

CP90
CV90

EP90
EV90

HC90

LN90

SN90

CS90



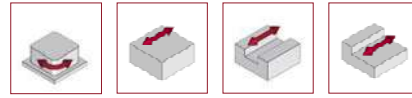
Shoulder milling cutters with tangentially installed inserts are more break resistant and deliver outstanding cast iron machining results thanks to fine tooth pitches. The high feed and depth of cut in roughing are also achieved when machining materials such as stainless and titanium; the surface quality is excellent. Optimum stability for high precision and maximum Q. Also with DIN-type screw-in connection.

High positive
stability at 90°

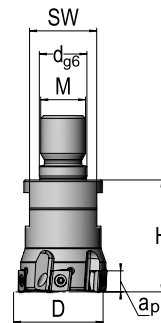
SHOULDER MILLING CUTTERS SHANK END MILLS

SHOULDER MILLING CUTTERS

CP90 | CV90



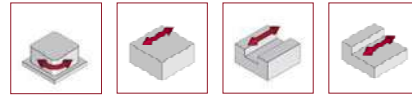
The versions with \varnothing 25–40 mm are optimal for powerful milling on live tooling lathes and machining centers with rather low rigidity and drive power
 DIN tool holders with standard adaptation shank and spindle connection for HSK, Capto and SK



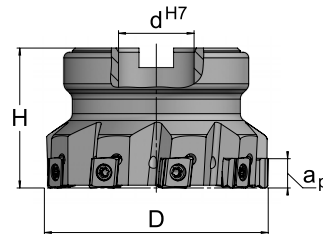
CV90 Screw-in milling cutters										
Article	D	dg6	H	M	SW	z _{eff}	a _p	lc	kg	INS
04C.0232.001	25	12.5	32	12	17	4	7.5	yes	0.11	CN..07T3L
04C.0340.002	32	17	40	16	24	5	7.5	yes	0.22	CN..07T3L
04C.0440.001	40	17	40	16	24	7	7.5	yes	0.28	CN..07T3L

SHOULDER MILLING CUTTERS

CP90 | CV90



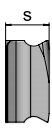
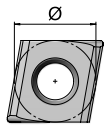
Maximum break resistance through tangential mounting of the 4-cutting edge CN indexable insert
High combined feed per tooth and depths of cut
Excellent for VA materials



CP90 Plug-in milling cutters								INS
Article	D	d ^{H7}	H	z ^{eff}	a _p	lc	kg	
04C.0540.001	50	22	40	5	10.0	yes	0.35	CN..1005L
04C.0640.001	63	22	40	6	10.0	yes	0.54	CN..1005L
04C.0850.001	80	27	50	8	10.0	yes	1.10	CN..1005L
04C.1050.001	100	32	50	9	10.0	yes	1.77	CN..1005L
04C.1263.002	125	40	63	13	10.0	yes	3.30	CN..1005L

CV90 Plug-in milling cutters								INS
Article	D	d ^{H7}	H	z ^{eff}	a _p	lc	kg	
04C.0332.001	32	22	32	5	7.5	yes	0.12	CN..07T3L
04C.0432.004	40	16	32	7	7.5	yes	0.19	CN..07T3L
04C.0540.002	50	22	40	8	7.5	yes	0.36	CN..07T3L
04C.0640.002	63	22	40	7	10.0	yes	0.56	CN..1005L
04C.0850.002	80	27	50	9	10.0	yes	1.09	CN..1005L
04C.1050.002	100	32	50	12	10.0	yes	1.81	CN..1005L
04C.1263.001	125	40	63	16	10.0	yes	3.36	CN..1005L

INS SHAPE CN



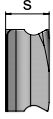
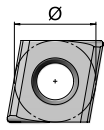
CN					
AS	Ø		s		
4	07	10	T3	05	
	7.5	10.4	4	5.6	

