

TRIGAWORX®

Size L

- allows extremely high feed rates per tooth up to $fz = 3.0 \text{ mm}$
- better utilization of insert because of its 3 effective cutting edges
- very smooth operation, especially in deep slots or profiles

Especially for roughing operations



Milling cutter bodies	Catalogue no.	d_1	l	r_p^*	l_3	l_2	l_1	d_2	d_3	z	Accessories	Features
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Threaded shank end mill bodies	Catalogue no.	d_1	l	r_p^*	l_3	l_2	l_1	d_2	d_3	z	Accessories	Features
	2 32 274	32	14.3	4.6*	42.5	2	-	M 16	29	2	A, B, C, D, E, F	<input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/>

Shell type milling cutter bodies	Catalogue no.	d_1	l	r_p^*	l_3	l_2	l_1	d_2	d_3	z	Accessories	Features
	4 52 374	52	14.3	4.6*	52.5	2	-	diam. 22	40	4	A, B, C, D, E, F	<input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/>
	4 66 374	66	14.3	4.6*	52.5	2	-	diam. 27	48	4	A, B, C, D, E, F	<input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/>
	5 80 374	80	14.3	4.6*	52.5	2	-	diam. 27	60	5	A, B, C, D, E, F	<input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/>

Accessories	* corner radius to be programmed				
<p>45 500 Torx screw A > Page 195</p>	<p>10 510 locking washer B > Page 196</p>	<p>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>

Indexable inserts	Catalogue no.	DIN Specification	Carbide Grade	Coating	l	s	r	M
	04 74 840	WDHX 140420 SR	P40	PVTi	14.3	4.76	2	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.						
P40 PVTi	f _z (mm) a _p (mm)	1,75-3 0,3-1,2	-	-	-	-	-

Cutting speed (Vc in m/min)

Material		steel	stainless steel	cast iron	non-ferrous materials	high-temperature alloys	hardened steel
Quality Coating	Application						
P40 PVTi	roughing pre finishing finishing	▽100 160 220 - -	-	-	-	-	-

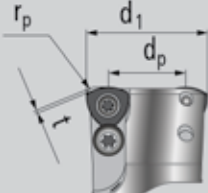
Extended operation data

Plunging		
Cutter diam. d1	D _p	X _{max}
32	17.4	2
52	37.4	2
66	51.4	2
80	65.4	2

Ramping		
Cutter diam. d1	α°	y
32	<11,3	10
52	<3,8	30
66	<2,6	44
80	<2	58

Helix		
Cutter diam. d1	D _{min}	D _{max}
32	42	64
52	82	104
66	110	132
80	138	160

Technical information



For the CAD/CAM set-up please program 4.6 mm corner radius (r_p).
The remainder of the material is theoretically 2.3 mm (t).
Please use „d_p“ for tool length measurement.