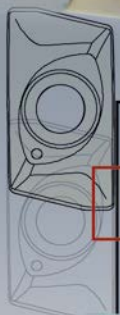


**Indexable**  
**Milling**  
+Modular Series

**AHU** High-Feed **Ultra** End Mill  
**AHUM** High-Feed **Ultra** End Mill Modular Type  
**AHUB** High-Feed **Ultra** Bore Type  
Ø 16 ~ Ø 63 · High Feed Cutting

Available Coatings:

- SD-DLC-Coating
- JS-Coating
- JM-Coating
- PTH-Coating
- TB-Coating
- JP-Coating



R 0.4  
R 0.8  
R 2.0

**FW Fine Wall Finishing**  
Improved wall surface accuracy



## Indexable Milling Tools

### AHUM | High-Feed Ultra End Mill Modular

#### AHU High Feed Ultra End Mill – Features

##### HIGH-FEED ULTRA END MILL

- 1 Main cutting forces are reduced by the unique high rake geometry
- 2 Ramp milling is possible
- 3 30% increased rigidity over conventional indexable end-mills due to the utilization of a special steel material and chip pocket geometry
- 4 Through tool coolant is available
- 5 New substrate and coating technology has been adopted which allows longer tool-life and the ability to use higher cutting speeds

##### HIGH-FEED ULTRA END MILL

- 1 Durch die einzigartige hochpositive Schneidengeometrie des AHU High Feed Ultra wird der Schnittdruck erheblich reduziert
- 2 Auch Fräsoperationen über Rampe sind möglich
- 3 Die Verwendung eines speziellen Stahls und einer neu entwickelten Spankammer-Geometrie erhöhte die Steifigkeit des AHU High Feed Ultra gegenüber konventionellen WSP-Haltern um 30%
- 4 Zusätzlich verfügt der AHU High Feed Ultra über innen liegende Kühlkanäle
- 5 Durch das neue Substrat der Wendeschneidplatten in Verbindung mit einer neuen Beschichtungstechnologie ermöglicht der AHU High Feed Ultra wesentlich höhere Schnittgeschwindigkeiten bei gleichzeitig längeren Standzeiten

##### HIGH-FEED ULTRA END MILL

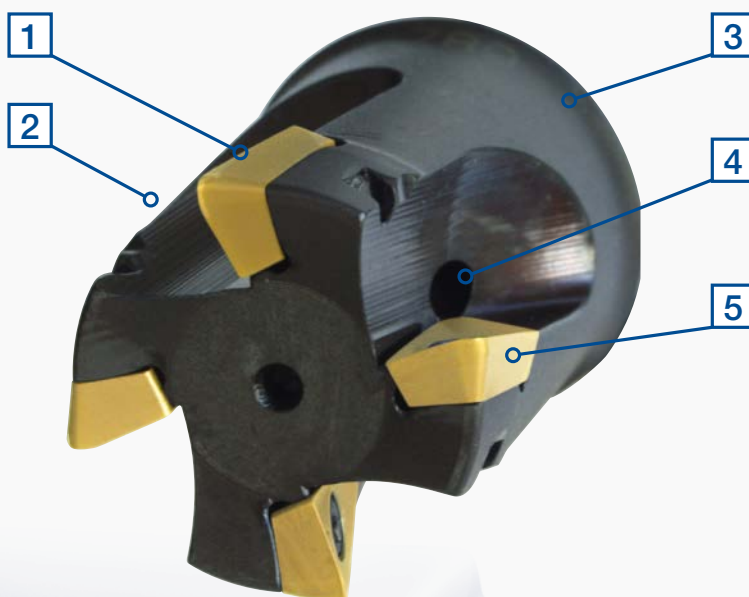
- 1 Maggiore stabilità e minori forze di taglio grazie alla nuova geometria positiva della spoglia.
- 2 La fresatura in rampa è possibile
- 3 30 % maggiore rigidità a confronto con frese convenzionali grazie alla particolare geometria del collo rompitrucolo e una microfusione di acciaio del corpo fresa.
- 4 Refrigerante attraverso il corpo fresa disponibile
- 5 La combinazione dello sviluppo di una micrograna particolare con l'ultimo sviluppo di rivestimenti rende possibile un grande allungamento di vita dell'utensile e l'utilizzo di velocità di taglio più elevate.

