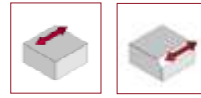
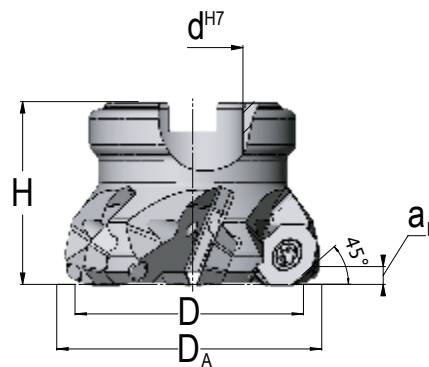


FACE MILLING CUTTERS

KC1.1

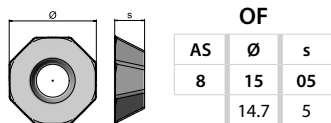


For universal use in cast iron and steel machining
 Excellent surface quality due to wiper geometry
 Optimal chip removal through improved cutting edge geometry



KC1.1 Plug-in milling cutters										
Article	D	D _A	d ^{H7}	H	z _{eff}	a _p	Wedge	Ic	kg	INS
030.5040.001	50	58.8	22	40	6	3.5	no	yes	0.35	OF..1505.N
030.6340.001	63	71.9	22	40	7	3.5	no	yes	0.56	OF..1505.N

INS SHAPE OF



Matching of machining parameters
with the AV material groups

Article	Designation	Recomm. a_e $0,7 \times D$	Steel						
			A22	A21	A20	A19	A18	A17	A16
OF..1505..	OF.1505.001.31 SKY77 OFEW 1505M0 TN-28S	h_{max}	0.55	0.50	0.45	0.40	0.35	0.30	0.30
		v_c	280-320	240-280	210-240	180-210	140-180	110-140	80-110
OF..1505..	OF.1505.001.40 SKY77 OFEW 1505M0 TN-25	h_{max}	0.60	0.55	0.50	0.45	0.40	–	–
		v_c	280-320	240-280	210-240	180-210	140-180	–	–

Article	Designation	Recomm. a_e $0,7 \times D$	Cast iron					
			D21	D20	D19	D18	D17	D16
OF..1505..	OF.1505.001.32 CAN ² 26 OFEW 1505M0 TN-25S	h_{max}	0.60	0.55	0.50	0.45	0.40	0.35
		v_c	340-380	280-340	240-280	210-240	180-210	140-180
OF..1505..	OF.1505.001.30 NERO ² 77 OFEW 1505M0 SN-28S	h_{max}	0.55	0.50	0.45	0.40	0.35	0.30
		v_c	300-340	270-300	240-280	210-240	180-210	140-180
OF..1505..	OF.1505.001.31 SKY77 OFEW 1505M0 TN-28S	h_{max}	0.55	0.50	0.45	0.40	0.35	0.30
		v_c	280-320	260-300	240-280	210-240	180-210	140-180
OF..1505..	OF.1505.001.40 SKY77 OFEW 1505M0 TN-25	h_{max}	0.60	0.55	0.50	0.45	0.40	0.35
		v_c	340-380	280-340	240-280	210-240	180-210	140-180

Article	Designation	Recomm. a_e $0,7 \times D$	NF metals		
			D21	D20	D19
OF..1505..	OF.1505.001.31 SKY77 OFEW 1505M0 TN-28S	h_{max}	0.55	0.50	0.35
		v_c	650-1000	450-650	280-450

INS		
OF..1505...	08B.4511.7991	TX220