



SPINWORX®

r5 - diam. 20 - 52 mm, 7° positive rake angle

The all-rounders in the SPINWORX series.

- wide range of use for almost all areas of application
- effective use of the cutting edge
- with specially adapted primary and secondary 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 in the tool! Wet machining up to max speed Vc of 140 m/min!

Milling cutter bodies

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

Threaded shank end mill bodies

	DR10-020-E10-02	20	10	5	29	2.5	-	M 10	18	2	A, B, C, D	
	DR10-025-E12-03	25	10	5	32.5	1.5	-	M 12	21	3	A, B, C, D	
	DR10-025-E12-04	25	10	5	32.5	1.5	-	M 12	21	4	A, B, C, D	
	DR10-030-E12-04	30	10	5	33	2.5	-	M 12	21	4	A, B, C, D	
	DR10-030-E16-04	30	10	5	43	2.5	-	M 16	29	4	A, B, C, D	
	DR10-032-E16-04	32	10	5	43	2.5	-	M 16	29	4	A, B, C, D	
	DR10-032-E16-05	32	10	5	43	2.5	-	M 16	29	5	A, B, C, D	
	DR10-035-E16-05	35	10	5	43	2.5	-	M 16	29	5	A, B, C, D	
	DR10-042-E16-06	42	10	5	43	2.5	-	M 16	29	6	A, B, C, D	

Shell-type milling cutter bodies

	DR10-040-A16-05	40	10	5	43	2.5	-	diam. 16	35	5	A, B, C, D	
	DR10-042-A16-05	42	10	5	43	2.5	-	diam. 16	35	5	A, B, C, D	
	DR10-042-A16-06	42	10	5	43	2.5	-	diam. 16	35	6	A, B, C, D	
	DR10-052-A22-07	52	10	5	52	2.5	-	diam. 22	40	7	A, B, C, D	

Accessories

<p>T10-1,4NM Torque Fix® - S torque screwdriver A > Page 197</p>	<p>T10 500 Torx interchangeable bit for Torque Vario® B > Page 197</p>	<p>T10 502 Torx MagicSpring compa- tible bit f. Torque Vario® C > Page 198</p>	<p>Z 00043 HTC ceramic paste WS 600 005 D > Page 198</p>		
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Indexable inserts	Catalogue no.	DIN Specification	Carbide Grade	Coating	d	s	r	M
	DR10-8C0	RORA 1035 MOSN	C0		10	3.5	5	
	DR10-8E0	RORA 1035 MOSN	E0		10	3.5	5	
	DR10-8B3	RORM 1035 MOEN	B3		10	3.5	5	
	DR10-8D1	RORM 1035 MOEN	D1		10	3.5	5	
	DR10-8D3	RORM 1035 MOEN	D3		10	3.5	5	
	DR10-8C4	RDRA 1035 MOSN	C4		10	3.5	5	
	DR10-8C6	RDRA 1035 MOSN	C6		10	3.5	5	
	DR10-8E4	RDRA 1035 MOSN	E4		10	3.5	5	
	DR10-8F4	RDRA 1035 MOSN	F4		10	3.5	5	
	DR10-8E6	RDRA 1035 MOSN	E6		10	3.5	5	
	DR10-8F6	RDRA 1035 MOSN	F6		10	3.5	5	
	DR10-8B7	RDRM 1035 MOEN	B7		10	3.5	5	
	DR10-8C7-P	RDRM 1035 MOEN	C7-P		10	3.5	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 _z (mm) a _p (mm)	0,1-0,45 0,2-1	-	0,15-0,35 0,1-1	-	-	0,1-0,15 0,1-0,3
E0	f _z (mm) a _p (mm)	0,1-0,45 0,2-1	-	0,15-0,25 0,1-0,55	-	-	-
B3	f _z (mm) a _p (mm)	-	0,15-0,6 0,2-2	-	-	0,1-0,4 0,15-2	-
D1	f _z (mm) a _p (mm)	-	0,15-0,6 0,2-2	-	-	0,1-0,4 0,15-2	-
D3	f _z (mm) a _p (mm)	-	0,15-0,6 0,2-2	-	0,2-0,3 0,2-1,7	0,1-0,4 0,15-2	-
C4	f _z (mm) a _p (mm)	0,1-0,45 0,2-1	-	0,15-0,35 0,1-1	-	-	0,1-0,15 0,1-0,3
C6	f _z (mm) a _p (mm)	0,1-0,45 0,2-1	-	0,15-0,35 0,1-1	-	-	0,1-0,15 0,1-0,3
E4	f _z (mm) a _p (mm)	0,1-0,45 0,2-1	-	0,15-0,25 0,1-0,55	-	-	-
F4	f _z (mm) a _p (mm)	0,1-0,5 0,2-1,5	-	0,15-0,35 0,1-1	-	-	-
E6	f _z (mm) a _p (mm)	0,1-0,45 0,2-1	-	0,15-0,25 0,1-0,55	-	-	-
F6	f _z (mm) a _p (mm)	0,1-0,5 0,2-1,5	-	0,15-0,35 0,1-1	-	-	-
B7	f _z (mm) a _p (mm)	-	0,15-0,6 0,2-2	-	-	0,1-0,4 0,15-2	-
C7-P	f _z (mm) a _p (mm)	-	-	-	0,2-0,3 0,2-1,7	-	-

