

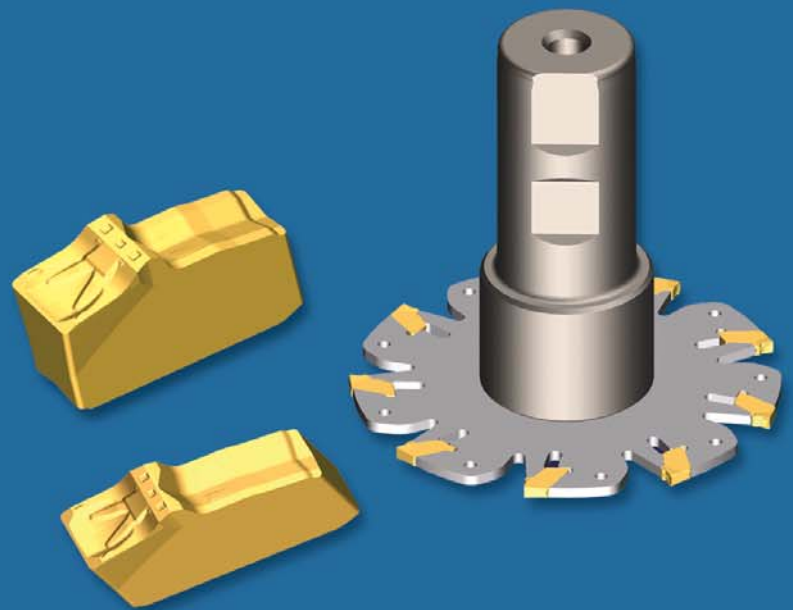
New

Slotting and Parting

Slitting Cutter

Features

- Optimal chip breaker design and N/L edge treatment make to increase cutting edge rigidity.
- Exact position of V-groove part enables to powerful clamping.
- Secure clamping system guarantees smooth cutting force with the positive geometry.
- Main application for slotting and parting off machining.

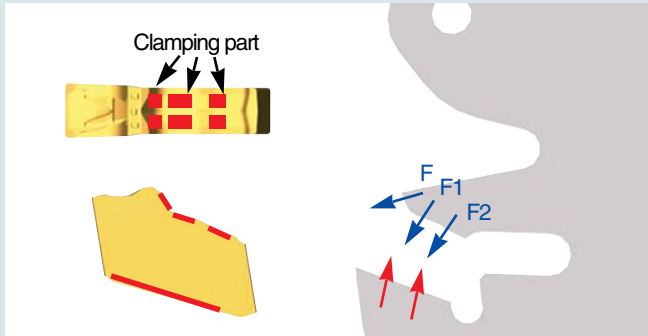




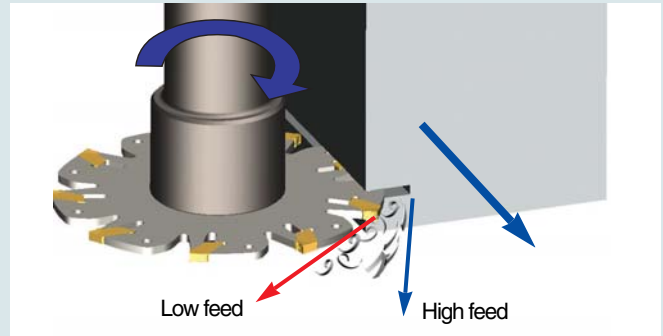
Slitting cutter

Clamping system | Chip control | Insert | Code system

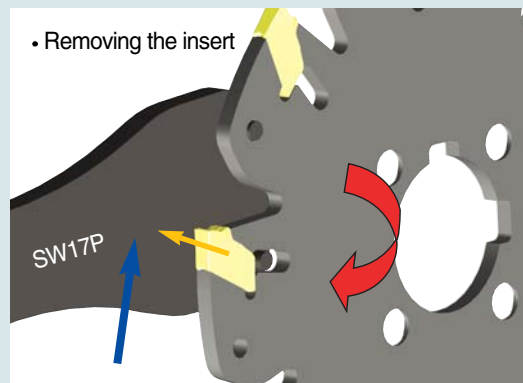
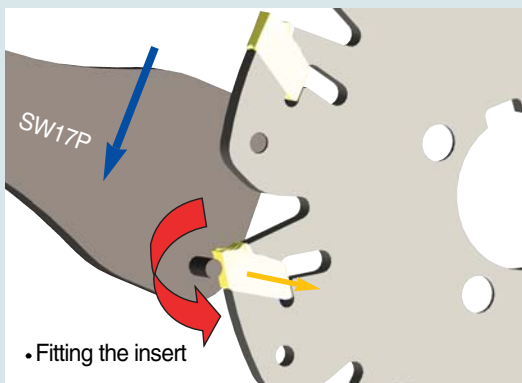
Clamping system



