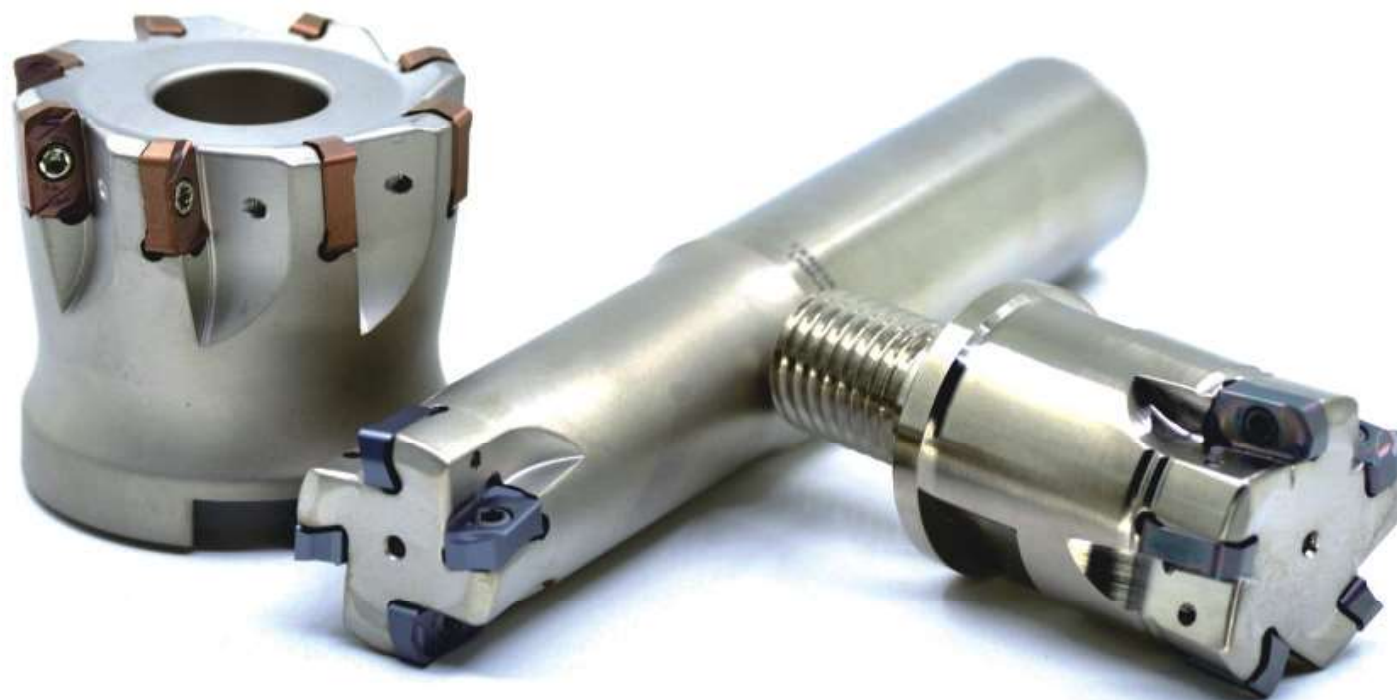




# LNMU0303ZER-CM

Passionate pursuit of perfection



end mills: 16-35mm

shell mills: 40, 50 63, 80mm

screw coupling: 16, 17, 20, 21, 25, 26, 32, 35mm





# LNMU0303 High feed milling insert



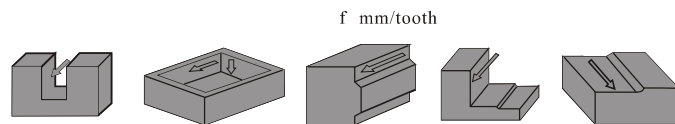
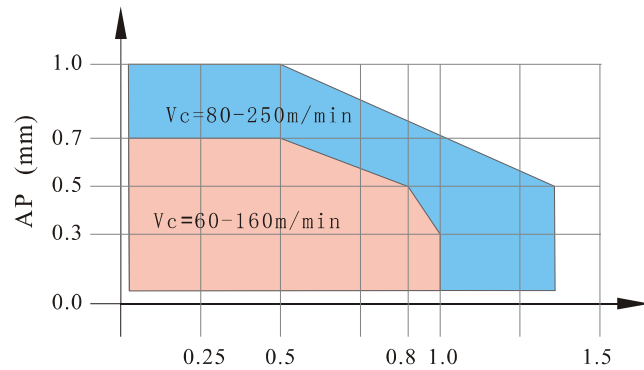
Feature:

Strong edge, perfect abrasive resistance, high stability and efficiency.

