



# TRIGAWORX®

## Size S

- allows extremely high feed rates per tooth up to  $fz = 1.5 \text{ mm}$
- better utilization of insert because of its 3 effective cutting edges
- very smooth operation, especially in deep slots or profiles

**Especially for roughing operations**

### Milling cutter bodies

Milling cutter bodies	Catalogue no.	Dimensions										Accessories	Features
		$d_1$	$l$	$r_p^*$	$l_3$	$l_2$	$l_1$	$d_2$	$d_3$	$z$			
	2 16 272 SG	16	7	1.5*	38.5	1	-	M 10	15	2	A, B, C, D, E, F	<input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/>	

### Threaded shank end mill bodies

	2 16 272	16	7	1.5*	28.5	1	-	M 8	13.8	2	A, B, C, D, E, F	<input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/>	
	3 20 272	20	7	1.5*	28.5	1	-	M 10	18	3	A, B, C, D, E, F	<input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/>	
	4 25 272	25	7	1.5*	32.5	1	-	M 12	21	4	A, B, C, D, E, F	<input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/>	

\* corner radius to be programmed

### Accessories

<p>25 500 Torx screw A &gt; Page 195</p>	<p>POKOLM 07 500 Torx-screwdriver B &gt; Page 196</p>	<p>TV 04-1 Screwdriver torque Vario®-S with window scale, C &gt; Page 197</p>	<p>T7 500 Torx interchangeable bit for Torque Vario® D &gt; Page 197</p>	<p>T7 502 Torx MagicSpring compatible bit f. Torque Vario® E &gt; Page 198</p>	<p>12 510 clamping claw for Trigaworx® S F &gt; Page 198</p>
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### Indexable inserts

Indexable inserts	Catalogue no.	DIN Specification	Carbide Grade	Coating	Geometry			
					$l$	$s$	$r$	$M$
	02 72 835	WDHX 070205 SN	HSC 05	PVTi	7	2.38	0.5	M 2.5
	02 72 840	WDHX 070205 SN	P40	PVTi	7	2.38	0.5	M 2.5

## 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.						
HSC 05 PVTi	f <sub>z</sub> (mm)	0,3-0,9	-	-	-	-	0,1-0,6
	a <sub>p</sub> (mm)	0,3-0,45	-	-	-	-	0,1-0,35
P40 PVTi	f <sub>z</sub> (mm)	0,9-1,5	-	-	-	-	-
	a <sub>p</sub> (mm)	0,45-0,6	-	-	-	-	-

## Cutting speed (Vc in m/min)

Material		steel	stainless steel	cast iron	non-ferrous materials	high-temperature alloys	hardened steel
Quality Coating	Application						
HSC 05 PVTi	roughing	-	-	-	-	-	-
	pre finishing	▽150 275 400	-	-	-	-	▽35 143 250
	finishing	-	-	-	-	-	-
P40 PVTi	roughing	▽100 160 220	-	-	-	-	-
	pre finishing	-	-	-	-	-	-
	finishing	-	-	-	-	-	-

## Extended operation data

Plunging		
Cutter diam. d1	D <sub>p</sub>	X <sub>max</sub>
16	8.8	1
20	12.8	1
25	17.8	1

Ramping		
Cutter diam. d1	α°	y
16	<14	4
20	<7,1	8
25	<4,4	13

Helix		
Cutter diam. d1	D <sub>min</sub>	D <sub>max</sub>
16	20	32
20	28	40
25	38	50

## Technical information



For the CAD/CAM set-up please program 1.5 mm corner radius (r<sub>p</sub>).  
The remainder of the material is theoretically 1.0 mm (t).  
Please use „d<sub>p</sub>“ for tool length measurement.