



ADEW - K90°

diam. 15 - 32 mm

These universal milling cutters for machine building and toolmaking are characterized for their low energy consumption.

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												
	15 242 A	15	9.52	0.8	27.5	0.9	-	M 8	13.8	2	A, B, C, D, E	✓
	20 242 A	20	9.52	0.8	27.5	0.9	-	M 10	18	3	A, B, C, D, E	✓
	25 242 A	25	9.52	0.8	32.5	0.9	-	M 12	21	4	A, B, C, D, E	✓
	32 242 A	32	9.52	0.8	37.5	0.9	-	M 16	29	5	A, B, C, D, E	✓

Accessories					
<p>25 500 Torx screw A > Page 195</p>	<p>POKOLM 07 500 Torx-screwdriver B > Page 196</p>	<p>TV 04-1 Screwdriver torque Vario®-S with window scale, C > Page 197</p>	<p>T7 500 Torx interchangeable bit for Torque Vario® D > Page 197</p>	<p>T7 502 Torx MagicSpring compatible bit f. Torque Vario® E > Page 198</p>	

Indexable inserts	Catalogue no.	DIN Specification	Carbide Grade	Coating	Dimensions			
					l	s	r	M
	02 78 835	ADEW 090208 TR	HSC 05	PVTi	9.52	2.38	0.8	M 2.5
	02 78 850	ADEW 090208 TR	P25	PVTi	9.52	2.38	0.8	M 2.5
	02 78 860 D	ADEW 090208 TR	K10	PVDiaN	9.52	2.38	0.8	M 2.5

Feed per tooth (f_z) | d.o.c. (a_p)

Material		steel	stainless steel	cast iron	non-ferrous materials	high-temperature alloys	hardened steel
Quality Coating	Feed per tooth d.o.c.						
	f _z (mm)						
HSC 05 PVTi	a _p (mm)	0,1-0,18 0,1-1,05	0,1 0,1	0,1-0,25 0,1-2	0,1-0,18 0,1-1,05	-	0,1-0,18 0,1-1,05
	f _z (mm)	0,1-0,25 0,1-2	-	0,1-0,18 0,1-1,05	-	-	-
P25 PVTi	a _p (mm)	-	-	-	-	-	-
	f _z (mm)	-	-	-	-	-	-
K10 PVDiaN	a _p (mm)	-	-	-	0,1-0,25 0,1-2	-	-
	f _z (mm)	-	-	-	-	-	-

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	-
P25 PVTi	roughing	▽100 200 300	-	-	-	-	-	-	-	-	-	-	-
	pre finishing	▽100 125 150	-	-	▽130 150 170	-	-	-	-	-	-	-	-
	finishing	▽150 250 350	-	-	▽150 200 250	-	-	-	-	-	-	-	-
K10 PVDiaN	roughing	-	-	-	-	-	-	▽100 450 800	-	-	-	-	-
	pre finishing	-	-	-	-	-	-	▽100 450 800	-	-	-	-	-
	finishing	-	-	-	-	-	-	▽100 450 800	-	-	-	-	-

Extended operation data

Plunging	
Cutter diam. d1	X _{max}
15-32	0.9

Ramping		
Cutter diam. d1	α°	y
15	4,5	11
20	3	16
25	2	21
32	1,5	28

Helix		
Cutter diam. d1	D _{min}	D _{max}
15	26	29
20	36	39
25	46	49
32	60	63