

CUTTERS FOR ROUND INSERTS - K0-90°

r3.5 - diam. 15 - 42 mm, s 2.38 mm

Our all-purpose milling cutter:

- for high-speed machining centres
- for roughing and finishing applications



Milling cutter bodies	Catalogue no.											Accessories	Features
		d ₁	d	r	l ₃	l ₂	l ₁	d ₂	d ₃	z			

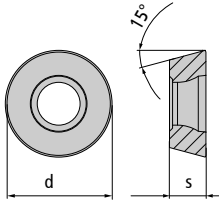
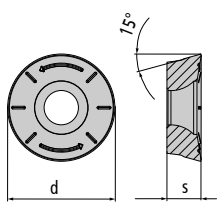
DuoPlug®													
	2 16 200 SG	16	7	3.5	28.5	1.5	-	M 10	15	2	A, B, C, D, E		
	3 16 200 SG	16	7	3.5	28.5	1.5	-	M 10	15	3	A, B, C, D, E		
	4 20 200 SG	20	7	3.5	28.5	1.5	-	M 12	18.6	4	A, B, C, D, E		
	5 25 200 SG	25	7	3.5	30	1.5	-	M 16	23.5	5	A, B, C, D, E		

Threaded shank end mill bodies													
	15 200	15	7	3.5	28.5	1.5	-	M 8	13.8	2	A, B, C, D, E		
	3 16 200	16	7	3.5	28.5	1.5	-	M 8	13.8	3	A, B, C, D, E		
	4 20 200	20	7	3.5	28.5	1.5	-	M 10	18	4	A, B, C, D, E		
	5 25 200	25	7	3.5	28.5	1.5	-	M 12	21	5	A, B, C, D, E		
	5 30 200	30	7	3.5	28.5	1.5	-	M 16	29	5	A, B, C, D, E		
	6 35 200	35	7	3.5	28.5	1.5	-	M 16	29	6	A, B, C, D, E		
	7 42 200	42	7	3.5	42.5	1.5	-	M 16	29	7	A, B, C, D, E		

End mill bodies with plain shanks and flats													
	40 15 100	15	7	3.5	40	2.6	23	diam. 16	-	2	A, B, C, D, E		
	60 15 100	15	7	3.5	60	2.6	23	diam. 16	-	2	A, B, C, D, E		
	80 15 100	15	7	3.5	80	2.6	22	diam. 20	-	2	A, B, C, D, E		
	100 15 100	15	7	3.5	100	2.6	22	diam. 20	-	2	A, B, C, D, E		

Accessories				
<p>25 500 Torx screw A > Page 195</p>	<p>POKOLM 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>

