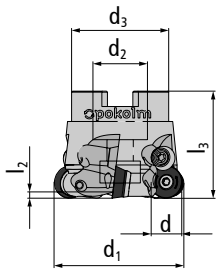
CUTTERS FOR ROUND INSERTS - K0-90°

r6 - diam. 42 - 80 mm, 7° positive rake angle, with shims

- increased reliability against fractures during machining
- optimum protection of milling cutter body by shim
- in case of insert fracture, shims, screws and threaded bushes can be replaced separately, it is not necessary to buy a new body

Milling cutter bodies

Shell type milling cutter bodies



Catalogue no.	d_1	d	r	l_3	l_2	l_1	d_2	d_3	z	Accessories	Features
42 310/7 HL	42	12	6	42	3.5	-	diam. 16	35	4	A, B, C, D, E, F, G, H, I	
52 310/7 HL	52	12	6	52.5	3.5	-	diam. 22	40	5	A, B, C, D, E, F, G, H, I	
66 310/7 HL	66	12	6	52.5	3.5	-	diam. 27	48	6	A, B, C, D, E, F, G, H, I	
80 310/7 HL	80	12	6	52.5	3.5	-	diam. 27	60	7	A, B, C, D, E, F, G, H, I	

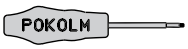
Accessories

35 500 L
Torx screw
A > Page 195

35 510
locking screw
B > Page 195

35 500 I
threaded and tapped bush
C > Page 196

09 511
Shim for RDHX 12T3
D > Page 196



15 500
Torx-screwdriver
E > Page 196

INBUS 3,5 W
Allen key 3,5
F > Page 197

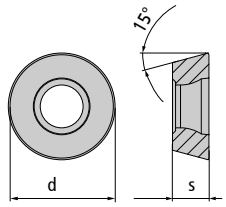
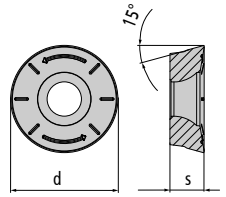
TV 2-8
Screwdriver torque Vario®-S with window scale
G > Page 197

T15 500
Torx interchangeable bit for Torque Vario®
H > Page 197

T15 502
Torx MagicSpring compatible bit f. Torque Vario®
I > Page 198

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

pokolm PREMIUMTOOLS. WE KNOW HOW.

Indexable inserts	Catalogue no.	DIN Specification	Carbide Grade	Coating	d	s	r	M
	03 12 835K	RDHX 12T3 M0T	HSC 05	PVTi	12	3.97	6	M 3.5
	03 12 837K	RDMX 12T3 M0T	HSC 05	PVFN	12	3.97	6	M 3.5
	03 12 840K	RDHX 12T3 M0T	P40	PVTi	12	3.97	6	M 3.5
	03 12 842K	RDEX 12T3 M0T	P40	PVSR	12	3.97	6	M 3.5
	03 12 8042K	RDEX 12T3 M0T	P40	PCSR	12	3.97	6	M 3.5
	03 12 844K	RDHX 12T3 M0T	P40	PVML	12	3.97	6	M 3.5
	03 12 846K	RDMX 12T3 M0T	P40	PVGO	12	3.97	6	M 3.5
	03 12 850K	RDHX 12T3 M0T	P25	PVTi	12	3.97	6	M 3.5
	03 12 852K	RDEX 12T3 M0T	P25	PVSR	12	3.97	6	M 3.5
	03 12 860K	RDHX 12T3 M0T	K10	PVTi	12	3.97	6	M 3.5
	03 12 831P	RDHX 12T3 M0T	K10	polished	12	3.97	6	M 3.5
	03 12 848K	RDMX 12T3 M0T	P40	PVGO	12	3.97	6	M 3.5
	03 12 880	RDHX 12T3 M0T	K10	PVTi	12	3.97	6	M 3.5
	03 12 880 D	RDHX 12T3 M0T	K10	PVDiaN	12	3.97	6	M 3.5
	03 12 896K	RDMT 12T3 M0EN	M40	PVST	12	3.97	6	M 3.5
	03 12 897K	RDPX 12T3 M0T	P25	PVGO	12	3.97	6	M 3.5
	03 12 8099K	RDMT 12T3 M0EN	M35	PCTC	12	3.97	6	M 3.5

