

RO18

UD90



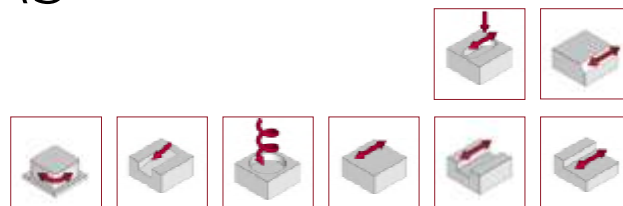
Copy milling cutters are specifically designed for high performance milling jobs that require extreme precision. The stable embedding of the indexable inserts delivers the required stability for precision and maximum Q in all machining applications, such as pocket milling or 90°-machining.

High performance milling  
with max. Q

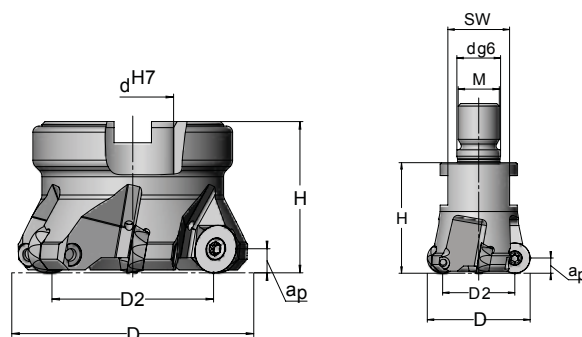
**COPY MILLING CUTTERS**  
**HIGH FEED MILLING CUTTERS**

# COPY MILLING CUTTERS

## RO18



The RDGX indexable insert with facets prevents twisting and defines the fixation in the tool body  
 The axial and radial cutting angle guarantees a soft cut

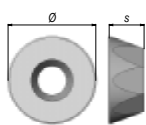


RO18 Screw-in milling cutters												
Article	D	D <sub>2</sub>	d <sub>g6</sub>	H	M	SW	z <sub>eff</sub>	a <sub>p</sub>	Ramp	Ic	kg	INS
18R.2028.001	20	10	10.5	28	10	15	2	5.0	–	no	0.05	RD..10T3.N*
18R.2433.001	24	12	12.5	33	12	17	2	6.0	5°	no	0.09	RD..1204.N*
18R.3243.003	32	20	17.0	43	16	24	3	6.0	4°	no	0.21	RD..1204.N
18R.3243.004	32	22	17.0	43	16	24	4	5.0	4°	yes	0.22	RD..10T3.N
18R.4043.001	40	28	17.0	43	16	24	4	6.0	3°	no	0.25	RD..1204.N
18R.4043.002	40	28	17.0	43	16	24	3	6.0	3°	no	0.23	RD..1204.N

\* Note that the screw length required varies depending on the insert used

RO18 Plug-in milling cutters											
Article	D	D <sub>2</sub>	d <sup>H7</sup>	H	z <sub>eff</sub>	a <sub>p</sub>	Ramp	Ic	kg	INS	
18R.5050.001	50	38	22	50	5	6.0	3°	yes	0.30	RD..1204.N	
18R.5050.002	50	40	22	50	5	5.0	3°	yes	0.31	RD..10T3.N	
18R.5250.001	52	40	22	50	5	6.0	3°	yes	0.35	RD..1204.N	
18R.5250.002	52	42	22	50	6	5.0	3°	yes	0.35	RD..10T3.N	
18R.6350.021	63	51	27	50	6	6.0	3°	yes	0.46	RD..1204.N	
18R.6350.001	63	47	27	50	5	8.0	3°	yes	0.42	RD..1605.N	
18R.6650.001	66	50	27	50	5	8.0	4°	yes	0.51	RD..1605.N	
18R.6650.005	66	56	27	50	8	5.0	4°	yes	0.51	RD..10T3.N	
18R.8050.002	80	64	27	50	6	8.0	3°	yes	0.96	RD..1605.N	
18R.1050.002	100	84	32	50	7	8.0	3°	yes	1.49	RD..1605.N	
18R.1263.001	125	109	40	63	8	8.0	2°	yes	2.91	RD..1605.N	

