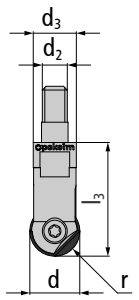
CUTTERS FOR INSERTS WITH 4 CUTTING EDGES

diam. 10 mm - 20 mm

The special insert geometry of these tools makes it ideally suited for finishing and pre-finishing operations on modern high-speed milling machines with 5 axes.
The advantage of the insert with 4 cutting edges is: it is reversible, thus it doubles its productivity.
Optimum cutting conditions can only be achieved with an approach angle of spindle.

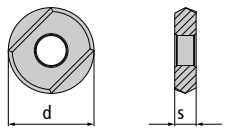
Milling cutter bodies

Threaded shank end mill bodies



Catalogue no.	d_1	d	r	l_3	l_2	l_1	d_2	d_3	z	Accessories	Features
10 210 M6	10	10	5	28.5	-	-	M 6	9.75	2	A, B, C, D, E	☑
12 210 M6	12	12	6	28.7	-	-	M 6	11.5	2	A, B, C, D, E	☑
16 210	16	16	8	36.4	-	-	M 8	13.8	2	A, B, C, D, E	☑
20 210	20	20	10	36.9	-	-	M 10	18	2	A, B, C, D, E	☑

Indexable inserts



Catalogue no.	DIN Specification	Carbide Grade	Coating	d	s	r	M
10 10 860	ROHX 1002	K05	PVTi	10	2.5	5	M 3.5
10 12 860	ROHX 1203	K05	PVTi	12	3	6	M 4.0
10 16 860	ROHX 16T3	K05	PVTi	16	4	8	M 5.0
10 20 860	ROHX 2004	K05	PVTi	20	5	10	M 5.0

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

Material Quality Coating	Feed per tooth | d.o.c.	steel	stainless steel	cast iron	non-ferrous materials	high-temperature alloys	hardened steel
d=10 mm							
K05 PVTi	f_z (mm) a_p (mm)	0,1 0,1	0,1 0,1	0,1 0,1	0,1 0,1	0,1 0,1	0,1 0,1
d=12 mm							
K05 PVTi	f_z (mm) a_p (mm)	0,12 0,1	0,12 0,1	0,12 0,1	0,12 0,1	0,12 0,1	0,12 0,1
d=16 mm							
K05 PVTi	f_z (mm) a_p (mm)	0,16 0,1	0,16 0,1	0,16 0,1	0,16 0,1	0,16 0,1	0,16 0,1
d=20 mm							
K05 PVTi	f_z (mm) a_p (mm)	0,2 0,1	0,2 0,1	0,2 0,1	0,2 0,1	0,2 0,1	0,2 0,1

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Cutting speed (Vc in m/min)

Material		steel	stainless steel	cast iron	non-ferrous materials	high-temperature alloys	hardened steel
Quality Coating	Application						
K05 PVTi	roughing	-	-	-	-	-	-
	pre finishing	-	-	-	-	-	-
	finishing	150 **250** 350	100 **175** 250	150 **200** 250	100 **450** 800	35 **43** 50	35 **143** 250

▼ *major application* ▽ *minor application* ▼▽ roughing ▼▽ pre-finishing ▼▽ finishing