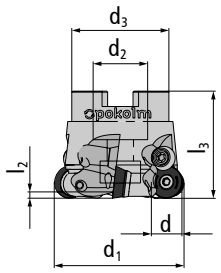
CUTTERS FOR ROUND INSERTS - K0-90°

r8 - diam. 52 - 100 mm, 7° positive rake angle, with shims

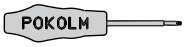
- increased reliability against fractures during machining
- optimum protection of milling cutter body by shim
- in case of insert fracture, shims, screws and threaded bushes can be replaced separately, it is not necessary to buy a new body

Shell type milling cutter bodies

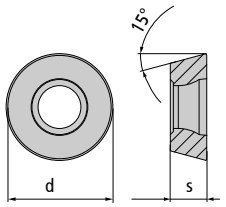
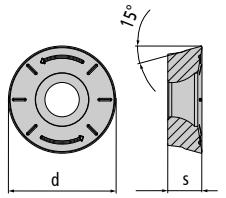


Milling cutter bodies Catalogue no.	d_1	d	r	l_3	l_2	l_1	d_2	d_3	z	Accessories	Features
52 300/7 HL	52	16	8	53	4.1	-	diam. 22	40	4	A, B, C, D, E, F, G, H, I, J	
66 300/7 HL	66	16	8	53	4.1	-	diam. 27	48	5	A, B, C, D, E, F, G, H, I, J	
80 300/7 HL	80	16	8	53	4.1	-	diam. 27	60	6	A, B, C, D, E, F, G, H, I, J	
100 300/7 HL	100	16	8	53	4.1	-	diam. 32	70	7	A, B, C, D, E, F, G, H, I, J	

Accessories

 45 500 Torx screw A > Page 195	 45 500 L Torx screw B > Page 195	 45 500 I threaded and tapped bush C > Page 196	 10 510 locking washer D > Page 196	 10 511 Shim for RDHX 1604 E > Page 196	 20 500 Torx-screwdriver F > Page 196
INBUS 4,5 W Allen Key 4,5 G > Page 197	 TV 2-8 Screwdriver torque Vario®-S with window scale, H > Page 197	 T20 500 Torx interchangeable bit for Torque Vario® I > Page 197	 T20 502 Torx MagicSpring compatible bit f. Torque Vario®, J > 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
	04 16 835	RDHX 1604 M0T	HSC 05	PVTi	16	4.76	8	M 4.5
	04 16 840	RDHX 1604 M0T	P40	PVTi	16	4.76	8	M 4.5
	04 16 842	RDEX 1604 M0T	P40	PVSR	16	4.76	8	M 4.5
	04 16 8042	RDEX 1604 M0T	P40	PCSR	16	4.76	8	M 4.5
	04 16 844	RDHX 1604 M0T	P40	PVML	16	4.76	8	M 4.5
	04 16 850	RDHX 1604 M0T	P25	PVTi	16	4.76	8	M 4.5
	04 16 852	RDEX 1604 M0T	P25	PVSR	16	4.76	8	M 4.5
	04 16 860	RDHX 1604 M0T	K10	PVTi	16	4.76	8	M 4.5
	04 16 831P	RDHX 1604 M0T	K10	polished	16	4.76	8	M 4.5
	04 16 848	RDMX 1604 M0T	P40	PVGO	16	4.76	8	M 4.5
	04 16 880	RDHX 1604 M0T	K10	PVTi	16	4.76	8	M 4.5
	04 16 896	RDMT 1604 M0EN	M40	PVST	16	4.76	8	M 4.5
	04 16 8099	RDMT 1604 M0EN	M35	PCTC	16	4.76	8	M 4.5
	04 16 897	RDPX 1604 M0T	P25	PVGO	16	4.76	8	M 4.5

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)	0,2-0,25 0,2-0,85	0,15 0,1	0,2-0,5 0,2-3	0,2-0,35 0,2-2,1	-	0,15-0,22 0,2-0,85
P40 PVTi	f_z (mm) a_p (mm)	0,2-0,9 0,2-4	-	-	-	-	-
P40 PVSR	f_z (mm) a_p (mm)	0,25-1 0,2-3	-	0,2-0,5 0,2-3	-	-	0,15-0,22 0,2-0,85
P40 PCSR	f_z (mm) a_p (mm)	0,25-1 0,25-3	-	0,25-1 0,25-3	-	-	-
P40 PVML	f_z (mm) a_p (mm)	0,25-1 0,2-3	-	0,2-0,5 0,2-3	-	-	0,15-0,22 0,2-0,85
P25 PVTi	f_z (mm) a_p (mm)	0,2-0,5 0,2-3	-	0,2-0,35 0,2-1,6	-	-	-
P25 PVSR	f_z (mm) a_p (mm)	0,25-1 0,2-3	-	0,2-0,5 0,2-3	-	-	0,15-0,22 0,2-0,85
K10 PVTi	f_z (mm) a_p (mm)	0,2 0,2	0,15 0,1	0,2-0,5 0,2-3		0,15-0,22 0,2-1,35	0,15-0,22 0,2-0,85
K10 polished	f_z (mm) a_p (mm)	-	-	-	0,2-0,5 0,2-4	-	-
P40 PVGO	f_z (mm) a_p (mm)	0,16-1,2 0,1-3	-	0,16-0,5 0,1-2	-	-	-
M40 PVST	f_z (mm) a_p (mm)	0,08-1,2 0,1-3	0,08-0,7 0,1-3	-	-	0,08-0,5 0,1-2	-
M35 PCTC	f_z (mm) a_p (mm)	-	0,08-0,7 0,1-3	-	-	0,08-0,5 0,12-3	-
P25 PVGO	f_z (mm) a_p (mm)	-	0,3-1 0,3-3	-	-	0,15-0,5 0,15-2	-