Matching of machining parameters with the AV material groups

				Steel						
Article		Designation		A22	A21	A20	A19	A18	A17	A16
CN..07T3..	CN.07T3.008.11 SKY77	CNHQ 07T306 SL-28W	h_{max}	0.16	0.16	0.15	0.13	0.12	-	-
			v_c	250-300	230-280	210-240	180-210	140-180	-	-
CN..07T3..	CN.07T3.008.11 AV1077	CNHQ 07T306 SL-28W	h_{max}	-	-	-	-	0.12	0.12	0.10
			v_c	-	-	-	-	140-180	110-140	80-110
CN..1005..	CN.1005.002.01 SKY77	CNHQ 100510 SL-25V	h_{max}	0.24	0.22	0.20	-	-	-	-
			v_c	280-320	240-280	210-240	-	-	-	-
	CN.1005.002.02 SKY77	CNHQ 100510 SL-28V	h_{max}	-	-	0.20	0.18	0.16	-	-
			v_c	-	-	210-240	180-210	140-180	-	-
	CN.1005.002.02 AV1077	CNHQ 100510 SL-28V	h_{max}	-	-	-	-	0.16	0.14	0.11
			v_c	-	-	-	-	140-180	110-140	80-110

				Cast iron					
Article		Designation		D21	D20	D19	D18	D17	D16
CN..07T3..	CN.07T3.008.11 SKY77	CNHQ 07T306 SL-28W	h_{max}	-	-	-	0.12	0.12	0.12
			v_c	-	-	-	170-200	150-180	120-160
CN..07T3..	CN.07T3.008.11 NERO ² 77	CNHQ 07T306 SL-28W	h_{max}	0.17	0.15	0.14	0.12	0.12	0.12
			v_c	260-320	240-280	200-240	180-220	160-200	120-160
CN..1005..	CN.1005.002.01 SKY77	CNHQ 100510 SL-25V	h_{max}	-	-	-	0.20	0.17	0.15
			v_c	-	-	-	170-200	150-180	120-160
	CN.1005.002.01 NERO ² 77	CNHQ 100510 SL-25V	h_{max}	0.28	0.26	0.22	0.20	0.17	0.15
			v_c	260-320	240-280	200-240	180-220	160-200	120-160



INS SHAPE CN



CN				
AS	Ø		s	
4	07	10	T3	05
	7.5	10.4	4	5.6

Matching of machining parameters
with the AV material groups

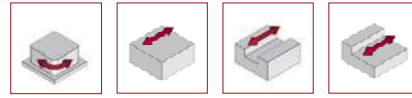
				Stainless steels			
Article		Designation		C12	C11	C10	C09
CN..07T3..	CN.07T3.008.11 AV1055	CNHQ 07T306 SL-28W	h_{max}	0.11	0.10	0.08	0.08
			v_c	150-220	140-170	90-120	60-100
CN..07T3..	CN.07T3.008.11 AV1077	CNHQ 07T306 SL-28W	h_{max}	0.11	–	–	–
			v_c	150-220	–	–	–
CN..1005..	CN.1005.002.02 AV1055	CNHQ 100510 SL-28V	h_{max}	0.18	0.15	0.15	0.12
			v_c	150-220	140-170	90-120	60-100
CN..1005..	CN.1005.002.02 AV1077	CNHQ 100510 SL-28V	h_{max}	0.18	–	–	–
			v_c	150-220	–	–	–

INS		
CN..07T3...	08B.0309.7991	TX208
CN..1005...	08B.3511.7991	TX215

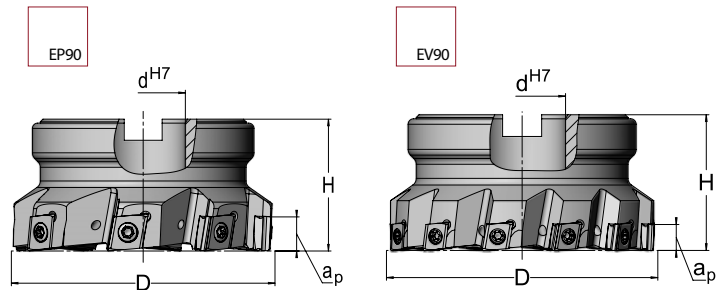
Mounting | CN/EN/FN
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SHOULDER MILLING CUTTERS

