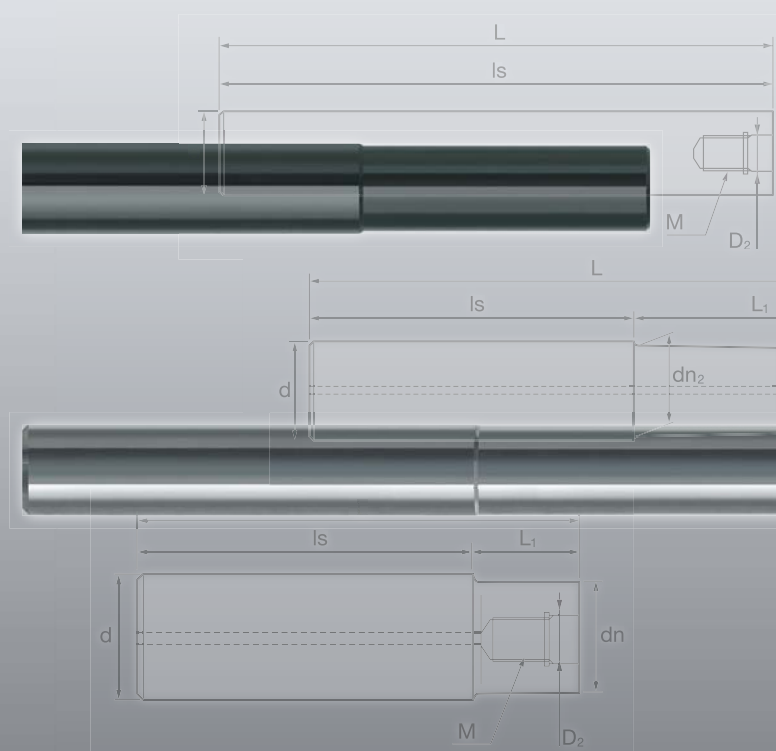


AS/ASC *Steel Shanks/Carbide Shanks* *For Modular Milling Tools*



AS Steel Shanks **for Modular Tools** **D8 mm - D32 mm**

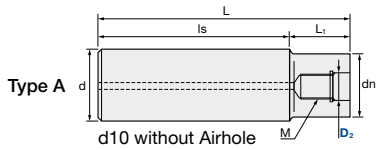
- M6 - M16
- Suitable for:
- **SUPER Lock Milling Chucks**

ASC Carbide Shanks **for Modular Types** **D8 mm - D40 mm**

- M6 - M16
- Suitable for:
- **SUPER Lock Milling Chucks**
- **Shrink-Fit Holders**



ASC | Carbide Shanks for Modular Mills

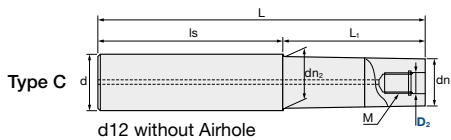


*ASC Carbide Shanks [mm]												
Fits Modular:	ID Code	Item Code	D ₂	M	L	L ₁	Is	dn	dn ₂	d	Type	Airhole
D8** D10** D12	FH137	ASC10-6.5-74-24	6.5	M6	74	24	50	9.3	–	10	A	No
	FH254	ASC10-6.5-84-34			84	34						
	FH255	ASC10-6.5-114-24			114	24	90					
	FH138	ASC10-6.5-114-49				49	65					
D25**	FH145	ASC25-12.5-145-65	12.5	M12	145	65	80	23	–	25	A	Yes
	FH265	ASC25-12.5-215-115			215	115	100					
	FH266	ASC25-12.5-265-145			265	145	120					
	FH267	ASC25-12.5-315-195			315	195						
	FH146	ASC25-12.5-265-65			265	65	200					
	FH268	ASC25-12.5-315-65			315		250					
D30** D32** D40***	FH147	ASC32-17-160-80	17	M16	160	80	80	28	–	32	A	Yes
	FH269	ASC32-17-260-140			260	140	120					
	FH270	ASC32-17-360-240			360	240						
	FH148	ASC32-17-310-80			310	80	230					

* ASC Carbide Shanks can be used with SUPER Lock Milling Chucks or Shrink-Fit Holders.

