



SLOTWORX® - K90°

SLOTWORX® - Size S - diam. 10 - 20 mm

Outstandingly capable for using on high-speed milling machines and smaller machining centres.

- the increased no. of teeth allows for very large feed-rates

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

DuoPlug®

	4 16 256 SG	16	6.9	0.8	34.4	1.3	-	M 10	15	4	A, B, C, D, E	
	5 20 256 SG	20	6.9	0.8	32.4	1.3	-	M 12	18.5	5	A, B, C, D, E	

Threaded shank end mill bodies

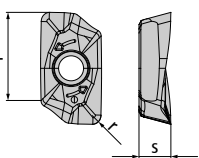
	2 10 256 M6	10	6.9	0.8	22.5	0.7	-	M 6	9.75	2	A, B, C, D, E	
	3 12 256 M6	12	6.9	0.8	27.5	0.7	-	M 6	11.5	3	A, B, C, D, E	
	4 16 256	16	6.9	0.8	27.5	1.3	-	M 8	13.8	4	A, B, C, D, E	
	5 20 256	20	6.9	0.8	27.5	1.3	-	M 10	18	5	A, B, C, D, E	

End mill bodies with plain shanks and flats

	15 10 156	10	6.9	0.8	16.7	0.7	55.6	diam. 10	-	2	A, B, C, D, E	
	15 12 156	12	6.9	0.8	17.5	0.7	60.5	diam. 12	-	3	A, B, C, D, E	
	40 16 156	16	6.9	0.8	42.5	1.3	90.5	diam. 16	-	4	A, B, C, D, E	

Accessories

<p>18 500 Torx screw A > Page 195</p>	<p>POKOLM 06 500 Torx-screwdriver B > Page 196</p>	<p>TV 04-1 Screwdriver torque Vario®-S with window scale, C > Page 197</p>	<p>T6 500 Torx interchangeable bit for Torque Vario® D > Page 197</p>	<p>T6 502 Torx MagicSpring compatible bit f. Torque Vario® E > Page 198</p>	
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Indexable inserts	Catalogue no.	DIN Specification	Carbide Grade	Coating	l	s	r	M
		02 71 840 R08	XOMX 060208	P40	PVML	6.9	2.45	0.8

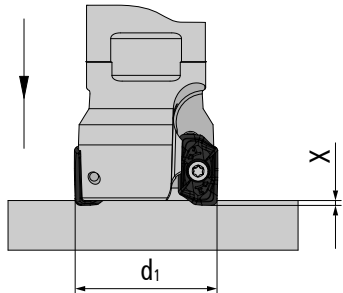
Feed per tooth (fz) | d.o.c. (ap)

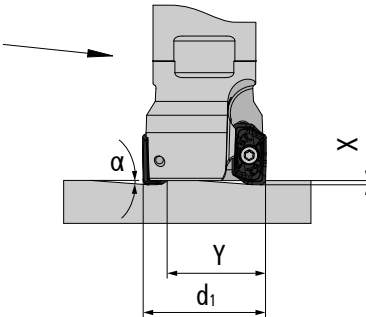
Material		steel	stainless steel	cast iron	non-ferrous materials	high-temperature alloys	hardened steel
Quality Coating	Feed per tooth d.o.c.						
P40 PVML	f _z (mm) a _p (mm)	0,05-0,17 0,2-3	0,02-0,17 0,1-2,5	0,05-0,17 0,2-2	-	-	-

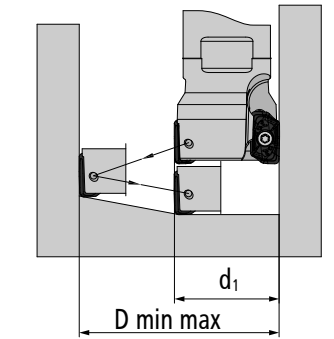
Cutting speed (Vc in m/min)

Material		steel	stainless steel	cast iron	non-ferrous materials	high-temperature alloys	hardened steel
Quality Coating	Application						
P40 PVML	roughing pre finishing finishing	▽100 200 300 ▽100 200 300 -	▽80 130 180 - -	▽140 170 200 - -	-	-	-

Extended operation data

Plunging	
	
Cutter diam. d1	X _{max}
10-12	0.7
16-20	1.3

Ramping		
		
Cutter diam. d1	α°	y
10	<10	3
12	<6,5	5
16	<4	9
20	<2,5	13

Helix		
		
Cutter diam. d1	D _{min}	D _{max}
10	13	20
12	17	24
16	25	32
20	33	40