EP90 | EV90



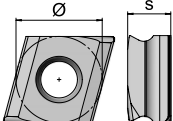
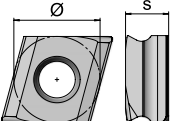
Maximum break resistance through tangential mounting of the 4-cutting edge EN indexable insert
 High combined feed per tooth and depths of cut
 EV90: Fine tooth pitch is an advantage in cast iron machining processes



EP90 Plug-in milling cutters								
Article	D	d ^{H7}	H	z _{eff}	a _p	lc	kg	INS
04E.0432.001	40	16	32	5	7.5	yes	0.18	EN..08T3.L
04E.0536.001	50	22	36	5	9.0	yes	0.31	EN..0904.L
04E.0640.005	63	22	40	5	12.0	yes	0.52	EN..1206.L
04E.0850.001	80	27	50	7	12.0	yes	1.06	EN..1206.L
04E.1050.001	100	32	50	8	12.0	yes	1.76	EN..1206.L
04E.1263.001	125	40	63	10	12.0	yes	3.13	EN..1206.L

EV90 Plug-in milling cutters								
Article	D	d ^{H7}	H	z _{eff}	a _p	lc	kg	INS
04E.0432.002	40	16	32	6	7.5	yes	0.20	EN..08T3.L
04E.0536.004	50	22	36	7	7.5	yes	0.32	EN..08T3.L
04E.0640.001	63	22	40	7	9.0	yes	0.54	EN..0904.L
04E.0640.006	63	22	40	9	7.5	yes	0.57	EN..08T3.L
04E.0850.004	80	27	50	10	9.0	yes	1.09	EN..0904.L
04E.0850.016	80	27	50	12	7.5	yes	1.12	EN..08T3.L
04E.1050.003	100	32	50	12	9.0	yes	1.77	EN..0904.L
04E.1050.004	100	32	50	12	12.0	yes	1.82	EN..1206.L
04E.1263.003	125	40	63	13	9.0	yes	3.16	EN..0904.L
04E.1263.007	125	40	63	15	12.0	yes	3.16	EN..1206.L

INS SHAPE EN

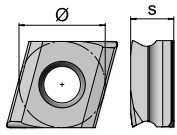
		EN*								EN												
		AS		Ø			s					AS		Ø			s					
	1	08	09	12	T3	04	06		4	08	09	12	T3	04	06	8	8	9.52	12.7	3.97	4.76	6.35
		8	9.52	12.7	3.97	4.76	6.35				8	9.52	12.7	3.97	4.76		6.35					

