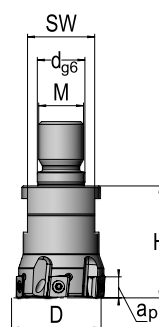


# SHOULDER MILLING CUTTERS

## CP90 | CV90



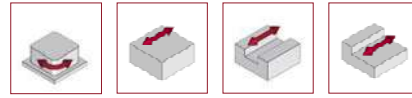
The versions with  $\varnothing$  25–40 mm are optimal for powerful milling on live tooling lathes and machining centers with rather low rigidity and drive power  
 DIN tool holders with standard adaptation shank and spindle connection for HSK, Capto and SK



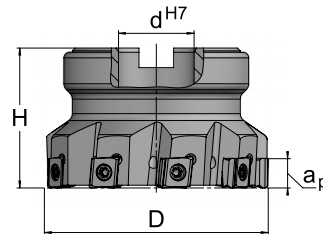
CV90 Screw-in milling cutters										
Article	D	dg6	H	M	SW	z <sub>eff</sub>	a <sub>p</sub>	lc	kg	INS
04C.0232.001	25	12.5	32	12	17	4	7.5	yes	0.11	CN..07T3L
04C.0340.002	32	17	40	16	24	5	7.5	yes	0.22	CN..07T3L
04C.0440.001	40	17	40	16	24	7	7.5	yes	0.28	CN..07T3L

# SHOULDER MILLING CUTTERS

## CP90 | CV90



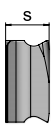
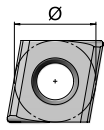
Maximum break resistance through tangential mounting of the 4-cutting edge CN indexable insert  
High combined feed per tooth and depths of cut  
Excellent for VA materials



CP90 Plug-in milling cutters								INS
Article	D	d <sup>H7</sup>	H	z <sup>eff</sup>	a <sub>p</sub>	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 <sup>H7</sup>	H	z <sup>eff</sup>	a <sub>p</sub>	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



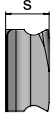
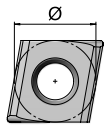
CN					
AS	Ø		s		
4	07	10	T3	05	
	7.5	10.4	4	5.6	

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	-	-
			$v_c$	250-300	230-280	210-240	180-210	140-180	-	-
CN..07T3..	CN.07T3.008.11 AV1077	CNHQ 07T306 SL-28W	$h_{max}$	-	-	-	-	0.12	0.12	0.10
			$v_c$	-	-	-	-	140-180	110-140	80-110
CN..1005..	CN.1005.002.01 SKY77	CNHQ 100510 SL-25V	$h_{max}$	0.24	0.22	0.20	-	-	-	-
			$v_c$	280-320	240-280	210-240	-	-	-	-
	CN.1005.002.02 SKY77	CNHQ 100510 SL-28V	$h_{max}$	-	-	0.20	0.18	0.16	-	-
			$v_c$	-	-	210-240	180-210	140-180	-	-
	CN.1005.002.02 AV1077	CNHQ 100510 SL-28V	$h_{max}$	-	-	-	-	0.16	0.14	0.11
			$v_c$	-	-	-	-	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	$h_{max}$	-	-	-	0.12	0.12	0.12
			$v_c$	-	-	-	170-200	150-180	120-160
CN..07T3..	CN.07T3.008.11 NERO <sup>2</sup> 77	CNHQ 07T306 SL-28W	$h_{max}$	0.17	0.15	0.14	0.12	0.12	0.12
			$v_c$	260-320	240-280	200-240	180-220	160-200	120-160
CN..1005..	CN.1005.002.01 SKY77	CNHQ 100510 SL-25V	$h_{max}$	-	-	-	0.20	0.17	0.15
			$v_c$	-	-	-	170-200	150-180	120-160
	CN.1005.002.01 NERO <sup>2</sup> 77	CNHQ 100510 SL-25V	$h_{max}$	0.28	0.26	0.22	0.20	0.17	0.15
			$v_c$	260-320	240-280	200-240	180-220	160-200	120-160



# 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

				Stainless steels			
Article		Designation		C12	C11	C10	C09
CN..07T3..	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..07T3..	CN.07T3.008.11 AV1077	CNHQ 07T306 SL-28W	$h_{max}$	0.11	–	–	–
			$v_c$	150-220	–	–	–
CN..1005..	CN.1005.002.02 AV1055	CNHQ 100510 SL-28V	$h_{max}$	0.18	0.15	0.15	0.12
			$v_c$	150-220	140-170	90-120	60-100
CN..1005..	CN.1005.002.02 AV1077	CNHQ 100510 SL-28V	$h_{max}$	0.18	–	–	–
			$v_c$	150-220	–	–	–

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

Mounting | CN/EN/FN  
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