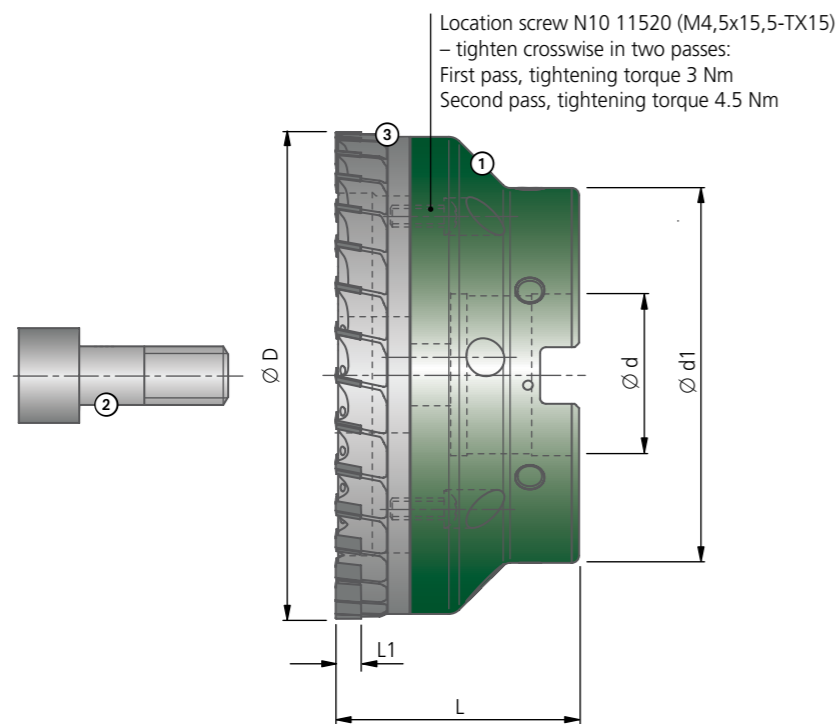
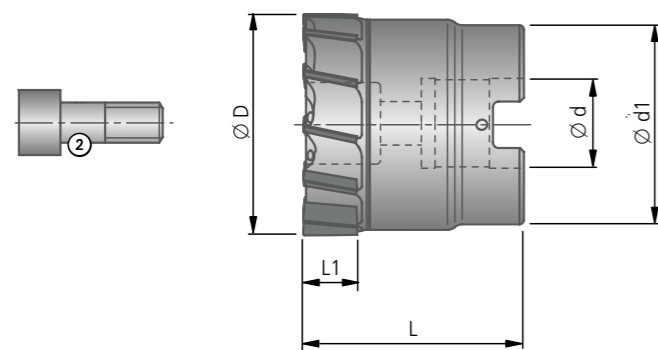
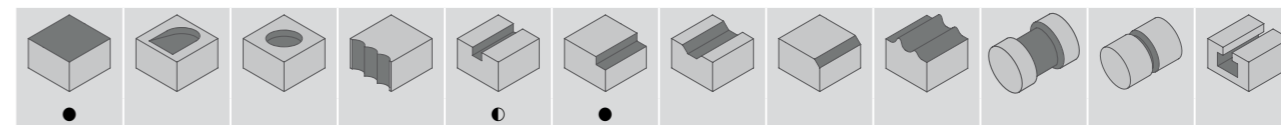


PCD Face milling cutter ECO | PERFORMANCE | HPC



PCD Face milling cutter ECO | PERFORMANCE | HPC



Arbor milling cutter											Cylindrical screw ②	
ØD	DIN 8030 form	Ød <sup>H6</sup>	Ød1	L	L1	kg	Z	Description	Order No.	Article	Order No.	
40	A	16	36	40	5	0,3	5	ECO	37163099004000	M8x25	55011 08025	
							8	PERFORMANCE	37164099004000			
							12	HPC	37165099004000			
50	A	22	41	40	5	0,4	5	ECO	37163099005000	M10x25	55011 10025	
							10	PERFORMANCE	37164099005000			
							16	HPC	37165099005000			

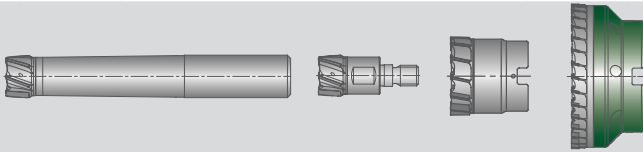
Supply includes milling cutter: with cylindrical screw ②.

