

# SPINWORX®

r3.5 - diam. 16 - 35 mm, 7° positive rake angle

The SPINWORX system in its smallest version

- effective use of cutting edge and machining of smaller workpieces
- wide range of use for almost all areas of application
- effective use of the cutting edge
- with specially adapted coolant supply
- low power consumption, high chip removal rate

### CAUTION - PLEASE NOTE!

For optimum results with the SPINWORX®-tooling system we recommend using internal coolant supply air, emulsion or MQL for chip removal from the tool! Wet machining up to max speed Vc of 140 m/min!



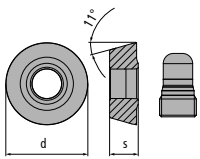
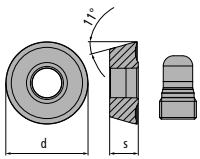
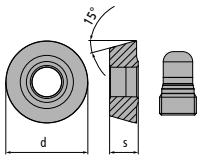
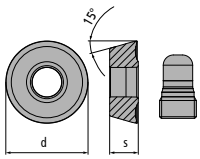
Milling cutter bodies												Accessories	Features
Catalogue no.													
	d <sub>1</sub>	d	r	l <sub>3</sub>	l <sub>2</sub>	l <sub>1</sub>	d <sub>2</sub>	d <sub>3</sub>	z				

### Threaded shank end mill bodies

	DR07-016-E08-02	16	7	3.5	28.5	1.2	-	M 8	13.8	2	A, B, C, D	
	DR07-020-E10-05	20	7	3.5	28.5	1.2	-	M 10	18	5	A, B, C, D	
	DR07-025-E12-06	25	7	3.5	28.5	1.2	-	M 12	21	6	A, B, C, D	
	DR07-030-E12-07	30	7	3.5	28.5	1.2	-	M 12	21	7	A, B, C, D	
	DR07-035-E16-08	35	7	3.5	28.5	1.2	-	M 16	29	8	A, B, C, D	

### Accessories

<p>T6-0,5NM Torque Fix® - S torque screwdriver A &gt; Page 197</p>	<p>T6 500 Torx interchangeable bit for Torque Vario® B &gt; Page 197</p>	<p>T6 502 Torx MagicSpring compatible bit f. Torque Vario® C &gt; Page 198</p>	<p>Z 00043 HTC ceramic paste WS 600 005 D &gt; Page 198</p>		
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Indexable inserts	Catalogue no.	DIN Specification	Carbide Grade	Coating	d	s	r	M
	DR07-8C0	RORA 0727 M0SN	C0		7	2.7	3.5	
	DR07-8E0	RORA 0727 M0SN	E0		7	2.7	3.5	
	DR07-8E1	RORM 0727 M0EN	E1		7	2.7	3.5	
	DR07-8B3	RORM 0727 M0EN	B3		7	2.7	3.5	
	DR07-8D1	RORM 0727 M0EN	D1		7	2.7	3.5	
	DR07-8D3	RORM 0727 M0EN	D3		7	2.7	3.5	
	DR07-8C4	RDRA 0727 M0SN	C4		7	2.7	3.5	
	DR07-8C6	RDRA 0727 M0SN	C6		7	2.7	3.5	
	DR07-8E4	RDRA 0727 M0SN	E4		7	2.7	3.5	
	DR07-8F4	RDRA 0727 M0SN	F4		7	2.7	3.5	
	DR07-8E6	RDRA 0727 M0SN	E6		7	2.7	3.5	
	DR07-8F6	RDRA 0727 M0SN	F6		7	2.7	3.5	
	DR07-8B7	RDRM 0727 M0EN	B7		7	2.7	3.5	
	DR07-8C7-P	RDRM 0727 M0EN	C7-P		7	2.7	3.5	