# INS SHAPE RD



RD						
AS	Ø			s		
8	10	12	16	T3	04	05
	10	12	16	3.97	4.76	5

Matching of machining parameters  
with the AV material groups

Article	Designation	Recomm. $a_p$ at 1/4 INS-Ø	Steel						
			A22	A21	A20	A19	A18	A17	A16
RD..10T3	RD.10T3.031.01 AV1055	$f_z$	0.75	0.65	0.60	0.55	0.50	0.40	0.35
		$v_c$	280-320	240-280	210-240	180-210	140-180	110-140	80-110
	RD.10T3.031.02 AV1055	$f_z$	0.65	0.60	0.55	0.50	0.45	0.35	0.25
		$v_c$	280-320	240-280	210-240	180-210	140-180	110-140	80-110
	RD.10T3.031.03 AV1055	$f_z$	-	-	-	-	-	0.30	0.25
		$v_c$	-	-	-	-	-	120-155	100-130
RD..1204..	RD.1204.031.02 SKY77	$f_z$	0.75	0.65	0.60	0.55	0.50	0.40	0.35
		$v_c$	280-320	240-280	210-240	180-210	140-180	110-140	80-110
	RD.1204.031.03 AV1055	$f_z$	-	-	-	-	0.45	0.35	0.30
		$v_c$	-	-	-	-	160-210	120-155	100-130
	RD.1204.031.04 AV1055	$f_z$	-	-	-	-	-	0.30	0.25
		$v_c$	-	-	-	-	-	120-155	100-130
RD..1605..	RD.1605.031.01 SKY77	$f_z$	0.65	0.60	0.55	0.50	0.45	0.35	0.25
		$v_c$	280-320	240-280	210-240	180-210	140-180	110-140	80-110
	RD.1605.031.02 AV1055	$f_z$	-	-	-	-	0.45	0.35	0.30
		$v_c$	-	-	-	-	160-210	120-155	100-130

Article	Designation	Recomm. $a_p$ at 1/4 INS-Ø	Cast iron					
			D21	D20	D19	D18	D17	D16
RD..10T3	RD.10T3.031.01 SKY77	$f_z$	0.50	0.45	0.40	0.40	0.35	0.25
		$v_c$	280-310	260-290	230-270	210-240	180-210	140-180
	RD.10T3.031.01 AV1055	$f_z$	0.70	0.55	0.50	0.45	0.45	0.30
		$v_c$	280-310	260-290	230-270	210-240	180-210	140-180
	RD.10T3.031.02 AV1055	$f_z$	0.50	0.45	0.40	0.40	0.35	0.25
		$v_c$	280-310	260-290	230-270	210-240	180-210	140-180
RD..1204..	RD.1204.001.02 SKY77	$f_z$	0.70	0.55	0.50	0.45	0.45	0.30
		$v_c$	280-310	260-290	230-270	210-240	180-210	140-180
	RD.1204.031.02 SKY77	$f_z$	0.70	0.55	0.50	0.45	0.45	0.30
		$v_c$	280-310	260-290	230-270	210-240	180-210	140-180
RD..1605..	RD.1605.001.02 SKY77	$f_z$	0.50	0.45	0.40	0.40	0.35	0.25
		$v_c$	280-310	260-290	230-270	210-240	180-210	140-180
	RD.1605.031.01 SKY77	$f_z$	0.50	0.45	0.40	0.40	0.35	0.25
		$v_c$	280-310	260-290	230-270	210-240	180-210	140-180