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
HSC 05 PVTi	f_z (mm) a_p (mm)	0,1-0,2 0,1-0,8	0,15 0,1	0,15-0,4 0,1-1,5	0,1-0,25 0,1-1,05	-	0,1-0,18 0,1-0,4
HSC 05 PVFN	f_z (mm) a_p (mm)	0,1-0,4 0,1-1,5	0,12-0,24 0,1-0,3	0,12-0,4 0,1-1,5	0,12-0,24 0,1-0,3	-	0,1-0,25 0,1-0,7
P40 PVTi	f_z (mm) a_p (mm)	0,2-0,7 0,2-2	-	-	-	-	-
P40 PVSR	f_z (mm) a_p (mm)	0,2-0,8 0,2-2	-	0,1-0,4 0,1-1,5	-	-	0,1-0,18 0,1-0,4
P40 PCSR	f_z (mm) a_p (mm)	0,2-1 0,2-2	-	0,15-1 0,2-1,5	-	-	-
P40 PVML	f_z (mm) a_p (mm)	0,2-0,8 0,2-2	-	0,1-0,4 0,1-1,5	-	-	0,1-0,18 0,1-0,4
P40 PVGO	f_z (mm) a_p (mm)	0,12-1 0,1-2	-	0,1-0,4 0,1-1,5	-	-	-
P25 PVTi	f_z (mm) a_p (mm)	0,15-0,4 0,1-1,5	-	0,15-0,28 0,1-0,8		-	-
P25 PVSR	f_z (mm) a_p (mm)	0,2-0,8 0,2-2	-	0,1-0,4 0,1-1,5	-	-	0,1-0,18 0,1-0,4
K10 PVTi	f_z (mm) a_p (mm)		0,15 0,1		0,1-0,4 0,1-2	0,1-0,25 0,1-1	
K10 polished	f_z (mm) a_p (mm)	-	-	-	0,1-0,4 0,1-2	-	-
K10 PVDiaN	f_z (mm) a_p (mm)	-	-	-	0,1-0,4 0,1-2	-	-
M40 PVST	f_z (mm) a_p (mm)	0,1-0,8 0,1-2	0,08-0,8 0,1-2,5	-	-	0,08-0,5 0,12-2,5	-
P25 PVGO	f_z (mm) a_p (mm)	-	0,2-0,8 0,25-2	-	-	0,12-0,5 0,12-1,5	-
M35 PCTC	f_z (mm) a_p (mm)	-	0,08-0,65 0,1-2,5	-	-	0,08-0,5 0,12-2,5	-

NEW latest items! ⚠ available as long as stock lasts ? on request ✔ stock item, subject to confirmation

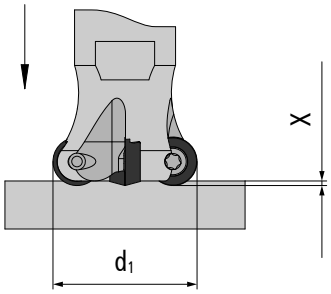
Cutting speed (Vc in m/min)