##### HIGH-FEED ULTRA END MILL

- 1 El esfuerzo de corte se reduce gracias a una exclusiva geometría altamente positiva.
- 2 Capaz de mecanizar en rampa
- 3 30% más de rigidez que herramientas de plaquita convencionales gracias a la utilización de un acero especial y a la geometría del canal de evacuación de viruta
- 4 Dispone de canal de refrigeración interior.
- 5 La combinación de substratos y recubrimientos de última tecnología permite una mayor vida de herramienta y la capacidad de usar velocidades de corte mayores

##### HIGH-FEED ULTRA END MILL

- 1 L'angle de dépouille très prononcé permet à lui seul de réduire la majeure partie des efforts de coupe.
- 2 L'usinage de rampes est possible (ramping).
- 3 Rigidité accrue de 30% par rapport aux fraises à plaquettes rapportées due à l'utilisation d'un acier spécial et à la forme des poches à copeaux.
- 4 Deux versions de corps sont disponibles : avec ou sans arrosage au centre.
- 5 Nous avons développés une nouvelle nuance et une nouvelle technologie de revêtement générant une durée de vie supérieure et une augmentation significative des vitesses de coupe.



#### AHU – Lineup & Content

Item	Type	D	Page
AHUM-1016R-2	High-Feed Ultra End Mill Modular	16	4
AHUM-1020R-3		20	
AHUM-1025R-4		25	
AHUM-1032R-5		32	
AHUB-1040RM-6		40	
AHUB-1050RM-7	High-Feed Ultra Bore Type	50	4
AHUB-1063RM-8	63		
AHU-1016R-2	High-Feed Ultra End Mill	16	
AHU-1020R-3		20	
AHU-1025R-4		25	
AHU-1032R-5		32	

Item	Type	D	Page
JDMT-1003-R04	Inserts	-	5
JDMT-1003-R04-FW			
JDMT-1003-R08			
JDMT-1003-R08-FW			
JDMT-1003-R20			
JDET-1003-R04-FA			
JDET-1003-R08-FA			
JDET-1003-R20-FA			
ASC			
AS	Steel Shanks for Modular Mills		



## Indexable Milling Tools

### AHU/AHUM/AHUB | High-Feed Ultra End Mill/Modular/Bore Type

#### AHU High Feed Ultra End Mill – New Insert Grades



##### TH (TiSiN) Nano PVD Coating

The new „Nano-composite“ coating material offers extraordinary heat resistance and hardness due to its new composite layer consisting of Nano-crystal material.

##### **TB (TiBoN) Hybrid Coating**

This new „Hybrid“ coating offers excellent lubrication under high temperature applications. It is the worlds first development to create this type of „Hybrid“ material

##### **JP4020 & JM4060 Coating**

Wider & thicker column morphology improves impact resistance. Higher adherence improves chipping and wear resistance. Substrate of JP4020 is micro grain for hardened material. Substrate of JM4060 is coarse grain for soft material.

##### **SD5010 Coating**

DLC coating grade for Aluminium, infinitely close to diamond. Low impurities coating provides stable tool life & high efficiency performance. New filtering technology enabled extremely smooth surface.

##### TH (TiSiN) Nano PVD-Beschichtung

Das neue „Nano-composite“-Beschichtungsmaterial, eine neuartige Misch-Beschichtung bestehend aus einem Nano-Kristall-Material, bietet eine bemerkenswert hohe Hitzebeständigkeit und Härte.

##### **TB (TiBoN) Hybrid-Beschichtung**

Diese neue, und bislang einmalige, „Hybrid“-Beschichtung bietet eine exzellente Schmierung bei Fräsoperationen mit hohen Temperaturen

##### **JP4020 & JM4060 Beschichtung**

Die breitere & dickere Säulenstruktur der Beschichtung erhöht die Schlagzähigkeit. Die erhöhte Haftfähigkeit verbessert die Resistenz gegenüber Absplittern und Verschleiß. Die JP4020 Feinstkorn-Beschichtung eignet sich für gehärtete Werkstoffe, die grobkörnigere JM4060 Beschichtung vor allem für weichere Materialien.

