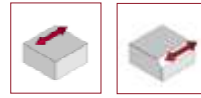
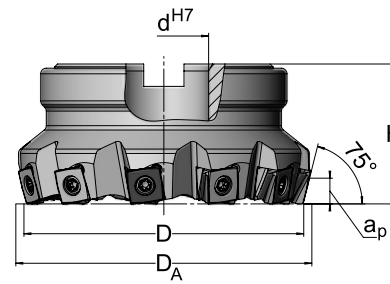


FACE MILLING CUTTERS

SN75



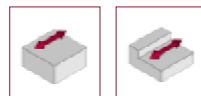
Kappa 75° – combined with the robust cutting edges permit both, high tooth feed rate and excellent surface quality
 8-cutting edge, tangential SN indexable insert
 Maximum metal removal rate combined with high process reliability



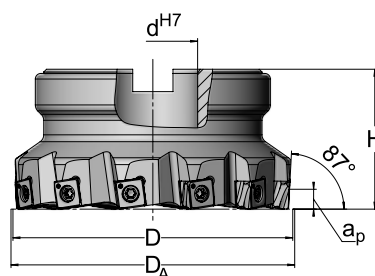
SN75 Plug-in milling cutters									
Article	D	DA	d ^{H7}	H	z _{eff}	a _p	lc	kg	INS
03S.0850.090	80	85.8	27	50	9	5.5	no	1.20	SN..1208.L
03S.1050.090	100	105.8	32	50	11	5.5	no	2.03	SN..1208.L
03S.1263.090	125	130.8	40	63	14	5.5	no	3.05	SN..1208.L
03S.1663.090	160	165.8	60	63	17	5.5	no	4.68	SN..1208.L
03S.2063.090	200	205.8	60	63	20	5.5	no	8.73	SN..1208.L

FACE MILLING CUTTERS

SN87



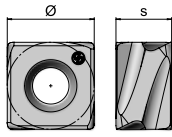
Kappa 87° – can also be used as shoulder milling cutters
 Multi-tooth design with fine tooth pitch
 optimal for thin-walled parts
 8-cutting edge, tangential SN
 indexable insert – robust and soft cutting



SN87 Plug-in milling cutters									
Article	D	DA	d ^{H7}	H	z _{eff}	a _p	lc	kg	INS
03S.0540.100	50	51.4	22	40	7	5.0	no	0.39	SN..1006.L
03S.0640.100	63	64.4	22	40	8	5.0	no	0.58	SN..1006.L
03S.0850.100	80	81.4	27	50	10	5.0	no	1.13	SN..1006.L
03S.0850.111	80	81.6	27	50	8	7.0	no	1.12	SN..1208.L
03S.1050.100	100	101.4	32	50	12	5.0	no	1.80	SN..1006.L
03S.1050.111	100	101.6	32	50	10	7.0	no	1.82	SN..1208.L
03S.1263.100	125	126.4	40	63	14	5.0	no	2.93	SN..1006.L
03S.1263.111	125	126.6	40	63	12	7.0	no	2.97	SN..1208.L
03S.1663.100	160	161.4	40	63	20	5.0	no	4.72	SN..1006.L
03S.1663.111	160	161.6	40	63	16	7.0	no	4.71	SN..1208.L

SN87+ Plug-in milling cutters									
Article	D	DA	d ^{H7}	H	z _{eff}	a _p	lc	kg	INS
03S.4040.101	40	41.4	16	40	5	5.0	yes	0.25	SN..1006.L*
03S.0640.101	63	64.4	22	40	10	5.0	no	0.58	SN..1006.L
03S.0850.101	80	81.4	27	50	15	5.0	no	1.16	SN..1006.L
03S.0850.190	80	81.6	27	50	9	7.0	no	1.15	SN..1208.L
03S.1050.101	100	101.4	32	50	18	5.0	no	1.88	SN..1006.L
03S.1263.101	125	126.4	40	63	23	5.0	no	3.02	SN..1006.L

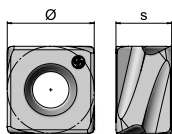
* Note that the screw length required varies depending on the insert used

