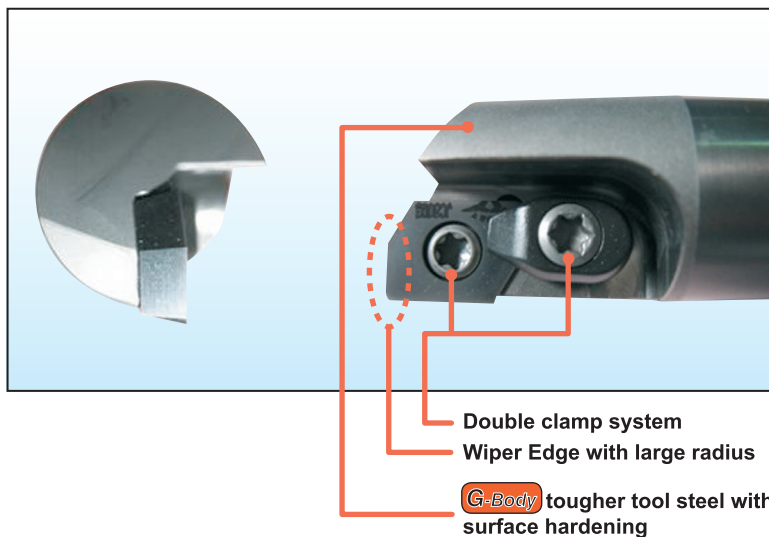


# Finish-One

## Finishing Indexable End Mill



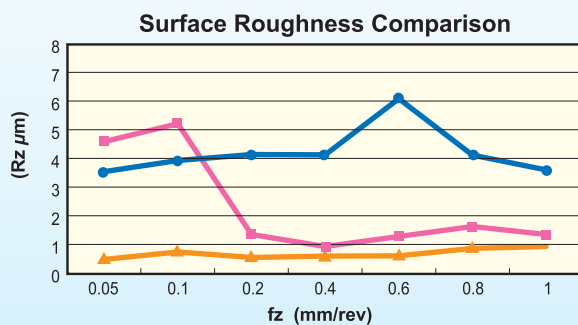
### Features:

- Can attain 1um or less surface finish on 2D work.
- Finish achieved using wiper edge with large radius.
- No tool deflection occurs due to single cutting edge design.
- Insert available in DV coated and cermet.

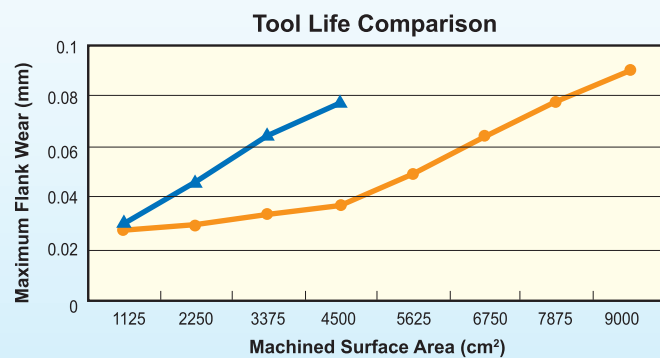
### PERFORMANCE RESULTS

**Material:** Carbon Steel (S50C)  
 (200-250HB)  
**Tool:** T-Fon-1200 (Ø20mm)  
**Insert:** LDGW120308

**Running Parameters:**  
 $n=4775 \text{ min}^{-1}$   
 $a_p=0.1\text{mm}$   
 $a_p=10\text{mm}$



● RNM-200-R10 JC8015  
 ■ T-FON-1200 JC8003  
 ▲ T-FON-1200 CX75

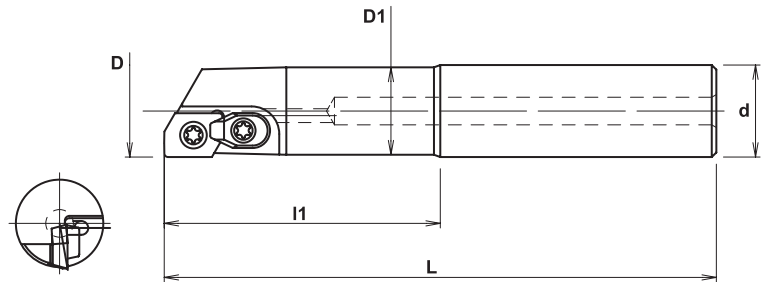


● T-FON-1200 CX75  
 ▲ RNM-200-R10 JC8015

# Finish-One Indexable End Mill

**METRIC**

## T-Fon type

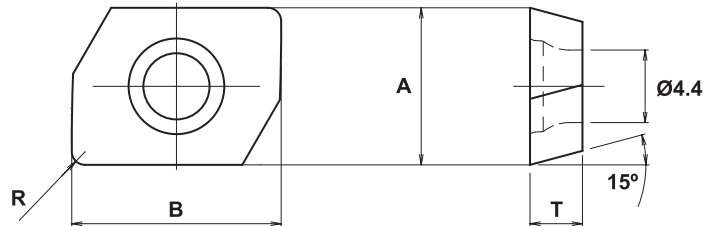
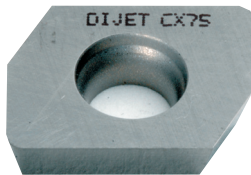


### Specifications

CATALOG NUMBER	STK	DIMENSIONS					INSERT	Q	PARTS		
		D	D1	L	I1	d			Screw	Wrench	Clamp
T-FON1160	•	16	15	110	60	16	LDGW120308	1	CSW-406H	T-15	DCM-18
T-FON1200	•	20	19	120	60	20	LDGW120308	1	CSW-408H	T-15	DCM-18

Note: All cutters are supplied without inserts.

### Inserts



### Specifications

CATALOG NUMBER	IC TOLERANCE	DIMENSIONS				PVD COATED	CERMET
		A	B	T	R	JC8003	CX75
LDGW120308	G	9.525	12.7	3.18	0.8	•	•

### Recommended Cutting Data

Work Materials	Insert Grade	Diameter							
		16				20			
		Vc (m/min)	fz (mm/rev)	ap (mm)	ae (mm)	Vc (m/min)	fz (mm/rev)	ap (mm)	ae (mm)
Carbon Steel (S50C, S55C) up to 250HB	CX75 JC8003	200~300	0.3~0.6	0.05~0.1	8~11	200~300	0.3~0.6	0.05~0.1	10~14
Cast Iron, Nodular Iron (FC, FCD) up to 300HB	JC8003	300~400	0.3~0.6	0.1~0.2	8~11	300~400	0.3~0.6	0.1~0.2	10~14

NOTE: 1. Continuous stroke processing is recommended to avoid vibration when tool is entering or exiting work material.  
 2. In case of chattering, coarse surface or steps, recommended to reduce cutting speed & maintain feed rate.  
 3. Figures should be adjusted according to the machine rigidity or work rigidity.