

# ASRF/M Turbo<sup>4</sup> Mini

Super Radius Mill Four Corners  
for High Feed Milling · D 20-66

Available Coatings:

GX-Coating

JM-Coating

JS-Coating

JP-Coating

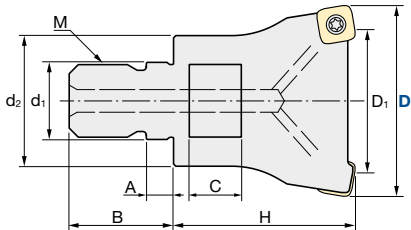
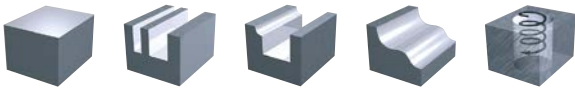
- **CAM Radius R2**
- **New Geometry:  
4 Cutting Edges  
per Insert**



**Indexable Milling Tools**

**ASRFM | Turbo4 - Mini | Modular Type**

<b>Q max</b> High Efficient	<b>Jet</b> Air Hole	<b>▽</b> Roughing	<b>▽▽</b> Semi-Finishing	<b>HRC</b> 60	<b>No. of Teeth</b> 2 - 5
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<b>Programming radius</b>	<b>2.0 mm</b>
Tolerance	D -0.1 ~ -0.2mm
Torque on screw	2.0 Nm
a <sub>p</sub> max	1.2 mm

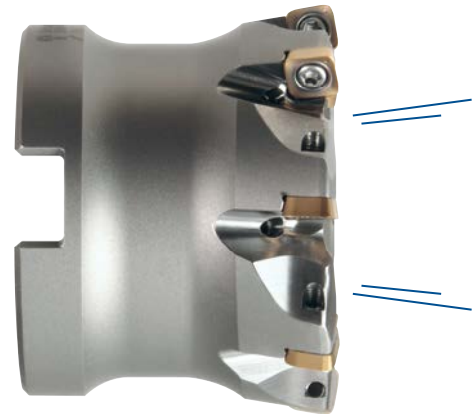
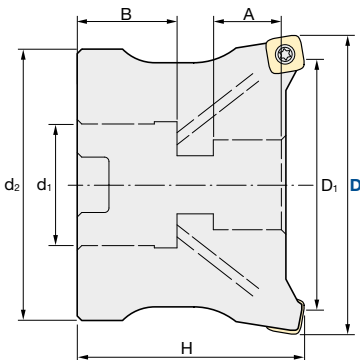
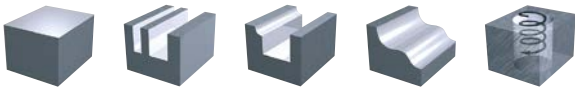
Modular Type												
ID Code	Item Code	Flutes	D	H	D <sub>1</sub>	d <sub>1</sub>	M	d <sub>2</sub>	A	B	Wrench	Inserts
FH552	<b>ASRFM-3020R-2-M10</b>	2	<b>20</b>	30	8	10.5	M10	17.8	5.5	19	15	SPNW07T2TR SPMT07T2TR SPMT07T2ER-LF
FH553	<b>ASRFM-3025R-3-M12</b>	3	<b>25</b>	35	13	12.5	M12	20.8	5.5	22	17	
FH554	<b>ASRFM-3032R-4-M16</b>	4	<b>32</b>	40	20	17	M16	28.8	6	23	22	
FH555	<b>ASRFM-3035R-4-M16</b>	4	<b>35</b>	40	23	17	M16	28.8	6	23	22	
FH556	<b>ASRFM-3040R-5-M16</b>	5	<b>40</b>	40	28	17	M16	28.8	6	23	22	
FH557	<b>ASRFM-3042R-5-M16</b>	5	<b>42</b>	40	30	17	M16	28.8	6	23	22	

↑ Wrench Size

[ASC | Carbide Shanks for Modular Mills & AS | Steel Shanks for Modular Mills: page 8](#)

**ASRFB | Turbo4 - Mini | Bore Type**

<b>Q max</b> High Efficient	<b>Jet</b> Air Hole	<b>▽</b> Roughing	<b>▽▽</b> Semi-Finishing	<b>HRC</b> 60	<b>No. of Teeth</b> 5 - 8
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<b>Programming radius</b>	<b>2.0 mm</b>
Tolerance	D -0.1 ~ -0.2mm
Torque on screw	2.0 Nm
a <sub>p</sub> max	1.2 mm

