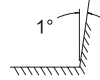


# 180 Series



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Specials

Inserts

General

Cavity Mold

Gray Iron

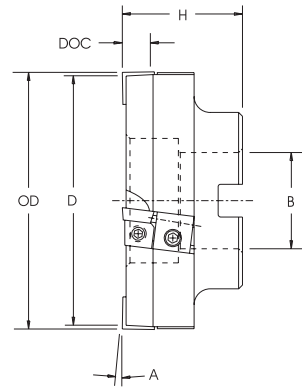
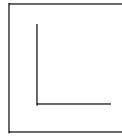
PCD / CBN

Slotters

Technical Data

HOLDERS

## Double Positive Geometry



7° Pos Axial  
Pos Radial  
1° Dish

• Face Mill

• Fine Pitch for finish machining with Maximum Feed Rates .020-.100 stock

### 180 Series Dimensional Specifications

Product Number	D	OD	A	B	H	DOC	Insert	Teeth	Weight
180F0300ASP4-100R	3.00	3.03	1°	1.00	1.875	.020-.100	SPC-43__	9	2.50
180F0400ASP4-150R	4.00	4.03	1°	1.50	1.875	.020-.100	SPC-43__	12	4.50
180F0500ASP4-150R	5.00	5.03	1°	1.50	1.875	.020-.100	SPC-43__	15	8.00
180F0600ASP4-200R	6.00	6.03	1°	2.00	1.875	.020-.100	SPC-43__	18	12.00

LEFT HAND cutters also available

Insert I.C. x Thickness							
	Insert Pg. 61	Insert Pg. 51	Lock	Lock Screw	Anvloc	Lock Screw	Lock Screw Wrench
.500 x .188	SPC-43__	0502-2802-0001	1313R	1319	1314R	#8-32 x 5/8 SHCS	1557-PT8

### Machining Parameters

Material	SFPM	FPT	Primary	Secondary
Gray Cast Iron G2500, G3000, G3500	800-4000*	.003-.025	SPC-433W820 GR LTC-1200	SPC-433W820 GR LTC-1000

\* 3600 SFPM MAX. unless extremely well guarded...

- Double positive geometry accommodates a broad range of workpiece materials
- Dense (fine) pitch insert count makes 180 ideal for all gray cast iron machining applications
- Adjustable self-locating anvocs provide quick and easy general purpose insert location
- Adjustable ANVOC anvils can fine tune axial runout to tenths (.0001") type tolerances

GAX