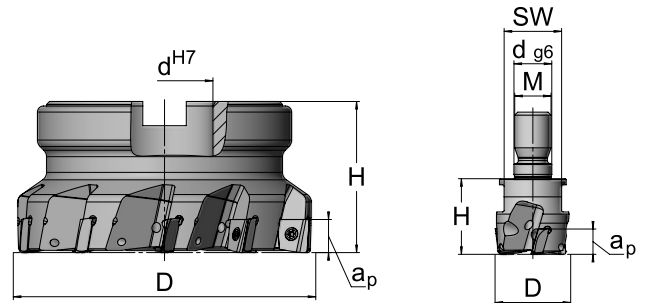


SHOULDER MILLING CUTTERS

HC90



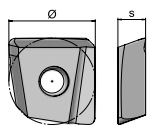
Highly compatible with materials that are difficult to machine, such as stainless and titanium
 High feed per tooth and depths of cut in 90°-machining
 The new screw-in versions with $\varnothing 25-40$ mm are optimal for powerful milling on live tooling lathes and machining centers with rather low rigidity and drive power



HC90 Screw-in milling cutters											
Article	D	d _{g6}	H	M	SW	z _{eff}	a _p	Ramp	lc	kg	INS
04M.0225.151	25	12.5	25	12	19	3	8.0	-	yes	0.10	MO..1003.R
04M.0325.151	32	17	25	16	27	4	8.0	-	yes	0.14	MO..1003.R
04M.0430.151	40	17	30	16	27	5	8.0	-	yes	0.22	MO..1003.R

HC90 Plug-in milling cutters										
Article	D	d ^{H7}	H	z _{eff}	a _p	Ramp	lc	kg	INS	
04M.0432.150	40	16	32	5	8.0	1.0°	yes	0.16	MO..1003.R	
04M.0540.150	50	22	40	6	8.0	0.8°	yes	0.32	MO..1003.R	
04M.0540.080	50	22	40	6	10.0	1.1°	yes	0.32	MO..12T3.R	
04M.0640.080	63	22	40	7	10.0	0.8°	yes	0.50	MO..12T3.R	
04M.0850.080	80	27	50	9	10.0	0.6°	yes	1.03	MO..12T3.R	
04M.1050.080	100	32	50	10	10.0	0.5°	yes	1.70	MO..12T3.R	

INS SHAPE MO



MO				
AS	Ø		s	
2	10	12	03	T3
	10	12.7	4	3.6

Matching of machining parameters
with the AV material groups

				Steel						
Article		Designation		A22	A21	A20	A19	A18	A17	A16
MO..1003..	MO.1003.031.04 SKY77	MOGU 100310 TR-28	h_{max}	0.18	0.16	0.15	0.13	0.12	0.11	0.08
			v_c	280-320	240-280	210-240	180-210	140-180	110-140	80-110
	MO.1003.031.04 AV1077	MOGU 100310 TR-28	h_{max}	-	-	-	-	0.12	0.11	0.08
			v_c	-	-	-	-	140-180	110-140	80-110
MO..12T3..	MO.12T3.081.01 SKY77	MOGU 12T310 TR-28	h_{max}	0.23	0.22	0.20	0.18	0.15	0.12	0.10
			v_c	280-320	240-280	210-240	180-210	140-180	110-140	80-110
	MO.12T3.081.01 AV1077	MOGU 12T310 TR-28	h_{max}	-	-	-	-	0.15	0.12	0.10
			v_c	-	-	-	-	140-180	110-140	80-110

				Cast iron					
Article		Designation		D21	D20	D19	D18	D17	D16
MO..1003..	MO.1003.031.04 SKY77	MOGU 100310 TR-28	h_{max}	0.20	0.18	0.16	0.14	0.12	0.10
			v_c	240-280	200-240	170-200	150-190	120-160	120-150
MO..12T3..	MO.12T3.081.01 SKY77	MOGU 12T310 TR-28	h_{max}	0.25	0.23	0.20	0.18	0.15	0.12
			v_c	240-280	200-240	170-200	150-190	120-160	120-150

				Stainless steels				NF metals		
Article		Designation		C12	C11	C10	C09	E82	E81	E80
MO..1003..	MO.1003.031.04 SKY77	MOGU 100310 TR-28	h_{max}	0.10	0.10	-	-	0.25	0.21	0.17
			v_c	120-200	100-150	-	-	650-1000	450-650	280-450
	MO.1003.031.04 AV1077	MOGU 100310 TR-28	h_{max}	0.10	0.10	-	-	-	-	-
			v_c	120-220	100-170	-	-	-	-	-
MO..12T3..	MO.12T3.081.01 SKY77	MOGU 12T310 TR-28	h_{max}	0.13	0.11	-	-	0.28	0.23	0.18
			v_c	120-200	100-150	-	-	650-1000	450-650	280-450
	MO.12T3.081.01 AV1077	MOGU 12T310 TR-28	h_{max}	0.13	0.11	-	-	-	-	-
			v_c	120-220	100-170	-	-	-	-	-

INS		
MO..1003...	08B.0309.001	TX208
MO..12T3...	08B.0309.001	TX208