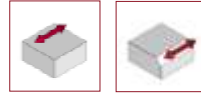


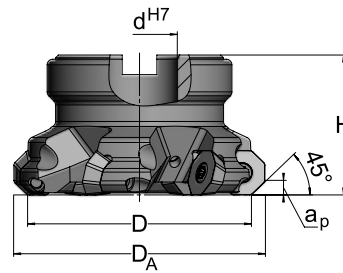
FACE MILLING CUTTERS

OE45

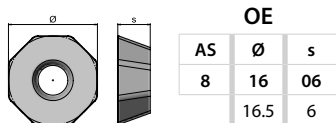


NEWTool

Well suited for the powerful machining of stainless steel materials
Optimal chip removal through improved cutting edge geometry
All diameters with internal cooling



OE45 Plug-in milling cutters									
Article	D	D _A	d ^{H7}	H	z _{eff}	a _p	lc	kg	INS
03O.6340.400	63	73.2	22	40	5	4.5	yes	0.55	OE.1606..
03O.8050.400	80	90.0	27	50	6	4.5	yes	1.08	OE.1606..
03O.1050.400	100	110.1	32	50	8	4.5	yes	1.78	OE.1606..
03O.1263.400	125	135.1	40	63	10	4.5	yes	3.41	OE.1606..
03O.1663.400	160	170.0	40	63	12	4.5	yes	5.02	OE.1606..


INS SHAPE **OE**

Matching of machining parameters
with the AV material groups

Article	Designation	Recomm. a_e 0,7 x D	Steel							
			A22	A21	A20	A19	A18	A17	A16	
OE.1606..	OE.1606.031.03 AV1077	OEEW 1606MO SN-28	h_{max}	0.55	0.50	0.45	0.40	0.40	0.35	0.25
			v_c	280-320	240-280	210-240	180-210	140-180	110-140	80-110
	OE.1606.031.03 AV1055	OEEW 1606MO SN-28	h_{max}	-	-	-	0.40	0.40	0.35	0.25
			v_c	-	-	-	180-210	140-180	110-140	80-110
	OE.1606.002.02 SKY77	OEEW 1606MO SN-25	h_{max}	0.60	0.55	0.50	0.45	0.45	-	-
			v_c	250-280	210-250	190-220	180-210	140-180	-	-
OE.1606.002.02 AV1077	OEEW 1606MO SN-25	h_{max}	0.60	0.55	0.50	0.45	0.45	-	-	
		v_c	280-320	240-280	210-240	180-210	140-180	-	-	
OE.1606.031.01 SKY77	OEEW 1606MO SN-23	h_{max}	0.60	0.55	0.55	-	-	-	-	
		v_c	250-280	210-250	190-220	-	-	-	-	
OE.1606.031.01 AV1077	OEEW 1606MO SN-23	h_{max}	0.60	0.55	0.55	-	-	-	-	
		v_c	280-320	240-280	210-240	-	-	-	-	

Article	Designation	Recomm. a_e 0,7 x D	Cast iron						
			D21	D20	D19	D18	D17	D16	
OE.1606..	OE.1606.002.02 SKY77	OEEW 1606MO SN-25	h_{max}	0.65	0.55	0.45	0.40	0.35	0.30
			v_c	260-300	240-270	200-260	190-220	170-210	140-180
OE.1606.031.01 SKY77	OEEW 1606MO SN-23	OEEW 1606MO SN-23	h_{max}	0.65	0.55	0.45	0.40	0.35	0.30
			v_c	260-300	240-270	200-260	190-220	170-210	140-180

Article	Designation	Recomm. a_e 0,7 x D	Stainless steels				NF metals			
			C12	C11	C10	C09	E82	E81	E80	
OE.1606..	OE.1606.031.03 AV1077	OEEW 1606MO SN-28	f_z	0.35	0.30	0.25	0.22	0.60	0.45	0.35
			v_c	100-150	100-150	80-120	60-100	650-1000	450-650	280-450
OE.1606.031.03 AV1055	OEEW 1606MO SN-28	OEEW 1606MO SN-28	f_z	0.35	0.30	0.25	0.22	-	-	-
			v_c	100-200	100-200	80-150	60-120	-	-	-

INS		
OE.1606...	08B.0513.7991	TX220