##### **SD5010 Beschichtung**

Diamant-ähnliche DLC-Beschichtung für die Bearbeitung von Aluminium. Die hohe Reinheit gewährleistet lange Werkzeuglebensdauer bei höchster Effizienz. Besonders glatte Oberfläche durch neuartige Filterungs-Technologie.

##### TH (TiSiN) Nano PVD Rivestimento

Il nuovo nano-rivestimento rende possibile una resistenza al calore e alla durezza straordinaria a causa di una nano-cristallo composizione dello strato.

##### **TB (TiBoN) Hybrid Rivestimento**

Il nuovo „Hybrid“-rivestimento rende possibile una lubrificazione straordinaria sotto temperature di taglio elevate. HITACHI TOOL ha sviluppato come prima azienda mondiale questo tipo di „Hybrid“-rivestimento (TiBoN).

##### **I gradi JP4020 e JM4060**

La morfologia colonnare più estesa e compatta migliora la resistenza all'impatto. Una maggiore aderenza migliora la resistenza all'usura ed alla scheggiatura. Il substrato del grado JP4020 è in micro grana per materiali temprati. Il substrato del grado JM4060 è a granulometria maggiorata per materiali più teneri.

##### **Grado SD5010**

Rivestimento DLC per Alluminio con caratteristiche similari al diamante. Il basso grado di impurità del rivestimento garantisce una durata tagliente stabile ed una efficiente performance. La nuova tecnologia di rivestimento permette una superficie tagliente estremamente liscia.

##### TH (TiSiN) Nano Recubrimiento PVD

El nuevo „Nano-Recubrimiento“ ofrece una extraordinaria dureza y resistencia al calor gracias a su composición basada en materiales Nano-Cristalinos.

##### **TB (TiBoN) Recubrimiento Híbrido**

Este nuevo recubrimiento „Híbrido“ ofrece una excelente lubricación en aplicaciones a altas temperaturas. Es el primer recubrimiento en el mundo que utiliza este tipo de material „Híbrido“

##### **Recubrimiento JP4020 & JM4060**

Su morfología de columna más amplia y gruesa mejora la resistencia al impacto. Una mayor adherencia incrementa la resistencia al mellado y al desgaste. El sustrato de la JP4020 es un micro-grano para materiales templados y el de la JP4060 es de grano grueso para materiales blandos.

##### **Recubrimiento SD5010**

El recubrimiento DLC para aluminio es infinitamente cercano al diamante. Su bajo contenido en impurezas proporciona a la herramienta estabilidad, duración y un rendimiento altamente eficaz.

La nueva tecnología de filtrado permite obtener una superficie extremadamente uniforme.

##### TH (TiSiN) Revêtement Nano PVD

Le nouveau revêtement „Nano-composite“ apporte une extraordinaire résistance en terme de dureté et de température grâce à sa structure Nano-cristalline.

##### **TB (TiBoN) Revêtement Hybride**

Ce nouveau revêtement „Hybride“ apporte un excellent coefficient de glissement lors d'opérations générant de hautes températures. Ce développement est une première mondiale, en effet, jusqu'à ce jours personne n'avait encore créé de matière « Hybride ».

##### **Revêtements JP4020 & JM4060**

La morphologie colonnaire plus épaisse et plus large améliore la résistance aux impactes. Une adhérence plus importante, améliorant les phénomènes d'écaillage et de résistance à l'usage. Le substrat du JP4020 est un substrat micro grain dédié aux aciers traités. Le substrat du JM4060 est un substrat avec une grosse granulométrie dédié aux matériaux tendres.

##### **Revêtement SD5010**

La nuance utilisée avec le revêtement DLC pour l'Aluminium, est infiniment proche du diamant. Le faible nombre d'impuretés apporte une durée de vie stable & de très hautes performances. Notre nouvelle technologie de filtrage permet une surface extrêmement homogène et lisse.

##### TH (TiSiN) Nano PVD Revestimento

O novo Nano- revestimento oferece uma extraordinária dureza e resistência ao calor devido a sua camada composta por materiais Nano-cristal.

