	0.5	0.5	160	0.5	0.6	170	0.5	0.8			
			180	0.4	0.3	210	0.4	0.4	230	0.4	0.6			
			210	0.3	0.2	240	0.3	0.2	290	0.3	0.4			

AJX

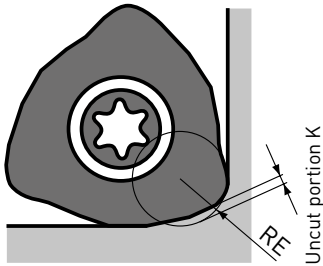
DEPTH OF CUT / FEED PER TOOTH

Material		Properties	DCX=30. 32. 35			DCX=40. (32 Shank Type)			DCX=40. (42 Shank Type)			DCX=50. 63		
			L	ap	fz	L	ap	fz	L	ap	fz	L	ap	fz
P	Mild steel	≤180HB	180	1.2	1.4	180	1.2	1.4	180	1.2	1.5	180	1.4	1.5
			230	1.0	1.2	240	1.0	1.2	240	1.0	1.3	240	1.2	1.3
			290	0.8	1.0	300	0.8	1.0	300	0.8	1.1	—	—	—
	Carbon steel Alloy steel	180 – 280HB	180	1.2	1.4	180	1.2	1.4	180	1.2	1.5	180	1.4	1.5
			230	1.0	1.2	240	1.0	1.2	240	1.0	1.3	240	1.2	1.3
			290	0.8	1.0	300	0.8	1.0	300	0.8	1.1	—	—	—
	Carbon steel Alloy steel	280 – 350HB	180	1.0	1.4	180	1.0	1.4	180	1.0	1.5	180	1.2	1.5
			230	0.8	1.2	240	0.8	1.2	240	0.8	1.3	240	1.0	1.3
			290	0.6	1.0	300	0.6	1.0	300	0.6	1.1	—	—	—
	Alloy tool steel	≤350 HB	180	1.0	1.4	180	1.0	1.4	180	1.0	1.5	180	1.2	1.5
			230	0.8	1.2	240	0.8	1.2	240	0.8	1.3	240	1.0	1.3
			290	0.6	1.0	300	0.6	1.0	300	0.6	1.1	—	—	—
	Pre-hardened steel	35 – 45HRC	180	1.0	1.2	180	1.0	1.2	180	1.0	1.3	180	1.2	1.3
			230	0.8	1.0	240	0.8	1.0	240	0.8	1.1	240	1.0	1.1
			290	0.6	0.8	300	0.6	0.8	300	0.6	0.9	—	—	—
M	Austenitic stainless steel	≤270HB	180	1.2	1.2	180	1.2	1.2	180	1.2	1.3	180	*1.4	1.3
			230	1.0	1.0	240	1.0	1.0	240	1.0	1.1	240	1.2	1.1
			290	0.8	0.8	300	0.8	0.8	300	0.8	0.9	—	—	—
K	Gray cast iron	≤350MPa	180	1.2	1.6	180	1.2	1.6	180	1.2	1.7	180	1.4	1.7
			230	1.0	1.4	240	1.0	1.4	240	1.0	1.5	240	1.2	1.5
			290	0.8	1.2	300	0.8	1.2	300	0.8	1.3	—	—	—
	Ductile cast iron	≤450MPa	180	1.0	1.4	180	1.0	1.4	180	1.0	1.5	180	1.2	1.5
			230	0.8	1.2	240	0.8	1.2	240	0.8	1.3	240	1.0	1.3
			290	0.6	1.0	300	0.6	1.0	300	0.6	1.1	—	—	—
S	Titanium alloy	—	180	1.2	0.6	180	1.2	0.6	180	1.2	0.6	180	1.2	0.6
	Heat resistant alloy	≤350 HB	230	1.0	0.4	240	1.0	0.4	240	1.0	0.4	240	1.0	0.4
			290	0.8	0.3	300	0.8	0.3	300	0.8	0.3	—	—	—
H	Hardened steel	40 – 55HRC	180	0.6	1.0	180	0.6	1.0	180	0.6	1.1	180	0.8	1.1
			230	0.5	0.8	240	0.5	0.8	240	0.5	0.9	240	0.6	0.9
			290	0.4	0.6	300	0.4	0.6	300	0.4	0.7	—	—	—

* Depth of cut of JL breaker is up to 0.6 mm for the size 06. up to 0.9 mm for the size 08 and up to 1.2 mm for the size 09. 12. 14.