Material		steel	stainless steel	cast iron	non-ferrous materials	high-temperature alloys	hardened steel
Quality Coating	Application						
HSC 05 PVTi	roughing	-	-	▼ 100 **150** 200	-		-
	pre finishing	▼ 150 **275** 400	-	▼ 150 **225** 300	▽ 200 **500** 800	-	▼ 35 **143** 250
	finishing	▼ 150 **275** 400	▼ 100 **150** 200	▼ 200 **275** 350	▽ 100 **450** 800		▼ 35 **143** 250
HSC 05 PVFN	roughing	-	-	▼ 100 **150** 200	-		-
	pre finishing	▼ 120 **160** 200	-	▼ 100 **150** 200	▽ 200 **500** 800	-	▼ 40 **130** 220
	finishing	▼ 150 **250** 350	▼ 100 **150** 200	▼ 200 **275** 350	▽ 200 **500** 800		▼ 40 **130** 220
P40 PVTi	roughing	▼ 100 **160** 220					
	pre finishing	▼ 100 **175** 250	-	-	-	-	-
	finishing	-					
P40 PVSR	roughing	▼ 100 **200** 300		▽ 160 **190** 220			-
	pre finishing	▼ 100 **200** 300	-	▽ 160 **190** 220	-	-	▽ 70 **110** 150
	finishing	-		▽ 160 **190** 220			-
P40 PCSR	roughing	▼ 130 **190** 250		▽ 120 **170** 220			
	pre finishing	▼ 150 **225** 300	-	▽ 150 **200** 250	-	-	-
	finishing	-		▽ 180 **230** 280			
P40 PVML	roughing	▼ 100 **200** 300		▽ 140 **215** 290			-
	pre finishing	▼ 100 **200** 300	-	▽ 140 **170** 200	-	-	▽ 70 **110** 150
	finishing	-		-			-
P40 PVGO	roughing	▼ 100 **150** 200		▽ 110 **130** 150			
	pre finishing	▼ 100 **150** 200	-	▽ 110 **130** 150	-	-	-
	finishing	-		-			
P25 PVTi	roughing	▽ 100 **200** 300		-	-		
	pre finishing	▼ 100 **125** 150	-	▽ 130 **150** 170	-	-	-
	finishing	▼ 150 **250** 350		▽ 150 **200** 250	-		
P25 PVSR	roughing	▼ 100 **160** 220		▽ 140 **180** 220			-
	pre finishing	▼ 100 **180** 260	-	▽ 160 **190** 220	-	-	▽ 70 **110** 150
	finishing	-		▽ 160 **190** 220			-
K10 PVTi	roughing	-	-	▽ 150 **175** 200	▼ 100 **450** 800	▽ 35 **43** 50	-
	pre finishing	-	-	▼ 150 **175** 200	▼ 100 **450** 800	▽ 35 **43** 50	▽ 35 **108** 180
	finishing	▽ 140 **220** 300	▼ 120 **150** 180	▼ 150 **200** 250	▼ 100 **450** 800	▽ 35 **43** 50	-
K10 polished	roughing				▼ 100 **450** 800		
	pre finishing	-	-	-	▼ 100 **450** 800	-	-
	finishing				▼ 100 **450** 800		
K10 PVDiaN	roughing				▼ 100 **450** 800		
	pre finishing	-	-	-	▼ 100 **450** 800	-	-
	finishing				▼ 100 **450** 800		
M40 PVST	roughing	▽ 80 **140** 200	▼ 80 **130** 180			▼ 30 **55** 80	
	pre finishing	▽ 100 **150** 200	▼ 100 **155** 210	-	-	▼ 40 **65** 90	-
	finishing	▽ 110 **180** 250	▼ 120 **185** 250			▼ 60 **90** 120	
P25 PVGO	roughing		▼ 80 **140** 200			▼ 20 **65** 110	
	pre finishing	-	▼ 100 **155** 210	-	-	▼ 20 **65** 110	-
	finishing		▽ 120 **175** 230			▽ 30 **70** 110	
M35 PCTC	roughing		▼ 110 **155** 200			▼ 30 **65** 100	
	pre finishing	-	▼ 120 **175** 230	-	-	▼ 40 **75** 110	-
	finishing		▼ 160 **220** 280			▼ 60 **100** 140	

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

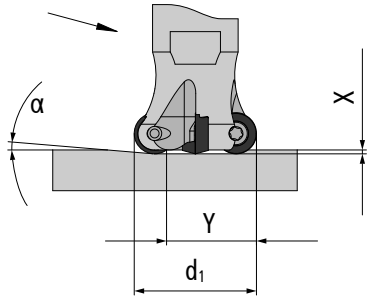
Extended operation data

Plunging



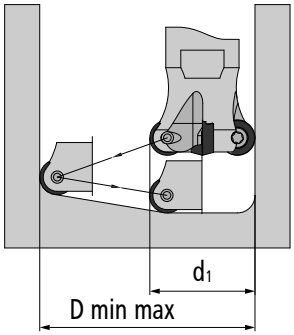
Cutter diam. d1	X_{max}
42-80	3

Ramping



Cutter diam. d1	α°	y
42	<6,5	20
52	<5,7	30
66	<3,9	44
80	<3,0	58

Helix



Cutter diam. d1	D_{min}	D_{max}
42	62	84
52	82	104
66	110	132
80	136	160

NEW latest items! ⚠ available as long as stock lasts ? on request ✔ stock item, subject to confirmation