

QUADWORX®

Size L

- four cutting edges per insert for extremely efficient operations
- very big metal removal rates and extremely easy cutting
- as a standard, every tool has our patent protected incorporated insert seats and internal coolant supply
- allows extremely high feed rates per tooth up to $f_z = 2.5 \text{ mm}$

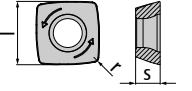
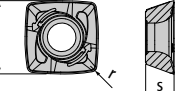


Milling cutter bodies		Catalogue no.										Accessories		Features
		d_1	l	r_p^*	l_3	l_2	l_1	d_2	d_3	z				

Threaded shank end mill bodies													
	3 35 249	35	10	2.3*	42	2.5	-	M 16	29	3	A, B, C, D, E		
	4 42 249	42	10	2.3*	42	2.5	-	M 16	29	4	A, B, C, D, E		

Shell type milling cutter bodies													
	4 42 349	42	10	2.3*	42	2.5	-	diam. 16	35	4	A, C, E, F, H		
	5 52 349	52	10	2.3*	52	2.5	-	diam. 22	40	5	B, D, E, G, I		
	7 66 349	66	10	2.3*	52	2.5	-	diam. 27	48	7	B, D, E, G, I		
	8 80 349	80	10	2.3*	52	2.5	-	diam. 27	60	8	B, D, E, G, I		

Accessories						* corner radius to be programmed
<p>40 505 K Torx screw A > Page 195</p>	<p>40 505 P Torx screw B > Page 195</p>	<p>15 500 Torx-screwdriver C > Page 196</p>	<p>15 500 P Torx-screwdriver (Torx-Plus) D > Page 196</p>	<p>TV 2-8 Screwdriver torque Vario®-S with window scale E > Page 197</p>	<p>T15 500 Torx interchangeable bit for Torque Vario® F > Page 197</p>	
<p>T15 500 P Torx interchangeable bit for Torque Vario® G > Page 197</p>	<p>T15 502 Torx MagicSpring compatible bit f. Torque Vario®, H > Page 198</p>	<p>T15 502 P Torx MagicSpring compatible bit f. Torque Vario® I > Page 198</p>				

Indexable inserts	Catalogue no.	DIN Specification	Carbide Grade	Coating	l	s	r	M
	04 49 842	SDMX 100510 SN	P40	PVTi	10	5	1	M 4.0
	04 49 846	SDMX 100510 SN	P40	PVGO	10	5	1	M 4.0
	04 49 852	SDMX 100510 SN	P25	PVTi	10	5	1	M 4.0
	04 49 860	SDHX 100510 SN	K10	PVTi	10	5	1	M 4.0
	04 49 896	SDMT 100510 SN	M40	PVST	10	5	1	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.						
P40 PVTi	f _z (mm) a _p (mm)	0,5-2,5 0,3-1,5	-	-	-	-	-
P40 PVGO	f _z (mm) a _p (mm)	0,5-2,5 0,3-1,5	-	-	-	-	-
P25 PVTi	f _z (mm) a _p (mm)	0,5-2,5 0,3-1,5	-	-	-	-	-
K10 PVTi	f _z (mm) a _p (mm)	-	-	0,5-2,5 0,3-1,7	-	-	0,3-1,5 0,3-0,8
M40 PVST	f _z (mm) a _p (mm)	-	0,3-1,5 0,25-1,3	-	-	0,3-1 0,25-0,9	-

Cutting speed (Vc in m/min)

Material		steel	stainless steel	cast iron	non-ferrous materials	high-temperature alloys	hardened steel
Quality Coating	Application						
P40 PVTi	roughing	▽100 160 220	-	-	-	-	-
	pre finishing	▽100 175 250	-	-	-	-	-
P40 PVGO	roughing	▽100 150 200	-	-	-	-	-
	pre finishing	▽100 150 200	-	-	-	-	-
P25 PVTi	roughing	▽100 200 300	-	-	-	-	-
	pre finishing	▽100 125 150	-	-	-	-	-
K10 PVTi	roughing	-	-	▽150 175 200	-	-	▽100 175 250
	pre finishing	-	-	▽150 175 200	-	-	▽120 150 180
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	D_p	X_{max}
35	17.7	2.5
42	24.7	2.5
52	34.7	2.5
66	48.7	2.5
80	62.7	2.5

Ramping		
Cutter diam. d1	α°	y
35	<8,3	17
42	<5,9	24
52	<4,2	34
66	<2,9	48
80	<2,3	62

Helix		
Cutter diam. d1	D_{min}	D_{max}
35	52	70
42	66	84
52	86	104
66	114	132
80	142	160

Technical information

	<p>For the CAD/CAM set-up please program 2.3 mm corner radius (r_p). The remainder of the material is theoretically 0.83 mm (t). Please use „d_p“ for tool length measurement.</p>
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