Bore Type										
ID Code	Item Code	Z	D	H	D <sub>1</sub>	d <sub>1</sub>	d <sub>2</sub>	A	B	Inserts
FH558	<b>ASRFB-3040RM-5-16</b>	5	<b>40</b>	40	28	16	35	10.54	19	SPNW07T2TR SPMT07T2TR SPMT07T2ER-LF
FH559	<b>ASRFB-3042RM-5-16</b>	5	<b>42</b>	40	30	16	35	10	19	
FH560	<b>ASRFB-3050RM-7-22</b>	7	<b>50</b>	50	38	22	40	17	20	
FH561	<b>ASRFB-3052RM-7-22</b>	7	<b>52</b>	50	40	22	40	17	20	
FH562	<b>ASRFB-3063RM-8-27</b>	8	<b>63</b>	50	51	27	60	16	22	
FH563	<b>ASRFB-3066RM-8-27</b>	8	<b>66</b>	50	54	27	60	16	22	

**Indexable Milling Tools**

**INSERTS ASRF | Turbo4 - Mini**

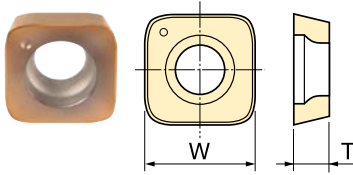


Fig.1 Standard type

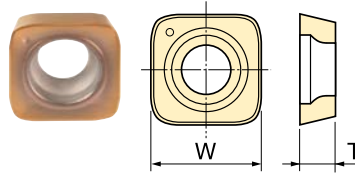


Fig.2 Low-resistance breaker type

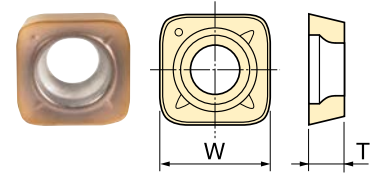
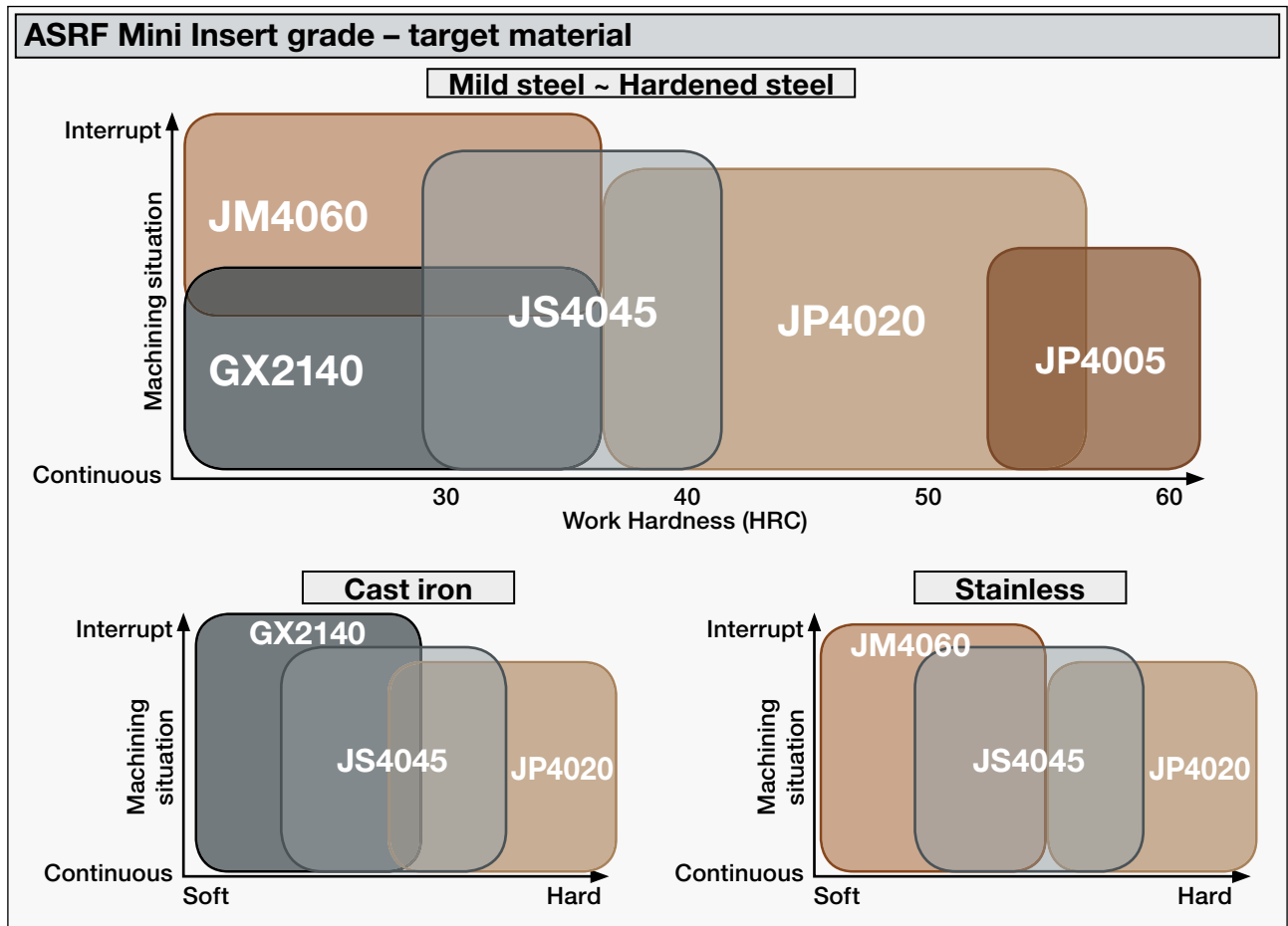


