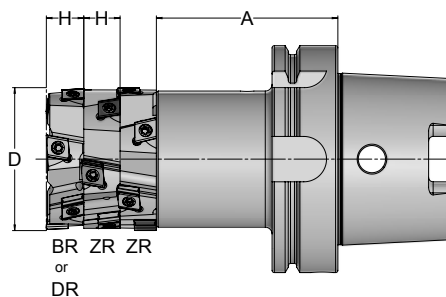


# MULTIRING CM90



Modular disc design  
 Custom cutting lengths up to 2.5 x D  
 4-cutting edge CN07 indexable insert  
 Rugged M3 fixation



### Tool holders CM90

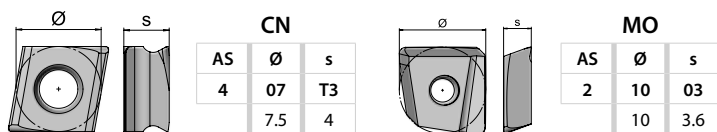
D	SK50 DIN69871	A	kg	SK40 DIN69871	A	kg	HSK-A63	A	kg	HSK-A100	A	kg
32	-	-	-	09A.4032.001	39	0.91	09E.6332.1050	50	0.82	-	-	-
40	09A.5004.001	49	2.85	09A.4004.001	39	0.95	09E.6304.1060	60	0.94	-	-	-
45/50	09A.5045.001	39	2.82	09A.4045.001	39	1.00	09E.6345.1060	60	1.02	09E.1045.001	85	3.3
45/50	09A.5045.016	90	3.37	09A.4045.007	90	1.54	-	-	-	-	-	-

Tool holders CM90 Ø 40 mm not compatible with tool holders EM90 Ø 40 mm. Other dimensions upon request

### Intermediate rings ZR | bottom rings BR | double cutting rings DR CM90

D	ZR Article	H	Z <sub>eff</sub>	BR Article	H	Z <sub>eff</sub>	INS Designation	Qty.	DR Article	H	Z <sub>eff</sub>	INS Designation	Qty.	Weight per ring in kg
32	12C.3212.001	11	2	12C.3213.002	13	2	CNHQ07T306.L CNHQ07T300.R	2 2	-	-	-	-	-	< 0.5
40	12C.4012.001	11	3	12C.4013.002	13	3	CNHQ07T306.L CNHQ07T300.R	3 3	12C.4021.001	21	3	CNHQ07T306.L CNHQ07T300.R MOGU100310.R	3 3 3	< 0.5
45	12C.4512.001	12.5	3	12C.4513.002	13.5	3	CNHQ07T306.L CNHQ07T300.R	3 3	-	-	-	-	-	< 0.5
50	12C.5012.001	12.5	3	12C.5013.002	13.5	3	CNHQ07T306.L CNHQ07T300.R	3 3	-	-	-	-	-	< 0.5

# INS SHAPE CN | MO





Matching of machining parameters  
with the AV material groups

	Article	Designation	Recomm. $a_e$ 0.2 x D	Steel						
				A22	A21	A20	A19	A18	A17	A16
CN..07T3..	CN.07T3.008.11 SKY77	CNHQ 07T306 SL-28W	$h_{max}$	0.17	0.17	0.17	0.15	0.14	0.12	-
			$v_c$	200-280	190-230	180-220	160-210	140-180	110-140	-
	CN.07T3.043.01 SKY77	CNHQ 07T300 SR-28V	$h_{max}$	0.17	0.17	0.17	0.15	0.14	0.12	-
			$v_c$	200-280	190-230	180-220	160-210	140-180	110-140	-
MO..1003..	MO.1003.031.04 SKY77	MOGU 100310TR-28	$h_{max}$	0.17	0.17	0.17	0.15	0.14	0.12	-
			$v_c$	200-280	190-230	180-220	160-210	140-180	110-140	-

	Article	Designation	Recomm. $a_e$ 0.2 x D	Cast iron						
				D21	D20	D19	D18	D17	D16	
CN..07T3..	CN.07T3.008.11 SKY77	CNHQ 07T306 SL-28W	$h_{max}$	0.18	0.18	0.16	0.14	0.11	0.10	
			$v_c$	200-280	200-260	180-230	170-210	160-190	140-180	
			CN.07T3.008.11 NERO <sup>2</sup> 77	$h_{max}$	0.18	0.18	0.16	0.14	0.11	0.10
				$v_c$	240-300	240-300	220-260	200-240	180-210	140-180
	CN.07T3.043.01 SKY77	CNHQ 07T300 SR-28V	$h_{max}$	0.18	0.18	0.16	0.14	0.11	0.10	
			$v_c$	200-280	200-260	180-230	170-210	160-190	140-180	
			CN.07T3.043.01 NERO <sup>2</sup> 77	$h_{max}$	0.18	0.18	0.16	0.14	0.11	0.10
				$v_c$	240-300	240-300	220-260	200-240	180-210	140-180
MO..1003..	MO.1003.031.04 SKY77	MOGU 100310TR-28	$h_{max}$	0.18	0.18	0.16	0.14	0.11	0.10	
			$v_c$	200-280	200-260	180-230	170-210	160-190	140-180	

Parameters vibration-/surface-dependent

INS		
CN..07T3...	08B.0375.7991	TX208
MO..1003...	08B.0375.001	TX208