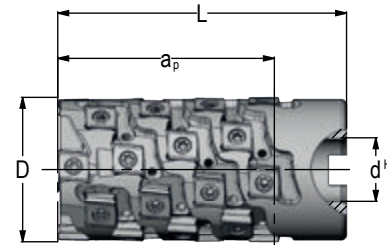
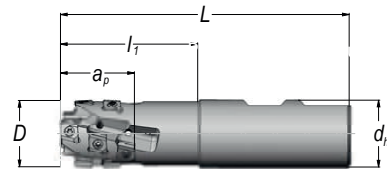


... since **maximum Q** is
the **ultimate goal**

Shell end mill CW90



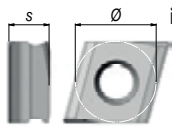
- < 4-cutting edge tangential indexable insert
- < cutting length up to 1,5 x D
- < extremely stable tool core
- < large insert seat contact surface
- < optimum cutting force absorption



Shell end mill CW90

article	D	dh6	L	l ₁	zz	z _{eff}	cl	ic	Kg	insert
02C.2511.001	25	25	110	54	12	2	40,0	yes	0,37	CN..07T3.L
02C.3212.001	32	25	126	70	24	3	54,0	yes	0,54	CN..07T3.L
02C.4014.001	40	32	140	73	27	3	60,0	yes	1,02	CN..07T3.L

article	D	dh ^{H7}	L	zz	z _{eff}	cl	ic	Kg	insert
02C.5010.001	50	22	100	32	4	75	yes	1,45	CN..1005.L
02C.6313.001	63	32	130	40	4	94,5	yes	2,49	CN..1005.L
02C.8011.001	80	32	110	45	5	85	yes	3,54	CN..1005.L



insert incircle diameter

Ø 07 = 7,50

Ø 10 = 10,40

insert thickness

S T3(CN) = 4,00

S 05 = 5,60

allocation from machining parameters of AV material groups

	article	AS	grade		cast iron			steel					
					D20	D18	D17	A22	A20	A18	A16	B15	B14
CN..07T3..	CNHQ07T30600811SL28W	4	SKY77	h _{max}	0,15	0,15	0,12	0,15	0,15	0,12	0,12	0,12	0,12
				v _c	240	200	160	200	200	180	180	180	160
			Nero ² 77	h _{max}	0,18	0,15	0,12						
				v _c	240	180	160						
CN..1005..	CN.1005.002.01 SR -25V	4	SKY77	h _{max}	0,2	0,18	0,15	0,18	0,18	0,15	0,15	0,15	0,15
				v _c	240	200	160	200	200	180	180	180	160
			Can ² 77	h _{max}	0,2	0,15	0,15						
				v _c	280	240	240						
	CN.1005.002.02 SR -28V	4	AV1077	h _{max}				0,18	0,18	0,15	0,15	0,15	0,15
				v _c				200	200	180	180	180	160
			SKY77	h _{max}				0,18	0,18	0,15	0,15	0,15	0,15
				v _c				200	200	180	180	180	160

insert



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