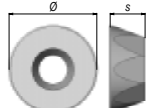
# INS SHAPE RD

RD						
AS	Ø			s		
8	10	12	16	T3	04	05
	10	12	16	3.97	4.76	5

Matching of machining parameters with the AV material groups

	Article	Designation	Recomm. a <sub>p</sub> at 1/4 INS-Ø	Stainless steels				NF metals		
				C12	C11	C10	C09	E82	E81	E80
RD..10T3	RD.10T3.031.02 AV1055	RDKT 10T3M0 SN-28	f <sub>z</sub>	-	-	-	-	1.00	0.85	0.50
			v <sub>c</sub>	-	-	-	-	650-1000	450-650	280-450
	RD.10T3.031.03 AV1055	RDKT 10T3M0 SN-30	f <sub>z</sub>	0.50	0.35	0.30	0.25	0.85	0.70	0.45
			v <sub>c</sub>	120-200	140-170	100-140	60-100	650-1000	450-650	280-450
RD..1204..	RD.1204.031.02 SKY77	RDKT 1204M0 SN-25	f <sub>z</sub>	0.50	-	-	-	1.00	0.65	0.55
			v <sub>c</sub>	100-150	-	-	-	650-1000	450-650	280-450
	RD.1204.031.03 AV1055	RDKT 1204M0 SN-28	f <sub>z</sub>	0.50	0.40	0.35	0.25	1.00	0.70	0.50
			v <sub>c</sub>	120-200	140-170	100-140	60-100	650-1000	450-650	280-450
	RD.1204.031.04 AV1055	RDKT 1204M0 EN-30	f <sub>z</sub>	0.50	0.35	0.30	0.25	0.85	0.70	0.45
			v <sub>c</sub>	120-200	140-170	100-140	60-100	650-1000	450-650	280-450
RD..1605..	RD.1605.031.01 SKY77	RDKT 1605M0 SN-23	f <sub>z</sub>	0.50	0.40	0.35	0.25	1.00	0.85	0.50
			v <sub>c</sub>	120-200	140-170	100-140	60-100	650-1000	450-650	280-450
	RD.1605.031.02 AV1055	RDKT 1605M0 SN-28	f <sub>z</sub>	0.50	0.40	0.35	0.25	1.00	0.70	0.50
			v <sub>c</sub>	120-200	140-170	100-140	60-100	650-1000	450-650	280-450

# INS SHAPE RD





RD						
AS	Ø			s		
8	10	12	16	T3	04	05
	10	12	16	3.97	4.76	5

Matching of machining parameters  
with the AV material groups

	Article	Designation	Recomm. $a_p$ at 1/4 INS-Ø	Titanium		
				S10	S09	S08
RD..10T3	RD.10T3.031.03 AV1055	RDKT 10T3M0 SN-30	$f_z$	0.35	0.30	0.25
			$v_c$	60-80	40-70	20-50
RD..1204..	RD.1204.031.03 AV1055	RDKT 1204M0 SN-28	$f_z$	0.45	0.35	–
			$v_c$	60-80	40-70	–
	RD.1204.031.04 AV1055	RDKT 1204M0 EN-30	$f_z$	0.35	0.30	0.25
			$v_c$	60-80	40-70	20-50
RD..1605..	RD.1605.031.02 AV1055	RDKT 1605M0 SN-28	$f_z$	0.45	0.35	–
			$v_c$	60-80	40-70	–

## Adaptation of $f_z$ at different $a_p$ values

INS	$a_p$	0,5	1	1,5	2	2,5	3	3,5	4	5	6	7	8
RD..10T3...	$f_z$	2.00	1.50	1.25	1.10	1.00	0.95	0.90	0.85	0.90	–	–	–
RD..1204...	$f_z$	2.10	1.50	1.30	1.15	1.10	1.00	0.95	0.90	0.85	0.85	–	–
RD..1605...	$f_z$	2.40	1.80	1.50	1.30	1.20	1.10	1.05	1.00	0.95	0.90	0.85	0.85

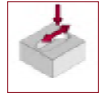
INS		
RD..10T3...	08B.0375.7991	TX208
RD..10T3...*	08B.0363.7991	TX208
RD..1204...	08B.3509.7991	TX215
RD..1204...*	08B.3578.7991	TX215
RD..1605...	08B.0513.7991	TX220