Arbor milling cutter								Milling ring ③		Basic body ①	
ØD	DIN 8030 form	Ød <sup>H6</sup>	Ød1	L	L1	kg	Z	Description	Order No.	Order No.	Order No. Article
63	A	22	48	40	5	0,34	5	ECO	37128099006300	50725085006300	55011 10025 M10x25
							10	PERFORMANCE	37129099006300		
							20	HPC	37130099006300		
80	A	27	58	50	5	0,62	6	ECO	37128099008000	50725085008000	55011 12040 M12x40
							12	PERFORMANCE	37129099008000		
							24	HPC	37130099008000		
100	A	32	77	50	5	1,0	8	ECO	37128099010000	50725085010000	55011 16045 M16x45
							16	PERFORMANCE	37129099010000		
							32	HPC	37130099010000		

Supply includes milling cutter:  
 Basic body ① with location screws N10 11520 (M4,5x15,5-TX15) and cylindrical screw ②.  
 Please order milling ring ③ separately.

Replacement milling rings are available ex stock as an exchange at a discounted price.  
 To do this, please send in the worn repairable tool with the order.

Recommended cutting data

Guideline values for milling				PCD Face milling cutter ECO   PERFORMANCE   HPC								
Material group	Strength Rm (N/mm <sup>2</sup> )	Hardness HB	Material  v <sub>C</sub> (m/min) = Cutting speed f <sub>Z</sub> (mm/tooth) = Milling feed									
				Ø 10		Ø 12		Ø 16   20   25   32		Ø 40 – 100		
				v <sub>C</sub> m/min	f <sub>Z</sub> mm/tooth	v <sub>C</sub> m/min	f <sub>Z</sub> mm/tooth	v <sub>C</sub> m/min	f <sub>Z</sub> mm/tooth	v <sub>C</sub> m/min	f <sub>Z</sub> mm/tooth	
N	6.1	≤350	≤100	non-alloy copper								
	6.2	≤700	≤200	short chip, brass, bronze, red brass	300-800	0,04-0,12	300-1000	0,04-0,15	300-1000	0,06-0,20	1000-1500	0,04-0,15
	6.3	≤700	≤200	long chip brass								
	6.4	≤500	≤470	Cu-Al-Fe alloy (Ampco)								
	7.1	≤350	≤100	Al, Mg non-alloy	400-1000	0,04-0,12	400-1500	0,04-0,15	400-1500	0,06-0,20	1000-3500	0,04-0,15
	7.2	≤600	≤180	Al wrought alloy, breaking strain (A 5) <14 %	400-1000	0,04-0,12	400-1500	0,04-0,15	400-1500	0,06-0,20	1000-3500	0,04-0,15
	7.3	≤600	≤180	Al wrought alloy, breaking strain (A 5) ≥14 %	400-1000	0,04-0,12	400-1500	0,04-0,15	400-1500	0,06-0,20	1000-3500	0,04-0,15
	7.4	≤600	≤180	Al cast alloy, Si <10 %	400-1000	0,04-0,12	400-1500	0,04-0,15	400-1500	0,06-0,20	1000-1500	0,04-0,15
	7.5	≤600	≤180	Al cast alloy, Si ≥10 %	400-1000	0,04-0,12	400-1500	0,04-0,15	400-1500	0,06-0,20	1000-1500	0,04-0,15
	8.1			thermoplastics								
8.2			thermosetting plastics									
8.3			fibre reinforced plastics	200-600	0,03-0,10	200-600	0,04-0,12	500-1200	0,05-0,15	500-1200	0,05-0,15	