



QUADWORX®

Size S

- 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 $f_z = 1.5 \text{ mm}$

Milling cutter bodies

DuoPlug®	Catalogue no.	d_1	l	r_p^*	l_3	l_2	l_1	d_2	d_3	z	Accessories	Features
	2 16 247 SG	16	7	1.3*	31	1	-	M 10	15	2	B, C, D, E, F	✓ H I J K L
	3 18 247 SG	18	7	1.3*	31	1	-	M 10	15	3	A, C, D, E, F	✓ H I J K L
	3 20 247 SG	20	7	1.3*	33	1	-	M 12	18.6	3	A, C, D, E, F	✓ H I J K L
	4 25 247 SG	25	7	1.3*	35	1	-	M 16	23.5	4	A, C, D, E, F	✓ H I J K L

Threaded shank end mill bodies

	2 14 247	14	7	1.3*	28.5	1	-	M 8	13.8	2	B, C, D, E, F	✓ H I J K L
	2 16 247	16	7	1.3*	28.5	1	-	M 8	13.8	2	B, C, D, E, F	✓ H I J K L
	3 18 247	18	7	1.3*	28.5	1	-	M 8	13.8	3	A, C, D, E, F	✓ H I J K L
	3 20 247	20	7	1.3*	28.5	1	-	M 10	18	3	A, C, D, E, F	✓ H I J K L
	4 25 247	25	7	1.3*	32.5	1	-	M 12	21	4	A, C, D, E, F	✓ H I J K L

* corner radius to be programmed

Accessories

<p>25 500 Torx screw A > Page 195</p>	<p>25 500 K Torx screw B > Page 195</p>	<p>07 500 Torx-screwdriver C > Page 196</p>	<p>TV 04-1 Screwdriver torque Vario®-S with window scale, D > Page 197</p>	<p>T7 500 Torx interchangeable bit for Torque Vario® E > Page 197</p>	<p>T7 502, Torx Magic- Spring compatible bit f. Torque Vario® F > Page 198</p>
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Indexable inserts

Indexable inserts	Catalogue no.	DIN Specification	Carbide Grade	Coating	l	s	r	M
	02 47 837	SDMX 070205 SN	HSC 05	PVTi	7	2.38	0.5	M 2.5
	02 47 842	SDMX 070205 SN	P40	PVTi	7	2.38	0.5	M 2.5
	02 47 896	SDMT 070205 SN	M40	PVST	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 _z (mm) a _p (mm)	-	-	0,2-1,5 0,2-0,5	-	-	0,1-1 0,1-0,5
P40 PVTi	f _z (mm) a _p (mm)	0,2-1,5 0,2-0,5	-	-	-	-	-
M40 PVST	f _z (mm) a _p (mm)	-	0,2-1 0,2-0,5	-	-	0,2-0,8 0,2-0,5	-

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 finishing	-	-	▽100 150 200 ▽150 225 300 -	-	-	▽100 175 250 ▽35 143 250 -
P40 PVTi	roughing pre finishing finishing	▽100 160 220 ▽100 175 250 -	-	-	-	-	-
M40 PVST	roughing pre finishing finishing	-	▽80 130 180 ▽100 155 210 -	-	-	▽30 55 80 ▽40 65 90 -	-

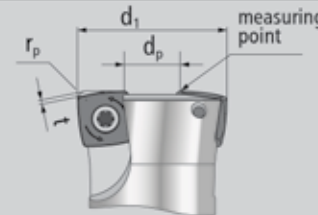
Extended operation data

Plunging		
Cutter diam. d1	D _p	X _{max}
14	3.7	1
16	5.7	1
18	7.7	1
20	9.7	1
25	14.8	1

Ramping		
Cutter diam. d1	α°	y
14	<13,5	4
16	<8,8	6
18	<6,6	8
20	<5,2	10
25	<3,3	15

Helix		
Cutter diam. d1	D _{min}	D _{max}
14	18	28
16	22	32
18	26	36
20	30	40
25	40	50

Technical information



For the CAD/CAM set-up please program 1.3 mm corner radius (r_p).
The remainder of the material is theoretically 0.51 mm (t).
Please use „d_p“ for tool length measurement.