



FINWORX®

diam. 16 - 42 mm | r1

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

- particularly smooth operating in corners and pockets
- extreme economic due to four effective cutting edges
- low energy consumption

Milling cutter bodies

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

DuoPlug®

	2 16 285 SG	16	6.5	1	31	0.7	-	M 10	15	2	A, B, C, D, E	
	3 20 285 SG	20	6.5	1	32.5	1	-	M 12	18.6	3	A, B, C, D, E	
	4 25 285 SG	25	6.5	1	37.5	1	-	M 16	23.5	4	A, B, C, D, E	

Threaded shank end mill bodies

	2 16 285	16	6.5	1	28.5	0.7	-	M 8	13.8	2	A, B, C, D, E	
	3 20 285	20	6.5	1	28.5	1	-	M 10	18	3	A, B, C, D, E	
	4 25 285	25	6.5	1	32.5	1	-	M 12	21	4	A, B, C, D, E	
	4 30 285	30	6.5	1	32.5	1	-	M 16	29	4	A, B, C, D, E	
	5 32 285	32	6.5	1	32.5	1	-	M 16	29	5	A, B, C, D, E	
	5 35 285	35	6.5	1	42.5	1	-	M 16	29	5	A, B, C, D, E	
	6 42 285	42	6.5	1	42.5	1	-	M 16	29	6	A, B, C, D, E	

Plain shank end mill bodies

	2 32 16 185 G	16	6.5	1	32	0.7	165	diam. 16	15.5	2	A, B, C, D, E	
	3 40 20 185 G	20	6.5	1	40	1	165	diam. 20	19.5	3	A, B, C, D, E	

Accessories

<p>25 505 Torx screw for ball nose inserts A > Page 195</p>	<p>POKOLM 08 500 P Torx-screwdriver (Torx-Plus) B > Page 196</p>	<p>TV 1-5 Screwdriver torque Vario®-S with window scale, C > Page 197</p>	<p>T8 500 P Torx interchangeable bit for Torque Vario® D > Page 197</p>	<p>T8 502 P 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
	03 85 835	XNHU 063010 EN	HSC 05	PVTi	6.5	3.1	1	
	03 85 836	XNHU 063010 EN	HSC 05	PVTiH	6.5	3.1	1	
	03 85 835 D	XNHU 063010 EN	HSC 05	PVDiaN	6.5	3.1	1	
	03 85 892	XNHU 063010 EN	CBN for steel	uncoated	6.5	3.1	1	
	03 85 894	XNHU 063010 EN	PCD	uncoated	6.5	3.1	1	

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)	-	-	-	-	-	-
HSC 05 PVTiH	f _z (mm) a _p (mm)	0,05-0,5 0,1-0,55	0,05-0,15 0,05-0,2	0,05-0,5 0,1-0,55	-	-	0,05-0,2 0,1-0,35
HSC 05 PVDiaN	f _z (mm) a _p (mm)	-	-	-	0,05-0,3 0,1-0,7	-	-
CBN for steel uncoated	f _z (mm) a _p (mm)	-	-	-	-	-	0,05-0,1 0,1
PCD uncoated	f _z (mm) a _p (mm)	-	-	-	0,05-0,2 0,1-0,5	-	-

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	-	-	-	-	-	-
HSC 05 PVTiH	roughing pre finishing finishing	- ▽150 275 400 ▽150 275 400	- ▽100 150 200	- ▽150 225 300 ▽200 275 350	-	-	- ▽35 143 250 ▽35 143 250
HSC 05 PVDiaN	roughing pre finishing finishing	-	-	-	- ▽200 500 800 ▽200 500 800	-	-
CBN for steel uncoated	roughing pre finishing finishing	-	-	-	-	-	- ▽400 700 1000
PCD uncoated	roughing pre finishing finishing	-	-	-	- ▽400 600 800 ▽400 700 1000	-	-

Extended operation data

Plunging	
Cutter diam. d1	X_{max}
16	0.7
20-42	1

Ramping		
Cutter diam. d1	α°	y
16	<2,8	14
20	<3,2	18
25	<2,5	23
30	<2	28
32	<1,9	30
35	<1,7	33
42	<1,4	40

Helix		
Cutter diam. d1	D_{min}	D_{max}
16	30	32
20	38	40
25	48	50
30	58	60
32	62	64
35	68	70
42	82	84