
LSE445

GENERAL FACE MILLING SERIES WITH 20° POSITIVE
INSERTS FOR RELIABLE AND EFFICIENT MACHINING



*M*plus...

LSE445

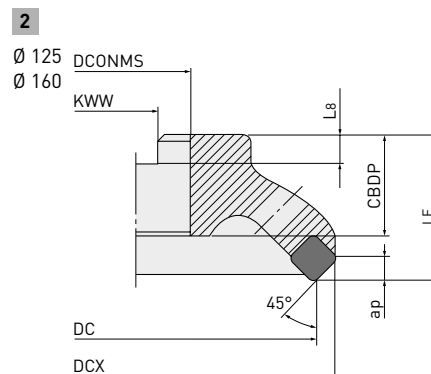
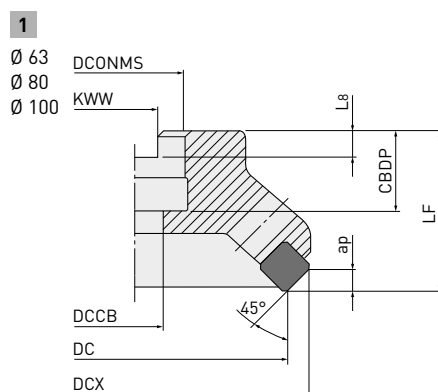


45° FACE MILLING GENERAL CUTTING

P M K N



C H: 45°
A.R: +19° T: +13°
RR: -2° I: +15°



ARBOR TYPE

Order number	Stock		ZEFP	DC	DCX	LF	DCONMS	CBDP	DCCB	KWW	L8	WT	APMX	Type	
	R	L													
LSE445-063A05R/L-E	●	□	5	63	76.5	40	22	20	11	10.4	6.4	0.8	5.5	—	1
LSE445-080A06R/L-E	●	□	6	80	93.5	50	27	22	13.5	12.4	7.0	1.0	5.5	—	1
LSE445-100A07R/L-E	●	□	7	100	113.5	50	32	25	17.5	14.4	8.0	1.4	5.5	—	1
LSE445-125B09R/L-E	□	□	9	125	138.5	50	40	32	—	16.4	9.0	2.0	5.5	—	2
LSE445-160B11R/L-E	□	□	11	160	173.5	50	40	32	—	16.4	9.0	3.0	5.5	—	2

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SPARE PARTS

Tool holder number	*1					
	Shim	Shim screw	Wedge	Clamp screw	Wrench	Wrench
LSE445 -063A05R/L-E				LS10T		
LSE445 -080A04R/L-E						
LSE445-100A07R/L-E	STBE445NF	CS300890T	CWSE445TR	LS15T	TKY25T	TKY08F
LSE445-125B09R/L-E						
LSE445 -160B11R/L-E						

*1 Clamp Torque (N • m) : LS10T= 8.5. LS15T= 8.5. CS300890T= 1.0

LSE445 – INSERTS

P	Steel	●	●		●	●	●							Cutting conditions: ●: Stable cutting ●: General cutting ✖: Unstable cutting
M	Stainless steel	●	●		●	●	●							
K	Cast iron				●	✖	●							Honing: ●: Round F: Sharp S: Chamfer +hone T: Chamfer Z: Strong
N	Non-ferrous metal													

Order number	Class	Honing	F7010	F7030	MC5020	VP15TF	NX2525	NX4545	UT120T	HTi10	IC	S	BS	RE	Shape
SEEN1203AFFN1	E	F								●	12.7	3.18	1.4	1.0	
SEEN1203AFEN1	E	E				●					12.7	3.18	1.4	1.0	
SEEN1203AFTN1	E	T	●				●		●		12.7	3.18	1.4	1.0	
SEEN1203AFTN3	E	T	●					●	★		12.7	3.18	1.4	—	
SEEN1203AFSN1	E	S	●	●							12.7	3.18	1.4	1.0	
SEEN1203AFSN3	E	S	●								12.7	3.18	1.4	—	
SEEN1203AFZN1	E	Z					●				12.7	3.18	1.4	1.0	

Inserts with breaker

SEER1203AFEN-JS	E	E	●	●	●	●					12.7	3.18	1.4	1.0	
SEER1204AFEN-JS	E	E	●								12.7	3.18	1.4	1.0	

Wiper inserts

WEC42AFTR5C	C	T					●				—	3.18	5	1.0	
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LSE445

RECOMMENDED CUTTING CONDITIONS

Material	Hardness	Grade	Vc	fz
P Mild steel	<180HB	F7030	300 (200 – 360)	0.2 (0.1 – 0.3)
		NX4545		
		UTi20T	240 (170 – 300)	
		UP20M		
Carbon steel Alloy steel	180 – 280HB	F7030	250 (170 – 300)	0.2 (0.1 – 0.3)
		NX4545		
		UTi20T	200 (140 – 240)	
		UP20M		
M Stainless steel	<200HB	UTi20T	140 (100 – 170)	0.15 (0.1 – 0.2)
		UP20M		
K Cast iron	Tensile Strength <450MPa	MC5020	200 (130 – 240)	0.2 (0.1 – 0.3)
		F5010		
		F5020	160 (110 – 190)	
		UTi20T		
N Aluminium alloy	—	MD220	1000 (200 – 1500)	0.15 (0.05 – 0.25)
		HTi10	1000 (700 – 1200)	0.12 (0.05 – 0.2)

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1. Revolution (min^{-1}) = $(1000 \times \text{Cutting speed}) \div (3.14 \times \text{ØD1})$.
2. Table feed (mm/min) = Feed per tooth \times Number of teeth \times Cutter revolution.





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