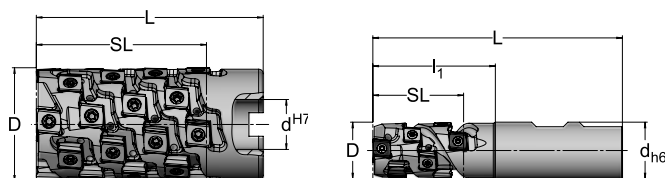


SHELL END MILLS **CW90****NEWT**ool

Fine tooth pitch thanks to tangential insert design
Soft cutting tool
Extremely smooth running thanks to the division of the cut



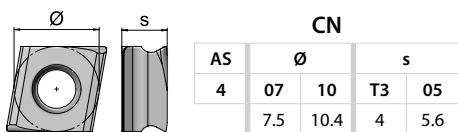
CW90 Shank end mills										
Article	D	dh6	L	l1	SL	zz	z _{eff}	lc	kg	INS
02C.2511.001	25	25	110	54	40.0	12	2	yes	0.37	CN..07T3.L
02C.3212.001	32	25	126	70	54.0	24	3	yes	0.54	CN..07T3.L
02C.4014.001	40	32	140	73	60.0	27	3	yes	1.02	CN..07T3.L

CW90 Plug-in milling cutters										
Article	D	dh7	L	SL	zz	z _{eff}	lc	kg	INS	
02C.5010.001	50	22	100	75	32	4	yes	1.45	CN..1005.L	
02C.6313.001	63	32	130	94.5	40	4	yes	2.49	CN..1005.L	
02C.8011.001	80	32	110	85	45	5	yes	3.54	CN..1005.L	

Use the multiring systems for length ratios of more than 1.5 x D

INS		
CN..07T3...	08B.0309.7991	TX208
CN..1005...	08B.3511.7991	TX215

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}	0.15	0.15	0.15	0.13	0.12	0.12	0.10
			v_c	220-280	200-260	180-240	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
CN..1005..	CN.1005.002.01 SKY77	CNHQ 100510 SL-25V	h_{max}	0.25	0.23	0.20	0.20	0.14	0.14	0.12
			v_c	220-280	200-260	180-240	180-210	140-180	110-140	80-110
	CN.1005.002.02 SKY77	CNHQ 100510 SL-28V	h_{max}	0.22	0.20	0.18	0.18	0.12	0.12	0.10
			v_c	220-280	200-260	180-240	180-210	140-180	110-140	80-110
	CN.1005.002.02 AV1077	CNHQ 100510 SL-28V	h_{max}	-	-	-	0.20	0.14	0.14	0.12
			v_c	-	-	-	190-230	160-200	130-160	80-130

				Cast iron					
Article		Designation		D21	D20	D19	D18	D17	D16
CN..07T3..	CN.07T3.008.11 SKY77	CNHQ 07T306 SL-28W	h_{max}	0.16	0.16	0.15	0.12	0.12	0.11
			v_c	220-280	200-240	170-200	150-190	120-160	120-150
	CN.07T3.008.11 NERO ² 77	CNHQ 07T306 SL-28W	h_{max}	0.16	0.16	0.13	0.13	0.12	0.10
			v_c	340-380	280-340	240-280	210-240	180-210	140-180
CN..1005..	CN.1005.002.01 SKY77	CNHQ 100510 SL-25V	h_{max}	0.25	0.25	0.20	0.15	0.14	0.11
			v_c	220-280	200-240	170-200	150-190	120-160	120-150
	CN.1005.002.01 CAN ² 77	CNHQ 100510 SL-25V	h_{max}	0.25	0.25	0.20	0.15	0.14	0.11
			v_c	340-380	280-340	240-280	210-240	180-210	140-180
	CN.1005.002.02 SKY77	CNHQ 100510 SL-28V	h_{max}	0.25	0.25	0.20	0.16	0.16	0.13
			v_c	220-280	200-240	170-200	150-190	120-160	120-150

				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	0.18	0.15
			v_c	120-200	100-170	-	-	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	120-220	100-170	90-120	60-100	-	-	-
CN..1005..	CN.1005.002.02 SKY77	CNHQ 100510 SL-28V	h_{max}	-	-	-	-	0.28	0.22	0.18
			v_c	-	-	-	-	650-1000	450-650	280-450
	CN.1005.002.02 AV1077	CNHQ 100510 SL-28V	h_{max}	0.18	0.15	-	-	-	-	-
			v_c	120-200	140-170	-	-	-	-	-

Parameters vibration-/surface-dependent