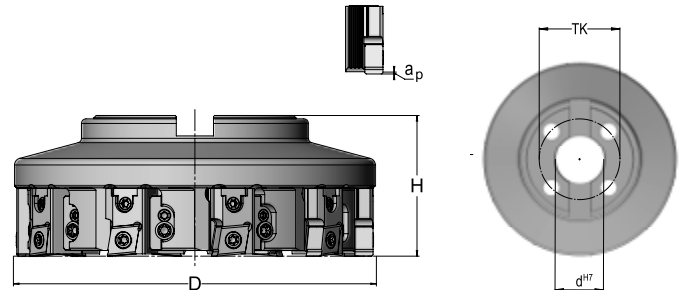


FINISHING CUTTERS

EK90



Highly precise finishing cutters with cartridge system
 Simple handling in setting and insert replacement
 Extremely high feed rates with 2-cutting edge
 ENFQ indexable insert
 Two indexable insert sizes for low axial impact of compressive forces when machining steel



EK90 Plug-in milling cutters									
Article	D	d ^{H7}	TK	H	z _{eff}	a _p	lc	kg	Cartridge
04E.0650.140	63	22	–	50	5	0.1–0.3	yes	0.87	K-EN08
04E.0850.140	80	27	–	50	6	0.1–0.3	yes	1.45	K-EN08
04E.1060.001	100	32	–	62	6	0.1–0.3	no	2.50	K-EN12
04E.1060.005	100	32	–	62	6	0.1–0.3	no	2.46	K-EN08-g
04E.1260.001	125	40	–	62	8	0.1–0.3	no	3.90	K-EN12
04E.1260.005	125	40	–	62	8	0.1–0.3	no	3.84	K-EN08-g
04E.1660.001	160	40	66.7	62	10	0.1–0.3	no	5.73	K-EN12
04E.1660.005	160	40	66.7	62	10	0.1–0.3	no	5.67	K-EN08-g

EK90 Cartridge	
Cartridge no.	Complete set*
K-EN08	08Z.0000.303
K-EN08-g	08Z.0000.301
K-EN12	08Z.0000.302

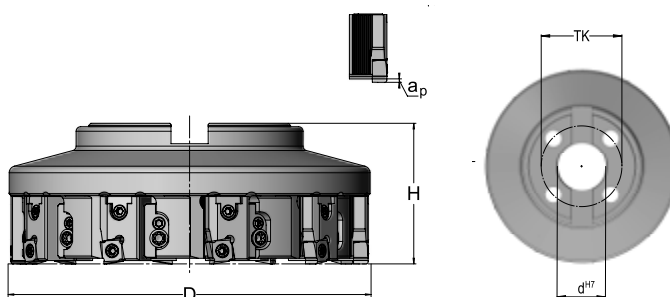
* The complete set consists of cartridge and all assembly and mounting components

FINISHING CUTTERS

SK90



Highly precise finishing cutters with cartridge system
 Simple handling in setting and insert replacement
 Excellent surface quality with 4-cutting edge
 SN indexable insert
 Very wide wiper edge for optimum use
 in cast materials

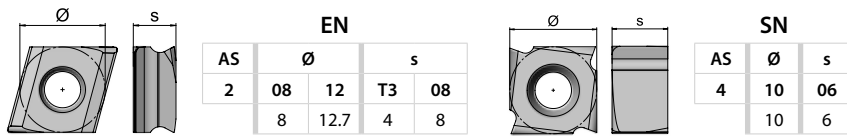


SK90 Plug-in milling cutters									
Article	D	d ^{H7}	TK	H	z _{eff}	a _p	lc	kg	Cartridge
04E.1060.010	100	32	–	62	6	0.1–0.3	no	2.47	K-SN10
04E.1260.010	125	40	–	62	8	0.1–0.3	no	3.86	K-SN10
04E.1660.010	160	40	66.7	62	10	0.1–0.3	no	5.70	K-SN10

SK90 Cartridge	
Cartridge no.	Complete set*
K-SN10	08Z.0000.304

* The complete set consists of cartridge and all assembly and mounting components

INS SHAPE EN | SN



Matching of machining parameters with the AV material groups

				Steel						
Article	Designation			A22	A21	A20	A19	A18	A17	A16
EN..08T3..	EN.08T3.063.04 SKY77	ENFQ 08T310 EL-33S	h_{max}	max 3.0						
			v_c	30-400*						
EN..08T3..	EN.08T3.063.04 NERO26	ENFQ 08T310 EL-33S	h_{max}	max 3.0						
			v_c	30-400*						
EN..1208..	EN.1208.041.04 SKY77	ENFQ 120808 EL-33S	h_{max}	max 5.0						
			v_c	30-400*						
EN..1208..	EN.1208.041.04 NERO26	ENFQ 120808 EL-33S	h_{max}	max 5.0						
			v_c	30-400*						
SN..1006..	SN.1006.042.01 SKY77	SNFQ 100610 EL-33S	h_{max}	max 3.0						
			v_c	30-400*						

				Cast iron					
Article	Designation			D21	D20	D19	D18	D17	D16
EN..08T3..	EN.08T3.063.04 SKY77	ENFQ 08T310 EL-33S	h_{max}	max 3.0					
			v_c	30-400*					
EN..08T3..	EN.08T3.063.04 NERO26	ENFQ 08T310 EL-33S	h_{max}	max 3.0					
			v_c	30-400*					
EN..1208..	EN.1208.041.04 SKY77	ENFQ 120808 EL-33S	h_{max}	max 5.0					
			v_c	30-400*					
EN..1208..	EN.1208.041.04 NERO26	ENFQ 120808 EL-33S	h_{max}	max 5.0					
			v_c	30-400*					
SN..1006..	SN.1006.042.01 SKY77	SNFQ 100610 EL-33S	h_{max}	max 3.0					
			v_c	30-400*					

* Parameters vibration-/surface-dependent

INS		
EN..08T3...	08B.0375.7991	TX208
EN..08T3... for K-EN08-g	08B.0309.7991	TX208
EN..1208...	08B.0516.7991	TX220
SN..1006...	08B.3511.7991	TX215