Performance exceed famous brand.

Application:

Stainless steel, Superalloy, Die steel, cast iron.



A-06

		PVD Coating			加工参数 parameters	
		CP2630TN CP2640TN	CP2430	CP6130MS	Vc (mm/min)	
Material group	P Steel	*	*		120-160-250	
	P P20,718,SKD11,S136H	*	*		100-130-160	
	P HRC50-63 Steel			*	50-80-120	
	M Stainless steel	*	*	*	60-110-150	
	K Cast iron		*	*	150-180-220	
	S Titanium alloy	*	*		40-60-80	
S Superalloy	*			40-60-100		
Type	purpose				Ap(mm)	f (mm/t)
LNMU0303ZER-CM	Stainless steel, Steel, Cast iron Ti-alloy, Superalloy	*	*	*	0.3-0.8	0.3-1.2

LNMU0303ZER-CM programming R angle is **R=1.5**

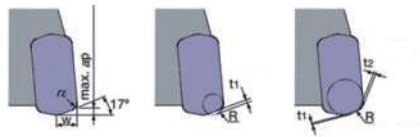
CP2430 Suitable For Dry Or Air-cooled Cutting



# LNMU0303



The edge of the tool on the program.  
 When using CAM programming, the tool should be regarded as a radius turning tool in the case of one vibration,  
 The flat diameter of the center of the tool should be set to R1.5mm.



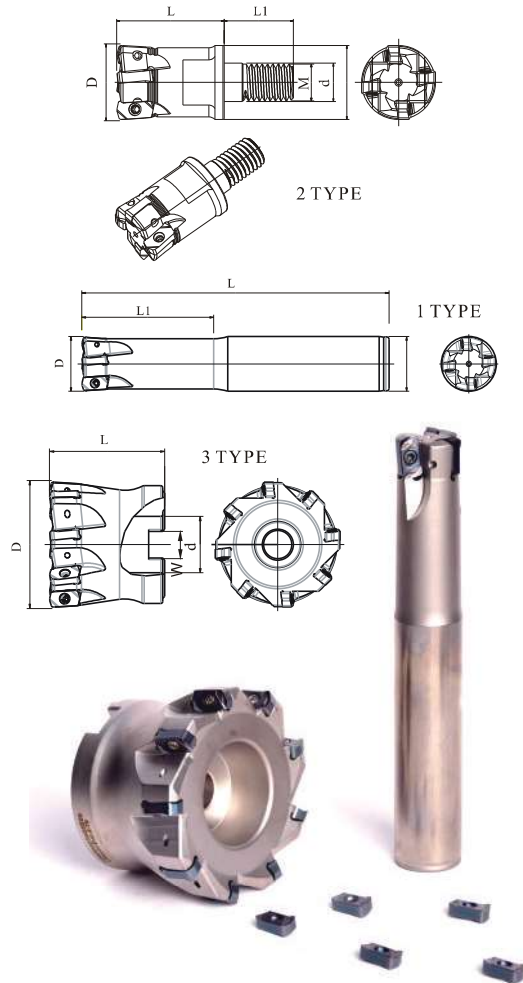
ap (mm)	f <sub>ε</sub> (mm)	W (mm)	R	t <sub>1</sub> (mm)	t <sub>2</sub> (mm)
1.0	1.2	3.0	1.0	0.6	-
			1.5	0.5	-
			2.0	0.25	0.08
			2.5	0.14	0.26

