



BASEWORX®

diam. 35 - 125 mm

Remarkably economic face milling cutters for highly efficient milling with medium depths of cut.

These tools stand out on account of their reduced power consumption.

These milling cutters can also be used for chamfering.

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

Threaded shank end mill bodies												
	3 35 288	35	12.7		42	3.5	-	M 16	29	3	A, C, D, E, F	☑ ☐ ☐ ☐

Shell type milling cutter bodies												
	4 40 388	40	12.7		42	3.5	-	diam. 16	35	4	A, B, C, D, E, F	☐ ☐ ☐ ☐
	4 42 388	42	12.7		42	3.5	-	diam. 16	35	4	A, B, C, D, E, F	☑ ☐ ☐ ☐
	5 50 388	50	12.7		52	3.5	-	diam. 22	40	5	A, C, D, E, F	☐ ☐ ☐ ☐
	5 52 388	52	12.7		52	3.5	-	diam. 22	40	5	A, C, D, E, F	☑ ☐ ☐ ☐
	7 63 388	63	12.7		52	3.5	-	diam. 27	48	7	A, C, D, E, F	☐ ☐ ☐ ☐
	7 66 388	66	12.7		52	3.5	-	diam. 27	48	7	A, C, D, E, F	☑ ☐ ☐ ☐
	8 80 388	80	12.7		52	3.5	-	diam. 27	60	8	A, C, D, E, F	☑ ☐ ☐ ☐
	9 100 388	100	12.7		52	3.5	-	diam. 32	70	9	A, C, D, E, F	☑ ☐ ☐
	12 125 388	125	12.7		52	3.5	-	diam. 40	90	12	A, C, D, E, F	☑ ☐ ☐

Accessories					
<p>40 505 K Torx screw A > Page 195</p>	<p>GWSTPS8ISK hexagon socket set screw B > Page 196</p>	<p>15 500 P Torx-screwdriver (Torx-Plus) C > Page 196</p>	<p>TV 2-8 Screwdriver torque Vario®-S with window scale, D > Page 197</p>	<p>T15 500 P Torx interchangeable bit for Torque Vario® E > Page 197</p>	<p>T15 502 P, Torx MagicSpring compatible bit f. Torque Vario® F > Page 198</p>

Indexable inserts	Catalogue no.	DIN Specification	Carbide Grade	Coating	DIN Specification			
					l	s	r	M
	03 88 831P	OFET 05T310 FN	K10	polished	12.7	3.77	-	M 4.0
	03 88 840	OFMW 05T310 SN	P40	PVTi	12.7	3.77	-	M 4.0

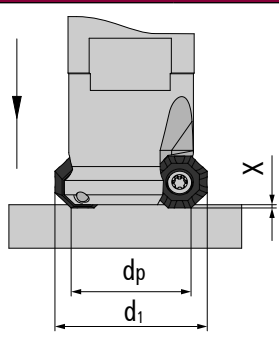
Feed per tooth (fz) | d.o.c. (ap)

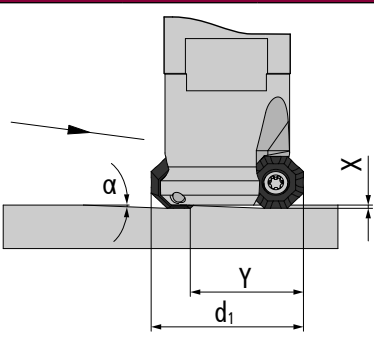
Material		steel	stainless steel	cast iron	non-ferrous materials	high-temperature alloys	hardened steel
Quality Coating	Feed per tooth d.o.c.						
K10 polished	f _z (mm) a _p (mm)	-	-	-	0,08-0,3 0,1-3,5	-	-
P40 PVTi	f _z (mm) a _p (mm)	0,1-0,5 0,2-3	-	0,1-0,5 0,2-3	-	-	-

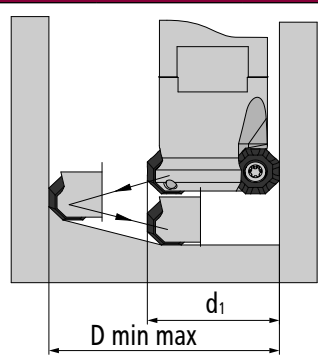
Cutting speed (Vc in m/min)

Material		steel	stainless steel	cast iron	non-ferrous materials	high-temperature alloys	hardened steel
Quality Coating	Application						
K10 polished	roughing pre finishing finishing	-	-	-	▽100 450 800 ▽100 450 800 ▽100 450 800	-	-
P40 PVTi	roughing pre finishing finishing	▽100 160 220 ▽100 175 250 ▽140 200 260	-	▽100 130 160 ▽100 130 160 -	-	-	-

Extended operation data

Plunging	
	
Cutter diam. d1	X _{max}
35-125	3.5

Ramping		
		
Cutter diam. d1	α°	y
35	<16	11.6
40	<11	16.6
42	<10	18.6
50	<7	26.6
52	<6,5	28.6
63	<4,5	39.6
66	<4	42.6
80	<3	56.6
100	<2	76.6
125	<1,5	101.6

Helix		
		
Cutter diam. d1	D _{min}	D _{max}
35	46.6	70
40	56.6	80
42	60.6	84
50	76.6	100
52	80.6	104
63	102.6	126
66	108.6	132
80	136.6	160
100	176.6	200
125	226.6	250