SPINWORX®

r6 - diam. 32 - 66 mm, 7° positive rake angle

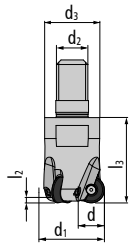
Highly efficient SPINWORX systems also available in intermediate sizes.

- 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!

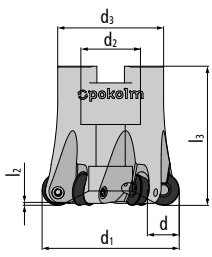
For optimum results with the SPINWORX®-tooling system we recommend using internal coolant supply air, emulsion or MQL for chip removal in the tool! Wet machining up to max speed Vc of 140 m/min!

Threaded shank end mill bodies



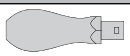
Milling cutter bodies Catalogue no.	d_1	d	r	l_3	l_2	l_1	d_2	d_3	z	Accessories	Features
DR12-032-E16-04	32	12	6	42.5	2.8	-	M 16	29	4	B, C, D, E	
DR12-035-E16-03	35	12	6	42.5	2.8	-	M 16	29	3	B, C, D, E	
DR12-035-E16-04	35	12	6	42.5	2.8	-	M 16	29	4	B, C, D, E	
DR12-035-E16-05	35	12	6	42.5	2.8	-	M 16	29	5	B, C, D, E	

Shell-type milling cutter bodies

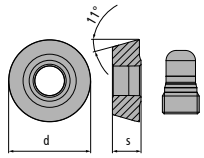
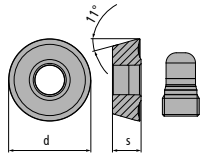
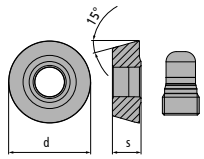
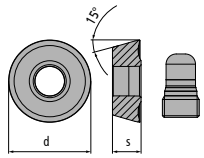


DR12-040-A16-05	40	12	6	42.5	2.8	-	diam. 16	35	5	A, B, C, D, E	
DR12-042-A16-05	42	12	6	42.5	2.8	-	diam. 16	35	5	A, B, C, D, E	
DR12-050-A22-06	50	12	6	52.5	2.8	-	diam. 22	40	6	B, C, D, E	
DR12-052-A22-06	52	12	6	52.5	2.8	-	diam. 22	40	6	B, C, D, E	
DR12-063-A27-06	63	12	6	52.5	2.8	-	diam. 27	48	6	B, C, D, E	
DR12-066-A27-07	66	12	6	52.5	2.8	-	diam. 27	48	7	B, C, D, E	

Accessories

 GWSTPS8ISK hexagon socket set screw A > Page 196	 T10-1,4NM Torque Fix® - S torque screwdriver B > Page 197	 T10 500 Torx interchangeable bit for Torque Vario® C > Page 197	 T10 502 Torx MagicSpring compatible bit f. Torque Vario®, D > Page 198	 Z 00043 HTC ceramic paste WS 600 005 E > Page 198	

NEW latest items! ⚠ available as long as stock lasts ? on request ✓ stock item, subject to confirmation

Indexable inserts	Catalogue no.	DIN Specification	Carbide Grade	Coating	d	s	r	M
	DR12-8C0	RORA 1245 M0SN	C0		12	4.5	6	
	DR12-8E0	RORA 1245 M0SN	E0		12	4.5	6	
	DR12-8B3	RORM 1245 M0EN	B3		12	4.5	6	
	DR12-8D1	RORM 1245 M0EN	D1		12	4.5	6	
	DR12-8D3	RORM 1245 M0EN	D3		12	4.5	6	
	DR12-8C4	RDRA 1245 M0SN	C4		12	4.5	6	
	DR12-8C6	RDRA 1245 M0SN	C6		12	4.5	6	
	DR12-8E4	RDRA 1245 M0SN	E4		12	4.5	6	
	DR12-8F4	RDRA 1245 M0SN	F4		12	4.5	6	
	DR12-8E6	RDRA 1245 M0SN	E6		12	4.5	6	
	DR12-8F6	RDRA 1245 M0SN	F6		12	4.5	6	
	DR12-8B7	RDRM 1245 M0EN	B7		12	4.5	6	

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.						
C0	f_z (mm) a_p (mm)	0,1-0,5 0,2-1,5	-	0,15-0,4 0,1-1,5	-	-	0,1-0,18 0,1-0,4
E0	f_z (mm) a_p (mm)	0,1-0,5 0,2-1,5	-	0,15-0,3 0,1-0,8	-	-	-
B3	f_z (mm) a_p (mm)	-	0,2-0,65 0,3-2,5	-	-	0,1-0,5 0,2-2,5	-
D1	f_z (mm) a_p (mm)	-	0,2-0,65 0,3-2,5	-	-	0,1-0,5 0,2-2,5	-
D3	f_z (mm) a_p (mm)	-	0,2-0,65 0,3-2,5	-	0,25-0,4 0,3-2	0,1-0,5 0,2-2,5	-
C4	f_z (mm) a_p (mm)	0,1-0,5 0,2-1,5	-	0,15-0,4 0,1-1,5	-	-	0,1-0,18 0,1-0,4
C6	f_z (mm) a_p (mm)	0,1-0,5 0,2-1,5	-	0,15-0,4 0,1-1,5	-	-	0,1-0,18 0,1-0,4
E4	f_z (mm) a_p (mm)	0,1-0,5 0,2-1,5	-	0,15-0,3 0,1-0,8	-	-	-
F4	f_z (mm) a_p (mm)	0,1-0,6 0,2-2	-	0,15-0,4 0,1-1,5	-	-	-
E6	f_z (mm) a_p (mm)	0,1-0,5 0,2-1,5	-	0,15-0,3 0,1-0,8	-	-	-
F6	f_z (mm) a_p (mm)	0,1-0,6 0,2-2	-	0,15-0,4 0,1-1,5	-	-	-
B7	f_z (mm) a_p (mm)	-	0,2-0,65 0,3-2,5	-	-	0,1-0,5 0,2-2,5	-