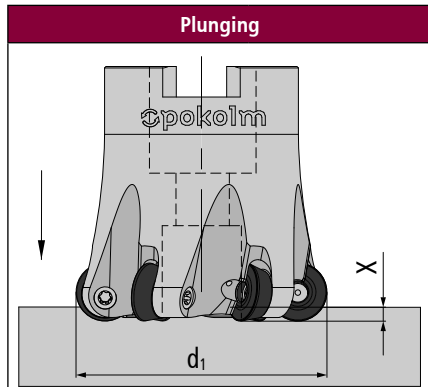
## Feed per tooth (fz) | d.o.c. (ap)

Material		steel	stainless steel	cast iron	non-ferrous materials	high-temperature alloys	hardened steel
Quality Coating	Feed per tooth   d.o.c.						
C0	f <sub>z</sub> (mm)	0,1-0,4	-	0,1-0,3	-	-	0,1-0,15
	a <sub>p</sub> (mm)	0,1-0,5	-	0,1-0,7	-	-	0,1-0,2
E0	f <sub>z</sub> (mm)	0,1-0,4	-	0,1-0,3	-	-	-
	a <sub>p</sub> (mm)	0,1-0,5	-	0,1-0,4	-	-	-
E1	f <sub>z</sub> (mm)	0,1-0,3	0,1-0,5	-	-	0,1-0,4	-
	a <sub>p</sub> (mm)	0,05-0,4	0,1-0,75	-	-	0,1-1	-
B3	f <sub>z</sub> (mm)	-	0,1-0,5	-	-	0,1-0,4	-
	a <sub>p</sub> (mm)	-	0,1-0,75	-	-	0,1-1	-
D1	f <sub>z</sub> (mm)	-	0,1-0,5	-	-	0,1-0,4	-
	a <sub>p</sub> (mm)	-	0,1-0,75	-	-	0,1-1	-
D3	f <sub>z</sub> (mm)	-	0,1-0,5	-	0,1-0,3	0,1-0,4	-
	a <sub>p</sub> (mm)	-	0,1-0,75	-	0,2-1	0,1-1	-
C4	f <sub>z</sub> (mm)	0,1-0,4	-	0,1-0,3	-	-	0,1-0,15
	a <sub>p</sub> (mm)	0,1-0,5	-	0,1-0,7	-	-	0,1-0,2
C6	f <sub>z</sub> (mm)	0,1-0,4	-	0,1-0,3	-	-	0,1-0,15
	a <sub>p</sub> (mm)	0,1-0,5	-	0,1-0,7	-	-	0,1-0,2
E4	f <sub>z</sub> (mm)	0,1-0,4	-	0,1-0,3	-	-	-
	a <sub>p</sub> (mm)	0,1-0,5	-	0,1-0,4	-	-	-
F4	f <sub>z</sub> (mm)	0,1-0,5	-	0,1-0,3	-	-	-
	a <sub>p</sub> (mm)	0,1-0,8	-	0,1-0,7	-	-	-
E6	f <sub>z</sub> (mm)	0,1-0,4	-	0,1-0,2	-	-	-
	a <sub>p</sub> (mm)	0,1-0,5	-	0,1-0,4	-	-	-
F6	f <sub>z</sub> (mm)	0,1-0,5	-	0,1-0,3	-	-	-
	a <sub>p</sub> (mm)	0,1-0,8	-	0,1-0,7	-	-	-
B7	f <sub>z</sub> (mm)	-	0,1-0,5	-	-	0,1-0,4	-
	a <sub>p</sub> (mm)	-	0,1-0,75	-	-	0,1-1	-
C7-P	f <sub>z</sub> (mm)	-	-	-	0,1-0,3	-	-
	a <sub>p</sub> (mm)	-	-	-	0,2-1	-	-

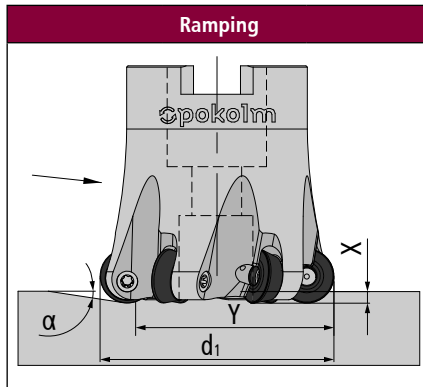
### Cutting speed (Vc in m/min)