Matching of machining parameters
with the AV material groups

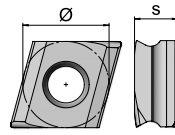
				Steel						
Article		Designation		A22	A21	A20	A19	A18	A17	A16
EN..08T3..	EN.08T3.012.09 SKY77	ENHQ 08T306 SL-28W	h_{max}	0.15	0.15	0.13	0.12	0.11	0.10	0.08
			v_c	250-300	230-280	210-240	180-210	140-180	110-140	80-110
	EN.08T3.017.26 SKY77	ENHQ 08T306 SL-28V	h_{max}	0.15	0.15	0.13	0.12	0.11	0.10	0.08
			v_c	250-300	230-280	210-240	180-210	140-180	110-140	80-110
	EN.08T3.031.01 SKY77*	ENFQ 08T306 FL-33S	h_{max}	0.15	0.15	0.13	0.12	0.11	0.10	0.08
			v_c	250-300	230-280	210-240	180-210	140-180	110-140	80-110
EN..0904..	EN.0904.023.12 SKY77	ENHQ 090408 SL-28W	h_{max}	0.18	0.18	0.15	0.15	0.12	0.12	0.10
			v_c	250-300	230-280	210-240	180-210	140-180	110-140	80-110
	EN.0904.017.26 SKY77	ENHQ 090408 SL-28V	h_{max}	0.18	0.18	0.15	0.15	0.12	0.12	0.10
			v_c	250-300	230-280	210-240	180-210	140-180	110-140	80-110
	EN.0904.033.02 SKY77*	ENFQ 090408 EL-33S	h_{max}	0.18	0.18	0.15	0.15	0.12	0.12	0.10
			v_c	250-300	230-280	210-240	180-210	140-180	110-140	80-110
EN..1206..	EN.1206.027.18 SKY77	ENHQ 120610 SL-25V	h_{max}	0.23	0.22	0.20	0.20	-	-	-
			v_c	250-300	230-280	210-240	180-210	-	-	-
	EN.1206.029.13 SKY77	ENHQ 120610 SL-28W	h_{max}	0.21	0.21	0.18	0.16	0.14	0.12	0.10
			v_c	250-300	230-280	210-240	180-210	140-180	110-140	80-110
	EN.1206.035.01 SKY77*	ENFQ 120610 EL-33S	h_{max}	0.21	0.21	0.18	0.16	0.14	0.12	0.10
			v_c	250-300	230-280	210-240	180-210	140-180	110-140	80-110

* Only one indexable wiper insert ENFQ required per tool. Only in combination with geometry -28W. The height changes.

INS SHAPE EN



EN*						
AS	Ø			s		
1	08	09	12	T3	04	06
	8	9.52	12.7	3.97	4.76	6.35



EN						
AS	Ø			s		
4	08	09	12	T3	04	06
	8	9.52	12.7	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
EN..08T3..	EN.08T3.012.09 SKY77	ENHQ 08T306 SL-28W	h_{max}	-	-	-	0.12	0.10	0.08
			v_c	-	-	-	150-190	120-160	120-150
	EN.08T3.012.09 NERO26	ENHQ 08T306 SL-28W	h_{max}	0.15	0.14	0.13	0.12	-	-
			v_c	260-320	240-280	200-240	180-220	-	-
	EN.08T3.017.26 SKY77	ENHQ 08T306 SL-28V	h_{max}	-	-	-	0.12	0.10	0.08
			v_c	-	-	-	150-190	120-160	120-150
	EN.08T3.017.26 NERO ² 77	ENHQ 08T306 SL-28V	h_{max}	0.15	0.14	0.13	0.12	0.10	0.08
			v_c	260-320	240-280	200-240	180-220	160-200	120-160
	EN.08T3.031.01 SKY77*	ENFQ 08T306 FL-33S	h_{max}	-	-	-	0.12	0.10	0.08
			v_c	-	-	-	150-190	120-160	120-150
	EN.08T3.031.01 NERO26*	ENFQ 08T306 FL-33S	h_{max}	0.15	0.14	0.13	0.12	0.10	0.08
			v_c	260-320	240-280	200-240	180-220	160-200	120-160
EN..0904..	EN.0904.023.12 SKY77	ENHQ 090408 SL-28W	h_{max}	-	-	-	0.12	0.11	0.10
			v_c	-	-	-	150-190	120-160	120-150
	EN.0904.023.12 NERO26	ENHQ 090408 SL-28W	h_{max}	0.18	0.17	0.15	0.12	-	-
			v_c	260-320	240-280	200-240	180-220	-	-
	EN.0904.017.26 SKY77	ENHQ 090408 SL-28V	h_{max}	-	-	-	0.12	0.11	0.10
			v_c	-	-	-	150-190	120-160	120-150
	EN.0904.017.26 NERO ² 77	ENHQ 090408 SL-28V	h_{max}	0.18	0.17	0.15	0.12	0.11	0.10
			v_c	260-320	240-280	200-240	180-220	160-200	120-160
	EN.0904.033.02 SKY77*	ENFQ 090408 EL-33S	h_{max}	0.18	0.17	0.15	0.12	0.11	0.10
			v_c	240-280	200-240	170-200	150-190	120-160	120-150



* Only one indexable wiper insert ENFQ required per tool. Only in combination with geometry -28W. The height changes.

