



DOUBLETRIGA

Size M

- six cutting edges per insert for maximum efficiency
- high cutting rate while maintaining an excellent finish quality
- all tools feature an internal coolant supply
- high feed rates of up to f_z 1.5 mm are feasible
- secure positioning and fixation with anti-twist protection of the inserts

Milling cutter bodies

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

Threaded shank end mill bodies	Catalogue no.	Dimensions									Accessories	Features	
		d_1	d	r	l_3	l_2	l_1	d_2	d_3	z			
	2 32 290	32	12	1 3	42.5	1	-	M 16	29	2	A, C, D, E, F	<input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/>	
	3 35 290	35	12	1 3	42.5	1	-	M 16	29	3	A, C, D, E, F	<input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/>	

Shell-type milling cutter bodies

Shell-type milling cutter bodies	Catalogue no.	Dimensions									Accessories	Features
		d_1	d	r	l_3	l_2	l_1	d_2	d_3	z		
	4 42 390	42	12	1 3	40	1	-	diam. 16	35	4	A, B, C, D, E, F	<input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/>
	5 52 390	52	12	1 3	50	1	-	diam. 22	48	5	A, C, D, E, F	<input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/>
	6 66 390	66	12	1 3	50	1	-	diam. 27	48	6	A, C, D, E, F	<input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/>
	8 80 390	80	12	1 3	50	1	-	diam. 27	60	8	A, C, D, E, F	<input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/>

Accessories

<p>35 505 P Torx screw A > Page 195</p>	<p>GWSTPS8ISK hexagon socket set screw B > Page 196</p>	<p>POKOLM 10 500 P Torx-screwdriver (Torx-Plus) C > Page 196</p>	<p>TV 1-5 Screwdriver torque Vario®-S with window scale, D > Page 197</p>	<p>T10 500 P Torx interchangeable bit for Torque Vario® E > Page 197</p>	<p>T10 502 P, Torx MagicSpring compatible bit f. Torque Vario® F > Page 198</p>
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Indexable inserts

Indexable inserts	Catalogue no.	DIN Specification	Carbide Grade	Coating	Dimensions			
					d	s	r	M
	05 90 854	WNHX 125010 ER	P25	PVGO	12	5	1	M 3,5
	05 90 850 R30	WNHX 125030 SR	P25	PVSR	12	5	3	M 3,5
	05 90 860 R30	WNHX 125030 SR	K10	PVTi	12	5	3	M 3,5
	05 90 890 R30	WNHX 125030 SR	M40	PVST	12	5	3	M 3,5

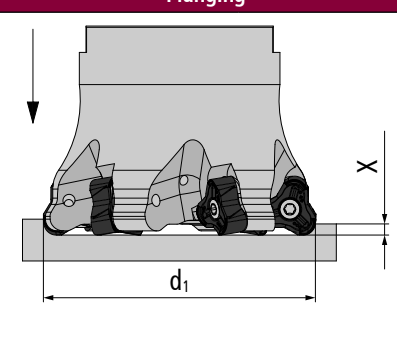
Feed per tooth (fz) | d.o.c. (ap)

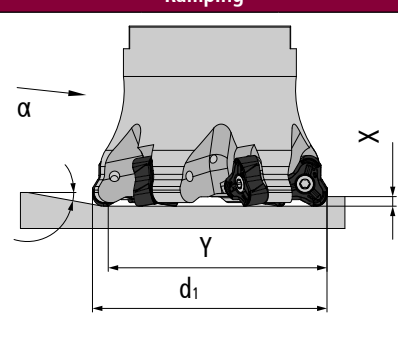
Material		steel	stainless steel	cast iron	non-ferrous materials	high-temperature alloys	hardened steel
Quality Coating	Feed per tooth d.o.c.						
r=1 mm							
P25 PVGO	f _z (mm) a _p (mm)	0,07-0,5 0,1-3	0,07-0,2 0,1-1	0,07-0,6 0,1-3,5	-	0,07-0,15 0,1-1	-
r=3 mm							
P25 PVSR	f _z (mm) a _p (mm)	0,15-1,5 0,1-1,5	-	0,15-1,5 0,1-1,5	-	-	-
K10 PVTi	f _z (mm) a _p (mm)	0,15-1,5 0,1-1,5	-	0,15-1,5 0,1-1,5	-	-	-
M40 PVST	f _z (mm) a _p (mm)	-	0,05-0,5 0,1-1,5	-	-	0,08-0,4 0,1-1,2	-

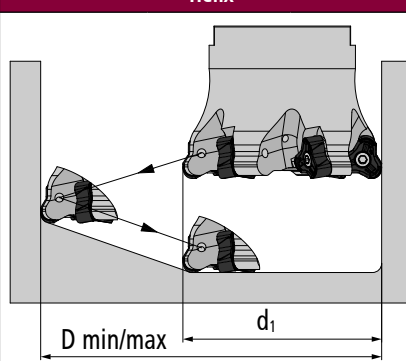
Cutting speed (Vc in m/min)

Material		steel	stainless steel	cast iron	non-ferrous materials	high-temperature alloys	hardened steel
Quality Coating	Application						
P25 PVGO	roughing	▽110 165 220	-	▽120 145 170	-	-	-
	pre finishing	▽120 185 250	-	▽130 150 170	-	-	-
	finishing	▽150 225 300	▽120 175 230	▽135 193 250	-	▽30 70 110	-
P25 PVSR	roughing	▽100 160 220	-	▽140 180 220	-	-	-
	pre finishing	▽100 180 260	-	▽160 190 220	-	-	-
	finishing	▽150 225 300	-	▽160 190 220	-	-	-
K10 PVTi	roughing	▽130 170 210	-	▽150 175 200	-	-	-
	pre finishing	▽150 185 220	-	▽150 175 200	-	-	-
	finishing	▽140 220 300	-	▽150 200 250	-	-	-
M40 PVST	roughing	-	▽80 130 180	-	-	▽30 55 80	-
	pre finishing	-	▽100 155 210	-	-	▽40 65 90	-
	finishing	-	▽120 185 250	-	-	▽60 90 120	-

Extended operation data

Plunging	
	
Cutter diam. d1	X _{max}
32-80	1

Ramping		
		
Cutter diam. d1	α°	y
32	<3	17.2
35	<2,8	20.2
42	<2,1	27.2
52	<1,5	37.2
66	<1,1	51.2
80	<0,8	65.2

Helix		
		
Cutter diam. d1	D _{min}	D _{max}
32	49.2	62
35	55.2	68
42	69.2	82
52	89.2	102
66	117.2	130
80	145.2	158