



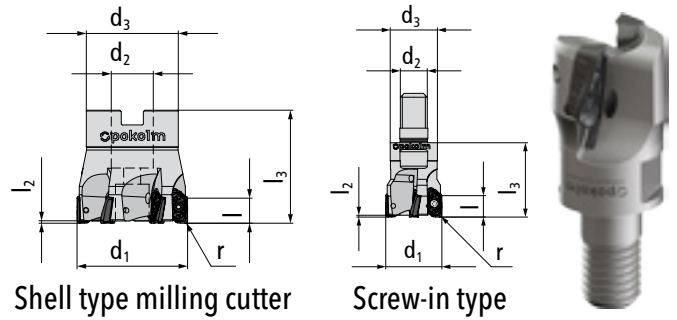
SLOTWORX®

Square shoulder face milling and slotting cutters with highly modern cutting edge geometry for universal applications

SLOTWORX® - K90°

Size L - diam. 25 - 100 mm

Universally applicable for maximum cutting depths. These tools stand out due to low energy consumption and maximum rigidity. Usable with indexable inserts of the Slotworx®-L-range with a corner radius of up to 5.0 mm.


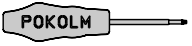





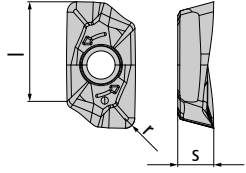
Shell type milling cutter

Screw-in type

	Catalogue no.	d ₁	l	r	l ₃	l ₂	l ₁	d ₂	d ₃	z	Accessories	Features
Screw-in type	2 25 268	25	15	1-5	35	3	-	M 12	21	2	A, B, C, D, E	☑ ■ ●
	3 32 268	32	15	1-5	43	3	-	M 16	29	3	A, B, C, D, E	☑ ■ ●
	4 40 268	40	15	1-5	43	3	-	M 16	29	4	A, B, C, D, E	☑ ■ ●
	4 42 268	42	15	1-5	43	3	-	M 16	29	4	A, B, C, D, E	☑ ■ ●

Shell type milling cutter	4 40 368	40	15	1-5	43	3	-	Ø 16	35	4	A, B, C, D, E	☑ ■ ●
	4 42 368	42	15	1-5	43	3	-	Ø 16	35	4	A, B, C, D, E	☑ ■ ●
	5 50 368	50	15	1-5	53	3	-	Ø 22	40	5	A, B, C, D, E	☑ ■ ●
	5 52 368	52	15	1-5	53	3	-	Ø 22	40	5	A, B, C, D, E	☑ ■ ●
	6 63 368	63	15	1-5	53	3	-	Ø 27	48	6	A, B, C, D, E	☑ ■ ●
	6 66 368	66	15	1-5	53	3	-	Ø 27	48	6	A, B, C, D, E	☑ ■ ●
	7 80 368	80	15	1-5	53	3	-	Ø 27	60	7	A, B, C, D, E	☑ ■ ●
	9 100 368	100	15	1-5	53	3	-	Ø 32	70	9	A, B, C, D, E	☑ ■ ●

Accessories	A	B	C	D	E
	 35 500	 15 500	 TV 2 - 8	 T15 500	 T15 502
Torque 2,4 Nm					

Indexable inserts	Catalogue no.	DIN description	Carbide Grade	Coating	l/d	s	r	Screw Size
	05 68 820	XDHT 155210	K10	polished	15	5.2	1	M 3.5
	05 68 848	XDMT 155210 ER	P40	PVGO	15	5.2	1	M 3.5
	05 68 862	XDMT 155210 ER	K10	PVTi	15	5.2	1	M 3.5
	05 68 896	XDMT 155210 ER	M40	PVST	15	5.2	1	M 3.5
	05 68 8099	XDMT 155210 ER	M35	PCTC	15	5.2	1	M 3.5
	05 68 8099 R20	XDMT 155220 ER	M35	PCTC	15	5.2	2	M3.5
	05 68 896 R20	XDMT 155220 ER	M40	PVST	15	5.2	2	M 3.5
	05 68 820 R30	XDMT 155230 FR	K10	polished	15	5.2	3	M 3.5
	05 68 896 R30	XDMT 155230 ER	M40	PVST	15	5.2	3	M 3.5
	05 68 820 R40	XDMT 155240 FR	K10	polished	15	5.2	4	M 3.5
	05 68 896 R40	XDMT 155240 ER	M40	PVST	15	5.2	4	M 3.5
	05 68 820 R50	XDMT 155250 FR	K10	polished	15	5.2	5	M 3.5
	05 68 896 R50	XDMT 155250 ER	M40	PVST	15	5.2	5	M 3.5

Feed per tooth (fz) | d.o.c. (ap)

Carbide Grade Coating	Feed per tooth d.o.c.	steel	stainless steel	cast iron	no-ferrous material	high-temperature alloys	hardened steel
K10 polished	f _z (mm)	-	0,08 - 0,1	-	0,08 - 0,35	-	-
	a _p (mm)	-	0,1 - 0,3	-	0,1 - 14	-	-
P40 PVGO	f _z (mm)	0,1 - 0,5	-	0,1 - 0,5	-	-	-
	a _p (mm)	0,2 - 14	-	0,2 - 14	-	-	-
K10 PVTi	f _z (mm)	0,1 - 0,3	-	0,1 - 0,3	-	-	0,08 - 0,15
	a _p (mm)	0,1 - 5	-	0,1 - 14	-	-	0,1 - 3,0
M40 PVST	f _z (mm)	0,1 - 0,5	0,08 - 0,5	-	-	0,08 - 0,25	-
	a _p (mm)	0,2 - 14	0,1 - 14	-	-	0,1 - 14	-
M35 PCTC	f _z (mm)	-	0,08 - 0,5	-	-	0,08 - 0,3	-
	a _p (mm)	-	0,1 - 14	-	-	0,1 - 14	-

Cutting speed (VC in m/min)

Carbide Grade Coating	Application	steel	stainless steel	cast iron	no-ferrous material	high-temperature alloys	hardened steel
K10 polished	roughing	-	-	-	▽100 450 800	-	-
	semifinishing	-	-	-	▽100 450 800	-	-
	finishing	-	▽150 200 250	-	▽100 450 800	-	-
P40 PVGO	roughing	▽100 150 200	-	▽110 130 150	-	-	-
	semifinishing	▽100 150 200	-	▽110 130 150	-	-	-
	finishing	▽160 205 250	-	▽120 150 180	-	-	-
K10 PVTi	roughing	▽130 170 210	-	▽150 175 200	-	-	▽80 100 120
	semifinishing	▽150 185 220	-	▽150 175 200	-	-	▽100 125 150
	finishing	▽150 215 280	-	▽150 200 250	-	-	▽140 170 200
M40 PVST	roughing	▽100 150 200	▽80 130 180	-	-	▽30 55 80	-
	semifinishing	▽100 150 200	▽100 155 210	-	-	▽40 65 90	-
	finishing	▽160 205 250	▽120 185 250	-	-	▽60 90 120	-
M35 PCTC	roughing	-	▽110 175 240	-	-	▽30 70 110	-
	semifinishing	-	▽120 185 250	-	-	▽40 75 110	-
	finishing	-	▽160 220 280	-	-	▽60 100 140	-

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