



VDGT - K93°

diam. 15 - 42 mm | r1

These milling cutters are especially suitable for milling aluminium, copper, plastics and graphite. It allows very easy cutting and very high cutting speeds and feed rates. These inserts have a 3° clearance (kappa 93°) - a design specially for milling vertical walls.

Only for roughing and pre-finishing operations!

Milling cutter bodies

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

DuoPlug®

	16 261-3 SG	16	9	1	38	4	-	M 10	15	2	A, B, C, D, E	<input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/>
	20 261-3 SG	20	9	1	39.5	4	-	M 12	18.5	2	A, B, C, D, E	<input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/>
	25 261-3 SG	25	9	1	42.5	4	-	M 16	23.5	3	A, B, C, D, E	<input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/>

Threaded shank end mill bodies

	15 261-3	15	9	1	35	4	-	M 8	13.8	2	A, B, C, D, E	<input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/>
	16 261-3	16	9	1	35.5	4	-	M 8	13.8	2	A, B, C, D, E	<input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/>
	20 261-3	20	9	1	35.5	4	-	M 10	18	2	A, B, C, D, E	<input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/>
	25 261-3	25	9	1	40	4	-	M 12	21	3	A, B, C, D, E	<input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/>
	32 261-3	32	9	1	47.5	4	-	M 16	29	4	A, B, C, D, E	<input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/>
	42 261-3	42	9	1	42.5	4	-	M 16	29	5	A, B, C, D, E	<input type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/>

Accessories

<p>25 500 Torx screw A > Page 195</p>	<p>07 500 Torx-screwdriver B > Page 196</p>	<p>TV 04-1 Screwdriver torque Vario®-S with window scale, C > Page 197</p>	<p>T7 500 Torx interchangeable bit for Torque Vario® D > Page 197</p>	<p>T7 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	DIN Specification			
				l	s	r	M
02 11 820	VDGT 11T210 FN	K10	polished	9	2.78	1	M 2.5
02 11 860	VDGT 11T210 FN	K10	PVTi	9	2.78	1	M 2.5
02 11 860 D	VDGT 11T210 FN	K10	PVDiaN	9	2.78	1	M 2.5

latest items!

available as long as stock lasts

on request

stock item, subject to confirmation

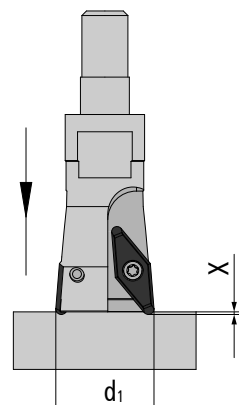
Feed per tooth (fz) | d.o.c. (ap)

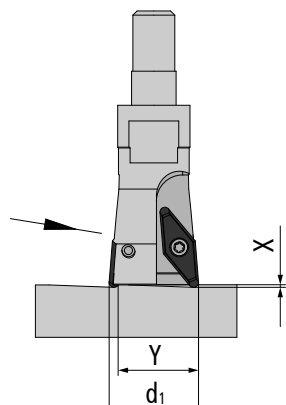
Material		steel	stainless steel	cast iron	non-ferrous materials	high-temperature alloys	hardened steel
Quality Coating	Feed per tooth d.o.c.						
K10 polished	f _z (mm) a _p (mm)	-	-	-	0,05-0,3 0,1-2,5	-	-
K10 PVTi	f _z (mm) a _p (mm)	-	-	-	0,05-0,3 0,1-2,5	-	-
K10 PVDiaN	f _z (mm) a _p (mm)	-	-	-	0,05-0,3 0,1-2,5	-	-

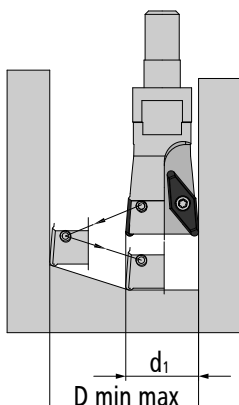
Cutting speed (Vc in m/min)

Material		steel	stainless steel	cast iron	non-ferrous materials	high-temperature alloys	hardened steel
Quality Coating	Application						
K10 polished	roughing	-	-	-	▽100 450 800	-	-
	pre finishing	-	-	-	▽100 450 800	-	-
	finishing	-	-	-	-	-	-
K10 PVTi	roughing	-	-	-	▽100 450 800	-	-
	pre finishing	-	-	-	▽100 450 800	-	-
	finishing	-	-	-	-	-	-
K10 PVDiaN	roughing	-	-	-	▽100 450 800	-	-
	pre finishing	-	-	-	▽100 450 800	-	-
	finishing	-	-	-	-	-	-

Extended operation data

Plunging	
	
Cutter diam. d1	X _{max}
15-42	4

Ramping		
		
Cutter diam. d1	α°	y
15	<63,4	2
16	<45	4
20	<26,6	8
25	<17,1	13
32	<11,3	20
42	<7,6	30

Helix		
		
Cutter diam. d1	D _{min}	D _{max}
15	26	30
16	28	32
20	36	40
25	46	50
32	60	64
42	80	84