##### **TB (TiBoN) Revestimento Híbrido**

Este novo revestimento „Híbrido“ oferece excelente lubrificação sob aplicações de alta temperatura é primeiro revestimento a ser criado no Mundo com este tipo de material „Híbrido“

##### **JP4020 & JM4060 Revestimento**

Estrutura maior & espessa melhora a resistência ao impacto. Maior aderência melhora a resistência à quebra e ao desgaste. Substrato do JP4020 é um micro grão para material mais duro. O substrato JM4060 é um grão mais tenaz para material macio.

##### **SD5010 Revestimento**

DLC grau de revestimento muito perto do diamante para o alumínio. Baixas impurezas no revestimento permitem ter uma vida da ferramenta estável e alta eficiência e desempenho. Nova Tecnologia de adesão permite ter uma superfície muito lisa.

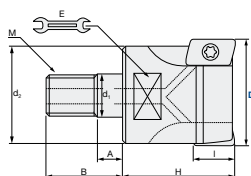
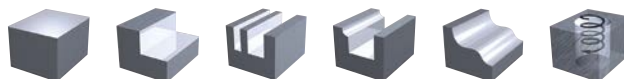
**Indexable Milling Tools**

**AHUM** | High-Feed Ultra End Mill Modular

**Q max**  
High Efficient

**▽**  
Roughing

**No. of Teeth**  
2-5



D	-0.05 / -0.2	Torque on screw: <b>1.3 Nm</b>
CR	+0.08 / -0.08	

Modular Type		Stock	Flutes	D	I	H	d <sub>1</sub>	M	d <sub>2</sub>	A	B	E	Inserts
FH 525	<b>AHUM-1016R-2</b>	■	2	16	9	25	8.5	M8	13	5.5	16	10	JDMT-1003-R../-FW JDET-1003-R../-FA
FH 526	<b>AHUM-1020R-3</b>		3	20		30	10.5	M10	18		18	15	
FH 527	<b>AHUM-1025R-4</b>		4	25		35	12.5	M12	21	20	17		
FH 528	<b>AHUM-1032R-5</b>		5	32		40	17	M16	29	6	22	22	

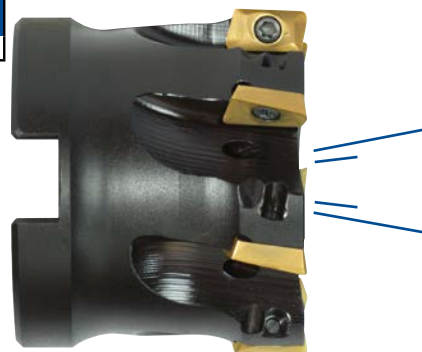
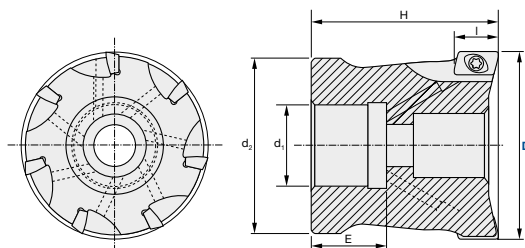
■ = Stock | Germany

**AHUB** | High-Feed Ultra Bore Type

**Q max**  
High Efficient

**▽**  
Roughing

**No. of Teeth**  
6-8



D	-0.05 / -0.2	Torque on screw: <b>1.3 Nm</b>
CR	+0.08 / -0.08	

Bore Type		Stock	Flutes	D	I	H	d <sub>1</sub>	d <sub>2</sub>	E	Inserts
FH 534	<b>AHUB-1040RM-6</b>	■	6	40	9	40	16	32	19	JDMT-1003-R../-FW JDET-1003-R../-FA
FH 535	<b>AHUB-1050RM-7</b>		7	50						
FH 536	<b>AHUB-1063RM-8</b>		8	63						