▼ *major application* ▽ *minor application* ▼▽ roughing ▼▽ pre-finishing ▼▽ finishing

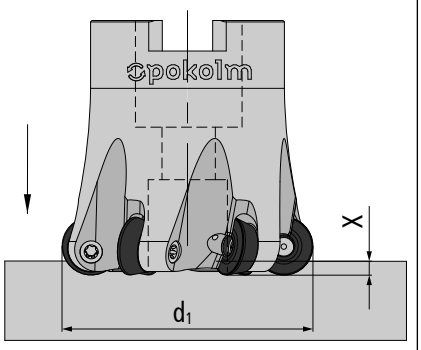
Cutting speed (Vc in m/min)

Material		steel	stainless steel	cast iron	non-ferrous materials	high-temperature alloys	hardened steel
Quality Coating	Application						
C0	roughing pre finishing finishing	90 **150** 210 110 **165** 220 -	-	150 **195** 240 140 **205** 270 -	-	-	- 35 **108** 180 -
E0	roughing pre finishing finishing	100 **175** 250 100 **200** 300 -	-	- 130 **165** 200 -	-	-	-
B3	roughing pre finishing finishing	-	110 **155** 200 120 **175** 230 -	-	-	30 **65** 100 40 **75** 110 -	-
D1	roughing pre finishing finishing	-	80 **130** 180 100 **155** 210 -	-	-	30 **55** 80 40 **65** 90 -	-
D3	roughing pre finishing finishing	-	80 **130** 180 100 **155** 210 -	-	100 **250** 400 200 **400** 600 -	30 **55** 80 40 **65** 90 -	-
C4	roughing pre finishing finishing	150 **180** 210 110 **165** 220 -	-	150 **195** 240 140 **205** 270 -	-	-	- 35 **108** 180 -
C6	roughing pre finishing finishing	90 **150** 210 110 **165** 220 -	-	150 **195** 240 140 **205** 270 -	-	-	- 35 **108** 180 -
E4	roughing pre finishing finishing	100 **175** 250 100 **200** 300 -	-	- 130 **165** 200 -	-	-	-
F4	roughing pre finishing finishing	100 **175** 250 100 **200** 300 -	-	110 **130** 150 140 **180** 220 -	-	-	-
E6	roughing pre finishing finishing	100 **175** 250 100 **200** 300 -	-	- 130 **165** 200 -	-	-	-
F6	roughing pre finishing finishing	100 **175** 250 100 **200** 300 -	-	110 **130** 150 140 **180** 220 -	-	-	-
B7	roughing pre finishing finishing	-	110 **155** 200 120 **175** 230 -	-	-	30 **65** 100 40 **75** 110 -	-

NEW latest items! ⚠ available as long as stock lasts ? on request ✔ stock item, subject to confirmation

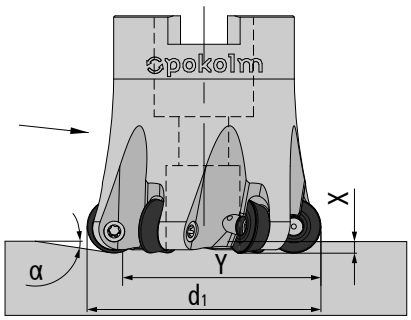
Extended operation data

Plunging



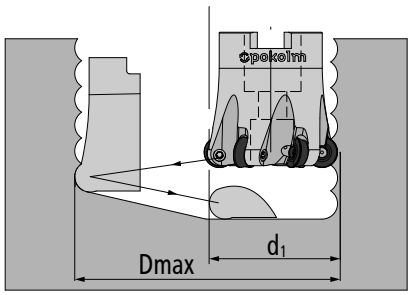
Cutter diam. d1	X_{max}
32-66	2.8

Ramping



Cutter diam. d1	α°	y
32	<15,5	10
35	<12,0	13
40	<8,5	18
42	<7,5	20
50	<5,5	28
52	<5,0	30
63	<3,5	41
66	<3,5	44

Helix



Cutter diam. d1	D_{min}	D_{max}
32	42	62
35	48	68
40	58	78
42	62	82
50	78	98
52	82	102
63	104	124
66	110	130

major application *minor application* roughing pre-finishing finishing