\* Note that the screw length required varies depending on the insert used

Technical information ramp and adaptation  
of  $f_z$  at different  $a_p$  values page 144

# HIGH FEED MILLING CUTTERS

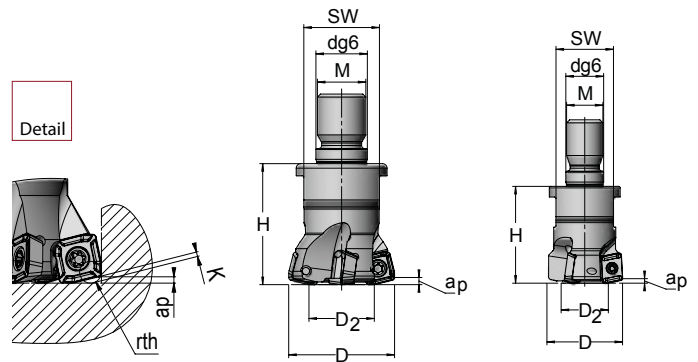
## UD90



**NEWT**ool

The versions with  $\varnothing$  16–50 mm are optimal for powerful milling on live tooling lathes and machining centers with rather low rigidity and drive power

DIN tool holders with standard adaptation shank and spindle connection for HSK, Capto and SK

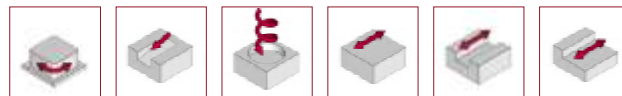


UD90 Screw-in milling cutters														INS
Article	D	D <sub>2</sub>	dg <sub>6</sub>	H	M	SW	z <sub>eff</sub>	a <sub>p</sub>	rth	K	Ramp	lc	kg	
18U.1625.130	16	6.6	8.5	25	8	12	2	1.0	1.5	0.7	3°	yes	0.05	UD..0602.R*
18U.2025.130	20	10.6	10.5	25	10	15	2	1.0	1.5	0.7	3°	yes	0.05	UD..0602.R
18U.2532.130	25	15.6	12.5	32	12	19	3	1.0	1.5	0.7	3°	yes	0.10	UD..0602.R
18U.2532.080	25	14.6	12.5	32	12	17	2	1.3	2.1	0.8	4°	yes	0.10	UD..0803.R
18U.3240.130	32	22.6	17	40	16	27	4	1.0	1.5	0.7	2.5°	yes	0.21	UD..0602.R
18U.3240.080	32	21.7	17	40	16	25	4	1.3	2.1	0.8	2.8°	yes	0.18	UD..0803.R
18U.3240.100	32	18.6	17	40	16	25	3	1.7	2.5	1.0	3.5°	yes	0.19	UD..10T3.R
18U.3540.130	35	25.6	17	40	16	30	5	1.0	1.5	0.7	2.5°	yes	0.25	UD..0602.R
18U.3540.080	35	24.7	17	40	16	27	4	1.3	2.1	0.8	2.5°	yes	0.22	UD..0803.R
18U.3540.100	35	21.6	17	40	16	25	4	1.7	2.5	1.0	2.9°	yes	0.20	UD..10T3.R
18U.3540.070	35	19.6	17	40	16	30	3	2.0	2.5	1.3	3.8°	yes	0.25	UD..1204.R
18U.4040.130	40	30.6	17	40	16	32	5	1.0	1.5	0.7	2.0°	yes	0.32	UD..0602.R
18U.4040.080	40	27.2	17	40	16	30	5	1.3	2.1	0.8	2.3°	yes	0.26	UD..0803.R
18U.4040.100	40	26.6	17	40	16	30	4	1.7	2.5	1.0	2.5°	yes	0.27	UD..10T3.R
18U.5040.070	50	33.5	17	40	16	30	5	2.0	2.5	1.3	3.0°	yes	0.36	UD..1204.R*

