

Rake Angle	Radial	0°
	Axial	+6°



## Shoulder Milling for Steel, Stainless Steel & Cast Iron



Fig 1

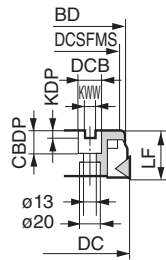


Fig 2

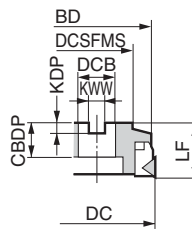
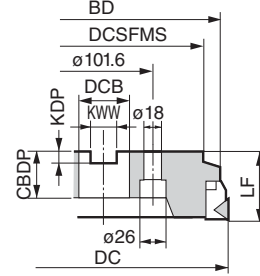


Fig 3



Body  Inch

Dimensions (mm)

Cat. No. (R)	Stock	Cat. No. (L)	Stock	Diameter	External Diameter	Boss	Height	Hole Size	Grooving Width	Grooving Depth	Mounting Depth	No. of Teeth	Weight (kg)	Fig
				DC	BD	DCSFMS	LF	DCB	KWW	KDP	CBDF			
<b>CPG 4080R</b>	●	<b>CPG 4080L</b>		*80	77	60	50	<b>25.4</b>	9.5	6	25	5	1.2	1
<b>4100R</b>	●	<b>4100L</b>		100	98	75	60	<b>31.75</b>	12.7	8	32	6	2.0	2
<b>4125R</b>	●	<b>4125L</b>		125	121	75	60	<b>38.1</b>	15.9	10	38	8	3.3	2
<b>4160R</b>	●	<b>4160L</b>		160	155	100	60	<b>50.8</b>	19.1	11	38	10	5.5	2
<b>4200R</b>	●	<b>4200L</b>		200	194	130	60	<b>47.625</b>	25.4	13.5	38	12	8.6	3
<b>CPG 4250R</b>		<b>CPG 4250L</b>		250	243	200	70	<b>47.625</b>	25.4	13.5	52	14	17.9	3
<b>4315R</b>		<b>4315L</b>		315	308	240	70	<b>47.625</b>	25.4	13.5	52	18	25.5	3

Inserts are not included.

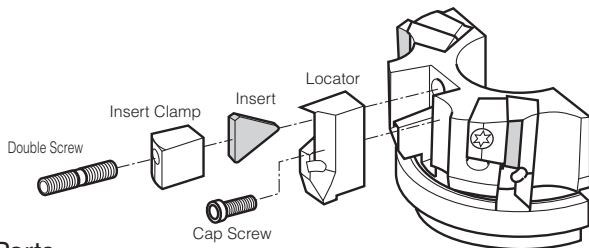
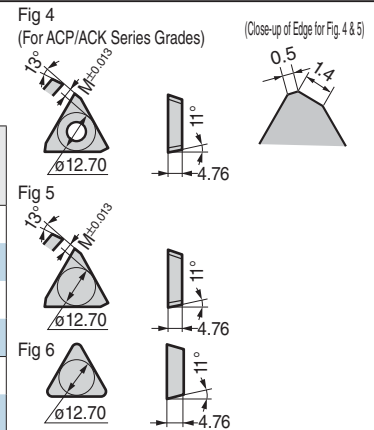


\*Please use JIS B1176 hexagonal bolt (M12x30 to 35mm) for securing ø80 cutter to the arbor.

### Inserts

**P** Steel **M** Stainless Steel **K** Cast Iron **N** Non-Ferrous Metal **S** Exotic Alloy **H** Hardened Steel

Application	Grade	Coated Carbide						Carbide				Cermet			Fig	
		High Speed/Light	P		K		M						P P			
		General Purpose	P	M	K				P	P	K	K	P			
	Roughing	P	M	K												
Cat. No.		ACP100	ACP200	ACP300	ACK200	ACK300	EH20Z	A30	A30N	H10E	G10E	T1500A	T130A	T250A		
<b>TPCH 43R</b>					●	●	●				●				4(5)	
<b>43L</b>											●				5	
<b>43TR</b>		●	●	●					●	●		●		●	4(5)	
<b>43TL</b>									●						5	
<b>TPMN 432</b>									●		●		●		6	
<b>433</b>									●		●				6	



### Parts

Applicable Cutters	Locator	Insert Clamp	Double Screw	Cap Screw	Wrench
CPG4080R	LCP40R	PTW40R	WB8-22T	BX0508	TT27 LH040
CPG4100R to CPG4125R	LCP40R	PTW41R	WB8-22T	BX0510	TT27 LH040
CPG4160R to CPG4500R	LCP40R	PTW41R	WB8-30T	BX0510	TT27 LH040
CPG4080L	LCP40L	PTW40L	WB8-22T	BX0508	TT27 LH040
CPG4100L to CPG4125L	LCP40L	PTW41L	WB8-22T	BX0510	TT27 LH040
CPG4160L to CPG4500L	LCP40L	PTW41L	WB8-30T	BX0510	TT27 LH040

TT27-Double Screw Wrench, LH040-Cap Screw Wrench

### Recommended Cutting Conditions

ISO	Work Material	Hardness	Cutting Speed $v_c$ (m/min) Min. - Optimum - Max.	Feed Rate $f_z$ (mm/t) Min. - Optimum - Max.	Grade
<b>P</b>	General Steel	180 to 280HB	80-110-140	0.10-0.18-0.25	ACP200
	Soft Steel	≤180HB	100-125-150	0.10-0.15-0.20	ACP200
	Die Steel	200 to 220HB	60-80-100	0.10-0.15-0.20	ACP200
<b>M</b>	Stainless Steel	—	100-125-150	0.10-0.18-0.25	ACP300
<b>K</b>	Cast Iron	250HB	60-90-120	0.10-0.18-0.25	ACK200

**Note** The cutting conditions above are a guide. Actual conditions will need to be adjusted according to machine rigidity, work clamp rigidity, cutting depth, and other factors.