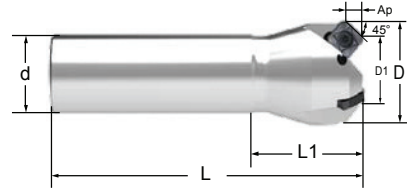


End Mill for SNKX 09T3-45°

Cutter Designation	D	D1	d	L1	L	Ap	z	Catalog Nr.
LT 945 W-D-D025/3	34.3	25	25	-	100	3	3	M2002075
LT 945 W-D-D032/4	41.3	32	32	40	110	3	4	M2002076

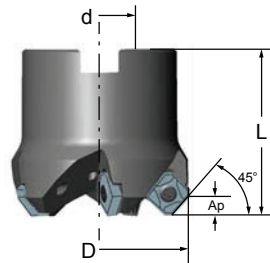
Screw: M2002101
Key: M2002911



Shell Mill for SNKX 09T3-45°

Cutter Designation	D	D1	d	L	Ap	z	Catalog Nr.
LT 945 M-W-D040/5	49.3	40	16	40	3	5	M2001988
LT 945 M-W-D050/6	59.3	50	22	45	3	6	M2002077
LT 945 M-W-D063/8	72.3	63	22	45	3	7	M2002078

Screw: M2002101
Key: M2002911



Shell Mill for SNKX 1607-45°

Cutter Designation	D	D1	d	L	Ap	z	Catalog Nr.	SNKX
LT 947 M-W-D050/4	69	50	22	50	7	4	M2002200	
LT 947 M-W-D063/5	82	63	22	50	7	5	M2002201	
LT 947 M-W-D080/6	99	80	27	50	7	6	M2002202	
LT 947 M-W-D100/7	119	100	32	63	7	7	M2002203	
LT 947 M-W-D125/8	144	125	40	63	7	8	M2002204	

Screw: M2002733 Key: M2000603

SNKX 1607-45° LT 30

Material Group	Gr. N°	VDI Group	Material Examples*	Hardness	D.O.C. [mm]		Feed [mm/tooth]		V _c [m/min]		Optimal cutting conditions			
					min	max	min	max	min	max	D.O.C.	Feed	V _c	
Steel	Non-alloyed	1	C35, Ck45, 1020, 1045, 1060, 28Mn6	125 HB	0.5	6.5	0.16	0.58	190	330	4.0	0.46	250	
				190 HB									220	
				250 HB									200	
	Low alloyed	2	6 4,6 5,7 8	42CrMo4, St50, Ck60, 4140, 4340, 100Cr6	180 HB	0.5	6.5	0.14	0.50	150	240	4.0	0.40	200
					230 HB									180
					280 HB									150
					350 HB									140
	High alloyed	3	10 10 11 11	X40CrMoV5, H13, M42, D3, S6-5-2, 12Ni19	220 HB	0.5	6.5	0.11	0.44	90	150	3.0	0.36	130
					280 HB									120
					320 HB									100
					350 HB									80
Stainless Steel	Austenitic	4	304, 316, X5CrNi18-9	180 HB	0.5	6.5	0.14	0.44	190	250	4.0	0.34	220	
				240 HB									190	
	Duplex	5	14 14	X2CrNiN23-4, S31500	290 HB	0.5	5.0	0.11	0.36	70	130	3.0	0.30	100
					310 HB									90
	Ferritic & Martensitic	6	12 13	410, X6Cr17, 17-4 PH, 430	200 HB	0.5	6.5	0.14	0.44	150	210	4.0	0.34	190
					42 HRC									130
Cast Iron	Grey	7	GG20, GG40, EN-GJL-250, No30B	150 HB	0.5	6.5	0.17	0.58	150	240	4.0	0.46	200	
				200 HB									180	
				250 HB									160	
	Malleable & Nodular	8	17,19 17,19 18,20	GGG40, GGG70, 50005	150 HB	0.5	6.5	0.14	0.52	100	200	4.0	0.40	180
					200 HB									150
					250 HB									130
High Temp. Alloys	Fe, Ni & Co based	9	Incoloy 800 Inconel 700 Stellite 21	240 HB	0.5	5.0	0.11	0.36	25	45	3.0	0.30	32	
				250 HB									30	
				350 HB									30	
	Ti based	10	36 37	TiAl6V4 T40	- -	0.5	5.0	0.11	0.40	40	65	3.0	55	
Hardened Mat.	Steel	11	X100CrMo13, 440C, G-X260NiCr42	45 HRC	0.4	3.0	0.10	0.36	40	80	2.0	0.28	60	
				50 HRC									55	
				55 HRC									50	
	Chilled Cast Iron		40	Ni-Hard 2	400 HB	0.4	3.0	0.10	0.36	40	80	1.5	0.28	50
	White Cast Iron		41	G-X300CrMo15	55 HRC	0.4	1.5	0.10	0.28	30	60	1.0	0.24	40
NF	Al (>8%Si)	12	25	AlSi12	130 HB	0.5	6.5	0.17	0.60	200	400	4.0	0.50	280