



SLOTWORX® - K90°

SLOTWORX® - Size L - diam. 25 - 100 mm

Universally applicable for maximum cutting depths. These tools stand out due to low energy consumption and maximum rigidity. Usable with indexable inserts of the Slotworx®-L-range with a corner radius of up to 3.0 mm.

Modified standard bodies for the use of indexable inserts with a corner radius ≥ 4 mm have additional R+ marking.

Milling cutter bodies

Catalogue no.											Accessories	Features
	d_1	l	r	l_3	l_2	l_1	d_2	d_3	z			

Threaded shank end mill bodies

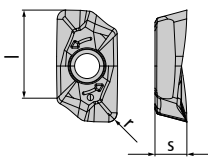
	2 25 268	25	15	1-3	35	3	-	M 12	21	2	A, B, C, D, E	✓	☐	☐	☐	☐		
	2 25 268 R+	25	15	4 5	35	3	-	M 12	21	2	A, B, C, D, E	✓	☐	☐	☐	☐	☐	
	3 32 268	32	15	1-3	43	3	-	M 16	29	3	A, B, C, D, E	✓	☐	☐	☐	☐	☐	
	3 32 268 R+	32	15	4 5	43	3	-	M 16	29	3	A, B, C, D, E	✓	☐	☐	☐	☐	☐	
	4 40 268	40	15	1-3	43	3	-	M 16	29	4	A, B, C, D, E	✓	☐	☐	☐	☐	☐	
	4 40 268 R+	40	15	4 5	43	3	-	M 16	29	4	A, B, C, D, E	✓	☐	☐	☐	☐	☐	☐
	4 42 268	42	15	1-3	43	3	-	M 16	29	4	A, B, C, D, E	✓	☐	☐	☐	☐	☐	☐
	4 42 268 R+	42	15	4 5	43	3	-	M 16	29	4	A, B, C, D, E	✓	☐	☐	☐	☐	☐	☐

Shell type milling cutter bodies

	4 40 368	40	15	1-3	43	3	-	diam. 16	35	4	A, B, C, D, E	✓	☐	☐	☐	☐		
	4 40 368 R+	40	15	4 5	43	3	-	diam. 16	35	4	A, B, C, D, E	✓	☐	☐	☐	☐	☐	
	4 42 368	42	15	1-3	43	3	-	diam. 16	35	4	A, B, C, D, E	✓	☐	☐	☐	☐	☐	
	4 42 368 R+	42	15	4 5	43	3	-	diam. 16	35	4	A, B, C, D, E	✓	☐	☐	☐	☐	☐	
	5 50 368	50	15	1-3	53	3	-	diam. 22	40	5	A, B, C, D, E	✓	☐	☐	☐	☐	☐	
	5 50 368 R+	50	15	4 5	53	3	-	diam. 22	40	5	A, B, C, D, E	✓	☐	☐	☐	☐	☐	☐
	5 52 368	52	15	1-3	53	3	-	diam. 22	40	5	A, B, C, D, E	✓	☐	☐	☐	☐	☐	☐
	5 52 368 R+	52	15	4 5	53	3	-	diam. 22	40	5	A, B, C, D, E	✓	☐	☐	☐	☐	☐	☐
	6 63 368	63	15	1-3	53	3	-	diam. 27	48	6	A, B, C, D, E	✓	☐	☐	☐	☐	☐	☐
	6 63 368 R+	63	15	4 5	53	3	-	diam. 27	48	6	A, B, C, D, E	✓	☐	☐	☐	☐	☐	☐
	6 66 368	66	15	1-3	53	3	-	diam. 27	48	6	A, B, C, D, E	✓	☐	☐	☐	☐	☐	☐
	6 66 368 R+	66	15	4 5	53	3	-	diam. 27	48	6	A, B, C, D, E	✓	☐	☐	☐	☐	☐	☐
	7 80 368	80	15	1-3	53	3	-	diam. 27	60	7	A, B, C, D, E	✓	☐	☐	☐	☐	☐	☐
	7 80 368 R+	80	15	4 5	53	3	-	diam. 27	60	7	A, B, C, D, E	✓	☐	☐	☐	☐	☐	☐
	9 100 368	100	15	1-3	53	3	-	diam. 32	70	9	A, B, C, D, E	✓	☐	☐	☐	☐	☐	☐
	9 100 368 R+	100	15	4 5	53	3	-	diam. 32	70	9	A, B, C, D, E	✓	☐	☐	☐	☐	☐	☐