major application
 minor application
 roughing
 pre-finishing
 finishing

Indexable inserts	Catalogue no.	DIN Specification	Carbide Grade	Coating	d	s	r	M
	02 07 835	RDHX 0702 M0T	HSC 05	PVTi	7	2.38	3.5	M 2.5
	02 07 840	RDHX 0702 M0T	P40	PVTi	7	2.38	3.5	M 2.5
	02 07 842	RDEX 0702 M0T	P40	PVSR	7	2.38	3.5	M 2.5
	02 07 8042	RDEX 0702 M0T	P40	PCSR	7	2.38	3.5	M 2.5
	02 07 844	RDHX 0702 M0T	P40	PVML	7	2.38	3.5	M 2.5
	02 07 846	RDMX 0702 M0T	P40	PVGO	7	2.38	3.5	M 2.5
	02 07 850	RDHX 0702 M0T	P25	PVTi	7	2.38	3.5	M 2.5
	02 07 860	RDHX 0702 M0T	K10	PVTi	7	2.38	3.5	M 2.5
	02 07 892	RDHX 0702 M0T	CBN for steel	uncoated	7	2.38	3.5	M 2.5
	02 07 848	RDMX 0702 M0T	P40	PVGO	7	2.38	3.5	M 2.5
	02 07 831P	RDHX 0702 M0E	K10	polished	7	2.38	3.5	M 2.5
	02 07 880	RDHX 0702 M0E	K10	PVTi	7	2.38	3.5	M 2.5
	02 07 880 D	RDHX 0702 M0E	K10	PVDiaN	7	2.38	3.5	M 2.5
	02 07 896	RDMT 0702 M0EN	M40	PVST	7	2.38	3.5	M 2.5
	02 07 8099	RDMT 0702 M0EN	M35	PCTC	7	2.38	3.5	M 2.5
	02 07 897	RDPX 0702 M0T	P25	PVGO	7	2.38	3.5	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 _z (mm)	0,1-0,2	0,1	0,1-0,3	0,1-0,2	-	0,1-0,15
	a _p (mm)	0,1-0,4	0,1	0,1-0,7	0,1-0,55	-	0,1-0,2
P40 PVTi	f _z (mm)	0,2-0,5	-	-	-	-	-
	a _p (mm)	0,1-0,75	-	-	-	-	-
P40 PVSR	f _z (mm)	0,2-0,5	-	0,1-0,3	-	-	0,1-0,15
	a _p (mm)	0,1-0,75	-	0,1-0,7	-	-	0,1-0,2
P40 PCSR	f _z (mm)	0,1-0,5	-	0,1-0,4	-	-	-
	a _p (mm)	0,1-0,75	-	0,1-0,7	-	-	-
P40 PVML	f _z (mm)	0,2-0,5	-	0,1-0,3	-	-	0,1-0,15
	a _p (mm)	0,1-0,75	-	0,1-0,7	-	-	0,1-0,2
P40 PVGO	f _z (mm)	0,2-0,5	-	-	-	-	-
	a _p (mm)	0,1-0,75	-	-	-	-	-
P25 PVTi	f _z (mm)	0,1-0,3	-	0,1-0,2	-	-	-
	a _p (mm)	0,1-0,7	-	0,1-0,4	-	-	-
K10 PVTi	f _z (mm)	0,1	0,1	0,1-0,3	-	0,1-0,15	0,1-0,15
	a _p (mm)	0,1	0,1	0,1-0,7	-	0,1-0,42	0,1-0,2
CBN for steel uncoated	f _z (mm)	-	-	-	-	-	0,1-0,2
	a _p (mm)	-	-	-	-	-	0,1
K10 polished	f _z (mm)	-	-	-	0,1-0,3	-	-
	a _p (mm)	-	-	-	0,1-1	-	-
K10 PVDiaN	f _z (mm)	-	-	-	0,1-0,3	-	-
	a _p (mm)	-	-	-	0,1-1	-	-
M40 PVST	f _z (mm)	0,1-0,5	0,05-0,5	-	-	0,05-0,4	-
	a _p (mm)	0,1-0,75	0,05-0,75	-	-	0,05-0,75	-
M35 PCTC	f _z (mm)	-	0,05-0,5	-	-	0,05-0,4	-
	a _p (mm)	-	0,05-0,75	-	-	0,05-0,75	-
P25 PVGO	f _z (mm)	-	0,1-0,4	-	-	0,1-0,3	-
	a _p (mm)	-	0,1-0,7	-	-	0,1-0,7	-

