"Rough finishing"
Complete at once
F=1.5-2.5mm / rev
Ap max=4.0mm
Ra max=0.8um

01
CP1140FH
Good wear resistance

16 insert edges
The quantity is installed according to the power of the machine tool

Feed F=1.5-2.5mm

8 edges
Only need to clamp 1~3 pieces
Big round solitary trimming blade

02
CP2630TN
CC3130D
Sharp Edge

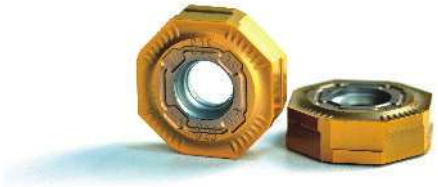
03
High stability

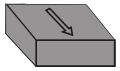
Efficient plane processing of cast iron and steel
Double-sided 16-edged iron cutting blade

ONHU0605ANTN-W (finishing) large round solitary trimming blade
ONMU0605ANTN (roughing of steel parts and cast iron)
ONMU0605ANFN (stainless steel and superalloy roughing)

ONMU06
ONHU06

Milling insert





High efficiency and high finish plane processing
The rough finishing is finished at one time
Feed per revolution: 1.5-2.5mm
Stainless steel and superalloy: Ap=0.2-0.4mm
Cast iron: Ap=0.5-1.0mm

Feature:

Strong blade, good wear resistance,
high stability, Apmax4.0mm, Roughness Ra min0. 6; ,
Performance exceed famous brand.

Application:

Preferred finish machining. Especially the
cast iron cylinder block Cylinder head processing.

		Re=0. 8	PVD Coating				parameters
			CP2640TN CP2650TN	CP6130MS	CP1140FH	CC3130D	Vc (mm/min)
Material group	P	Steel	✱	✱	✱		120-160-250
	P	P20,718,SKD11,S136H	✱	✱	✱		100-130-160
	P	HRC40-63 Steel			✱		50-80-120
	M	Stainless steel	✱	✱			60-110-150
	K	Cast iron	✱		✱	✱	150-180-220
	S	Titanium alloy		✱			40-60-80
	S	Heat-resisting stee	✱	✱			40-60-100

Type	purpose					Ap(mm)	f (mm/t)
ONMU0605ANSN strong	Cast iron, Steel	✱	✱		✱	0.1-3.8	0.1-0.50
ONMU0605ANFN sharp	Stainless steel Heat-resisting steel	✱	✱	✱			
ONHU0605ANR-W sharp	Special for finishing			✱			

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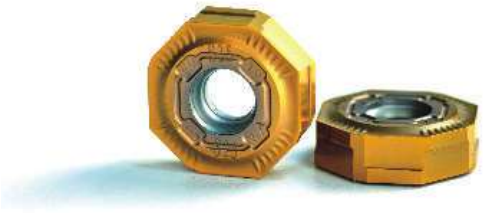


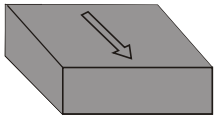
8 cutting edges on both sides

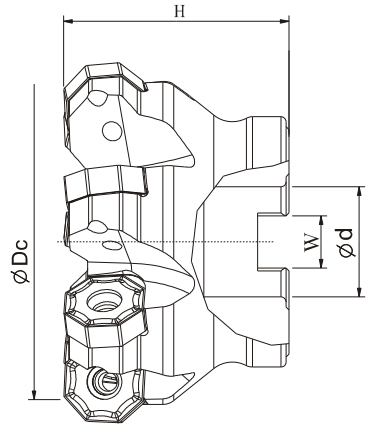
High-performance and efficient finishing
F=0.5-1.5mm
Ra min= 0. 6
High life span: twice the life span of similar products

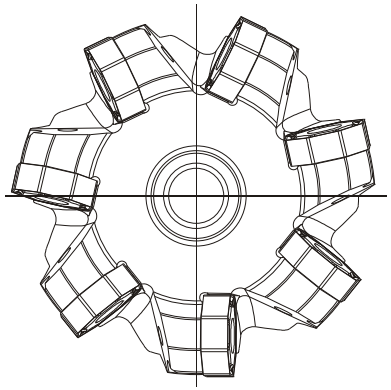
Ap max<4.0mm

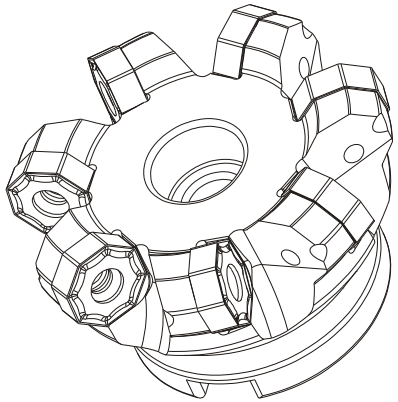
Material examples	Edge preparation	Hardness	Grade	Vc m/min	fz mm/t
345C, S50C	ANFN	~220HB	CP2650TN CP1140FH	100-250	1.0-2.0
20CrMoTi, 42CrMo	ANFN	~200HB	CP2650TN CP1140FH	100-200	1.0-2.0
S136H, NAK80, 4Cr13	ANFN	HRC30-45	CP2650TN CP1140FH	100-150	1.0-2.0
P20, 718, 738	ANFN	HRC28-32	CP2650TN CP1140FH	100-180	1.0-2.0
SKD61(H13), SKD11	ANFN	350HB	CP2650TN CP1140FH	100-150	1.0-2.0
FCD400, QT300, 400, 500, 600	ANSN	~200HB	CP2650TN CP1140FH	120-200	1.5-2.0
FC250, HT250	ANSN	~200HB	CP2640TN CC3130D CP1140FH	120-220	1.5-2.5
304, 316	ANFN		CP2650TN CP1140FH	100-180	1.0-2.0
1.4848 1.4837 1.4849 718	ANFN		CP2650TN CP1140FH	100-180	1.0-2.0

ONM(H)U0605 44°









type		Ap max	Z	type	Size mm				cooling			
					Dc	d	H	W				
Cutter head	50A04R-S44W-ON06	3.8	4	1	50	22	40	10.4		MS45120	T20	ONMU0605 + ONHU0605
	63A04R-S44W-ON06	3.8	4	1	63	22	50	10.4				
	80A06R-S44W-ON06	3.8	6	1	80	27	50	12.4				
	100A08R-S44W-ON06	3.8	8	1	100	32	50	14.4				
	125A10R-S44W-ON06	3.8	10	2	125	40	63	16.4				
	160A12R-S44W-ON06	3.8	12	2	160	40	63	16.4				
	200A14R-S44W-ON06	3.8	14	2	200	60	63	25.7				
	250A16R-S44W-ON06	3.8	16	2	250	60	63	25.7				
	315A18R-S44W-ON06	3.8	18	2	315	60	63	25.7				

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