

# CUTTERS FOR ROUND INSERTS - K0-90°

r5 - diam. 20 - 35 mm, CBN, neutral - 0° axial rake angle

Specially designed for high-speed super-finish milling of hardened steel.



Milling cutter bodies	Catalogue no.	d <sub>1</sub>	d	r	l <sub>3</sub>	l <sub>2</sub>	l <sub>1</sub>	d <sub>2</sub>	d <sub>3</sub>	z	Accessories	Features
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DuoPlug®												
	2 20 294 SG	20	10	5	39.5	-	-	M 12	18.5	2	A, B, C, D, E	
	3 25 294 SG	25	10	5	41.5	2.5	-	M 16	23.5	3	A, B, C, D, E	

Threaded shank end mill bodies												
	20 294	20	10	5	28.5	-	-	M 10	18	2	A, B, C, D, E	
	25 294	25	10	5	32.5	2.5	-	M 12	21	3	A, B, C, D, E	
	30 294	30	10	5	32.5	2.5	-	M 12	21	4	A, B, C, D, E	
	35 294	35	10	5	42.5	2.5	-	M 16	29	4	A, B, C, D, E	

Accessories					
<p>10 500 Torx-screwdriver A &gt; Page 196</p>	<p>TV 2-8 Screwdriver torque Vario®-S with window scale, B &gt; Page 197</p>	<p>T10 500 Torx interchangeable bit for Torque Vario® C &gt; Page 197</p>	<p>T10 502 Torx MagicSpring compatible bit f. Torque Vario®, D &gt; Page 198</p>	<p>10 514 clamping finger for CBN E &gt; Page 198</p>	

Indexable inserts	Catalogue no.	DIN Specification	Carbide Grade	Coating	d	s	r	M
	02 10 092	RPHN 1003 M0	CBN for steel	uncoated	10	3.18	5	
	02 10 093	RPHN 1003 M0	CBN for cast iron	uncoated	10	3.18	5	

major application
 minor application
 roughing
 pre-finishing
 finishing

### 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.						
CBN for steel uncoated	f <sub>z</sub> (mm) a <sub>p</sub> (mm)	-	-	-	-	-	0,1-0,2 0,1-0,3
CBN for cast iron uncoated	f <sub>z</sub> (mm) a <sub>p</sub> (mm)	-	-	0,1-0,2 0,1-0,3	-	-	-

### Cutting speed (Vc in m/min)

Material		steel	stainless steel	cast iron	non-ferrous materials	high-temperature alloys	hardened steel
Quality Coating	Application						
CBN for steel uncoated	roughing pre finishing finishing	-	-	-	-	-	- ▽400 700 1000 ▽400 700 1000
CBN for cast iron uncoated	roughing pre finishing finishing	-	-	- ▽500 750 1000 ▽500 750 1000	-	-	-

### Extended operation data

**Plunging**

Cutter diam. d1	X <sub>max</sub>
20-35	2.5

**Ramping**

Cutter diam. d1	α°	y
20	-	-
25	<19,7	7
30	<11,7	12
35	<8,4	17

**Helix**

Cutter diam. d1	D <sub>min</sub>	D <sub>max</sub>
20	22	40
25	32	50
30	42	60
35	52	70