Chip control



The assembly of insert



Insert width	KEY
0.087 ~ 0.118	SW17P

Slitting cutter code system

SP	S	A	400	-	118
Using SP Insert	Slitting cutter Side cutter	Inch type	Cutter diameter(φ)		Insert width

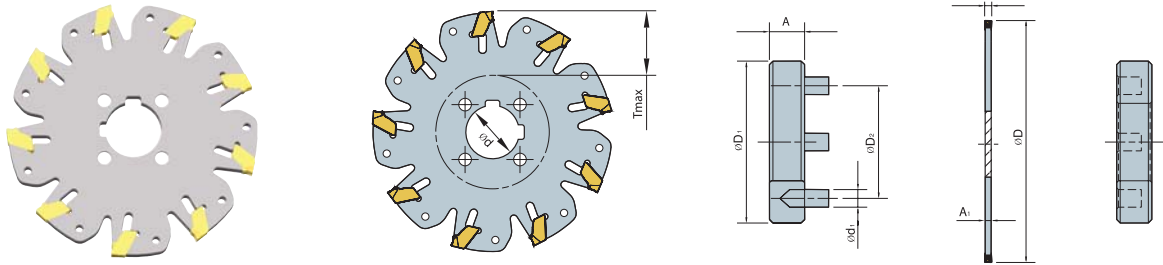
09	-	0875	R
Number of tooth		Arbor size(φ)	- R : Weldon Shank type - F : Drive Flange type - R/F : Interchangeably (WSA type/DFA type)



Slitting cutter

SPSA | WSA()-() | DFA()-()

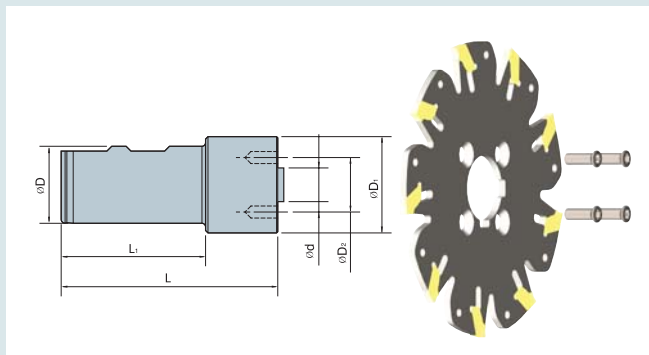
SPSA



Desingation	Stock		Dimensions(inch)									T max	Adaptor		Inserts
	R	L	øD	øD ₁	øD ₂	ød	ød ₁	W	A	A ₁	Tooth		WSA	DFA	
SPSA200-08704-0500R	○	○	2.0	1.102	0.709	0.500	-	0.087	-	0.071	4	0.449	✓	-	SPFN 200 - ()
SPSA250-08705-0500R	○	○	2.5	1.260	0.866	0.500	-		-		5	0.620	✓	-	
SPSA300-08707-0875R/F	○	○	3.0	1.575 /1.811	1.260	0.875	0.197		0.394		7	0.713 /0.594	✓	✓	
SPSA400-08709-0875R/F	○	○	4.0	1.575 /1.811	1.260	0.875	0.197		0.394		9	1.213 /1.094	✓	✓	
SPSA500-08711-1250F	○	○	5.0	2.165	1.772	1.250	0.236		0.394		11	1.417	-	✓	
SPSA600-08714-1250F	○	○	6.0	2.165	1.772	1.250	0.236		0.394		14	1.917	-	✓	
SPSA250-11805-0500R	○	○	2.5	1.260	0.866	0.500	-	0.118	-	0.100	5	0.620	✓	-	SPFN 300 - ()
SPSA300-11807-0875R/F	○	○	3.0	1.575 /1.811	1.260	0.875	0.197		0.394		7	0.713 /0.594	✓	✓	
SPSA400-11809-0875R/F	○	○	4.0	1.575 /1.811	1.260	0.875	0.197		0.394		9	1.213 /1.094	✓	✓	
SPSA500-11811-1250F	○	○	5.0	2.165	1.772	1.250	0.236		0.394		11	1.417	-	✓	
SPSA600-11814-1250F	○	○	6.0	2.165	1.772	1.250	0.236		0.394		14	1.917	-	✓	
SPSA800-11818-1500F	○	○	8.0	3.150	2.480	1.500	0.433		0.472		18	2.425	-	✓	

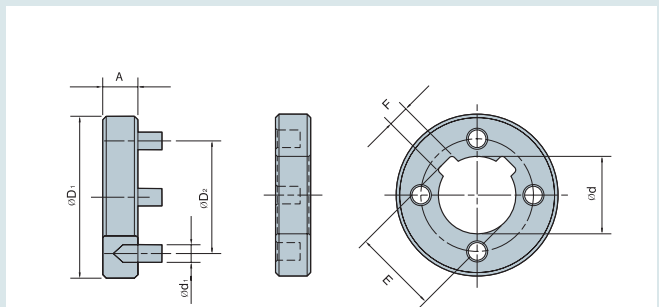
● Stock item, ○ Under preparing for stock

