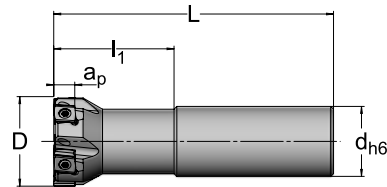


SHANK END MILLS

CS90

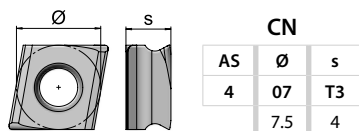


Maximum break resistance through tangential mounting of the 4-cutting edge CN indexable insert, even in small indexable inserts
 High combined feed per tooth and depths of cut
 Fine tooth pitch is an advantage in cast iron machining processes



CS90 Shank end mills									INS
Article	D	dh6	L	l ₁	z _{eff}	a _p	lc	kg	
11C.2509.001	25	25	90	31.5	4	7	yes	0.30	CN..07T3..L
11C.3210.001	32	25	100	43	5	7	yes	0.37	CN..07T3..L
11C.4011.001	40	32	110	48.5	6	7	yes	0.67	CN..07T3..L

INS SHAPE CN



Matching of machining parameters
with the AV material groups

				Steel						
Article		Designation		A22	A21	A20	A19	A18	A17	A16
CN..07T3..	CN.07T3.008.11 SKY77	CNHQ 07T306 SL-28W	h_{max}	0.16	0.16	0.15	0.13	0.12	0.12	0.10
			v_c	280-320	240-280	210-240	180-210	140-180	110-140	80-110
	CN.07T3.008.11 AV1055	CNHQ 07T306 SL-28W	h_{max}	-	-	-	-	-	0.12	0.10
			v_c	-	-	-	-	-	110-140	80-110

				Cast iron					
Article		Designation		D21	D20	D19	D18	D17	D16
CN..07T3..	CN.07T3.008.11 SKY77	CNHQ 07T306 SL-28W	h_{max}	0.17	0.15	0.14	0.12	0.12	0.12
			v_c	290-320	260-295	230-270	210-240	180-210	140-180
	CN.07T3.008.11 NERO ² 77	CNHQ 07T306 SL-28W	h_{max}	0.17	0.15	0.14	0.12	0.12	0.12
			v_c	340-380	280-340	240-280	210-240	180-210	140-180

				Stainless steels				NF metals		
Article		Designation		C12	C11	C10	C09	E82	E81	E80
CN..07T3..	CN.07T3.008.11 SKY77	CNHQ 07T306 SL-28W	h_{max}	0.11	0.10	-	-	0.22	0.21	0.16
			v_c	150-220	120-170	-	-	650-1000	450-650	280-450
	CN.07T3.008.11 AV1055	CNHQ 07T306 SL-28W	h_{max}	0.11	0.10	0.08	0.08	-	-	-
			v_c	150-220	120-170	90-120	60-100	-	-	-

INS		
CN..07T...	08B.0309.7991	TX208