\* Note that the screw length required varies depending on the insert used

# HIGH FEED MILLING CUTTERS

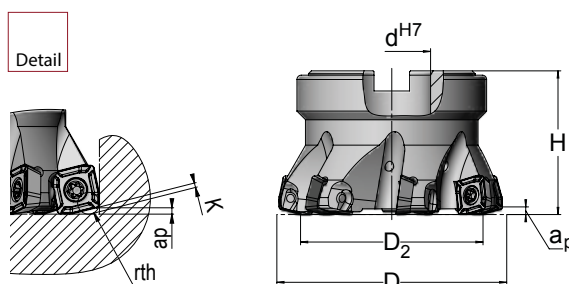
## UD90



**NEWT**ool



Suitable for universal use, with 4-cutting edge UDGT indexable insert, in particular for high alloy steels  
 "Soft" cutting ensures maximum metal removal rate Q even in case of extreme overhang – ideal for pocket milling  
 Remarkable finishing quality even at high feed rates – excellent surface quality

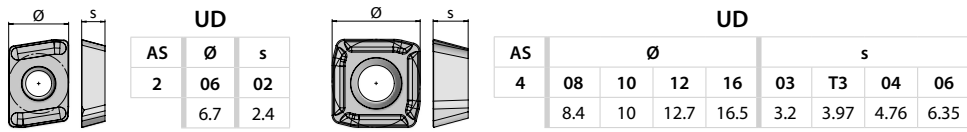


UD90 Plug-in milling cutters												
Article	D	D <sub>2</sub>	d <sup>H7</sup>	H	Z <sub>eff</sub>	a <sub>p</sub>	rth	K	Ramp	Ic	kg	INS
18U.5050.100	50	36.6	22	50	6	1.7	2.5	1.0	2.1°	yes	0.38	UD..10T3.R
18U.5050.070	50	33.5	22	50	5	2.0	2.5	1.3	3.0°	yes	0.36	UD..1204.R*
18U.5250.100	52	38.6	22	50	6	1.7	2.5	1.0	1.9°	yes	0.40	UD..10T3.R
18U.5250.070	52	36.6	22	50	5	2.0	2.5	1.3	3.0°	yes	0.42	UD..1204.R*
18U.6350.100	63	49.6	22	50	7	1.7	2.5	1.0	1.6°	yes	0.65	UD..10T3.R
18U.6350.070	63	46.5	22	50	6	2.0	2.5	1.3	2.0°	yes	0.62	UD..1204.R
18U.6650.100	66	52.6	27	50	7	1.7	2.5	1.0	1.5°	yes	0.65	UD..10T3.R
18U.6650.070	66	49.5	27	50	6	2.0	2.5	1.3	1.8°	yes	0.67	UD..1204.R
18U.8050.070	80	63.5	27	50	7	2.0	2.5	1.3	1.3°	yes	1.03	UD..1204.R
18U.8050.160	80	56.2	27	50	5	3.0	3.8	3.0	1.1°	yes	0.94	UD..1606.R
18U.1050.070	100	83.5	32	50	9	2.0	2.5	1.3	1.2°	yes	1.57	UD..1204.R
18U.1050.160	100	76.2	32	50	7	3.0	3.8	3.0	1.1°	yes	1.57	UD..1606.R
18U.1263.070	125	108.5	40	63	11	2.0	2.5	1.3	0.8°	yes	3.14	UD..1204.R
18U.1263.160	125	98.6	40	63	9	3.0	3.8	3.0	1.1°	yes	3.10	UD..1606.R
18U.1663.160**	160	136.2	40	63	10	3.0	3.8	3.0	0.8°	yes	5.73	UD..1606.R

