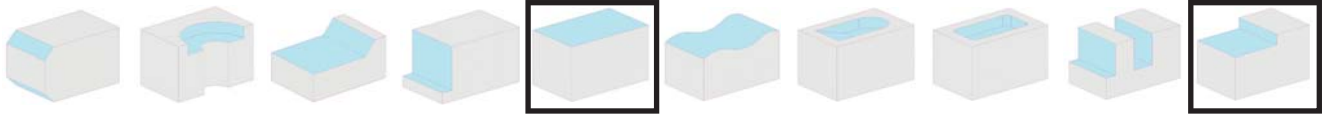
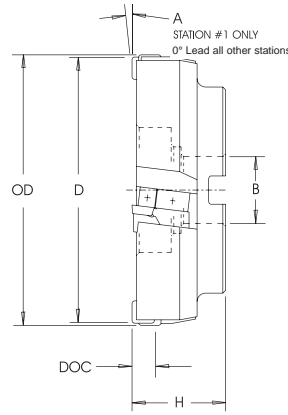
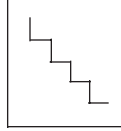


# SX Series



## Free Cutting Geometry



7° Pos Axial  
Pos Radial  
1° Dish (Sta. 1)

• Stepped Face Mill

• Rough & Finish in one pass .150-.250 stock

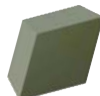







## SX Series Dimensional Specifications

Product Number	D	OD	A	B	H	DOC	Insert	Inserts per Set	Effective Sets	Teeth	Weight
3SX23R4	2.96	3.00	1°	1.00	2.10	.150-.250	SPC-43__	3	2	6	3.75
4SX24R6	3.94	4.00	1°	1.50	2.10	.150-.250	SPC-43__	4	2	8	6.25
5SX25R6	4.92	5.00	1°	1.50	2.10	.150-.250	SPC-43__	5	2	10	10.50
6SX26R6	5.90	6.00	1°	1.50	2.10	.150-.250	SPC-43__	6	2	12	15.75
8SX35R8	7.92	8.00	1°	2.00	2.10	.150-.250	SPC-43__	5	3	15	28.00
8SX44R8	7.94	8.00	1°	2.00	2.10	.150-.250	SPC-43__	4	4	16	28.00

LEFT HAND cutters also available

## SX Series Setting Specifications for Stepped Configuration Tooling

Tool	Station 1 (H)	Station 2 (H)	Station 3 (H)	Station 4 (H)	Station 5 (H)	Station 6 (H)
3SX23R4	2.100	2.080	2.030	N/A	N/A	N/A
4SX24R6	2.100	2.085	2.030	1.970	N/A	N/A
5SX25R6	2.100	2.085	2.035	1.990	1.945	N/A
6SX26R6	2.100	2.085	2.055	2.020	1.985	1.950
8SX35R8	2.100	2.085	2.035	1.990	1.945	N/A
8SX44R8	2.100	2.085	2.030	1.970	N/A	N/A

Insert I.C. x Thickness	 Insert Pg. 61	 Insert Pg. 51	 Anvil	 Insert Lock	 Lock Screw	 Anvil Lock	 Lock Screw	 Lock Screw Wrench
.500 x .188	SPC-43__	0502-2802-0001	1357RA	3502-0933-0031 RH 3502-0933-0032 LH	1573	1571	#10-32 x 5/8 BHCS	1557-PT8

## Machining Parameters

Material	SFPM	FPT	Primary	Secondary
Gray Cast Iron G2500, G3000 and G3500	800-4000*	.003-.025	SPC-433W630 GR LTC-1200	SPC-433W630 GR LTC-1000

\* 3600 SFPM MAX. unless really well guarded...

- Free cutting positive geometry is ideally suited for all gray cast iron materials
- Stepdex configuration generates metal removal rates up to 2 inch<sup>3</sup> per minute per unit of horsepower
- Stepdex provides excellent force and load management during overextended or weak setups
- Self-locating precision anvils ensure quick accurate indexes and little down time
- LOVEJOY S LTC-1200 Si<sub>3</sub>N<sub>4</sub> material operates in the advanced range machining parameters