Accessories

<p>35 500 Torx screw A > Page 195</p>	<p>15 500 Torx-screwdriver B > Page 196</p>	<p>TV 2-8 Screwdriver torque Vario®-S with window scale, C > Page 197</p>	<p>T15 500 Torx interchangeable bit for Torque Vario® D > Page 197</p>	<p>T15 502 Torx MagicSpring compatible bit f. Torque Vario® E > Page 198</p>	
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Indexable inserts	Catalogue no.	DIN Specification	Carbide Grade	Coating	l	s	r	M
	05 68 820	XDHT 155210	K10	polished	15	5.2	1	M 3.5
	05 68 848	XDMT 155210 ER	P40	PVGO	15	5.2	1	M 3.5
	05 68 862	XDMT 155210 ER	K10	PVTi	15	5.2	1	M 3.5
	05 68 896	XDMT 155210 ER	M40	PVST	15	5.2	1	M 3.5
	05 68 820 R20	XDHT 155230 FR	K10	polished	15	5.2	2	M 3.5
	05 68 896 R20	XDMT 155220 ER	M40	PVST	15	5.2	2	M 3.5
	05 68 820 R30	XDHT 155230 FR	K10	polished	15	5.2	3	M 3.5
	05 68 896 R30	XDMT 155230 ER	M40	PVST	15	5.2	3	M 3.5
	05 68 820 R40	XDHT 155240 FR	K10	polished	15	5.2	4	M 3.5
	05 68 896 R40	XDMT 155240 ER	M40	PVST	15	5.2	4	M 3.5
	05 68 820 R50	XDHT 155250 FR	K10	polished	15	5.2	5	M 3.5
	05 68 896 R50	XDMT 155250 ER	M40	PVST	15	5.2	5	M 3.5

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.						
K10 polished	f _z (mm) a _p (mm)	-	-	-	0,08-0,35 0,1-14	-	-
P40 PVGO	f _z (mm) a _p (mm)	0,1-0,5 0,2-14	-	0,1-0,5 0,2-14	-	-	-
K10 PVTi	f _z (mm) a _p (mm)	0,1-0,4 4-14	-	0,1-0,4 0,2-14	-	-	-
M40 PVST	f _z (mm) a _p (mm)	-	0,08-0,5 0,1-14	-	-	0,08-0,25 0,1-14	-

Cutting speed (Vc in m/min)

Material		steel	stainless steel	cast iron	non-ferrous materials	high-temperature alloys	hardened steel
Quality Coating	Application						
K10 polished	roughing pre finishing finishing	-	-	-	▽100 450 800 ▽100 450 800 ▽100 450 800	-	-
P40 PVGO	roughing pre finishing finishing	▽100 150 200 ▽100 150 200 ▽160 205 250	-	▽110 130 150 ▽110 130 150 ▽120 150 180	-	-	-
K10 PVTi	roughing pre finishing finishing	▽130 170 210 ▽150 185 220 -	-	▽150 175 200 ▽150 175 200 ▽150 200 250	-	-	-
M40 PVST	roughing pre finishing finishing	-	▽80 130 180 ▽100 155 210 ▽120 185 250	-	-	▽30 55 80 ▽40 65 90 ▽60 90 120	-

Extended operation data

Plunging	
Cutter diam. d1	X _{max}
25-100	3

Ramping		
Cutter diam. d1	α°	y
25	<8,3	17
32	<5,9	24
40	<4,4	32
42	<4,2	34
50	<3,3	42
52	<3,2	44
63	<2,5	55
66	<2,4	58
80	<1,9	72
100	<1,5	92

Helix		
Cutter diam. d1	D _{min}	D _{max}
25	42	50
32	56	64
40	72	80
42	76	84
50	92	100
52	96	104
63	118	126
66	124	132
80	152	160
100	192	200