\* Note that the screw length required varies depending on the insert used

\*\* On request

# INS SHAPE UD



Matching of machining parameters with the AV material groups

				Steel						
Article		Designation		A22	A21	A20	A19	A18	A17	A16
UD.0602..	UD.0602.002.01 SKY77	UDGT 060215 SR-28	f <sub>z</sub>	1.10	1.00	0.85	0.80	0.80	0.70	0.60
			v <sub>c</sub>	280-320	240-280	210-240	180-210	140-180	110-140	70-110
	UD.0602.002.01 AV1044	UDGT 060215 SR-28	f <sub>z</sub>	-	-	0.85	0.80	0.80	0.70	0.60
			v <sub>c</sub>	-	-	230-290	190-240	170-200	140-180	90-130
	UD.0602.002.01 AV1055	UDGT 060215 SR-28	f <sub>z</sub>	-	-	-	0.80	0.80	0.70	0.60
			v <sub>c</sub>	-	-	-	190-240	170-200	140-180	90-130
UD.0803..	UD.0803.003.01 SKY77	UDGT 080321 SR-28	f <sub>z</sub>	1.30	1.15	1.00	1.00	1.00	0.80	0.60
			v <sub>c</sub>	280-320	240-280	210-240	180-210	140-180	110-140	70-110
	UD.0803.003.01 AV1044	UDGT 080321 SR-28	f <sub>z</sub>	-	-	1.00	1.00	1.00	0.80	0.60
			v <sub>c</sub>	-	-	230-290	190-240	170-200	140-180	90-130
	UD.0803.003.01 AV1055	UDGT 080321 SR-28	f <sub>z</sub>	-	-	-	1.00	1.00	0.80	0.60
			v <sub>c</sub>	-	-	-	190-240	170-200	140-180	90-130
UD.10T3..	UD.10T3.002.01 SKY77	UDGT 10T325 SR-25	f <sub>z</sub>	1.40	1.30	1.20	1.20	1.20	0.90	0.65
			v <sub>c</sub>	280-320	240-280	210-240	180-210	140-180	110-140	70-110
	UD.10T3.002.01 AV1077	UDGT 10T325 SR-25	f <sub>z</sub>	1.40	1.30	1.20	1.20	1.20	0.90	0.65
			v <sub>c</sub>	290-340	260-300	220-250	190-230	150-210	130-170	80-120
	UD.10T3.002.02 AV1044	UDGT 10T325 SR-28	f <sub>z</sub>	-	-	1.20	1.20	1.20	0.90	0.65
			v <sub>c</sub>	-	-	230-290	190-240	170-200	140-180	90-130
UD.10T3.002.02 AV1055	UDGT 10T325 SR-28	f <sub>z</sub>	-	-	-	1.20	1.20	0.90	0.65	
		v <sub>c</sub>	-	-	-	190-240	170-200	140-180	90-130	
UD.1204..	UD.1204.002.01 SKY77	UDGT 120425 SR-25	f <sub>z</sub>	1.70	1.50	1.40	1.40	1.40	1.00	0.70
			v <sub>c</sub>	280-320	240-280	210-240	180-210	140-180	110-140	70-110
	UD.1204.002.01 AV1077	UDGT 120425 SR-25	f <sub>z</sub>	1.70	1.50	1.40	1.40	1.40	1.00	0.70
			v <sub>c</sub>	290-340	260-300	220-250	190-230	150-210	130-170	80-120
	UD.1204.002.02 AV1044	UDGT 120425 SR-28	f <sub>z</sub>	-	-	1.40	1.40	1.40	1.00	0.70
			v <sub>c</sub>	-	-	230-290	190-240	170-200	140-180	90-130
UD.1204.002.02 AV1055	UDGT 120425 SR-28	f <sub>z</sub>	-	-	-	1.40	1.40	1.00	0.70	
		v <sub>c</sub>	-	-	-	190-240	170-200	140-180	90-130	
UD.1606..	UD.1606.002.01 SKY77	UDGT 160638 SR-25	f <sub>z</sub>	2.00	1.80	1.60	1.60	1.60	1.20	0.80
			v <sub>c</sub>	280-320	240-280	210-240	180-210	140-180	110-140	70-110
	UD.1606.002.01 AV1077	UDGT 160638 SR-25	f <sub>z</sub>	2.00	1.80	1.60	1.60	1.60	1.20	0.80
			v <sub>c</sub>	290-340	260-300	220-250	190-230	150-210	130-170	80-120
	UD.1606.002.02 AV1044	UDGT 160638 SR-28	f <sub>z</sub>	-	-	1.60	1.60	1.60	1.20	0.80
			v <sub>c</sub>	-	-	230-290	190-240	170-200	140-180	90-130
UD.1606.002.02 AV1055	UDGT 160638 SR-28	f <sub>z</sub>	-	-	-	1.60	1.60	1.20	0.80	
		v <sub>c</sub>	-	-	-	190-240	170-200	140-180	90-130	