INS SHAPE EN

		EN*								EN						
		Ø			s					Ø			s			
AS		08	09	12	T3	04	06		AS		08	09	12	T3	04	06
1		8	9.52	12.7	3.97	4.76	6.35		4		8	9.52	12.7	3.97	4.76	6.35

Matching of machining parameters
with the AV material groups

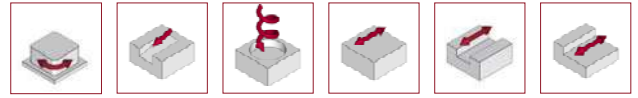
				Cast iron						
Article		Designation		D21	D20	D19	D18	D17	D16	
EN..1206..	EN.1206.027.18 SKY77	ENHQ 120610 SL-25V	h_{max}	0.26	0.26	0.23	0.20	0.16	0.13	
			v_c	240-280	200-240	170-200	150-190	120-160	120-150	
	EN.1206.027.18 NERO26	ENHQ 120610 SL-25V	h_{max}	0.26	0.26	0.23	0.20	-	-	
			v_c	260-320	240-280	200-240	180-220	-	-	
	EN.1206.027.18 CAN ² 77	ENHQ 120610 SL-25V	h_{max}	0.26	0.26	0.23	0.20	0.16	0.13	
			v_c	260-320	240-280	200-240	180-220	160-200	120-160	
	EN..1206..	EN.1206.029.13 SKY77	ENHQ 120610 SL-28W	h_{max}	0.24	0.23	0.22	0.17	0.15	0.12
				v_c	240-280	200-240	170-200	150-190	120-160	120-150
		EN.1206.029.13 NERO ² 77	ENHQ 120610 SL-28W	h_{max}	0.24	0.23	0.22	0.17	0.15	0.12
				v_c	260-320	240-280	200-240	180-220	160-200	120-160
	EN.1206.035.01 SKY77*	ENFQ 120610 EL-33S	h_{max}	0.24	0.23	0.22	0.17	0.15	0.12	
			v_c	240-280	200-240	170-200	150-190	120-160	120-150	

INS		
EN..08T3...	08B.0309.7991	TX208
EN..0904...	08B.3509.7991	TX215
EN..1206...	08B.0513.7991	TX220

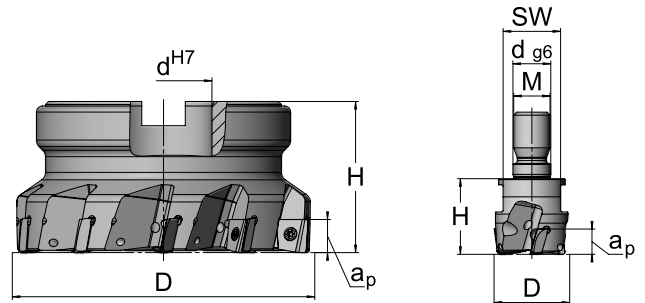
Mounting | CN/EN/FN
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SHOULDER MILLING CUTTERS

HC90



Highly compatible with materials that are difficult to machine, such as stainless and titanium
 High feed per tooth and depths of cut in 90°-machining
 Helix and ramp machining possible
 Screw-in versions with Ø 25–40 mm are optimal for powerful milling on live tooling lathes and machining centers with rather low rigidity and drive power



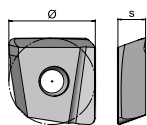
HC90 Screw-in milling cutters

Article	D	dg6	H	M	SW	z _{eff}	a _p	Ramp	lc	kg	INS
04M.0225.151	25	12.5	25	12	19	3	8.0	–	yes	0.10	MO..1003.R
04M.0325.151	32	17	25	16	27	4	8.0	–	yes	0.14	MO..1003.R
04M.0430.151	40	17	30	16	27	5	8.0	–	yes	0.22	MO..1003.R

