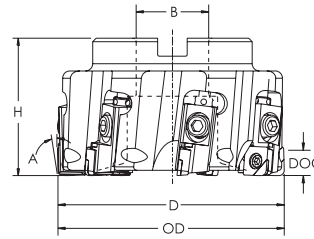
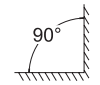
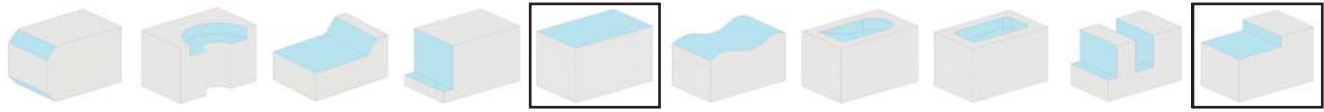


190 Series



7° Pos
Pos Radial
90° shoulder

- Uses PCD tipped inserts mounted in insert cartridges which allows for quicker setups
- Cutter bodies are made of high strength aluminum and coated for greater surface hardness

• Replaces CJA and 188 Series Tools

190 Series - Dimensional Specifications

Product Number	D O.S.C.	OD	B	H	A	Max DOC "B" Tip	Insert	# of Teeth	Weight / LBS	Max RPM
190F0300AFP4-100R	3.00	3.000	1.000	2.375	90°	.225	WFPCW-436R	5	< 2.0	14,200
190F0400AFP4-125R	4.00	4.000	1.250	2.375	90°	.225	WFPCW-436R	7	2.0	12,250
190F0500AFP4-150R	5.00	5.000	1.500	2.375	90°	.225	WFPCW-436R	8	3.0	11,000
190F0600AFP4-150R	6.00	6.000	1.500	2.375	90°	.225	WFPCW-436R	10	4.5	10,000
190F0800AFP4-UNVR	8.00	8.000	2.500	2.375	90°	.225	WFPCW-436R	10	6.5	8,600
190F1000AFP4-UNVR	10.00	10.000	2.500	2.375	90°	.225	WFPCW-436R	12	8.0	7,750

LEFT HAND cutters also available

Spare Parts

Insert I.C. x Thickness						
.500 x .188	Insert * Page 58	Insert Cartridge *	Adjusting Screw	SHCS -Cartridge	Insert Screw	Insert Screw Wrench
	WFPCW-43__R	3502-0914-0017	3602-0002-0004	1/4-28 x 5/8	3605-0001-0046	1557-TX15

* The 190 cutter body can accommodate a square insert, SPCW-43__, by changing the 3502-0914-0017 cartridge to a 3502-0914-0022 cartridge.

Note: This setup (change over) will not allow this tool to cut a 90° shoulder with the square insert.

PCD - Starting Parameters

Material	SFM Range	IPR Range	DOC Range
Aluminum Alloy - Silicon Aluminum	3,000 - 6,000	.006 - .012	.010 >
Brass - Bronze	1,500 - 3,000	.002 - .008	.005 >
Carbon	750 - 2,000	.004 - .008	.100 >
Copper - Copper Alloys	900 - 1,800	.004 - .008	.005 >
Fiberglass - Fiberglass Epoxy	1,500 - 3,000	.004 - .008	.010 >
Graphite - Graphite Composite	1,500 - 2,000	.004 - .008	.010 >
Phenolic Materials	1,500 - 3,000	.004 - .008	.010 >
Plastic	1,500 - 3,000	.008 - .012	.005 >
Tungsten Carbide (over 6% Cobalt)	45 - 150	.004 - .006	.002 - .010

Recommended Applications

Non-ferrous metals:

- aluminum alloys
- bronze, copper and brass alloys
- magnesium alloys

Abrasive non-metallic:

- carbon composites
- fiberglass and plastics
- graphic and carbon



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