## INS SHAPE UD

UD			UD							
AS	Ø	s	Ø				s			
2	06	02	08	10	12	16	03	T3	04	06
	6.7	2.4	8.4	10	12.7	16.5	3.2	3.97	4.76	6.35

Matching of machining parameters  
with the AV material groups

				Cast iron					
Article		Designation		D21	D20	D19	D18	D17	D16
UD.0602..	UD.0602.002.01 SKY77	UDGT 060215 SR-28	f <sub>z</sub>	1.20	1.10	0.95	0.80	0.60	0.60
			v <sub>c</sub>	290-340	260-310	240-280	210-240	180-210	140-180
UD.0803..	UD.0803.003.01 SKY77	UDGT 080321 SR-28	f <sub>z</sub>	1.40	1.20	1.00	1.00	0.80	0.70
			v <sub>c</sub>	290-340	260-310	240-280	210-240	180-210	140-180
UD.10T3..	UD.10T3.002.01 SKY77	UDGT 10T325 SR-25	f <sub>z</sub>	1.50	1.40	1.20	1.20	1.00	0.75
			v <sub>c</sub>	290-340	260-310	240-280	210-240	180-210	140-180
UD.1204..	UD.1204.002.01 SKY77	UDGT 120425 SR-25	f <sub>z</sub>	1.80	1.60	1.40	1.40	1.20	0.90
			v <sub>c</sub>	290-340	260-310	240-280	210-240	180-210	140-180
UD.1606..	UD.1606.002.01 SKY77	UDGT 160638 SR-25	f <sub>z</sub>	2.10	1.90	1.60	1.60	1.40	1.00
			v <sub>c</sub>	290-340	260-310	240-280	210-240	180-210	140-180



				Stainless steels				Titanium		
Article		Designation		C12	C11	C10	C09	S10	S09	S08
UD.0602..	UD.0602.002.01 SKY77	UDGT 060215 SR-28	f <sub>z</sub>	0.80	-	-	-	-	-	-
			v <sub>c</sub>	100-150	-	-	-	-	-	-
	UD.0602.002.01 AV1044	UDGT 060215 SR-28	f <sub>z</sub>	0.80	0.75	0.70	-	-	-	-
			v <sub>c</sub>	100-150	140-170	100-140	-	-	-	-
	UD.0602.002.01 AV1055	UDGT 060215 SR-28	f <sub>z</sub>	0.80	0.75	0.70	0.50	0.70	0.50	0.45
			v <sub>c</sub>	120-200	140-170	100-140	60-100	60-80	40-70	20-50
UD.0803..	UD.0803.003.01 SKY77	UDGT 080321 SR-28	f <sub>z</sub>	0.80	-	-	-	-	-	-
			v <sub>c</sub>	100-150	-	-	-	-	-	-
	UD.0803.003.01 AV1044	UDGT 080321 SR-28	f <sub>z</sub>	0.80	0.75	0.70	-	-	-	-
			v <sub>c</sub>	100-170	100-170	100-140	-	-	-	-
	UD.0803.003.01 AV1055	UDGT 080321 SR-28	f <sub>z</sub>	0.80	0.75	0.70	0.55	0.70	0.50	0.45
			v <sub>c</sub>	120-200	100-170	100-140	60-100	60-80	40-70	20-50
UD.10T3..	UD.10T3.002.01 SKY77	UDGT 10T325 SR-25	f <sub>z</sub>	0.90	-	-	-	-	-	-
			v <sub>c</sub>	100-150	-	-	-	-	-	-
	UD.10T3.002.01 AV1077	UDGT 10T325 SR-25	f <sub>z</sub>	0.90	0.80	-	-	-	-	-
			v <sub>c</sub>	100-150	100-150	-	-	-	-	-
	UD.10T3.002.02 AV1044	UDGT 10T325 SR-28	f <sub>z</sub>	0.90	0.80	0.75	-	-	-	-
			v <sub>c</sub>	100-170	100-170	100-140	-	-	-	-
UD.10T3.002.02 AV1055	UDGT 10T325 SR-28	f <sub>z</sub>	0.90	0.80	0.75	0.60	0.70	0.60	0.45	
		v <sub>c</sub>	100-200	100-170	100-140	60-100	60-80	40-70	20-50	

