



VCGT - K92°

diam. 32 - 125 mm | r3

These milling cutters are especially suitable for milling aluminium, copper, plastics and graphite. It allows very easy cutting and very high cutting speeds and feed rates.
Only for roughing and pre-finishing operations!

Milling cutter bodies

Milling cutter bodies	Catalogue no.	Dimensions									Accessories	Features
		d ₁	l	r	l ₃	l ₂	l ₁	d ₂	d ₃	z		

Threaded shank end mill bodies

Threaded shank end mill bodies	Catalogue no.	Dimensions									Accessories	Features
		d ₁	l	r	l ₃	l ₂	l ₁	d ₂	d ₃	z		
	32 260	32	16	3	48	9.5	-	M 16	29	2	A, C, D, E, F	☑
	42 260	42	16	3	48	9.5	-	M 16	29	3	A, C, D, E, F	☑

Shell type milling cutter bodies

Shell type milling cutter bodies	Catalogue no.	Dimensions									Accessories	Features
		d ₁	l	r	l ₃	l ₂	l ₁	d ₂	d ₃	z		
	42 360	42	16	3	57	9.5	-	diam. 16	35	3	A, B, C, D, E, F	☑
	52 360	52	16	3	57	9.5	-	diam. 22	40	3	A, C, D, E, F	☑
	66 360	66	16	3	57	9.5	-	diam. 27	48	4	A, C, D, E, F	☑
	80 360	80	16	3	57	9.5	-	diam. 27	60	5	A, C, D, E, F	☑
	100 360	100	16	3	57	9.5	-	diam. 32	70	6	A, C, D, E, F	☑
	125 360	125	16	3	57	9.5	-	diam. 40	90	7	A, C, D, E, F	☑

Accessories

<p>45 500 Torx screw A > Page 195</p>	<p>GWSTPS81SK hexagon socket set screw B > Page 196</p>	<p>POKOLM 20 500 Torx-screwdriver C > Page 196</p>	<p>TV 2-8 Screwdriver torque Vario®-S with window scale, D > Page 197</p>	<p>T20 500 Torx interchangeable bit for Torque Vario® E > Page 197</p>	<p>T20 502, Torx Magic-Spring compatible bit f. Torque Vario® F > Page 198</p>
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Indexable inserts

Indexable inserts	Catalogue no.	DIN Specification	Carbide Grade	Coating	Dimensions			
					l	s	r	M
	05 22 820	VCGT 220530 FN	K10	polished	16	5.56	3	M 4.5
	05 22 860	VCGT 220530 FN	K10	PVTi	16	5.56	3	M 4.5
	05 22 860 D	VCGT 220530 FN	K10	PVDiaN	16	5.56	3	M 4.5

Feed per tooth (fz) | d.o.c. (ap)

Material		steel	stainless steel	cast iron	non-ferrous materials	high-temperature alloys	hardened steel
Quality Coating	Feed per tooth d.o.c.						
K10 polished	f _z (mm) a _p (mm)	-	-	-	0,1-0,6 0,1-7	-	-
K10 PVTi	f _z (mm) a _p (mm)	-	-	-	0,1-0,6 0,1-7	-	-
K10 PVDiaN	f _z (mm) a _p (mm)	-	-	-	0,1-0,6 0,1-7	-	-

Cutting speed (Vc in m/min)

Material		steel	stainless steel	cast iron	non-ferrous materials	high-temperature alloys	hardened steel
Quality Coating	Application						
K10 polished	roughing	-	-	-	▽100 450 800	-	-
	pre finishing	-	-	-	▽100 450 800	-	-
	finishing	-	-	-	-	-	-
K10 PVTi	roughing	-	-	-	▽100 450 800	-	-
	pre finishing	-	-	-	▽100 450 800	-	-
	finishing	-	-	-	-	-	-
K10 PVDiaN	roughing	-	-	-	▽100 450 800	-	-
	pre finishing	-	-	-	▽100 450 800	-	-
	finishing	-	-	-	-	-	-

Extended operation data

Plunging	
Cutter diam. d1	X _{max}
32-125	9

Ramping		
Cutter diam. d1	α°	y
32	<42	10
42	<24,2	20
52	<16,7	30
66	<11,6	44
80	<8,8	58
100	<6,6	78
125	<5,3	103

Helix		
Cutter diam. d1	D _{min}	D _{max}
32	42	64
42	62	84
52	82	104
66	110	132
80	138	160
100	178	200
125	228	250