** Since the cutter diameter is below the shank diameter, interference occurs at the shank.

*** For D40 it is recommended that the protrusion length is 200mm or less.

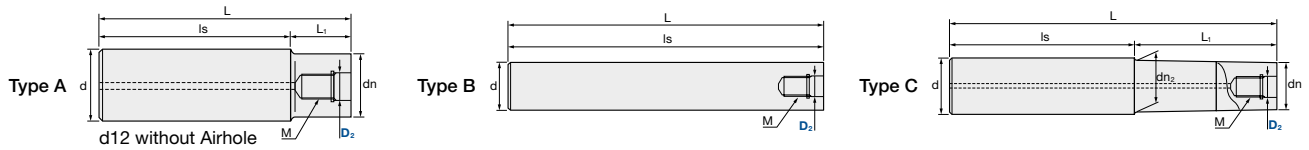


*ASC Carbide Shanks [mm]												
Fits Modular:	ID Code	Item Code	D ₂	M	L	L ₁	Is	dn	dn ₂	d	Type	Airhole
D8** D10** D12	FH139	ASC12-6.5-74-24	6.5	M6	74	24	50	11	11.5	12	C	No
	FH256	ASC12-6.5-94-44			94	44						
	FH257	ASC12-6.5-129-24			129	24	105					
	FH140	ASC12-6.5-129-64				64	65					
D16**	FH141	ASC16-8.5-95-30	8.5	M8	95	30	65	14.5	15.5	16	C	Yes
	FH258	ASC16-8.5-120-55			120	55						
	FH142	ASC16-8.5-140-75			140	75						
	FH259	ASC16-8.5-160-95			160	95						
	FH260	ASC16-8.5-160-30				30	130					
D20**	FH143	ASC20-10.5-120-50Z	10.5	M10	120	50	70	18.5	19.5	20	C	Yes
	FH261	ASC20-10.5-170-90Z			170	90	80					
	FH262	ASC20-10.5-220-120Z			220	120	100					
	FH263	ASC20-10.5-270-150Z			270	150	120					
	FH144	ASC20-10.5-220-50Z			220	50	170					
	FH264	ASC20-10.5-270-50Z			270		220					

* ASC Carbide Shanks can be used with SUPER Lock Milling Chucks or Shrink-Fit Holders.

** Since the cutter diameter is below the shank diameter, interference occurs at the shank.

AS | Steel Shanks for Modular Mills



*AS Steel Shanks [mm]													
Fits Modular:	ID Code	Item Code	D ₂	M	L	L ₁	ls	dn	dn ₂	d	Type	Airhole	
D 10	FH131	AS10-6.5-74-0	6.5	M6	74	–	74	–	–	10	B	No	
D 12	FH132	AS12-6.5-84-4	6.5	M6	84	4	80	11	–	12	A	No	
D 16	FH133	AS16-8.5-95-15	8.5	M8	95	15	80	14.5	15.5	16	C	Yes	
D 20	FH134	AS20-10.5-100-20	10.5	M10	100	20	80	18	–	20	A	Yes	
D 25	FH271	AS25-12.5-115-35	12.5	M12	115	35	80	23	–	25	A	Yes	
D 30 D 32	FH272	AS32-17-110-30	17	M16	110	30	80	28	–	32	A	Yes	

* AS Steel Shanks can be used with SUPER Lock milling chucks.

➔ For more information about Modular Tools and available Chucks please check our brochures:

Indexable Modular No. 328.x



Milling Chucks No. 709.x



Always up to date: Please check our P50 QuickFinder



Attentions on Safety

1. Cautions regarding handling

- (1) When removing the tool from its case (packaging), be careful that the tool does not pop out or is dropped. Be particularly careful regarding contact with the tool flutes.
- (2) When handling tools with sharp cutting flutes, be careful not to touch the cutting flutes directly with your bare hands.

2. Cautions regarding mounting

- (1) Before use, check the outside appearance of the tool for scratches, cracks, etc. and that it is firmly mounted in the collet chuck, etc.
- (2) When preparing for use, be sure that the inserts are firmly mounted in place and that they are firmly mounted on the arbor, etc.
- (3) If abnormal chattering, etc. occurs during use, stop the machine immediately and remove the cause of the chattering.

3. Cautions during use

- (1) Before use, confirm the dimensions and direction of rotation of the tool and milling work material.
- (2) The numerical values in the standard cutting conditions table should be used as criteria when starting new work. The cutting conditions should be adjusted as appropriate when the cutting depth is large, the rigidity of the machine being used is low, or according to the conditions of the work material.
- (3) Cutting tools are made of a hard material. During use, they may break and fly off. In addition, cutting chips may also fly off. Since there is a danger of injury to workers, fire, or eye damage from such flying pieces, a safety cover should be attached when work is performed and safety equipment such as safety goggles should be worn to create a safe environment for work.
- (4) There is a risk of fire or inflammation due to sparks, heat due to breakage, and cutting chips. Do not use where there is a risk of fire or explosion. Please caution of fire while using oil base coolant, fire prevention is necessary.
- (5) Do not use the tool for any purpose other than that for which it is intended.

4. Cautions regarding regrinding

- (1) If regrinding is not performed at the proper time, there is a risk of the tool breaking. Replace the tool with one in good condition, or perform regrinding.
- (2) Grinding dust will be created when regrinding a tool. When regrinding, be sure to attach a safety cover over the work area and wear safety clothes such as safety goggles, etc.
- (3) This product contains the specified chemical substance cobalt and its inorganic compounds. When performing regrinding or similar processing, be sure to handle the processing in accordance with the local laws and regulations regarding prevention of hazards due to specified chemical substances.

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Specifications for the products listed in this catalog are subject to change without notice due to replacement or modification.

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