Fig.3 Low-Force type

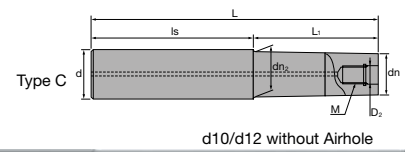
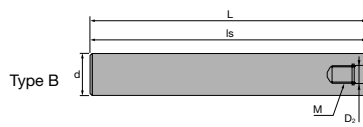
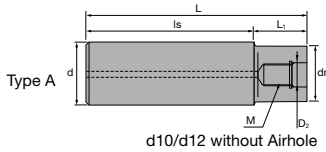
Inserts	Tolerance Class	Grade					Size (mm)			Shape
		GX2140	JM4060	JS4045	JP4020	JP4005	CAM R	W	T	
Item code		ID-Code								
SPNW07T2TR	M	WF716	WF717	WF715	WF714	WF713	2	7.94	2.78	Fig.1
SPMT07T2TR			WF720	WF719	WF718					Fig.2
SPMT07T2ER-LF			WF721							Fig.3

GX2140	CVD · For heavy roughing of mild steels   Recommended for dry cutting
JM4060	PVD · For stainless steels
JS4045	PVD · General grade for 30–40HRC   Recommended for dry cutting
JP4020	PVD · For pre-hardened steels 40–55HRC
JP4005	PVD · For hardened steels > 50HRC



Clamp Screw		Wrench	
ID-Code	Item-Code	ID-Code	Item-Code
ET176	265-143	ET011	104-T10





ASC | Carbide Shanks for Modular Mills



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

- UK SUPER Lock milling chucks or shrink-fit holders can be used.
- DE SUPER Lock Aufnahmen oder Schrumpffutter können verwendet werden.
- IT Possono essere utilizzati mandrini a forte serraggio SUPER Lock.

- ES Aptos para amarrar en portapinzas SUPER Lock.
- FR Les attachements SUPER Lock peuvent être utilisés.
- PT Cones hidráulicos de grande aperto e aperto térmico podem ser usados.

AS | Steel Shanks for Modular Mills



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

- UK SUPER Lock milling chucks can be used.
- DE SUPER Lock Aufnahmen können verwendet werden.
- IT Possono essere utilizzati mandrini a forte serraggio SUPER Lock.

- ES Aptos para amarrar en portapinzas SUPER Lock.
- FR Les attachements SUPER Lock peuvent être utilisés.
- PT Cones hidráulicos de grande aperto e aperto térmico podem ser usados.

UK For further information about modular chucks please see our brochure *Indexable Modular Series No. 328.2*  
DE Weitere Informationen über modulare Werkzeugaufnahmen finden Sie in unserem Prospekt: *Indexable Modular Series No. 328.2*  
ES Para obtener más información sobre conos modulares consulte nuestro folleto *Indexable Modular Series No. 328.2*  
IT Per maggiori informazioni riguardanti la gamma dei mandrini avvitalibili consultate il catalogo *Indexable Modular Series No. 328.2*

FR Pour de plus amples informations concernant les attachements modulaires, voyez SVP notre brochure *Indexable Modular Series No. 328.2*  
PT Para mais informações sobre Cones Modulares consulte o nosso folheto *Indexable Modular Series No. 328.2*

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