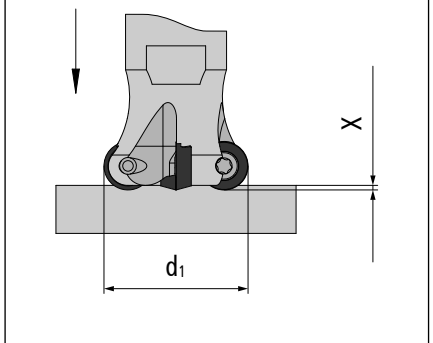
major application *minor application* roughing pre-finishing finishing

Cutting speed (Vc in m/min)

Material: Quality Coating	Application	steel	stainless steel	cast iron	non-ferrous materials	high-temperature alloys	hardened steel
HSC 05 PVTi	roughing	-	-	100 **150** 200	-		-
	pre finishing	150 **275** 400	-	150 **225** 300	200 **500** 800	-	35 **143** 250
	finishing	150 **275** 400	100 **150** 200	200 **275** 350	100 **450** 800		35 **143** 250
P40 PVTi	roughing	100 **160** 220					
	pre finishing	100 **175** 250	-	-	-	-	-
	finishing	-					
P40 PVSR	roughing	100 **200** 300		160 **190** 220			-
	pre finishing	100 **200** 300	-	160 **190** 220	-	-	70 **110** 150
	finishing	-		160 **190** 220			-
P40 PCSR	roughing	130 **190** 250		120 **170** 220			
	pre finishing	150 **225** 300	-	150 **200** 250	-	-	-
	finishing	-		180 **230** 280			
P40 PVML	roughing	100 **200** 300		140 **215** 290			-
	pre finishing	100 **200** 300	-	140 **170** 200	-	-	70 **110** 150
	finishing	-		-			-
P25 PVTi	roughing	100 **200** 300		-			
	pre finishing	100 **125** 150	-	130 **150** 170	-	-	-
	finishing	150 **250** 350		150 **200** 250			
P25 PVSR	roughing	100 **160** 220		140 **180** 220			-
	pre finishing	100 **180** 260	-	160 **190** 220	-	-	70 **110** 150
	finishing	-		160 **190** 220			-
K10 PVTi	roughing	-	-	150 **175** 200	100 **450** 800	35 **43** 50	-
	pre finishing	-	-	150 **175** 200	100 **450** 800	35 **43** 50	35 **108** 180
	finishing	140 **220** 300	120 **150** 180	150 **200** 250	100 **450** 800	35 **43** 50	-
K10 polished	roughing				100 **450** 800		
	pre finishing	-	-	-	100 **450** 800	-	-
	finishing				100 **450** 800		
P40 PVGO	roughing	100 **150** 200		110 **130** 150			
	pre finishing	100 **150** 200	-	110 **130** 150	-	-	-
	finishing	-		-			
M40 PVST	roughing	80 **140** 200	80 **130** 180			30 **55** 80	
	pre finishing	100 **150** 200	100 **155** 210	-	-	40 **65** 90	-
	finishing	110 **180** 250	120 **185** 250			60 **90** 120	
M35 PCTC	roughing		110 **155** 200			30 **65** 100	
	pre finishing	-	120 **175** 230	-	-	40 **75** 110	-
	finishing		160 **220** 280			60 **100** 140	
P25 PVGO	roughing		80 **140** 200			20 **65** 110	
	pre finishing	-	100 **155** 210	-	-	20 **65** 110	-
	finishing		120 **175** 230			30 **70** 110	

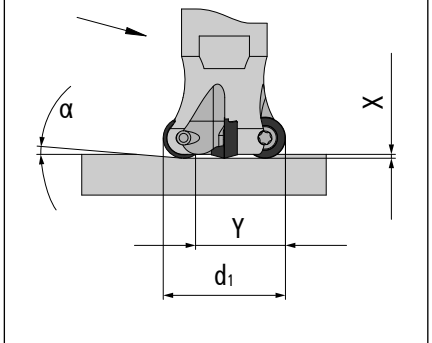
Extended operation data

Plunging



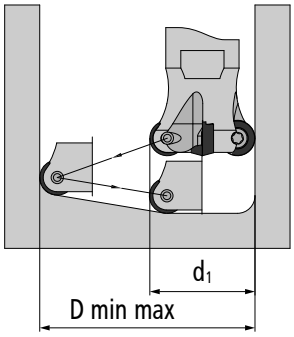
Cutter diam. d1	X_{max}
52-100	4

Ramping



Cutter diam. d1	α°	y
52	<10,3	22
66	<6,4	36
80	<4,6	50
100	<3,3	70

Helix



Cutter diam. d1	D_{min}	D_{max}
52	74	104
66	102	132
80	130	160
100	170	200

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