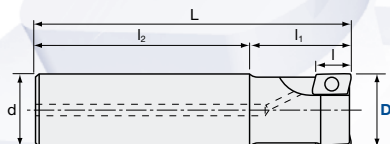
■ = Stock | Germany

**AHU** | High-Feed Ultra End Mill

**Q max**  
High Efficient

**▽**  
Roughing

**No. of Teeth**  
2-5



D	-0.05 / -0.2	Torque on screw: <b>1.3 Nm</b>
CR	+0.08 / -0.08	

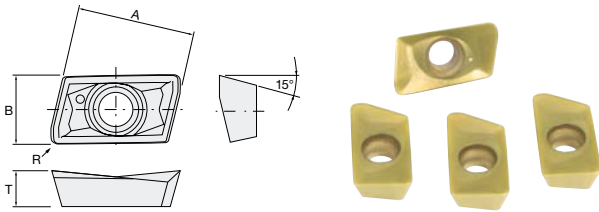
Shank Type		Stock	Flutes	D	I	l <sub>1</sub>	l <sub>2</sub>	L	d	Inserts
FH 506	<b>AHU-1016R-2</b>	■	2	16	9	30	70	100	16	JDMT-1003-R../-FW JDET-1003-R../-FA
FH 507	<b>AHU-1020R-3</b>		3	20			80	110	20	
FH 508	<b>AHU-1025R-4</b>		4	25		35	85	120	25	
FH 509	<b>AHU-1032R-5</b>		5	32		45		130	32	

■ = Stock | Germany

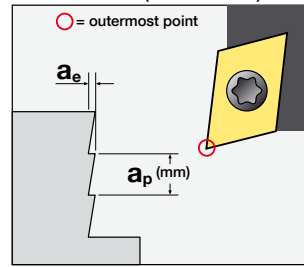
**ASC** | Carbide Shanks for Modular Mills & **AS** | Steel Shanks for Modular Mills: page 6

**Indexable Milling Tools**

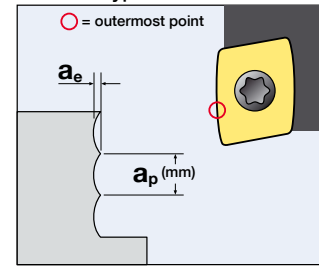
**INSERTS** | Improved cutting surface



Conventional (JDMT.....R)



