

CUTTERS FOR ROUND INSERTS - K0-90°

r10 - diam. 40 - 160 mm, neutral, 7° positive

These tools have extremely rigid inserts, which provide optimal conditions for heavy-duty milling operations under most difficult conditions and allows for very high-performance milling and extremely high feed-rates.

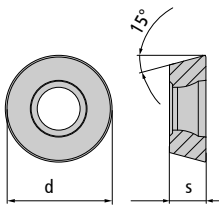
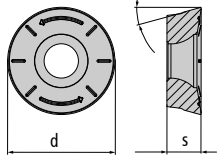


Milling cutter bodies	Catalogue no.										Accessories		Features
	d ₁	d	r	l ₃	l ₂	l ₁	d ₂	d ₃	z				

Threaded shank end mill bodies												
	40 200	40	20	10	53.5	-	-	M 16	29	2	A, B, C, D, E, F	

Shell tp. mill. cutt. bodies 7° pos. rake angle												
	5 66 340/7	66	20	10	53	6.5	-	diam. 27	48	5	A, B, C, D, E, F	
	80 340/7	80	20	10	53	6.5	-	diam. 27	60	5	A, B, C, D, E, F	
	100 340/7	100	20	10	53	6.5	-	diam. 32	70	6	A, B, C, D, E, F	
	125 340/7	125	20	10	53	6.5	-	diam. 40	90	7	A, B, C, D, E, F	
	160 340/7	160	20	10	53	6.5	-	diam. 40	120	8	A, B, C, D, E, F	

Accessories					
<p>45 500 Torx screw A > Page 195</p>	<p>10 510 locking washer B > Page 196</p>	<p>20 500 Torx-screwdriver C > Page 196</p>	<p>TV 2-8 Screwdriver torque Vario®-S with window scale, D > Page 197</p>	<p>T20 500 Torx interchangeable bit for Torque Vario® E > Page 197</p>	<p>T20 502, Torx Magic- Spring compatible bit f. Torque Vario® F > Page 198</p>

Indexable inserts	Catalogue no.	DIN Specification	Carbide Grade	Coating	d	s	r	M
	06 20 835	RDMX 2006 M0T	HSC 05	PVTi	20	6	10	M 4.5
	06 20 840	RDMX 2006 M0T	P40	PVTi	20	6	10	M 4.5
	06 20 850	RDMX 2006 M0T	P25	PVTi	20	6	10	M 4.5
	06 20 860	RDMX 2006 M0T	K10	PVTi	20	6	10	M 4.5
	06 20 831P	RDHT 2006 M0T	K10	polished	20	6	10	M 4.5
	06 20 880	RDHT 2006 M0T	K10	PVTi	20	6	10	M 4.5

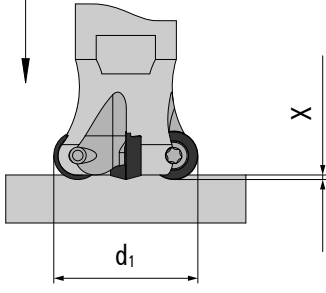
Feed per tooth (fz) | d.o.c. (ap)

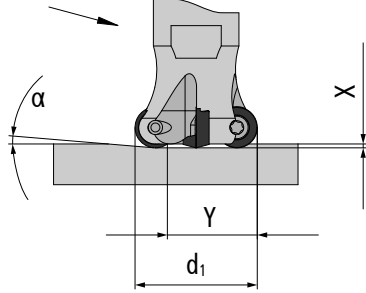
Material		steel	stainless steel	cast iron	non-ferrous materials	high-temperature alloys	hardened steel
HSC 05 PVTi	f _z (mm)	0,25-0,32	0,15	0,25-0,6	0,25-0,42	-	0,2-0,3
	a _p (mm)	0,2-1,1	0,1	0,2-4	0,2-5	-	0,2-1,1
P40 PVTi	f _z (mm)	0,25-1,2	-	-	-	-	-
	a _p (mm)	0,2-5	-	-	-	-	-
P25 PVTi	f _z (mm)	0,25-0,6	-	0,25-0,42	-	-	-
	a _p (mm)	0,2-4	-	0,2-2,1	-	-	-
K10 PVTi	f _z (mm)	-	0,15	-	0,25-0,6	0,2-0,4	-
	a _p (mm)	-	0,1	-	0,2-5	0,2-3	-
K10 polished	f _z (mm)	-	-	-	0,25-0,6	-	-
	a _p (mm)	-	-	-	0,2-5	-	-

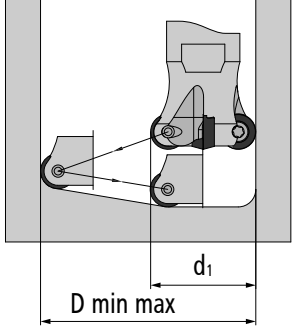
Cutting speed (Vc in m/min)

Material		steel	stainless steel	cast iron	non-ferrous materials	high-temperature alloys	hardened steel
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	-	-	-	-	-
P25 PVTi	roughing	▽100 200 300	-	-	-	-	-
	pre finishing	▽100 125 150	-	▽130 150 170	-	-	-
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	-	-	-	▽100 450 800	-	-
	pre finishing	-	-	-	▽100 450 800	-	-

Extended operation data

Plunging	
	
Cutter diam. d1	X _{max}
40-160	5

Ramping		
		
Cutter diam. d1	α°	y
40	-	-
66	<10,1	28
80	<6,8	42
100	<4,6	62
125	<3,3	87
160	<2,3	122

Helix		
		
Cutter diam. d1	D _{min}	D _{max}
40	42	80
66	94	132
80	122	160
100	162	200
125	212	250
160	282	320