NOTE FOR PROGRAMMING

When using AJX, please programme as an R3 radius cutter.
The approximate uncut portions for the programme are as follows.

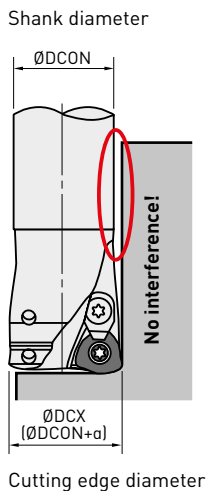


Insert size		Approx. RE	Uncut portion K
06	FT/JM	2.0	0.33
	JL	2.5	0.32
08	FT/JM	2.5	0.46
	JL	2.0	0.40
09	FT/JM	3.0	0.47
	JL	3.0	0.46
12	FT/JM/ST	3.0	0.63
	JL	3.0	0.53
14	FT/JM/ST	3.0	0.64
	JL	3.0	0.55

1. The uncut portion may change slightly depending on cutting conditions.

NO WORKPIECE INTERFERENCE

The shank type AJX is designed with an offset from the cutting diameter for workpiece and chip clearance as shown. It is ideal for deep applications and reduces the need for special long tools.

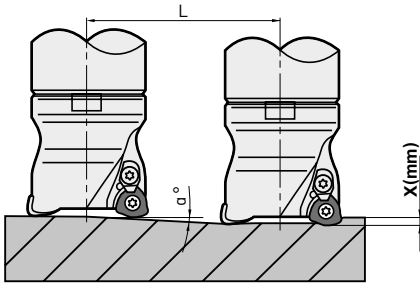


Order number	DCX	DCON
AJX06R172SA16	17	16
AJX06R223SA20	22	20
AJX08R222SA20	22	20
AJX08R283SA20	28	20
AJX09R282SA25	28	25
AJX09R353SA32	35	32
AJX09R404SA32	40	32
AJX12R352SA32	35	32
AJX12R400SA32	40	32
AJX14R503SA42	50	42
AJX14R634SA42	63	42

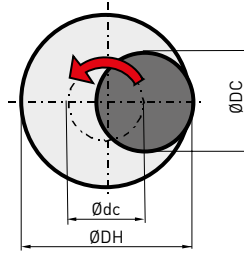
1. Please refer to page 12/13 for details of the holder.

RECOMMENDED CUTTING CONDITIONS

RAMPING



HELICAL DRILLING



- How to derive a locus of the centre of the tool

$$\varnothing_{dc} = \varnothing_{DH} - \varnothing_{DC}$$

Locus of the center of the tool Desired hole diameter Cutting edge diameter

- For the depth of cut per pass, refer to the Cutting conditions above for helical drilling.
- Set the machine spindle revolution so that the tool is rotating and cutting in a down cut direction.

- When ramping and helical cutting, please apply a lower feed (60 % of the calculated feed rate or less).
- When drilling, please set the feed in the axial direction at 0.2 mm/rev or less.
- The long chips generated can disperse, so ensure that adequate safety precautions are taken.

