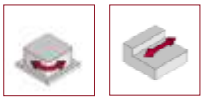
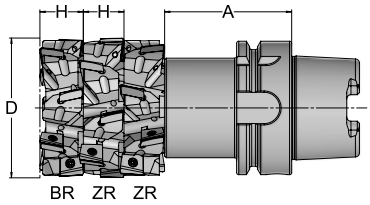
MULTIRING **MM90**



Especially suitable for materials
which are difficult to machine
Extremely smooth running
Optimum precision paired with maximum Q



Tool holders
MM90

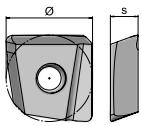
D	SK50 DIN69871	A	kg	HSK-A63	A	kg	HSK-A100	A	kg
66	09A.5050.015	49	3.00	–	–	–	–	–	–
66	–	–	–	09E.6350.1060	60	1.10	–	–	–
80	09A.5063.008	49	3.21	09E.6363.1060	60	1.28	09E.1063.1080	80	3.11
80	09A.5063.031	100	4.30	–	–	–	–	–	–
80	09A.5063.021	150	5.36	–	–	–	–	–	–
100	09A.5080.006	49	3.56	–	–	–	09E.1080.1080	80	3.77
100	09A.5080.025	100	5.35	–	–	–	–	–	–

Intermediate rings ZR | bottom rings BR
MM90

D	ZR Article	H	z_{eff}	BR Article	H	z_{eff}	INS Article	Qty.	Weight per ring in kg
66	12M.6619.081	19.2	4	12M.6620.082	20.5	4	MOGU12T310.L MOGU12T310.R	3 3	< 0.5
80	12M.8019.081	19.2	4	12M.8020.082	20.5	4	MOGU12T310.L MOGU12T310.R	3 3	< 1.0
100	12M.1019.081	19.2	4	12M.1020.082	20.5	4	MOGU12T310.L MOGU12T310.R	3 3	< 1.0

Other dimensions upon request

INS SHAPE **MO**



MO

AS	Ø	s
2	12	T3
	12.7	4

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
MO..12T3..	MO.12T3.082.01 SKY77	MOGU 12T310 TL-28	h_{max}	0.18	0.18	0.18	0.16	0.14	0.12	0.10
			v_c	200-280	190-230	180-220	160-210	140-180	110-140	–
	MO.12T3.082.01 AV1077	MOGU 12T310 TL-28	h_{max}	–	–	0.18	0.16	0.14	0.12	0.10
			v_c	–	–	180-210	160-200	140-180	110-140	80-110
	MO.12T3.081.01 SKY77	MOGU 12T310 TR-28	h_{max}	0.18	0.18	0.18	0.16	0.14	0.12	0.10
			v_c	200-280	190-230	180-220	160-210	140-180	110-140	–
	MO.12T3.081.01 AV1077	MOGU 12T310 TR-28	h_{max}	–	–	0.18	0.16	0.14	0.12	0.10
			v_c	–	–	180-210	160-200	140-180	110-140	80-110

	Article	Designation	Recomm. a_e 0.2 x D	Cast iron D21	D20	D19	D18	D17	D16
MO..12T3..	MO.12T3.082.01 SKY77	MOGU 12T310 TL-28	h_{max}	0.22	0.22	0.20	0.18	0.16	0.13
			v_c	200-280	200-260	180-230	170-210	160-190	140-180
	MO.12T3.081.01 SKY77	MOGU 12T310 TR-28	h_{max}	0.22	0.22	0.20	0.18	0.16	0.13
			v_c	200-280	200-260	180-230	170-210	160-190	140-180

	Article	Designation	Recomm. a_e 0.2 x D	Stainless steels C12	C11	C10	C09	NF metals E82	E81	E80
MO..12T3..	MO.12T3.082.01 SKY77	MOGU 12T310 TL-28	h_{max}	–	–	–	–	0.25	0.23	0.20
			v_c	–	–	–	–	280-450	250-350	250-350
	MO.12T3.082.01 AV1077	MOGU 12T310 TL-28	h_{max}	0.12	0.10	0.08	–	0.25	0.23	0.20
			v_c	120-170	100-150	80-140	–	280-450	250-350	250-350
	MO.12T3.081.01 SKY77	MOGU 12T310 TR-28	h_{max}	–	–	–	–	0.25	0.23	0.20
			v_c	–	–	–	–	280-450	250-350	250-350
	MO.12T3.081.01 AV1077	MOGU 12T310 TR-28	h_{max}	0.12	0.10	0.08	–	0.25	0.23	0.20
			v_c	120-170	100-150	80-140	–	280-450	250-350	250-350

Parameters vibration-/surface-dependent

INS		
MO..12T3...	08B.0309.001	TX208