



CUTTERS FOR ROUND INSERTS - K0-90°

r3.5 - diam. 12 - 30 mm, s 1.99 mm

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

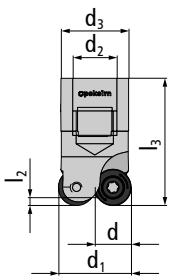
Milling cutter bodies

Catalogue no.

d_1 d r l_3 l_2 l_1 d_2 d_3 z

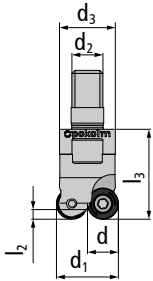
Accessories
Features

DuoPlug®



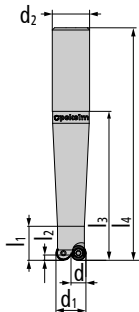
2 12 235 SG	12	7	3.5	24.5	-	-	M 7	10.8	2	B, C, D, E, F	<input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/>
3 15 235 SG	15	7	3.5	28	1.5	-	M 10	14	3	A, C, D, E, F	<input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/>
5 25 235 SG	25	7	3.5	30	1.5	-	M 16	23.5	5	A, C, D, E, F	<input type="checkbox"/> <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



12 200 M6	12	7	3.5	28.5	-	-	M 6	11.5	2	B, C, D, E, F	<input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/>
12 200	12	7	3.5	28.5	-	-	M 8	11.8	2	B, C, D, E, F	<input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/>
3 15 235	15	7	3.5	28.5	1.5	-	M 8	13.8	3	A, C, D, E, F	<input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/>
4 20 235	20	7	3.5	28.5	1.5	-	M 10	18	4	A, C, D, E, F	<input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/>
5 25 235	25	7	3.5	28.5	1.5	-	M 12	21	5	A, C, D, E, F	<input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/>
6 30 235	30	7	3.5	28.5	1.5	-	M 16	29	6	A, C, D, E, F	<input type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/>

Plain shank end mill bodies

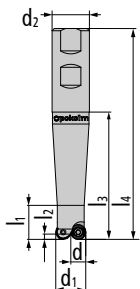


30 12 100	12	7	3.5	30	-	23	diam. 12	-	2	B, C, D, E, F	<input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/>

Milling cutter bodies







Catalogue no. d_1 d r l_3 l_2 l_1 d_2 d_3 z Accessories Features

End mill bodies with plain shanks and flats



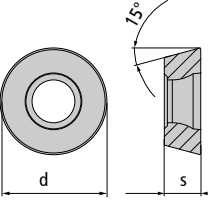
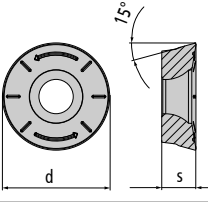
40 12 100	12	7	3.5	40	-	19.5	diam. 16	-	2	B, C, D, E, F	
60 12 100	12	7	3.5	60	-	19.5	diam. 16	-	2	B, C, D, E, F	
80 12 100	12	7	3.5	80	-	19.5	diam. 16	-	2	B, C, D, E, F	
30 15 100	15	7	3.5	30	1.2	19.5	diam. 12	-	3	A, C, D, E, F	

Accessories

 25 500 Torx screw A > Page 195	 25 500 K Torx screw B > Page 195	 07 500 Torx-screwdriver C > Page 196	 TV 04-1 Screwdriver torque Vario®-S with window scale, D > Page 197	 T7 500 Torx interchangeable bit for Torque Vario® E > Page 197	 T7 502, Torx Magic-Spring compatible bit f. Torque Vario® F > Page 198
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Indexable inserts






Catalogue no. DIN Specification Carbide Grade Coating d s r M

01 07 835	RDHX 07T1 M0T	HSC 05	PVTi	7	1.99	3.5	M 2.5
01 07 840	RDHX 07T1 M0T	P40	PVTi	7	1.99	3.5	M 2.5
01 07 842	RDEX 07T1 M0T	P40	PVSR	7	1.99	3.5	M 2.5
01 07 8042	RDEX 07T1 M0T	P40	PCSR	7	1.99	3.5	M 2.5
01 07 860	RDHX 07T1 M0T	K10	PVTi	7	1.99	3.5	M 2.5
01 07 831P	RDHX 07T1 M0E	K10	polished	7	1.99	3.5	M 2.5
01 07 880 D	RDHX 07T1 M0E	K10	PVDiaN	7	1.99	3.5	M 2.5
01 07 880	RDHX 07T1 M0E	K10	PVTi	7	1.99	3.5	M 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) a_p (mm)	0,1-0,2 0,1-0,3	0,1 0,1	0,1-0,3 0,1-0,5	0,1-0,2 0,1-0,4	-	0,1-0,12 0,1-0,15
P40 PVTi	f_z (mm) a_p (mm)	0,1-0,3 0,1-0,5	-	-	-	-	-
P40 PVSR	f_z (mm) a_p (mm)	0,1-0,3 0,1-0,7	-	0,1-0,3 0,1-0,5	-	-	0,1-0,15 0,1-0,2
P40 PCSR	f_z (mm) a_p (mm)	0,05-0,45 0,05-0,7	-	0,1-0,4 0,05-0,65	-	-	-
K10 PVTi	f_z (mm) a_p (mm)	0,1 0,1	0,1 0,1	0,1-0,3 0,1-0,5	-	0,1-0,15 0,1-0,3	0,1-0,12 0,1-0,15
K10 polished	f_z (mm) a_p (mm)	-	-	-	0,1-0,3 0,1-0,7	-	-
K10 PVDiaN	f_z (mm) a_p (mm)	-	-	-	0,1-0,3 0,1-0,7	-	-

 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														
HSC 05 PVTi	roughing	-	-	▽100	150	200	-	-	-	-	-	-	-		
	pre finishing	▽150	275	400	-	-	▽150	225	300	▽200	500	800	▽35	143	250
P40 PVTi	roughing	▽100	160	220	-	-	-	-	-	-	-	-	-		
	pre finishing	▽100	175	250	-	-	-	-	-	-	-	-	-		
P40 PVSR	roughing	▽100	200	300	-	-	▽160	190	220	-	-	-	-		
	pre finishing	▽100	200	300	-	-	▽160	190	220	-	-	▽70	110	150	
P40 PCSR	roughing	▽130	190	250	-	-	▽120	170	220	-	-	-	-		
	pre finishing	▽150	225	300	-	-	▽150	200	250	-	-	-	-		
K10 PVTi	roughing	-	-	-	-	-	▽150	175	200	▽100	450	800	▽35	43	50
	pre finishing	-	-	-	-	-	▽150	175	200	▽100	450	800	▽35	43	50
K10 polished	roughing	-	-	-	-	-	▽150	200	250	▽100	450	800	▽35	43	50
	pre finishing	▽140	220	300	▽120	150	180	▽150	200	250	▽100	450	800	▽35	108
K10 PVDiaN	roughing	-	-	-	-	-	-	-	-	-	-	-	-		
	pre finishing	-	-	-	-	-	-	-	-	-	-	-	-		

Extended operation data

Plunging

Cutter diam. d1	X _{max}
12-30	1.2

Ramping

Cutter diam. d1	α°	y
12	-	-
15	<26,5	2
20	<8,5	8
25	<5,3	13
30	<3,8	18

Helix

Cutter diam. d1	D _{min}	D _{max}
12	14	24
15	17	30
20	28	40
25	38	50
30	48	60