HC90 Plug-in milling cutters

Article	D	d ^{H7}	H	z _{eff}	a _p	Ramp	lc	kg	INS
04M.0432.150	40	16	32	5	8.0	1.0°	yes	0.16	MO..1003.R
04M.0540.150	50	22	40	6	8.0	0.8°	yes	0.32	MO..1003.R
04M.0540.080	50	22	40	6	10.0	1.1°	yes	0.32	MO..12T3.R
04M.0640.080	63	22	40	7	10.0	0.8°	yes	0.50	MO..12T3.R
04M.0850.080	80	27	50	9	10.0	0.6°	yes	1.03	MO..12T3.R
04M.1050.080	100	32	50	10	10.0	0.5°	yes	1.70	MO..12T3.R

INS SHAPE MO





MO				
AS	Ø		s	
2	10	12	03	T3
	10	12.7	3.6	4

Matching of machining parameters
with the AV material groups

				Steel						
Article		Designation		A22	A21	A20	A19	A18	A17	A16
MO..1003..	MO.1003.031.04 SKY77	MOGU 100310 TR-28	h_{max}	0.18	0.16	0.15	0.13	0.12	–	–
			v_c	280-320	240-280	210-240	180-210	140-180	–	–
	MO.1003.031.04 AV1077	MOGU 100310 TR-28	h_{max}	–	–	–	–	0.12	0.11	0.08
			v_c	–	–	–	–	140-180	110-140	80-110
MO..12T3..	MO.12T3.081.01 SKY77	MOGU 12T310 TR-28	h_{max}	0.23	0.22	0.20	0.18	0.15	–	–
			v_c	280-320	240-280	210-240	180-210	140-180	–	–
	MO.12T3.081.01 AV1077	MOGU 12T310 TR-28	h_{max}	–	–	–	–	0.15	0.12	0.10
			v_c	–	–	–	–	140-180	110-140	80-110

				Cast iron					
Article		Designation		D21	D20	D19	D18	D17	D16
MO..1003..	MO.1003.031.04 SKY77	MOGU 100310 TR-28	h_{max}	0.20	0.18	0.16	0.14	0.12	0.10
			v_c	240-280	200-240	170-200	150-190	120-160	120-150
MO..12T3..	MO.12T3.081.01 SKY77	MOGU 12T310 TR-28	h_{max}	0.25	0.23	0.20	0.18	0.15	0.12
			v_c	240-280	200-240	170-200	150-190	120-160	120-150

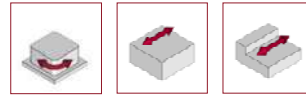
				Stainless steels				NF metals		
Article		Designation		C12	C11	C10	C09	E82	E81	E80
MO..1003..	MO.1003.031.04 SKY77	MOGU 100310 TR-28	h_{max}	–	–	–	–	0.25	0.21	0.17
			v_c	–	–	–	–	650-1000	450-650	280-450
	MO.1003.031.04 AV1055	MOGU 100310 TR-28	h_{max}	0.12	0.10	0.08	0.08	–	–	–
			v_c	150-220	140-170	90-120	60-100	–	–	–
	MO.1003.031.04 AV1077	MOGU 100310 TR-28	h_{max}	0.12	–	–	–	–	–	–
			v_c	120-220	–	–	–	–	–	–
MO..12T3..	MO.12T3.081.01 SKY77	MOGU 12T310 TR-28	h_{max}	–	–	–	–	0.28	0.23	0.18
			v_c	–	–	–	–	650-1000	450-650	280-450
	MO.12T3.081.01 AV1055	MOGU 12T310 TR-28	h_{max}	0.15	0.13	0.10	0.10	–	–	–
			v_c	150-220	140-170	90-120	60-100	–	–	–
	MO.12T3.081.01 AV1077	MOGU 12T310 TR-28	h_{max}	0.15	–	–	–	–	–	–
			v_c	120-220	–	–	–	–	–	–

