



SPINWORX®

r8 - diam. 40 - 100 mm, 7° positive rake angle

Highly efficient SPINWORX systems also available in intermediate sizes.

- wide range of use for almost all areas of application
- effective use of the cutting edge
- with specially adapted primary and secondary coolant supply.
- unrivalled in terms of machining volume and tool life.

CAUTION! PLEASE NOTE!

For optimum results with the SPINWORX®-tooling system we recommend using internal coolant supply air, emulsion or MQL for chip removal in the tool! Wet machining up to max speed Vc of 140 m/min!

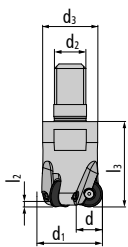
Milling cutter bodies

Catalogue no.

d₁ d r l₃ l₂ l₁ d₂ d₃ z

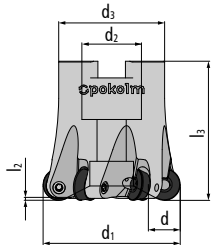
Accessories Features

Threaded shank end mill bodies



DR16-040-E16-04	40	16	8	43.5	2.5	-	M 16	29	4	C, D, E, F	<input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/>

Shell-type milling cutter bodies



DR16-052-A22-05	52	16	8	53	2.5	-	diam. 22	40	5	B, C, D, E, F	<input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/>
DR16-063-A27-07	63	16	8	53	2.5	-	diam. 27	48	7	C, D, E, F	<input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/>
DR16-066-A27-06	66	16	8	53	2.5	-	diam. 27	48	6	C, D, E, F	<input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/>
DR16-080-A27-07	80	16	8	53	2.5	-	diam. 27	60	7	C, D, E, F	<input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/>
DR16-100-A32-08	100	16	8	53	2.5	-	diam. 32	70	8	A, C, D, E, F	<input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/>

Accessories



M16X35
screw short head
A > Page 196



GWSTPS10ISK
hexagon socket set
screw
B > Page 196



T20-2,5NM
Torque Fix® - S torque
screwdriver
C > Page 197



T20 500
Torx interchangeable bit
for Torque Vario®
D > Page 197



T20 502
Torx MagicSpring compatible
bit f. Torque Vario®
E > Page 198



Z 00043
HTC ceramic paste
WS 600 005
F > Page 198

Indexable inserts	Catalogue no.	DIN Specification	Carbide Grade	Coating	d	s	r	M
	DR16-8D3	RORM 1655 MOEN	D3		16	5.5	8	
	DR16-8B3	RORM 1655 MOEN	B3		16	5.5	8	
	DR16-8C4	RDRA 1655 MOSN	C4		16	5.5	8	
	DR16-8C6	RDRA 1655 MOSN	C6		16	5.5	8	
	DR16-8E4	RDRA 1655 MOSN	E4		16	5.5	8	
	DR16-8T4	RDRA 1655 MOSN	T4		16	5.5	8	
	DR16-8T6	RDRA 1655 MOSN	T6		16	5.5	8	
	DR16-8F4	RDRA 1655 MOSN	F4		16	5.5	8	
	DR16-8E6	RDRA 1655 MOSN	E6		16	5.5	8	
	DR16-8B7	RDRM 1655 MOEN	B7		16	5.5	8	

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.						
D3	f _z (mm) a _p (mm)	-	0,2-0,7 0,5-3	-	0,25-0,4 0,3-2,5	0,1-0,5 0,2-3	-
B3	f _z (mm) a _p (mm)	-	0,2-0,7 0,5-3	-	-	0,15-0,5 0,2-3	-
C4	f _z (mm) a _p (mm)	0,2-0,7 0,2-2,5	-	0,2-0,5 0,2-3	-	-	0,15-0,22 0,2-0,55
C6	f _z (mm) a _p (mm)	0,2-0,7 0,2-2,5	-	0,2-0,5 0,2-3	-	-	0,15-0,22 0,2-0,55
E4	f _z (mm) a _p (mm)	0,2-0,7 0,2-2,5	-	0,2-0,35 0,2-1,6	-	-	-
T4	f _z (mm) a _p (mm)	0,2-0,8 0,2-3	-	0,2-0,5 0,2-3	-	-	0,1-0,2 0,2-0,45
T6	f _z (mm) a _p (mm)	0,2-0,8 0,2-3	-	0,2-0,5 0,2-3	-	-	0,1-0,2 0,2-0,45
F4	f _z (mm) a _p (mm)	0,2-0,8 0,2-3	-	0,2-0,5 0,2-3	-	-	-
E6	f _z (mm) a _p (mm)	0,2-0,7 0,2-2,5	-	0,2-0,35 0,2-1,6	-	-	-
F6	f _z (mm) a _p (mm)	0,2-0,8 0,2-3	-	0,2-0,5 0,2-3	-	-	-
B7	f _z (mm) a _p (mm)	-	0,2-0,7 0,5-3	-	-	0,15-0,5 0,2-3	-

Cutting speed (Vc in m/min)

Material		steel		stainless steel		cast iron		non-ferrous materials		high-temperature alloys		hardened steel	
Quality Coating	Application												
D3	roughing	-	▽80	130	180	-	▽100	250	400	▽30	55	80	-
	pre finishing	-	▽100	155	210	-	▽200	400	600	▽40	65	90	-
B3	roughing	-	▽110	155	200	-	-	-	-	▽30	65	100	-
	pre finishing	-	▽120	175	230	-	-	-	-	▽40	75	110	-
C4	roughing	▽90	150	210	-	▽150	195	240	-	-	-	-	-
	pre finishing	▽110	165	220	-	▽140	205	270	-	-	-	▽35	108 180
C6	roughing	▽90	150	210	-	▽150	195	240	-	-	-	-	-
	pre finishing	▽110	165	220	-	▽140	205	270	-	-	-	▽35	108 180
E4	roughing	▽100	175	250	-	-	-	-	-	-	-	-	-
	pre finishing	▽100	200	300	-	▽130	165	200	-	-	-	-	-
T4	roughing	▽100	165	230	-	▽140	180	220	-	-	-	▽70	110 150
	pre finishing	▽100	190	280	-	▽160	205	250	-	-	-	-	-
T6	roughing	▽100	165	230	-	▽140	180	220	-	-	-	▽70	110 150
	pre finishing	▽100	190	280	-	▽160	205	250	-	-	-	-	-
F4	roughing	▽100	175	250	-	▽110	130	150	-	-	-	-	-
	pre finishing	▽100	200	300	-	▽140	180	220	-	-	-	-	-
E6	roughing	▽100	175	250	-	-	-	-	-	-	-	-	-
	pre finishing	▽100	200	300	-	▽130	165	200	-	-	-	-	-
F6	roughing	▽100	175	250	-	▽110	130	150	-	-	-	-	-
	pre finishing	▽100	200	300	-	▽140	180	220	-	-	-	-	-
B7	roughing	-	▽110	155	200	-	-	-	-	▽30	65	100	-
	pre finishing	-	▽120	175	230	-	-	-	-	▽40	75	110	-

Extended operation data

Plunging

Cutter diam. d1	X _{max}
40-100	2.5

Ramping

Cutter diam. d1	α°	y
40	<14,0	10
52	<6,0	22
63	<4,0	33
66	<3,5	36
80	<2,5	50
100	<2,0	70

Helix

Cutter diam. d1	D _{min}	D _{max}
40	50	78
52	74	102
63	96	124
66	102	130
80	130	158
100	170	198