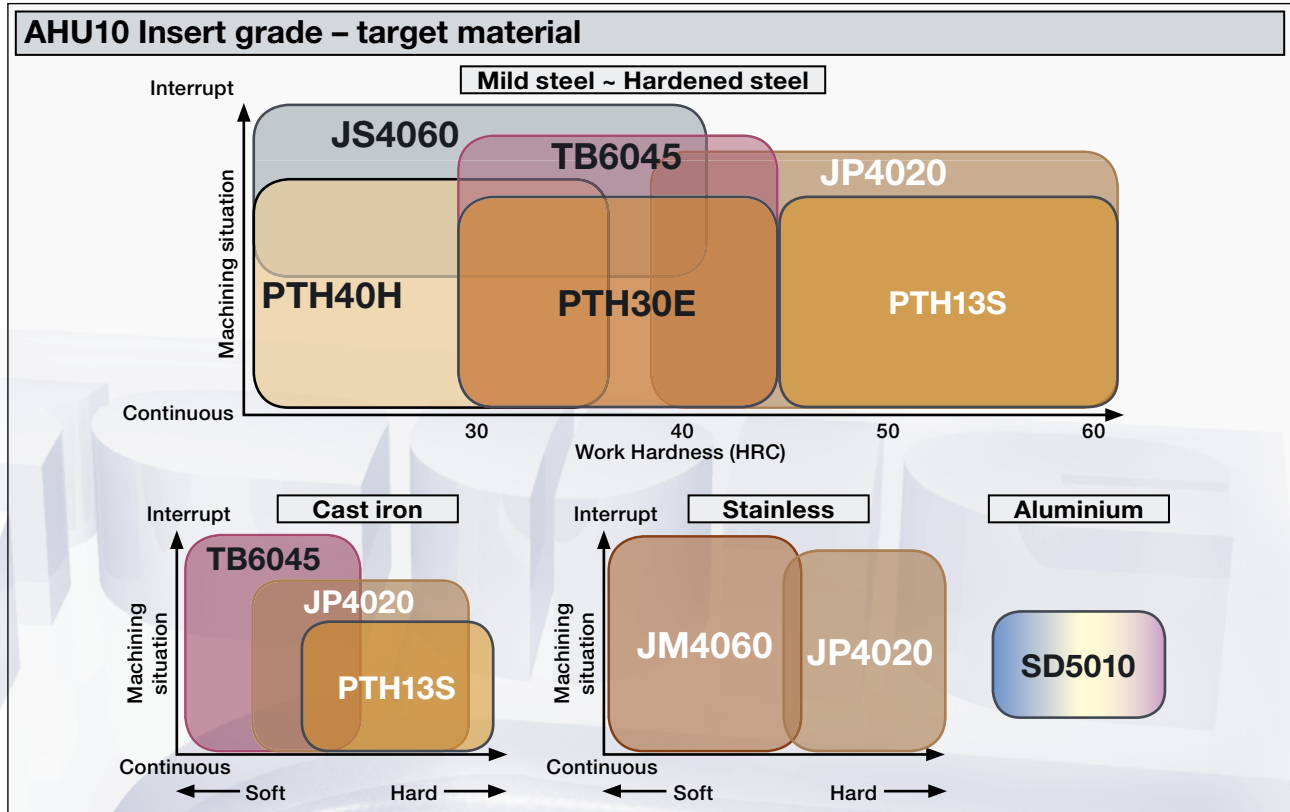
Fine Wall type **JDMT.....R-FW**



Item Code	Tolerance Class	Corner-R	Grade							Size			
			SD5010	JS4060	JM4060	PTH40H	PTH30E	TB6045	PTH13S	JP4020	A	B	T
JDMT-1003-R04	M	0.4					WF633	WF634	WF637		11	6.1	3.5
JDMT-1003-R04-FW		0.4-FW			WF696				WF695				
JDMT-1003-R08		0.8		WF701	WF702	WF636	WF631	WF635	WF638	WF700			
JDMT-1003-R08-FW		0.8-FW		WF698	WF699					WF697			
JDMT-1003-R20		2.0		WF704	WF705		WF632			WF703			
JDET-1003-R04-FA	E	0.4-FA	WF706										
JDET-1003-R08-FA		0.8-FA	WF707										
JDET-1003-R20-FA		2.0-FA	WF708										

SD5010: DLC coated grade for Aluminium

<b>SD5010</b>	PVD · For Aluminium
<b>JS4060</b>	PVD · For carbon steels < 35HRC
<b>JM4060</b>	PVD · For stainless steels & carbon steels < 35HRC
<b>PTH40H</b>	PVD · For carbon steels < 35HRC
<b>PTH30E</b>	PVD · General steels for 30–40 HRC
<b>TB6045</b>	PVD · General steels for 30–40 HRC / Recommended for dry cutting
<b>PTH13S</b>	PVD · For pre-hardened steels 40–55 HRC
<b>JP4020</b>	PVD · For pre-hardened steels 40–55 HRC

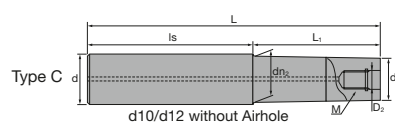
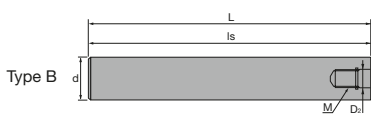
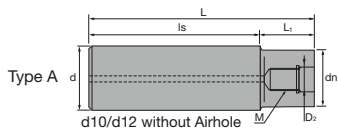


Clamp Screw		Wrench	
<b>ID Code</b>	<b>Item-Code</b>	<b>ID Code</b>	<b>Item-Code</b>
ET175	250-141	ET013	104-T8



## Indexable Milling Tools

### ASC | Carbide Shanks for Modular Mills

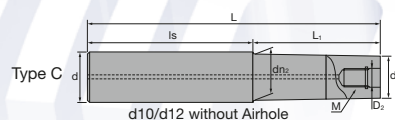
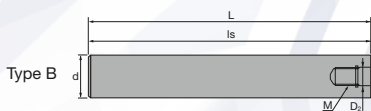
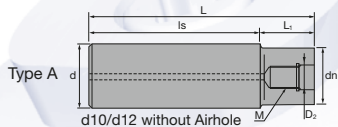


