



CUTTERS FOR ROUND INSERTS - K0-90°

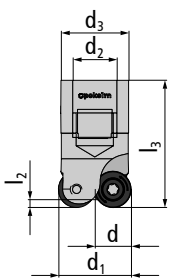
r2.5 - diam. 8 - 20 mm

Tools especially suitable for milling small dies and engraving.
The larger number of teeth allows much higher feed rates.

Milling cutter bodies

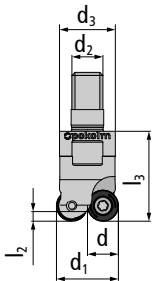
Catalogue no.											Accessories	Features
	d ₁	d	r	l ₃	l ₂	l ₁	d ₂	d ₃	z			

DuoPlug®



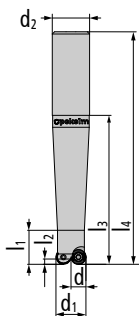
3 12 225 SG	12	5	2.5	24.5	1.3	-	M 7	10.8	3	A, B, C, D, E	<input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/>
4 15 225 SG	15	5	2.5	28	1.3	-	M 10	14	4	A, B, C, D, E	<input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/>
4 16 225 SG	16	5	2.5	28	1.3	-	M 10	15	4	A, B, C, D, E	<input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/>
5 20 225 SG	20	5	2.5	28	1.3	-	M 12	18.5	5	A, B, C, D, E	<input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/>

Threaded shank end mill bodies








2 10 225 M6	10	5	2.5	19	-	-	M 6	9.75	2	A, B, C, D, E	<input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/>
3 12 225 M6	12	5	2.5	20.5	1.3	-	M 6	11.5	3	A, B, C, D, E	<input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/>
4 15 225	15	5	2.5	20.5	1.3	-	M 8	13.8	4	A, B, C, D, E	<input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/>
5 20 225	20	5	2.5	25.5	1.3	-	M 10	18	5	A, B, C, D, E	<input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/>

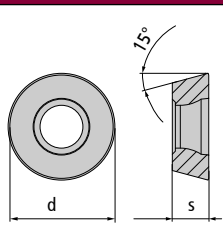
Plain shank end mill bodies



30 08 125	8	5	2.5	30	-	18	diam. 10	-	1	A, B, C, D, E	<input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/>
30 10 125	10	5	2.5	30	-	24	diam. 10	-	2	A, B, C, D, E	<input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/>
30 12 125	12	5	2.5	30	1.3	24	diam. 12	-	3	A, B, C, D, E	<input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/>
30 16 125	16	5	2.5	30	1.3	23.5	diam. 16	-	5	A, B, C, D, E	<input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/>

Accessories

 21 500 Torx screw A > Page 195	 POKOLM 06 500 Torx-screwdriver B > Page 196	 TV 04-1 Screwdriver torque Vario®-S with window scale, C > Page 197	 T6 500 Torx interchangeable bit for Torque Vario® D > Page 197	 T6 502 Torx MagicSpring compati- ble bit f. Torque Vario® E > Page 198	
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Indexable inserts	Catalogue no.	DIN Specification	Carbide Grade	Coating	d	s	r	M
		01 05 835	RDHX 0501 M0T	HSC 05	PVTi	5	1.5	2.5

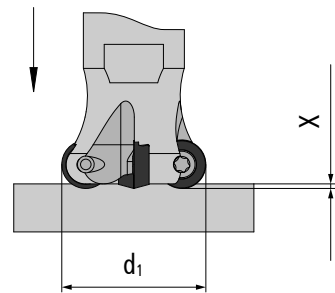
Feed per tooth (fz) | d.o.c. (ap)

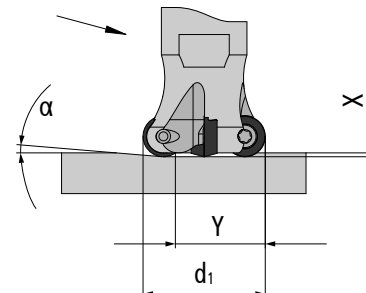
Material		steel	stainless steel	cast iron	non-ferrous materials	high-temperature alloys	hardened steel
Quality Coating	Feed per tooth d.o.c.						
HSC 05 PVTi	f _z (mm)	0,1-0,2	0,1	0,1-0,15	0,1-0,15	-	0,1-0,12
	a _p (mm)	0,1-0,2	0,1	0,1-0,2	0,1-0,2	-	0,1-0,15

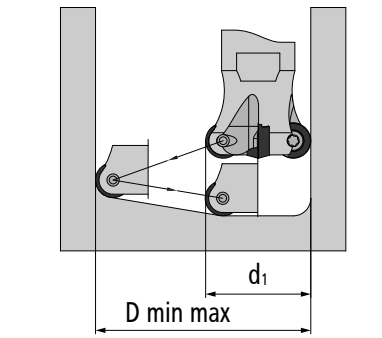
Cutting speed (Vc in m/min)

Material		steel	stainless steel	cast iron	non-ferrous materials	high-temperature alloys	hardened steel
Quality Coating	Application						
HSC 05 PVTi	roughing	-	-	-	-	-	-
	pre finishing	▽150 275 400	▽100 150 200	▽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

Extended operation data

Plunging	
	
Cutter diam. d1	X _{max}
8-20	1

Ramping		
		
Cutter diam. d1	α°	y
8	-	-
10	-	-
12	< 14,0	4
15	< 8,1	7
16	< 7,1	8
20	< 4,7	24

Helix		
		
Cutter diam. d1	D _{min}	D _{max}
8	10	16
10	12	20
12	16	24
15	22	30
16	24	32
20	32	40