# INS SHAPE UD

UD			UD							
AS	Ø	s	Ø				s			
2	06	02	08	10	12	16	03	T3	04	06
	6.7	2.4	8.4	10	12.7	16.5	3.2	3.97	4.76	6.35

Matching of machining parameters with the AV material groups

Article	Designation		Stainless steels				Titanium				
			C12	C11	C10	C09	S10	S09	S08		
UD.1204..	UD.1204.002.01 SKY77	UDGT 120425 SR-25	f <sub>z</sub>	1.00	-	-	-	-	-	-	
			v <sub>c</sub>	100-150	-	-	-	-	-	-	
	UD.1204.002.01 AV1077	UDGT 120425 SR-25	f <sub>z</sub>	1.00	0.85	0.75	-	-	-	-	
			v <sub>c</sub>	100-150	100-150	100-140	-	-	-	-	
UD.1204.002.02 AV1044	UDGT 120425 SR-28	UDGT 120425 SR-28	f <sub>z</sub>	1.00	0.85	0.75	-	-	-	-	
			v <sub>c</sub>	100-170	100-170	100-140	-	-	-	-	
	UD.1204.002.02 AV1055	UDGT 120425 SR-28	f <sub>z</sub>	1.00	0.85	0.75	0.60	0.70	0.60	0.45	
			v <sub>c</sub>	120-200	100-170	100-140	60-100	60-80	40-70	20-50	
UD.1606..	UD.1606.002.01 SKY77	UDGT 160638 SR-25	f <sub>z</sub>	1.20	-	-	-	-	-	-	
			v <sub>c</sub>	100-150	-	-	-	-	-	-	
	UD.1606.002.01 AV1077	UDGT 160638 SR-25	f <sub>z</sub>	1.20	0.90	0.80	-	-	-	-	
			v <sub>c</sub>	100-150	100-150	100-140	-	-	-	-	
	UD.1606.002.02 AV1044	UDGT 160638 SR-28	UDGT 160638 SR-28	f <sub>z</sub>	1.20	0.90	0.80	-	-	-	-
				v <sub>c</sub>	100-170	100-170	100-140	-	-	-	-
		UD.1606.002.02 AV1055	UDGT 160638 SR-28	f <sub>z</sub>	1.20	0.90	0.80	0.70	0.75	0.70	0.50
				v <sub>c</sub>	120-200	100-170	100-140	60-100	60-80	40-70	20-50

INS		
UD..0602...*	08TP.2555.500	TP711
UD..0602...	08TP.2565.501	TP711
UD..0803...	08B.0307.7991	TX208
UD..10T3...	08B.3509.7991	TX215
UD..1204...*	08B.0409.7991	TX215
UD..1204...	08B.0411.7991	TX215
UD..1606...	08B.0513.7991	TX220

\* Note that the screw length required varies depending on the insert used

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