		Carbide Shank																	
		ID Code	Item Code	D <sub>2</sub>	M	L	L <sub>1</sub>	Is	dn	dn <sub>2</sub>	d	Type							
Without Airhole	FH137	ASC10-6.5-74-24	6.5	M6	74	24	50	9.3	-	10	10	A							
	FH254	ASC10-6.5-84-34											84	34					
	FH255	ASC10-6.5-114-24											114	24	90				
	FH138	ASC10-6.5-114-49												49	65				
	FH139	ASC12-6.5-74-24											74	24	50	11	11.5	12	C
	FH256	ASC12-6.5-94-44											94	44	50				
	FH257	ASC12-6.5-129-24											129	24	105				
	FH140	ASC12-6.5-129-64												64	65				
With Airhole	FH141	ASC16-8.5-95-30	8.5	M8	95	30	65	14.5	15.5	16	16	C							
	FH258	ASC16-8.5-120-55			120	55													
	FH142	ASC16-8.5-140-75			140	75													
	FH260	ASC16-8.5-160-30			160	30							130						
	FH259	ASC16-8.5-160-95			160	95							65						
	FH143	ASC20-10.5-120-50	10.5	M10	120	50	70	18	-	20	20	A							
	FH261	ASC20-10.5-170-90Z			170	90	80	18.5	19.5			C							
	FH144	ASC20-10.5-220-50			220	50	170	18	-			A							
	FH262	ASC20-10.5-220-120Z			220	120	100	18.5	19.5			20	C						
	FH263	ASC20-10.5-270-150Z			270	150	120												
	FH264	ASC20-10.5-270-50Z			270	50	220												
	FH145	ASC25-12.5-145-65			12.5	M12	145	65	80			23	-	25	25	A			
	FH146	ASC25-12.5-265-65	265	200															
	FH265	ASC25-12.5-215-115	215	115			100												
	FH266	ASC25-12.5-265-145	265	145			120												
	FH268	ASC25-12.5-315-65	315	65			250												
	FH267	ASC25-12.5-315-195	315	195			120												
	FH147	ASC32-17-160-80	17	M16	160	80	80	28	-	32	32	A							
	FH269	ASC32-17-260-140			260	140	120												
	FH148	ASC32-17-310-80			310	80	230												
FH270	ASC32-17-360-240	360			240	120													

- 🇬🇧 SUPER Lock milling chucks or shrink-fit holders can be used.
- 🇩🇪 SUPER Lock Aufnahmen oder Schrumpffutter können verwendet werden.
- 🇮🇹 Possono essere utilizzati mandrini a forte serraggio SUPER Lock.

- 🇪🇸 Aptos para amarrar en portapinzas SUPER Lock.
- 🇫🇷 Les attachements SUPER Lock peuvent être utilisés.
- 🇧🇷 Cones hidráulicos de grande aperto e aperto térmico podem ser usados.

### AS | Steel Shanks for Modular Mills









		Steel Shank														
		ID Code	Item Code	D <sub>2</sub>	M	L	L <sub>1</sub>	Is	dn	dn <sub>2</sub>	d	Type				
Without Airhole	FH131	AS10-6.5-74-0	6.5	M6	74	-	74	-	-	-	10	B				
	FH132	AS12-6.5-84-4			84	4	80	11	-	12	A					
With Airhole	FH133	AS16-8.5-95-15	8.5	M8	95	15	80	14.5	15.5	16	16	C				
	FH134	AS20-10.5-100-20	10.5	M10	100	20							18	-	20	A
	FH271	AS25-12.5-115-35	12.5	M12	115	35							23	23	25	
	FH272	AS32-17-110-30	17	M16	110	30							28	28	32	

- 🇬🇧 SUPER Lock milling chucks can be used.
- 🇩🇪 SUPER Lock Aufnahmen können verwendet werden.
- 🇮🇹 Possono essere utilizzati mandrini a forte serraggio SUPER Lock.

- 🇪🇸 Aptos para amarrar en portapinzas SUPER Lock.
- 🇫🇷 Les attachements SUPER Lock peuvent être utilisés.
- 🇧🇷 Cones hidráulicos de grande aperto e aperto térmico podem ser usados.

## Indexable Milling Tools

### AHUM | High-Feed Ultra End Mill Modular

-  For further information about Modular Chucks please see our brochure *Indexable Modular Series No. 328.2*
-  Weitere Informationen über Modulare Werkzeugaufnahmen finden Sie in unserem Prospekt *Indexable Modular Series No. 328.2*
-  Per maggiori informazioni riguardanti la gamma dei mandrini avvitabili consultate il catalogo *Indexable Modular Series No. 328.2*
-  Para obtener más información sobre conos modulares consulte nuestro folleto *Indexable Modular Series No. 328.2*
-  Pour de plus amples informations concernant les attachements modulaires, voyez SVP notre brochure *Indexable Modular Series No. 328.2*
-  Para mais informações sobre Conos Modulares consulte o nosso folheto *Indexable Modular Series No. 328.2*



### Ramping / Helical Milling



#### Ramping

Ramping is possible please use the following data for direct milling without pre-drilling any starter holes.