■ WSA()-() Weldon Shank type



Desingation	Stock		Dimensions(inch)						Screw
	R	L	L	L ₁	øD	øD ₁	øD ₂	ød	
WSA2528-M5	○		4.331	3.346	0.984	1.102	0.709	0.500	PTKA 0515
WSA2532-M5	○		4.331	3.346	0.984	1.260	0.866	0.500	
WSA3240-M5	○		4.724	3.543	1.260	1.575	1.260	0.875	

■ DFA()-() Drive Flange set



Desingation	Stock		Dimensions(inch)						
	R	L	øD ₁	øD ₂	ød	ød ₁	A	E	F
DFA22-46	○		1.811	1.260	0.875	0.197	0.394	0.948	0.125
DFA32-55	○		2.165	1.772	1.250	0.236	0.394	1.385	0.313
DFA40-80	○		3.150	2.480	1.500	0.433	0.472	1.666	0.375
DFA50-110	○		4.331	3.150	2.000	0.551	0.551	2.198	0.500

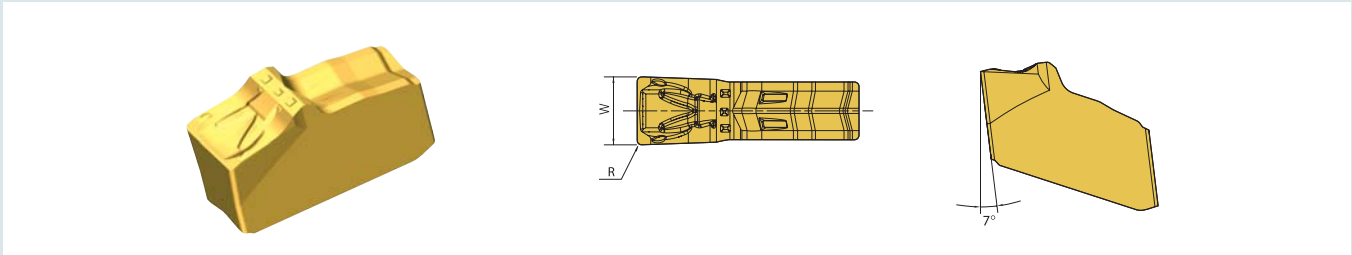
● Stock item, ○ Under preparing for stock



Slitting cutter

SPFN insert | Recommended cutting condition | Correction factor

SPFN insert



Desigation	Dimensions (inch)		Grade						
			PVD				CVD		Uncoated
	W	R	PC3525	PC3535	PC9530	PC215K	NCM325	NCM335	ST30A
SPFN200-N	0.087	0.008	○	○	○	○	○	○	○
SPFN300-N	0.118	0.008	○	○	○	○	○	○	○

● Stock item, ○ Under preparing for stock

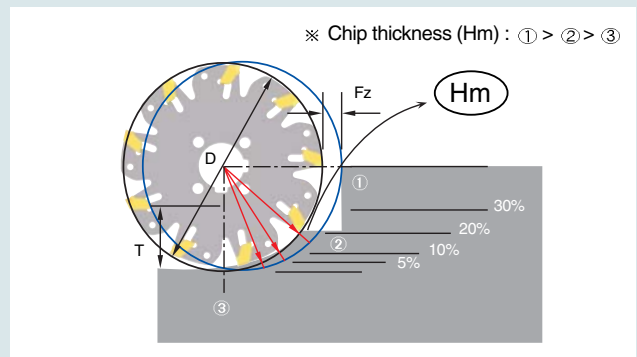
Recommended cutting condition

※ T/D = 10% (T: cutting depth)

Workpiece		Hardness	Grade	vc(sfm)	fz(ipt)
P	Low carbon steel / Alloy steel	≤ 180HB	PC3525	690 (560 ~ 820)	0.005 ~ 0.120
	High carbon steel / Alloy steel	180 ~ 260HB	PC3525	490 (560 ~ 660)	0.005 ~ 0.010
	High alloy steel	260 ~ 350HB	PC3525	390 (260 ~ 560)	0.004 ~ 0.007
M	Stainless steel	150 ~ 300HB	PC9530	360 (230 ~ 490)	0.004 ~ 0.009
K	Cast iron	T/S ≤ 350 N/mm ²	PC215K	110 (70 ~ 150)	0.004 ~ 0.010

Correction factor of fz(ipt) as cutting depth

Machining	T/D (%)	Factor	fz (ipt)	
	50 ~ 100	Standard = 1.0	0.003	0.006
	2.5	3.7	0.010	0.022
	5	2.5	0.007	0.015
	10	1.8	0.005	0.011
	15	1.5	0.004	0.009
	20	1.3	0.004	0.008
	25	1.2	0.003	0.007



• Correction factor by T/D(%): The value of chip thickness rate as feed (fz)