major application
 minor application
 roughing
 pre-finishing
 finishing

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				-						
	finishing	-	-	-	-	-	-	-	-	-	-	-	-
B3	roughing	-	▽110 155 200	-	-	-	-	-	-	-	-	-	-
	pre finishing	-	▽120 175 230										
	finishing	-	-	-	-	-	-	-	-	-	-	-	-
D1	roughing	-	▽80 130 180	-	-	-	-	-	-	-	-	-	-
	pre finishing	-	▽100 155 210										
	finishing	-	-	-	-	-	-	-	-	-	-	-	-
D3	roughing	-	▽80 130 180	-	-	-	-	▽100 250 400	-	-	-	-	-
	pre finishing	-	▽100 155 210										
	finishing	-	-	-	-	-	-	-	-	-	-	-	-
C4	roughing	▽90	150 210	-	-	▽150	195 240	-	-	-	-	-	-
	pre finishing	▽110	165 220			▽140	205 270						
	finishing	-	-	-	-	-	-	-	-	-	-	▽35	108 180
C6	roughing	▽90	150 210	-	-	▽150	195 240	-	-	-	-	-	-
	pre finishing	▽110	165 220			▽140	205 270						
	finishing	-	-	-	-	-	-	-	-	-	-	▽35	108 180
E4	roughing	▽100	175 250	-	-	▽130	165 200	-	-	-	-	-	-
	pre finishing	▽100	200 300				-						
	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				-						
	finishing	-	-	-	-	-	-	-	-	-	-	-	-
F6	roughing	▽100	175 250	-	-	▽110	130 150	-	-	-	-	-	-
	pre finishing	▽100	200 300			▽140	180 220						
	finishing	-	-	-	-	-	-	-	-	-	-	-	-
B7	roughing	-	▽110 155 200	-	-	-	-	-	-	-	-	-	-
	pre finishing	-	▽120 175 230										
	finishing	-	-	-	-	-	-	-	-	-	-	-	-
C7-P	roughing	-	-	-	-	-	-	▽100	350 600	-	-	-	-
	pre finishing	-	-					▽200	500 800				
	finishing	-	-	-	-	-	-	-	-	-	-	-	-

Extended operation data

Plunging	
Cutter diam. d1	X _{max}
20-52	2.5

Ramping		
Cutter diam. d1	α°	y
20	<17,0	2
25	<19,5	7
30	<11,5	12
32	<10,0	14
35	<8,0	17
40	<6,0	22
42	<5,5	24
52	<4,0	34

Helix		
Cutter diam. d1	D _{min}	D _{max}
20	22	38
25	32	48
30	42	58
32	46	62
35	52	68
40	62	78
42	66	82
52	86	102