INS		
MO..1003...	08B.0309.001	TX208
MO..12T3...	08B.0309.001	TX208

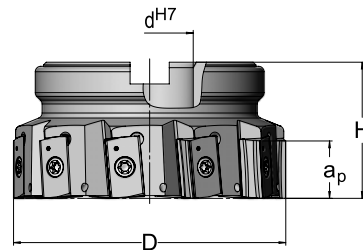
Technical information ramp page 146

SHOULDER MILLING CUTTERS

LN90

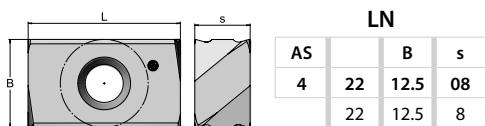


With insert sizes for extremely high depths of cut in 90° machining
 Enormous stability due to sturdy cutting wedge
 Achieves excellent roughing and finishing surface quality



LN90 Plug-in milling cutters								INS
Article	D	d ^{H7}	H	z ^{eff}	a _p	lc	kg	
04L.0550.003	50	22	50	5	20.0	yes	0.52	LN..2208..L
04L.0650.005	63	22	50	6	20.0	yes	0.84	LN..2208..L
04L.0850.005	80	27	50	8	20.0	yes	1.33	LN..2208..L
04L.1050.005	100	32	50	10	20.0	yes	2.05	LN..2208..L
04L.1263.005	125	40	63	13	20.0	yes	3.54	LN..2208..L



INS SHAPE LN



Matching of machining parameters
with the AV material groups

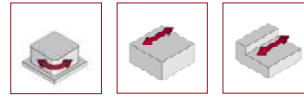
				Steel						
Article		Designation		A22	A21	A20	A19	A18	A17	A16
LN..2208..	LN.2208.003.01 SKY77	LNHQ 220805 SL-28	h_{max}	0.23	0.20	0.18	-	-	-	-
			v_c	280-320	220-280	180-230	-	-	-	-

				Cast iron					
Article		Designation		D21	D20	D19	D18	D17	D16
LN..2208..	LN.2208.003.01 SKY77	LNHQ 220805 SL-28	h_{max}	-	-	-	0.20	0.16	0.12
			v_c	-	-	-	150-190	120-160	120-150
	LN.2208.003.01 CAN ² 77	LNHQ 220805 SL-28	h_{max}	0.28	0.26	0.22	0.20	0.16	0.12
			v_c	300-380	270-320	230-280	170-220	150-200	120-150

INS		
LN..2208...	08B.0513.7991	TX220

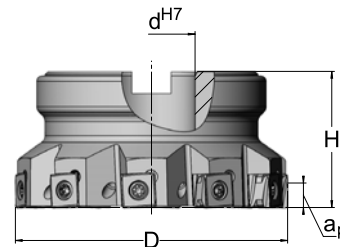
SHOULDER MILLING CUTTERS

SN90



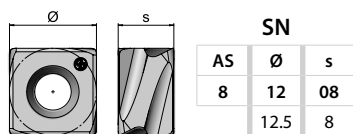
NEWTool

Crosscut angle 90°
 Economical with 8-edged tangential
 SN indexable insert
 Robust and easy-cutting and ideal
 for machining cast iron





SN90 Plug-in milling cutters								INS
Article	D	d ^{H7}	H	Z ^{eff}	a _p	lc	kg	
04S.0540.090	50	22	40	5	9.0	yes	0.40	SN.1208..L
04S.0640.090	63	22	40	7	9.0	yes	0.60	SN.1208..L
04S.0850.090	80	27	50	9	9.0	yes	1.15	SN.1208..L
04S.1050.090	100	32	50	10	9.0	yes	1.85	SN.1208..L
04S.1263.090	125	40	63	12	9.0	no	2.85	SN.1208..L
04S.1663.090	160	40	63	16	9.0	no	4.25	SN.1208..L