INS SHAPE **SN**

SN				
AS	Ø		s	
8	10	12	06	08
	10	12.5	6	8

Matching of machining parameters
with the AV material groups



Article	Designation	Recomm. a_e $0,7 \times D$	Cast iron						
			D21	D20	D19	D18	D17	D16	
SN.1006...	SN.1006.003.01 SKY77	SNHX 100608 TL-25S	h_{max}	0.25	0.25	0.23	0.20	0.18	0.15
			v_c	280-320	260-300	230-290	210-240	180-210	140-180
	SN.1006.003.04 NERO26	SNHX 100608 SL-28	h_{max}	0.25	0.25	0.23	0.20	0.18	0.15
			v_c	300-340	280-320	240-280	210-240	180-210	140-180
	SN.1006.003.04 CAN ² 26	SNHX 100608 SL-28	h_{max}	0.25	0.25	0.23	0.20	0.18	0.15
			v_c	340-380	280-340	240-280	210-240	180-210	140-180
	SN.1006.018.01 SKY77	SNKY 100608 TL-23	h_{max}	0.30	0.28	0.26	0.22	0.18	–
			v_c	280-320	260-300	230-290	210-240	180-210	–
	SN.1006.018.01 CAN ² 26	SNKY 100608 TL-23	h_{max}	0.30	0.28	0.26	0.22	0.18	–
			v_c	340-380	280-340	240-280	210-240	180-210	–
	SN.1006.018.02 CAN ² 26	SNKY 100608 TL-28	h_{max}	0.25	0.25	0.23	0.20	0.18	0.15
			v_c	340-380	280-340	240-280	210-240	180-210	140-180
	SN.1006.020.01 SKY26	SNKY 100608 SL-20	h_{max}	0.23	0.23	0.21	0.19	0.17	0.14
			v_c	280-320	260-300	230-290	210-240	180-210	140-180
SN.1208... (SN75)	SN.1208.003.05 NERO26	SNHX 120808 SL-25S	h_{max}	0.28	0.26	0.24	0.20	0.16	0.15
			v_c	340-380	280-340	240-280	210-240	180-210	140-180
	SN.1208.003.05 CAN ² 26	SNHX 120808 SL-25S	h_{max}	0.28	0.26	0.24	0.20	0.16	0.15
			v_c	340-380	280-340	240-280	210-240	180-210	140-180
	SN.1208.020.02 SKY77	SNHY 120808 SL-25S	h_{max}	0.28	0.26	0.24	0.20	0.16	0.15
			v_c	280-320	260-300	230-290	210-240	180-210	140-180
	SN.1208.020.02 CAN ² 77	SNHY 120808 SL-25S	h_{max}	0.28	0.26	0.24	0.20	0.16	0.15
			v_c	340-380	280-340	240-280	210-240	180-210	140-180

INS SHAPE **SN**

SN				
AS	Ø		s	
8	10	12	06	08
	10	12.5	6	8

Matching of machining parameters
with the AV material groups

Article	Designation	Recomm. a_e 0,7 x D	Cast iron					
			D21	D20	D19	D18	D17	D16
SN.1208.007.01 SKY77	SNHX 120812 TL-25S	h_{max}	0.28	0.26	0.24	0.20	0.16	0.15
		v_c	280-320	260-300	230-290	210-240	180-210	140-180
SN.1208.007.01 NERO26	SNHX 120812 TL-25S	h_{max}	0.28	0.26	0.24	0.20	0.16	0.15
		v_c	340-380	280-340	240-280	210-240	180-210	140-180
SN.1208.007.01 CAN ² 26	SNHX 120812 TL-25S	h_{max}	0.28	0.26	0.24	0.20	0.16	0.15
		v_c	340-380	280-340	240-280	210-240	180-210	140-180
SN.1208.018.01 SKY77	SNKY 120810 SL-25S	h_{max}	0.28	0.26	0.24	0.20	0.16	0.15
		v_c	280-320	260-300	230-290	210-240	180-210	140-180
SN.1208.018.01 CAN ² 77	SNKY 120810 SL-25S	h_{max}	0.28	0.26	0.24	0.20	0.16	0.15
		v_c	340-380	280-340	240-280	210-240	180-210	140-180
SN.1208.018.02 SKY77	SNKY 120810 SL-25S	h_{max}	0.25	0.25	0.23	0.20	0.18	0.15
		v_c	280-320	260-300	230-290	210-240	180-210	140-180
SN.1208.018.02 CAN ² 77	SNKY 120810 SL-25S	h_{max}	0.25	0.25	0.23	0.20	0.18	0.15
		v_c	340-380	280-340	240-280	210-240	180-210	140-180
SN.1208.022.01 SKY77	SNKY 120810 SL-20S	h_{max}	0.23	0.23	0.21	0.19	0.17	0.14
		v_c	280-320	260-300	230-290	210-240	180-210	140-180
SN.1208.022.01 CAN ² 77	SNKY 120810 SL-20S	h_{max}	0.23	0.23	0.21	0.19	0.17	0.14
		v_c	340-380	280-340	240-280	210-240	180-210	140-180

INS		
SN..1006...*	08B.3511.7991	TX215
SN..1006...	08B.3514.7991	TX215
SN..1208...	08B.0416.7991	TX215

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