



# XDHW | XDHT 06

diam. 16 - 42 mm | r1

Universal milling cutters for finishing and profile milling with small radii.

- particularly smooth operating in corners and pockets
- low energy consumption

## Milling cutter bodies

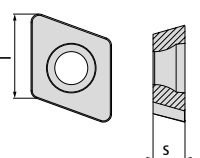
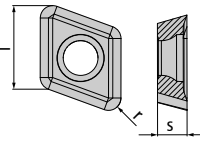
	Catalogue no.	Dimensions									Accessories	Features
		d <sub>1</sub>	l	r	l <sub>3</sub>	l <sub>2</sub>	l <sub>1</sub>	d <sub>2</sub>	d <sub>3</sub>	z		
<b>DuoPlug®</b>												
	16 281 SG	16	6.5	1	31	1.3	-	M 10	15	2	A, B, C, D, E	<input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/>
	20 281 SG	20	6.5	1	31.5	1.3	-	M 12	18.5	3	A, B, C, D, E	<input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/>
	25 281 SG	25	6.5	1	37.5	1.3	-	M 16	23.5	4	A, B, C, D, E	<input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/>

## Threaded shank end mill bodies

	16 281	16	6.5	1	28.5	1.3	-	M 8	13.8	2	A, B, C, D, E	<input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/>
	20 281	20	6.5	1	28.5	1.3	-	M 10	18	3	A, B, C, D, E	<input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/>
	25 281	25	6.5	1	32.5	1.3	-	M 12	21	4	A, B, C, D, E	<input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/>
	30 281	30	6.5	1	32.5	1.3	-	M 12	21	5	A, B, C, D, E	<input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/>
	35 281	35	6.5	1	42.5	1.3	-	M 16	29	6	A, B, C, D, E	<input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/>
	42 281	42	6.5	1	42.5	1.3	-	M 16	29	6	A, B, C, D, E	<input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/> <input checked="" type="checkbox"/>

## Accessories

<p>25 500 Torx screw A &gt; Page 195</p>	<p>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>	
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Indexable inserts	Catalogue no.	DIN Specification	Carbide Grade	Coating	l	s	r	M
	02 79 835	XDHW 060210 SN	HSC 05	PVTi	6.5	2.38	1	M 2.5
	02 79 892	XDHW 060210 SN	CBN for steel	uncoated	6.5	2.38	1	M 2.5
	02 79 894	XDHW 060210 SN	PCD	uncoated	6.5	2.38	1	M 2.5
	02 79 831P	XDHT 060210 EN	K10	polished	6.5	2.38	1	M 2.5
	02 79 880	XDHT 060210 EN	K10	PVTi	6.5	2.38	1	M 2.5
	02 79 880 D	XDHW 060210 SN	K10	PVDiaN	6.5	2.38	1	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) a <sub>p</sub> (mm)	0,1-0,2 0,1-0,55	0,1-0,2 0,1-0,25	0,1-0,3 0,1-1	-	-	0,1-0,2 0,1-0,55
CBN for steel uncoated	f <sub>z</sub> (mm) a <sub>p</sub> (mm)	-	-	-	-	-	0,1 0,1
PCD uncoated	f <sub>z</sub> (mm) a <sub>p</sub> (mm)	-	-	-	0,1-0,35 0,1-1	-	-
K10 polished	f <sub>z</sub> (mm) a <sub>p</sub> (mm)	-	-	-	0,1-0,2 0,1-0,55	-	-
K10 PVTi	f <sub>z</sub> (mm) a <sub>p</sub> (mm)	-	-	-	0,1-0,2 0,1-0,55	-	-
K10 PVDiaN	f <sub>z</sub> (mm) a <sub>p</sub> (mm)	-	-	-	0,1-0,35 0,1-1	-	-

### 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	-	-	▽35 143 250
CBN for steel uncoated	roughing	-	-	-	-	-	-
	pre finishing	-	-	-	-	-	▽400 700 1000
PCD uncoated	roughing	-	-	-	-	-	-
	pre finishing	-	-	-	▽200 500 800 ▽400 700 1000	-	-
K10 polished	roughing	-	-	-	-	-	-
	pre finishing	-	-	-	▽100 450 800 ▽100 450 800	-	-
K10 PVTi	roughing	-	-	-	-	-	-
	pre finishing	-	-	-	▽100 450 800 ▽100 450 800	-	-
K10 PVDiaN	roughing	-	-	-	-	-	-
	pre finishing	-	-	-	▽100 450 800 ▽100 450 800	-	-

## Extended operation data

Plunging	
Cutter diam. d1	X <sub>max</sub>
16-42	1.2

Ramping		
Cutter diam. d1	α°	y
16	<16,7	4
20	<8,5	8
25	<5,3	13
30	<3,8	18
35	<3,8	23
42	<2,3	30

Helix		
Cutter diam. d1	D <sub>min</sub>	D <sub>max</sub>
16	28	32
20	36	40
25	46	50
30	56	60
35	66	70
42	80	84