Tool holder type	DCX	DC	APMX		RMPX	Ramping				Helical drilling		AZ
			Breaker			L (mm) Required distance for X mm depth				DH		
			FT/JM/ST	JL		X=1	x=1.2	x=1.5	x=2	Min	Max.	
SHANK TYPE/SCREW-IN TYPE												
AJX06	16	8.9	1	0.6	3°	19.1	—	—	—	23	29	0.3
AJX06	17	9.9	1	0.6	2.5°	22.9	—	—	—	25	31	0.3
AJX06	20	12.9	1	0.6	1.5°	38.2	—	—	—	31	37	0.3
AJX06	22	14.9	1	0.6	1°	57.3	—	—	—	35	41	0.3
AJX08	20	11.4	1.5	0.9	3.5°	16.3	19.6	24.5	—	27	36	0.5
AJX08	22	13.4	1.5	0.9	3°	19.1	22.9	28.6	—	31	40	0.5
AJX08	25	16.4	1.5	0.9	2°	28.6	34.4	43	—	37	46	0.5
AJX08	28	19.4	1.5	0.9	1.7°	33.7	40.4	50.5	—	43	52	0.5
AJX09	25	14.9	2	1.2	4°	14.3	17.2	21.5	28.6	33	46	1
AJX09	28	17.9	2	1.2	3°	19.1	22.9	28.6	38.1	39	52	1
AJX09	30	20	2	1.2	2.7°	21.2	25.4	31.8	42.4	43	56	1
AJX09	32	21.9	2	1.2	2.5°	22.9	27.5	34.4	45.8	47	60	1
AJX09	35	24.9	2	1.2	2°	28.6	34.4	43	57.3	53	66	1
AJX09	40	29.9	2	1.2	1.5°	38.2	45.8	57.3	76.4	63	76	1
AJX12	30	18.3	2	1.2	4.5°	12.7	15.2	19	25.4	39	56	1.5
AJX12	32	20.3	2	1.2	4°	14.3	17.2	21.4	28.6	41	60	1.5
AJX12	35	23.3	2	1.2	3.5°	16.3	19.6	24.5	32.7	47	66	1.5
AJX12	40	28.3	2	1.2	3°	19.1	22.9	28.6	38.2	57	76	1.5
AJX14	50	38.2	2	1.2	4.2°	13.6	16.3	20.4	27.2	72	96	2
AJX14	63	51.1	2	1.2	2.8°	20.4	24.5	30.7	40.9	98	122	2
ARBOR TYPE												
AJX09	50	40	2	1.2	1.1°	52.1	62.5	78.1	104.2	83	96	1
AJX12-050	50	38	2	1.2	2°	28.6	34.4	43	57.3	77	96	1.5
AJXR050	50	38	2	1.2	2°	28.6	34.4	43	57.3	77	96	1.5
AJX12-063	63	51	2	1.2	1° 30´	38.2	45.8	57.3	76.4	103	122	1.5
AJXR063	63	51	2	1.2	1° 30´	38.2	45.8	57.3	76.4	103	122	1.5
AJXR080	80	68	2	1.2	1° 06´	52.1	62.5	78.1	104.2	137	156	1.5
AJXR100	100	88	2	1.2	0° 48´	71.6	85.9	107.4	143.2	177	196	1.5
AJX14-063	63	51	2	1.2	2° 48´	20.4	24.5	30.7	40.9	98	122	2
AJXR063	63	51	2	1.2	2° 48´	20.4	24.5	30.7	40.9	98	122	2
AJXR080	80	68	2	1.2	1° 48´	31.8	38.2	47.7	63.6	132	156	2
AJXR100	100	88	2	1.2	1° 12´	47.7	57.3	71.6	95.5	172	196	2
AJXR125	125	113	2	1.2	0° 48´	71.6	85.9	107.4	143.2	222	246	2
AJXR160	160	148	2	1.2	0° 30´	114.6	137.5	171.9	229.2	292	316	2

SELECTION REFERENCE TABLE

CUTTING EDGE COUNT AND CUTTING CONDITIONS

DCX	Coarse pitch			Fine pitch			Extra fine pitch			Ultra fine pitch					
	Tool holder type	ZEFP	Vf	Tool holder type	ZEFP	Vf	Tool holder type	ZEFP	Vf	Tool holder type	ZEFP	Vf	Tool holder type	ZEFP	Vf
ARBOR TYPE															
32										AJX06	5	7400	AJX06	6	8900
40										AJX08	6	7100			
42										AJX08	6	6800			
50	AJX12	3	3100	AJX12	4	4200	AJX09	5	5200	AJX09	6	6300	AJX08	7	7300
52										AJX09	6	6000	AJX08	7	7000
63	AJX14	3	2500	AJX14	4	3300	AJX12	5	4100	AJX12	6	5000	AJX09	7	5800
63	AJX14	3	2500	AJX14	4	3300	AJX12	5	4100	AJX12	6	5000	AJX09	7	5800
66	AJX14	3	2300	AJX14	4	3100	AJX12	5	3900	AJX12	6	4700	AJX09	7	5500
80	AJX14	4	2300	AJX14	5	2900	AJX12	6	3500	AJX12	8	4700			
100	AJX14	5	2300	AJX14	6	2800	AJX12	7	3300	AJX12	9	4200			
125	AJX14	5	1900	AJX14	7	2600				AJX14	9	3400			
160	AJX14	6	1700	AJX14	8	2300									
SHANK TYPE AND LONG SHANK TYPE															
16	AJX06	2	2300												
17	AJX06	2	2200												
20	AJX08	2	2800	AJX06	3	4200									
22	AJX08	2	2600	AJX06	3	3900									
25	AJX09	2	3000	AJX08	3	4500	AJX06	4	6100						
28	AJX09	2	2700	AJX08	3	4000	AJX06	4	5400						
30	AJX12	2	3100	AJX09	3	4700									
32	AJX12	2	2900	AJX09	3	4400	AJX08	4	5900	AJX06	5	7400	AJX06	6	8900
40 (DCON=40)	AJX12	3	3500	AJX09	4	4700	AJX08	6	7100						
40 (DCON=42)	AJX12	3	3900	AJX09	4	5200									
50	AJX14	3	3700												
63	AJX14	4	3900												
SCREW-IN TYPE															
16	AJX06	2	2300												
17	AJX06	2	2200												
20	AJX08	2	2800	AJX06	3	4200									
22	AJX08	2	2600	AJX06	3	3900									
25	AJX09	2	3000	AJX08	3	4500	AJX06	4	6100						
28	AJX09	2	2700	AJX08	3	4000	AJX06	4	5400						
30	AJX12	2	3100	AJX09	3	4700									
32	AJX12	2	2900	AJX09	3	4400	AJX08	4	5900						
35	AJX12	2	2700	AJX09	3	4000	AJX08	4	5400						
40	AJX12	3	3500	AJX09	4	4700	AJX08	6	7100						

