

SHOULDER MILLING CUTTERS

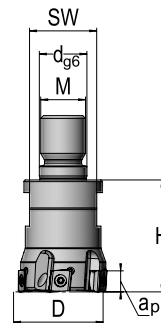
CP90 | CV90



NEWTool

The versions with \varnothing 25–40 mm are optimal for powerful milling on live tooling lathes and machining centers with rather low rigidity and drive power

DIN tool holders with standard adaptation shank and spindle connection for HSK, Capto and SK



CV90 Screw-in milling cutters										
Article	D	dg6	H	M	SW	z _{eff}	a _p	lc	kg	INS
04C.0232.001	25	12.5	32	12	17	4	7.5	yes	0.11	CN..07T3L
04C.0340.002	32	17	40	16	24	5	7.5	yes	0.22	CN..07T3L
04C.0440.001	40	17	40	16	24	7	7.5	yes	0.28	CN..07T3L

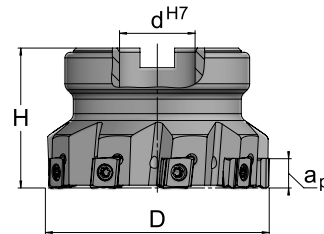
SHOULDER MILLING CUTTERS

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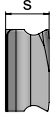
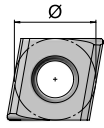
Maximum break resistance through tangential mounting of the 4-cutting edge CN indexable insert
High combined feed per tooth and depths of cut
CV90: Fine tooth pitch is an advantage in cast iron machining processes



CP90 Plug-in milling cutters								INS
Article	D	d ^{H7}	H	z ^{eff}	a _p	lc	kg	
04C.0540.001	50	22	40	5	10.0	yes	0.35	CN..1005L
04C.0640.001	63	22	40	6	10.0	yes	0.54	CN..1005L
04C.0850.001	80	27	50	8	10.0	yes	1.10	CN..1005L
04C.1050.001	100	32	50	9	10.0	yes	1.77	CN..1005L
04C.1263.002	125	40	63	13	10.0	yes	3.30	CN..1005L

CV90 Plug-in milling cutters								INS
Article	D	d ^{H7}	H	z ^{eff}	a _p	lc	kg	
04C.0332.001	32	22	32	5	7.5	yes	0.12	CN..07T3L
04C.0432.004	40	16	32	7	7.5	yes	0.19	CN..07T3L
04C.0540.002	50	22	40	8	7.5	yes	0.36	CN..07T3L
04C.0640.002	63	22	40	7	10.0	yes	0.56	CN..1005L
04C.0850.002	80	27	50	9	10.0	yes	1.09	CN..1005L
04C.1050.002	100	32	50	12	10.0	yes	1.81	CN..1005L
04C.1263.001	125	40	63	16	10.0	yes	3.36	CN..1005L

INS SHAPE CN



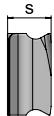
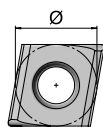
CN				
AS	Ø		s	
4	07	10	T3	05
	7.5	10.4	4	5.6

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..	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}	0.24	0.22	0.20	0.20	-	-	-
			v_c	280-320	240-280	210-240	180-210	-	-	-
	CN.1005.002.02 SKY77	CNHQ 100510 SL-28V	h_{max}	0.24	0.22	0.20	0.18	0.16	0.14	0.11
			v_c	280-320	240-280	210-240	180-210	140-180	110-140	80-110
	CN.1005.002.02 AV1077	CNHQ 100510 SL-28V	h_{max}	-	-	0.20	0.18	0.16	0.14	0.11
			v_c	-	-	210-240	180-210	140-180	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..	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
CN..1005..	CN.1005.002.01 SKY77	CNHQ 100510 SL-25V	h_{max}	0.28	0.26	0.22	0.20	0.17	0.15
			v_c	290-320	260-295	230-270	210-240	180-210	140-180
	CN.1005.002.01 CAN ² 77	CNHQ 100510 SL-25V	h_{max}	0.28	0.26	0.22	0.20	0.17	0.15
			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}	-	-	0.20	0.18	0.16	0.13
			v_c	-	-	230-270	210-240	180-210	140-180

INS SHAPE CN



CN				
AS	Ø		s	
4	07	10	T3	05
	7.5	10.4	4	5.6

Matching of machining parameters
with the AV material groups

Article	Designation		Stainless steels				NF metals			
			C12	C11	C10	C09	E82	E81	E80	
CN..07T3..	CN.07T3.008.11 SKY77	CNHQ 07T306 SL-28W	h_{max}	0.11	0.10	-	-	0.20	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	140-170	90-120	60-100	-	-	-
CN..1005..	CN.1005.002.02 SKY77	CNHQ 100510 SL-28V	h_{max}	-	-	-	-	0.25	0.25	0.20
			v_c	-	-	-	-	650-1000	450-650	280-450
	CN.1005.002.02 AV1077	CNHQ 100510 SL-28V	h_{max}	0.11	-	-	-	-	-	-
			v_c	150-220	-	-	-	-	-	-

INS



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