#### Fräsoptionen über Rampe

Für Fräsoptionen über Rampe nutzen Sie bitte die nachfolgend abgebildeten Schnittwerte für die direkte Bearbeitung ohne Startlochbohrung.

#### Lavorazioni in rampa

È possibile lavorare in rampa senza alcun preforo. Usate per questa lavorazione i seguenti dati.

#### Rampa

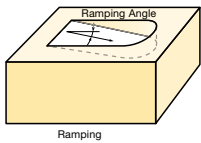
El mecanizado en rampa es posible. Por favor, utilizar las condiciones siguientes para mecanizado directo sin pretaladrado.

#### Usinage de rampes

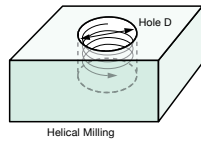
Cette application est possible, utilisez, les données suivantes pour un fraisage direct, sans avant trou.

#### Rampa

A fresagem em rampa é possível. Por favor utilizar as condições seguintes em maquinação directa sem pré-furo.



Ramping



Helical Milling

Tool Diameter D mm	D 16	D 20	D 25	D 32	D 40	D 50	D 63
Max Ramp Angle°	4°	3°	2.5°	2°	1.5°	1°	1°
Hole D (mm)	21~29	29~37	39~47	53~61	68~80	85~100	107~126



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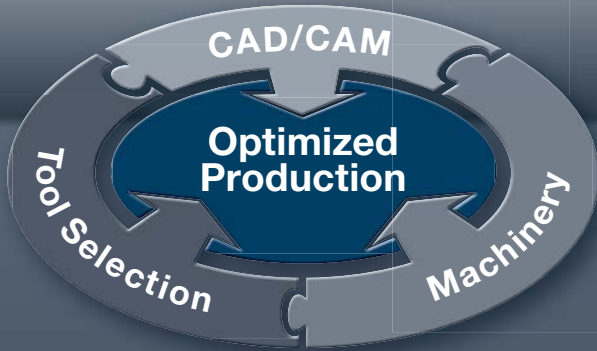
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**Filtering by contour shape**  
Gefiltert nach Bearbeitungs-Kontur

**Additional search parameters**  
Zusätzliche Parameter-Suche

ID code	Item code	Z	ØD	ØR	CR	In	s	l	Ødn	L	Ød	Grade	Inserts1	Inserts2	Inserts3
EP597	ETMP-4040-40-10	4	4		1	40	1	6		90	6				
EP370	ETM-4050-12	4	5		1.2	15		10		70	6				
EP598	ETMP-4050-30-12	4	5		1.2	30	1	7.5		90	6				
EP599	ETMP-4050-40-12	4	5		1.2	40	1	7.5		100	6				
EP600	ETMP-4050-50-12	4	5		1.2	50	1	7.5		110	6				
EP371	ETM-4050-15	4	6		1.5			12		90	6				
EP379	ETMLN-4060-30-15	4	6		1.5	30		9	5.7	75	6				
EP380	ETMLN-4060-42-15	4	6		1.5	42		9	5.7	90	6				
EP381	ETMLN-4060-54-15	4	6		1.5	54		9	5.7	100	6				
EP601	ETMP-4060-40-15	4	6		1.5	40	1	9		100	8				
EP602	ETMP-4060-55-15	4	6		1.5	55	1	9		110	8				
EP603	ETMP-4060-67-15	4	6		1.5	67	1	9		125	8				
EP372	ETMLN-4080-20	4	8		2			15		100	8				
EP382	ETMLN-4080-40-20	4	8		2	40		12	7.6	85	8				
EP383	ETMLN-4080-55-20	4	8		2	55		12	7.6	100	8				
EP384	ETMLN-4080-72-20	4	8		2	72		12	7.6	120	8				
EP373	ETM-4100-20	4	10		2			20		110	10				

**Selected product**  
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