

SIDE MILLING CUTTERS TANGENTIAL

CB18 | CN18



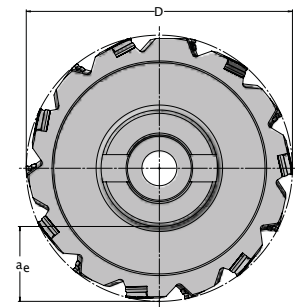
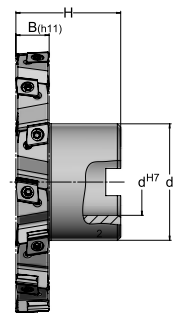
NEWTool

4-cutting edge CN indexable insert

Fine tooth pitch through tangential insert design

Very smooth cutting through left and right hand inserts

Secondary cutting edge positioned outside of the cutting zone – face milling possible with CB18



CB18

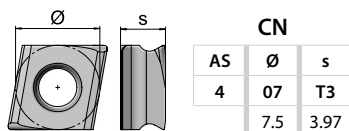
Article	D	d ₂	d ^{H7}	H	B _(h11)	zz	z _{eff}	a _e	lc	kg	INS
01C.1010.001	100	45	27	45	10	6x2	6	25.0	no	0.59	CN.07T3..
01C.1012.002	100	45	27	45	12	6x2	6	25.0	no	0.75	CN.07T3..
01C.1014.001	100	45	27	45	14	6x2	6	25.0	no	0.93	CN.07T3..
01C.1210.002	125	58	32	50	10	7x2	7	33.0	no	0.67	CN.07T3..
01C.1212.003	125	58	32	50	12	7x2	7	33.0	no	1.27	CN.07T3..
01C.1214.001	125	58	32	50	14	7x2	7	33.0	no	1.54	CN.07T3..
01C.1610.001	160	70	40	63	10	9x2	9	44.0	no	2.28	CN.07T3..
01C.1612.001	160	70	40	63	12	9x2	9	44.0	no	2.58	CN.07T3..
01C.1614.001	160	70	40	63	14	9x2	9	44.0	no	2.79	CN.07T3..

CN18

Article	D	d ₂	d ^{H7}	B _(h11)	zz	z _{eff}	a _e	lc	kg	INS
14C.1010.005	100	47	32	10	6x2	6	28.0	no	0.43	CN.07T3..
14C.1012.001	100	47	32	12	6x2	6	28.0	no	0.53	CN.07T3..
14C.1014.001	100	47	32	14	6x2	6	28.0	no	0.66	CN.07T3..
14C.1210.001	125	47	32	10	7x2	7	39.0	no	0.71	CN.07T3..
14C.1212.001	125	47	32	12	7x2	7	39.0	no	0.83	CN.07T3..
14C.1214.003	125	47	32	14	7x2	7	39.0	no	1.02	CN.07T3..
14C.1610.001	160	55	40	10	9x2	9	52.0	no	1.17	CN.07T3..
14C.1612.001	160	55	40	12	9x2	9	52.0	no	1.43	CN.07T3..
14C.1614.001	160	55	40	14	9x2	9	52.0	no	1.70	CN.07T3..

Width of cut B_(h11) can only be achieved with an indexable insert with W-geometry. Other dimensions on request.

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	0.10	0.10
			v_c	280-320	240-280	210-240	180-210	140-180	110-140	80-110
	CN.07T3.009.11 SKY77	CNHQ 07T306 SR-28W	h_{max}	0.16	0.16	0.15	0.13	0.12	0.10	0.10
			v_c	280-320	240-280	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.07T3.008.11 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.07T3.009.11 SKY77	CNHQ 07T306 SR-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.07T3.009.11 NERO ² 77	CNHQ 07T306 SR-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

				NF metals		
Article		Designation		E82	E81	E80
CN..07T3..	CN.07T3.008.11 SKY77	CNHQ 07T306 SL-28W	h_{max}	0.20	0.20	0.16
			v_c	650-1000	450-650	280-450
	CN.07T3.009.11 SKY77	CNHQ 07T306 SR-28W	h_{max}	0.20	0.20	0.16
			v_c	650-1000	450-650	280-450

INS		
CN..07T3...	08B.0309.7991	TX208