Material		steel		stainless steel		cast iron		non-ferrous materials		high-temperature alloys		hardened steel			
Quality Coating	Application														
C0	roughing	▽90	150 210	-	-	▽150	195 240	-	-	-	-	▽35	108 180		
	pre finishing	▽110	165 220			▽140	205 270								
	finishing	-	-			-	-								
E0	roughing	▽100	175 250	-	-	▽130	165 200	-	-	-	-	-	-		
	pre finishing	▽100	200 300			▽130	165 200								
	finishing	-	-			-	-								
E1	roughing	▽80	155 230	▽70	110 150	-	-	-	-	-	-	-	-		
	pre finishing	▽75	163 250	▽80	130 180									▽20	45 70
	finishing	-	-	-	-									▽20	50 80
B3	roughing	-	-	▽110	155 200	-	-	-	-	-	-	-	▽30	65 100	
	pre finishing			▽120	175 230								▽40	75 110	
	finishing			-	-								-	-	
D1	roughing	-	-	▽80	130 180	-	-	-	-	-	-	-	▽30	55 80	
	pre finishing			▽100	155 210								▽40	65 90	
	finishing			-	-								-	-	
D3	roughing	-	-	▽80	130 180	-	-	▽100	250 400	-	-	-	▽30	55 80	
	pre finishing			▽100	155 210			▽200	400 600				▽40	65 90	
	finishing			-	-			-	-				-	-	
C4	roughing	▽90	150 210	-	-	▽150	195 240	-	-	-	-	-	▽35	108 180	
	pre finishing	▽110	165 220			▽140	205 270								
	finishing	-	-			-	-								
C6	roughing	▽90	150 210	-	-	▽150	195 240	-	-	-	-	-	▽35	108 180	
	pre finishing	▽110	165 220			▽140	205 270								
	finishing	-	-			-	-								
E4	roughing	▽100	175 250	-	-	▽130	165 200	-	-	-	-	-	-	-	
	pre finishing	▽100	200 300			▽130	165 200								
	finishing	-	-			-	-								
F4	roughing	▽100	175 250	-	-	▽110	130 150	-	-	-	-	-	-	-	
	pre finishing	▽100	200 300			▽140	180 220								
	finishing	-	-			-	-								
E6	roughing	▽100	175 250	-	-	▽130	165 200	-	-	-	-	-	-	-	
	pre finishing	▽100	200 300			▽130	165 200								
	finishing	-	-			-	-								
F6	roughing	▽100	175 250	-	-	▽110	130 150	-	-	-	-	-	-	-	
	pre finishing	▽100	200 300			▽140	180 220								
	finishing	-	-			-	-								
B7	roughing	-	-	▽110	155 200	-	-	-	-	-	-	-	▽30	65 100	
	pre finishing			▽120	175 230								▽40	75 110	
	finishing			-	-								-	-	
C7-P	roughing	-	-	-	-	-	-	▽100	350 600	-	-	-	-	-	
	pre finishing							▽200	500 800						
	finishing							-	-						

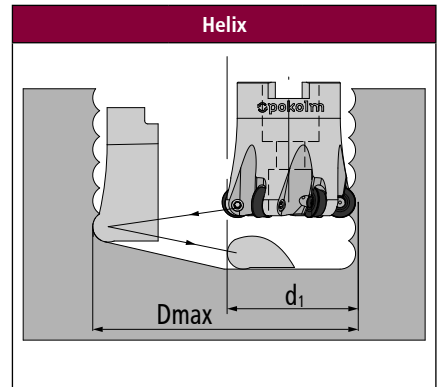
## Extended operation data



Cutter diam. d1	X <sub>max</sub>
16-35	1.2



Cutter diam. d1	$\alpha^\circ$	y
16	<16,0	4
20	<8,5	8
25	<5,0	13
30	<3,5	18
35	<3,0	23



Cutter diam. d1	D <sub>min</sub>	D <sub>max</sub>
16	20	30
20	28	38
25	38	48
30	48	58
35	58	68