INS SHAPE SN



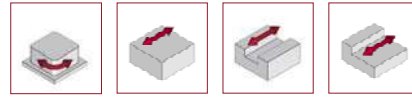
Matching of machining parameters
with the AV material groups

				Cast iron					
Article		Designation		D21	D20	D19	D18	D17	D16
SN..1208..	SN.1208.090.01 NERO ²⁷⁷	SNHQ 120808 SL-28	h _{max}	0.28	0.26	0.22	0.2	0.17	0.15
			v _c	260-320	240-280	200-240	180-220	160-200	120-160
	SN.1208.090.02 NERO26	SNHQ 120808 SL-25	h _{max}	0.28	0.26	0.22	0.20	0.17	0.15
			v _c	260-320	240-280	200-240	180-220	160-200	120-160
	SN.1208.094.01 NERO ²⁷⁷	SNFQ 120808 EL-33	f _n	3.50	3.50	3.50	3.50	3.50	3.50
			v _c	260-320	240-280	200-240	180-220	160-200	120-160

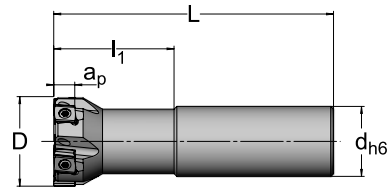
INS		
SN..1208..L	08B.0416.7991	TX215

SHANK END MILLS

CS90

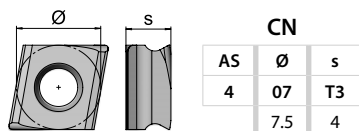


Maximum break resistance through tangential mounting of the 4-cutting edge CN indexable insert, even in small indexable inserts
 High combined feed per tooth and depths of cut
 Fine tooth pitch is an advantage in cast iron machining processes



CS90 Shank end mills									INS
Article	D	dh6	L	l ₁	Z _{eff}	a _p	lc	kg	
11C.2509.001	25	25	90	31.5	4	7	yes	0.30	CN..07T3..L
11C.3210.001	32	25	100	43	5	7	yes	0.37	CN..07T3..L
11C.4011.001	40	32	110	48.5	6	7	yes	0.67	CN..07T3..L

INS SHAPE CN



Matching of machining parameters
with the AV material groups

				Steel						
Article		Designation		A22	A21	A20	A19	A18	A17	A16
CN..07T3..	CN.07T3.008.11 SKY77	CNHQ 07T306 SL-28W	h_{max}	0.16	0.16	0.15	0.13	0.12	–	–
			v_c	250-300	230-280	210-240	180-210	140-180	–	–
	CN.07T3.008.11 AV1077	CNHQ 07T306 SL-28W	h_{max}	–	–	–	–	0.12	0.12	0.10
			v_c	–	–	–	–	140-180	110-140	80-110

				Cast iron					
Article		Designation		D21	D20	D19	D18	D17	D16
CN..07T3..	CN.07T3.008.11 SKY77	CNHQ 07T306 SL-28W	h_{max}	–	–	–	0.12	0.12	0.12
			v_c	–	–	–	170-200	150-180	120-160
	CN.07T3.008.11 NERO ² 77	CNHQ 07T306 SL-28W	h_{max}	0.17	0.15	0.14	0.12	0.12	0.12
			v_c	260-320	240-280	200-240	180-220	160-200	120-160

				Stainless steels			
Article		Designation		C12	C11	C10	C09
CN..07T3..	CN.07T3.008.11 AV1055	CNHQ 07T306 SL-28W	h_{max}	0.11	0.10	0.08	0.08
			v_c	150-220	140-170	90-120	60-100
	CN.07T3.008.11 AV1077	CNHQ 07T306 SL-28W	h_{max}	0.11	–	–	–
			v_c	150-220	–	–	–

INS		
CN..07T...	08B.0309.7991	TX208

Mounting | CN/EN/FN
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