Material examples	Hardness	Grade	V <sub>c</sub> m/min	fz mm/t / Ap mm		
				Φ16-22	Φ25-50	
S45C, S50C	~220HB	CP2630TN CP2430	100-250	fz=0.5-1.2 Ap=0.5-0.8	fz=0.5-1.5 Ap=0.5-0.8	0.1
20CrMoTi, 42CrMo	~200HB	CP2630TN CP2430	100-200	fz=0.5-1.0 Ap=0.4-0.6	fz=0.5-1.2 Ap=0.4-0.6	0.1
SKD61 (H13), SKD11	350HB	CP2630TN CP2430	100-150	fz=0.5-0.7 Ap=0.3-0.5	fz=0.5-0.8 Ap=0.3-0.5	0.1
P20, 718, 738	HRC28-32	CP2630TN CP2430	100-180	fz=0.5-1.0 Ap=0.3-0.5	fz=0.5-1.0 Ap=0.3-0.5	0.1
S136H, NAK80, 4Cr13	HRC30-40	CP2630TN	100-150	fz=0.5-0.7 Ap=0.3-0.5	fz=0.5-0.8 Ap=0.3-0.5	0.1
SKD61 (H13)	HRC40-50	CP2630TN CP6130MS	80-120	fz=0.1-0.25 Ap=0.2-0.3	fz=0.1-0.25 Ap=0.2-0.3	0.05
SKD11 (Cr12MoV)	HRC50-62	CP6130MS	70-120	fz=0.1-0.2 Ap=0.15-0.2	fz=0.1-0.2 Ap=0.15-0.2	0.05
304, 316	200HB	CP2630TN CP2430	100-150	fz=0.3-0.6 Ap=0.3-0.6	fz=0.3-0.7 Ap=0.3-0.6	0.08
Ti-alloy		CP2630TN CP2430	60-120	fz=0.3-0.5 Ap=0.3-0.5	fz=0.3-0.5 Ap=0.3-0.5	0.08
FC250, HT250	~200HB	CP6130MS CP2430	120-220	fz=0.5-1.5 Ap=0.5-1.0	fz=0.5-1.5 Ap=0.5-1.0	0.1
FCD400, QT300, 400, 500, 600	~200HB	CP6130MS CP2430	100-200	fz=0.5-1.5 Ap=0.5-0.8	fz=0.5-1.5 Ap=0.5-0.8	0.1

CP2430 Suitable For Dry Or Air-cooled Cutting



# Cutter tool EXN LNMU0303



Cutter Tool: SKD61 material, processed after heat treatment, good rigidity, strong seismic performance, high precision <0.03mm

Designation	Z	type	mm					MS2560	T8	LNMU0303
			D	d	L	L1 W	M			
EXN03R 16X16X90-2T	2	1	16	16	90	25	MS2560	T8	LNMU0303	
EXN03R 17X16X90-2T	2	1	17	16	90	-				
EXN03R 17.5X16X90-2T	2	1	17.5	16	90	-				
EXN03R 18X16X90-2T	2	1	18	16	90	-				
EXN03R 20X20X100-3T	3	1	20	20	100	30				
EXN03R 21X20X100-3T	3	1	21	20	100	-				
EXN03R 21.5X20X100-3T	3	1	21.5	20	100	-				
EXN03R 25X25X110-4T	3	1	25	25	110	40				
EXN03R 26X25X110-4T	4	1	26	25	110	40				
EXN03R 27.5X25X110-4T	4	1	27.5	25	110	40				
EXN03R 32X32X130-5T	5	1	32	32	130	50				
EXN03R 32X32X200-5T	5	1	32	32	200	50				
EXN03R 35X32X130-5T	5	1	35	32	130	50				
EXN03R 35X32X200-5T	5	1	35	32	200	50				
EXN03R 16-M8-2T	2	2	16	8.5	25	16.5	M8			
EXN03R 17-M8-2T	2	2	17	8.5	25	16.5	M8			
EXN03R 20-M10-3T	3	2	20	10.5	30	18.5	M10			
EXN03R 21-M10-3T	3	2	21	10.5	30	18.5	M10			
EXN03R 25-M12-4T	4	2	25	12.5	35	22.5	M12			
EXN03R 26-M12-4T	4	2	26	12.5	35	22.5	M12			
EXN03R 32-M16-5T	5	2	32	16.5	43	25	M16			
EXN03R 35-M16-5T	5	2	35	16.5	43	25	M16			
EXN03R 40X16X40-5T	5	3	40	16	40	10.4				
EXN03R 50X22X45-6T	6	3	50	22	45	10.4				
EXN03R 63X22X45-8T	8	3	63	22	45	10.4				