Cutting conditions

Material: SCM440

Insert: FH7020

Vc (m/min): 150

Protrusion amount is calculated based on the maximum value in the table for recommended conditions. (Rounded down to the last two digits.)

STRAIGHT SHANK ARBOR



Order number	Stock	DCONWS	DCONMS	DCSFWS	LF	LB	H	CRKS
STEEL SHANK								
SC16M08S100S	★	8.5	16	14.5	100	10	10	M8
SC16M08S200L	★	8.5	16	14.5	200	10	10	M8
SC20M10S120S	★	10.5	20	18.5	120	10	14	M10
SC20M10S220L	★	10.5	20	18.5	220	10	14	M10
SC25M12S125S	★	12.5	25	23.5	125	10	19	M12
SC25M12S245L	★	12.5	25	23.5	245	10	19	M12
SC32M16S140S	★	17.0	32	28.5	140	15	24	M16
SC32M16S280L	★	17.0	32	28.5	280	15	24	M16
CARBIDE SHANK								
SC16M08S100SW	★	8.5	16	14.5	100	10	10	M8
SC16M08S200LW	★	8.5	16	14.5	200	10	10	M8
SC20M10S120SW	★	10.5	20	18.5	120	10	14	M10
SC20M10S220LW	★	10.5	20	18.5	220	10	14	M10
SC25M12S125SW	★	12.5	25	23.5	125	10	19	M12
SC25M12S245LW	★	12.5	25	23.5	245	10	19	M12
SC32M16S140SW	★	17.0	32	28.5	140	15	24	M16
SC32M16S280LW	★	17.0	32	28.5	280	15	24	M16

BT30 SHANK ARBOR

Order number	Stock	DCONWS	DCSFWS	LPR	LB	CRKS	Execution
SC16M08S10-BT30	★	8.5	14.5	32	10	M8	
SC20M10S10-BT30	★	10.5	18.5	32	10	M10	
SC25M12S10-BT30	★	12.5	23.5	32	10	M12	
SC32M16S10-BT30	★	17.0	28.5	32	10	M16	

BT40 SHANK ARBOR

Order number	Stock	DCONWS	DCSFWS	LPR	LB	CRKS	Execution
SC16M08S10-BT40	★	8.5	14.5	37	10	M8	
SC20M10S10-BT40	★	10.5	18.5	37	10	M10	
SC25M12S10-BT40	★	12.5	23.5	37	10	M12	
SC32M16S10-BT40	★	17.0	28.5	37	10	M16	

HSK63A SHANK ARBOR

Order number	Stock	DCONWS	DCSFWS	LPR	LB	CRKS	Execution
SC16M08S22-HSK63A	★	8.5	14.5	48	22	M8	
SC20M10S24-HSK63A	★	10.5	18.5	50	24	M10	
SC25M12S27-HSK63A	★	12.5	23.5	53	27	M12	
SC32M16S28-HSK63A	★	17.0	28.5	54	28	M16	

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