



VDGT - K90°

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.
Only for roughing and pre-finishing operations!

Milling cutter bodies

DuoPlug®	Catalogue no.										Accessories	Features
	d ₁	l	r	l ₃	l ₂	l ₁	d ₂	d ₃	z			
	16 261 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 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 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	15	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"/>
	16 261	16	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"/>
	20 261	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"/>
	25 261	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"/>
	32 261	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"/>
	42 261	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"/>

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

Indexable inserts	Catalogue no.				DIN Specification		Carbide Grade		Coating		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						

NEW latest items!

available as long as stock lasts

on request

stock item, subject to confirmation

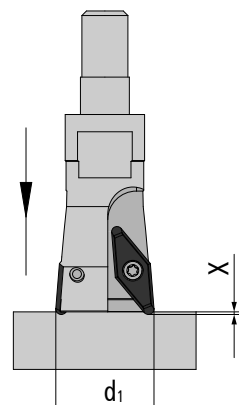
Feed per tooth (fz) | d.o.c. (ap)

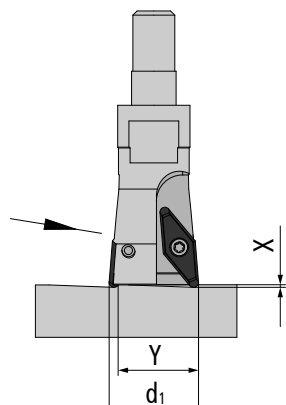
Material		steel	stainless steel	cast iron	non-ferrous materials	high-temperature alloys	hardened steel
Quality Coating	Feed per tooth d.o.c.						
K10 polished	f _z (mm) a _p (mm)	-	-	-	0,05-0,3 0,1-2,5	-	-
K10 PVTi	f _z (mm) a _p (mm)	-	-	-	0,05-0,3 0,1-2,5	-	-
K10 PVDiaN	f _z (mm) a _p (mm)	-	-	-	0,05-0,3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

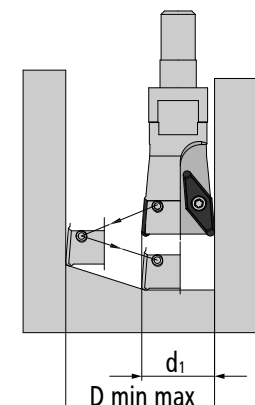
Cutting speed (Vc in m/min)

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