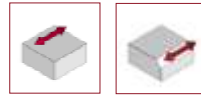
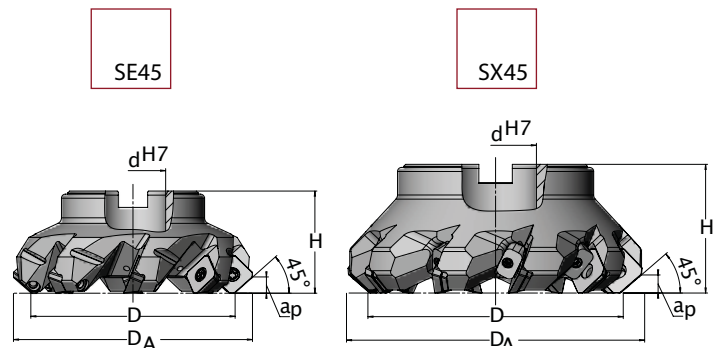


FACE MILLING CUTTERS

SE45 | SX45



Roughing and finishing with the same indexable insert
 SE45 is optimal for long-chipping materials
 SX45 for jobs requiring an increased number of teeth



SE45 Plug-in milling cutters									
Article	D	D _A	d ^{H7}	H	z _{eff}	a _p	lc	kg	INS
03S.8050.005	80	96.9	27	50	6	8.4	yes	1.19	SE..1506.N
03S.1050.005	100	117.0	32	50	8	8.4	yes	1.70	SE..1506.N
03S.1263.008	125	142.0	40	63	8	8.4	yes	2.98	SE..1506.N
03S.1663.007	160	177.2	40	63	12	8.4	no	4.93	SE..1506.N
03S.2063.008	200	217.4	60	63	14	8.4	no	6.94	SE..1506.N

SX45 Plug-in milling cutters										
Article	D	D _A	d ^{H7}	H	z _{eff}	a _p	Wedge	lc	kg	INS
03S.1263.031	125	145.2	40	63	10	8.8	yes	yes	3.87	SX..1906.N
03S.1663.032	160	180.4	40	63	12	8.8	yes	yes	5.99	SX..1906.N
03S.1663.031	160	180.2	40	63	16	8.8	yes	no	6.15	SX..1906.N

Wedge set SX45

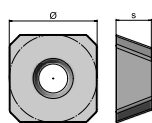


08Z.0000.126

08K.1908.001

08Z.0000.093

TX215

INS SHAPE **SE | SX**

SE SX			
AS	Ø		s
4	15	19	06
	15.88	19	6.35

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
SE..1506...	SE.1506.002.21 SKY77	SEHW 1506AF SN-25	h_{max}	0.60	0.60	0.55	0.50	0.45	0.40	0.35
			v_c	270-300	240-280	210-240	180-210	140-180	110-140	80-110
	SE.1506.002.22 SKY77	SEHW 1506AF SN-28	h_{max}	0.55	0.50	0.45	0.40	0.35	0.30	0.30
			v_c	270-300	240-280	210-240	180-210	140-180	110-140	80-110
SX..1906...	SX.1906.002.21 SKY77	SXMW 1906AF SN-25	h_{max}	0.60	0.55	0.50	0.45	0.45	-	-
			v_c	270-300	240-280	210-240	180-210	140-180	-	-
	SX.1906.002.22 SKY77	SXMW 1906AF SN-28	h_{max}	0.55	0.50	0.45	0.40	0.35	0.30	0.30
			v_c	270-300	240-280	210-240	180-210	140-180	110-140	80-110

	Article	Designation	Recomm. a_e 0,7 x D	Cast iron					
				D21	D20	D19	D18	D17	D16
SE..1506...	SE.1506.002.21 SKY77	SEHW 1506AF SN-25	h_{max}	0.65	0.65	0.60	0.50	0.40	0.35
			v_c	280-320	260-290	240-280	210-240	180-210	140-180
	SE.1506.002.22 SKY77	SEHW 1506AF SN-28	h_{max}	0.55	0.50	0.45	0.40	0.35	0.30
			v_c	280-320	260-290	240-280	210-240	180-210	140-180
SX..1906...	SX.1906.002.21 SKY77	SXMW 1906AF SN-25	h_{max}	0.65	0.55	0.45	0.40	0.35	0.30
			v_c	280-320	260-290	240-280	210-240	180-210	140-180
	SX.1906.002.21 CAN ² 26	SXMW 1906AF SN-25	h_{max}	0.65	0.55	0.45	0.40	0.35	0.30
			v_c	340-380	280-340	240-280	210-240	180-210	140-180
	SX.1906.002.22 SKY77	SXMW 1906AF SN-28	h_{max}	0.55	0.50	0.45	0.40	0.35	0.30
			v_c	280-320	260-290	240-280	210-240	180-210	140-180

	Article	Designation	Recomm. a_e 0,7 x D	NF metals		
				E82	E81	E80
SE..1506...	SE.1506.002.22 SKY77	SEHW 1506AF SN-28	h_{max}	0.55	0.50	0.35
			v_c	650-1000	450-650	280-450
SX..1906...	SX.1906.002.22 SKY77	SXMW 1906AF SN-28	h_{max}	0.55	0.50	0.35
			v_c	650-1000	450-650	280-450

INS		
SE..1506...	08B.4511.7991	TX220