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	-	-	▽100	150	200	-	-	-	-	-	-	-
	pre finishing	▽150	275 400	-	-	▽150	225 300	▽200	500 800	-	-	▽35	143 250
	finishing	▽150	275 400	▽100	150 200	▽200	275 350	▽100	450 800	-	-	▽35	143 250
P40 PVTi	roughing	▽100	160 220	-	-	-	-	-	-	-	-	-	-
	pre finishing	▽100	175 250	-	-	-	-	-	-	-	-	-	-
	finishing	-	-	-	-	-	-	-	-	-	-	-	-
P40 PVSR	roughing	▽100	200 300	-	-	▽160	190 220	-	-	-	-	-	-
	pre finishing	▽100	200 300	-	-	▽160	190 220	-	-	-	-	▽70	110 150
	finishing	-	-	-	-	▽160	190 220	-	-	-	-	-	-
P40 PCSR	roughing	▽130	190 250	-	-	▽120	170 220	-	-	-	-	-	-
	pre finishing	▽150	225 300	-	-	▽150	200 250	-	-	-	-	-	-
	finishing	-	-	-	-	▽180	230 280	-	-	-	-	-	-
P40 PVML	roughing	▽100	200 300	-	-	▽140	215 290	-	-	-	-	-	-
	pre finishing	▽100	200 300	-	-	▽140	170 200	-	-	-	-	▽70	110 150
	finishing	-	-	-	-	-	-	-	-	-	-	-	-
P40 PVGO	roughing	▽100	150 200	-	-	-	-	-	-	-	-	-	-
	pre finishing	▽100	150 200	-	-	-	-	-	-	-	-	-	-
	finishing	-	-	-	-	-	-	-	-	-	-	-	-
P25 PVTi	roughing	▽100	200 300	-	-	-	-	-	-	-	-	-	-
	pre finishing	▽100	125 150	-	-	▽130	150 170	-	-	-	-	-	-
	finishing	▽150	250 350	-	-	▽150	200 250	-	-	-	-	-	-
K10 PVTi	roughing	-	-	-	-	▽150	175 200	▽100	450 800	▽35	43 50	-	-
	pre finishing	-	-	-	-	▽150	175 200	▽100	450 800	▽35	43 50	▽35	108 180
	finishing	▽140	220 300	▽120	150 180	▽150	200 250	▽100	450 800	▽35	43 50	-	-
CBN for steel uncoated	roughing	-	-	-	-	-	-	-	-	-	-	-	-
	pre finishing	-	-	-	-	-	-	-	-	-	-	▽400	700 1000
	finishing	-	-	-	-	-	-	-	-	-	-	-	-
K10 polished	roughing	-	-	-	-	-	-	▽100	450 800	-	-	-	-
	pre finishing	-	-	-	-	-	-	▽100	450 800	-	-	-	-
	finishing	-	-	-	-	-	-	▽100	450 800	-	-	-	-
K10 PVDiaN	roughing	-	-	-	-	-	-	▽100	450 800	-	-	-	-
	pre finishing	-	-	-	-	-	-	▽100	450 800	-	-	-	-
	finishing	-	-	-	-	-	-	▽100	450 800	-	-	-	-
M40 PVST	roughing	▽80	140 200	▽80	130 180	-	-	-	-	▽30	55 80	-	-
	pre finishing	▽100	150 200	▽100	155 210	-	-	-	-	▽40	65 90	-	-
	finishing	▽110	180 250	▽120	185 250	-	-	-	-	▽60	90 120	-	-
M35 PCTC	roughing	-	-	▽110	155 200	-	-	-	-	▽30	65 100	-	-
	pre finishing	-	-	▽120	175 230	-	-	-	-	▽40	75 110	-	-
	finishing	-	-	▽160	220 280	-	-	-	-	▽60	100 140	-	-
P25 PVGO	roughing	-	-	▽80	140 200	-	-	-	-	▽20	65 110	-	-
	pre finishing	-	-	▽100	155 210	-	-	-	-	▽20	65 110	-	-
	finishing	-	-	▽120	175 230	-	-	-	-	▽30	70 110	-	-

Extended operation data

Plunging	
Cutter diam. d1	X _{max}
15-42	1.2

Ramping		
Cutter diam. d1	α°	y
15	<26,5	2
16	<14,0	4
20	<8,5	8
25	<5,3	13
30	<3,8	18
35	<3,0	23
42	<2,3	30

Helix		
Cutter diam. d1	D _{min}	D _{max}
15	17	30
16	20	32
20	28	40
25	38	50
30	48	60
35	58	70
42	72	84