PRAMET

New products 2015.1

/ NEW PRODUCTS

2015.1

CONTENTS

PRAMET

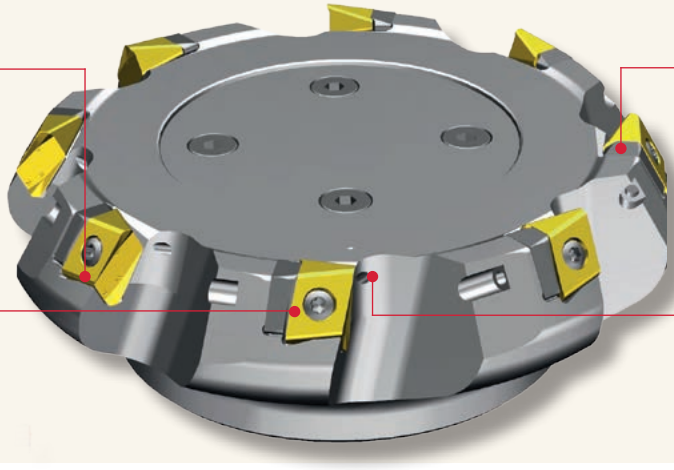
MILLING CUTTERS

S60LN15C

FACE MILLING CUTTERS FOR HEAVY ROUGHING

NEW RANGE OF HIGHLY PRODUCTIVE TANGENTIAL FACE MILLING CUTTERS

A completely new range of tools and indexable cutting inserts for productive roughing of cast iron and steel. Tangential face cutters with adjustment angle of 60° with double-sided cutting insert.
High feed and cutting depth up to 12 mm.



Tangential mounting of the insert
- rigid clamping

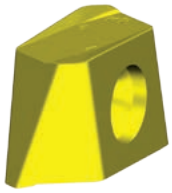
Robust insert
- for heavy machining conditions

Shim
- protects the body

Internal cooling
- aids chip evacuation

Chipbreaker M:

- positive geometry
- for standard workpieces
- low cutting forces, appropriate chip formation
- for milling of cast iron and steel



Chipbreaker KR

- more negative geometry
- for hard workpieces with inclusions, hard encrustation, etc.
- first choice for cast iron
- alternatively for steel with heavy cutting conditions

BENEFITS:

- New **highly productive** tangential cutters
- **High feed and cutting depth up to 12 mm**
- **High impact strength** reduces risk of insert failure in heavy roughing applications
- Low cutting forces due to positive geometry
- High durability as a result of combination with
- Possibility of internal fluid or air **cooling**

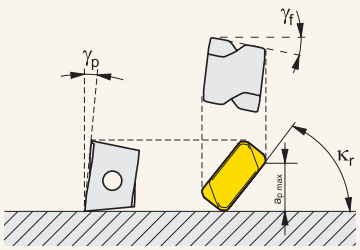
TIP!

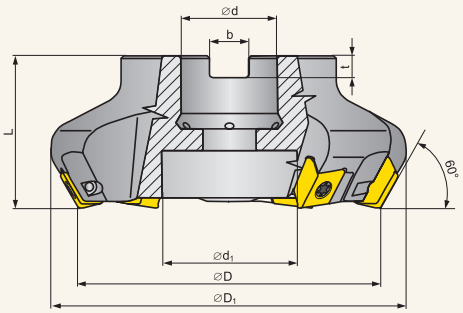
The LNEX inserts are produced **from new materials** we launched in November 2014. For more information, see the catalogue New Products 2014, on pp. 36-39.

S60LN15C

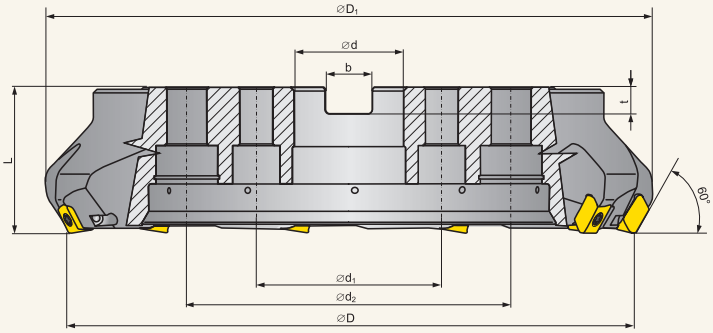
FACE MILLING CUTTERS FOR HEAVY ROUGHING

γ_p	+4°	κ_r	60°
γ_f	-12° ÷ -13,5°	$a_{p\,max}$	12 mm





∅ 125 mm



∅ 160 ÷ 315 mm

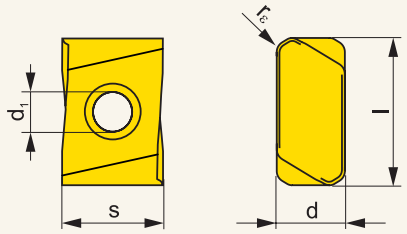
Z* - / Number of teeth

ISO	/ Assortment	/ Dimensions D	D_1	d	L	d_1	d_2	t	b	Z*			Cooling	[kg]
125A06R-S60LN15C-C	●	125	147	40	63	56	-	9	16,4	6			+	4
160C08R-S60LN15C-C	●	160	181,6	40	63	66,7	-	9	16,4	8			+	6,10
200C08R-S60LN15C-C	●	200	221,6	60	63	101,6	-	14	25,7	8			+	9,40
200C10R-S60LN15C-C	●	200	221,6	60	63	101,6	-	14	25,7	10			+	9,40
250C09R-S60LN15C-C	●	250	269,6	60	63	101,6	-	14	25,7	9			+	15,60
250C12R-S60LN15C-C	●	250	269,6	60	63	101,6	-	14	25,7	12			+	15,90
315C11R-S60LN15C-C	●	315	333,9	60	80	101,6	177,8	14	25,7	11			+	31,50
315C14R-S60LN15C-C	●	315	333,9	60	80	101,6	177,8	14	25,7	14			+	31,90

● / Stock assortment ○ / Non-stock assortment / All dimensions [mm]
. / Actual assortment is given by the valid price list.

S60LN15C

FACE MILLING CUTTERS FOR HEAVY ROUGHING



LNEX 15

LNEX 15-KR LNEX 15-M

/ INDEXABLE CUTTING INSERTS

ISO	/ Grade			/ Dimensions				
	M5326	M8326	M8346	(l)	d	s	d_1	r_ε
LNEX 1513DPSR-M	●	●	●	20,750	9,600	14,3	5,7	1,6
LNEX 1513DPSR-KR	●	●	●	20,750	9,600	13,6	5,7	1,6

/ SPARE PARTS

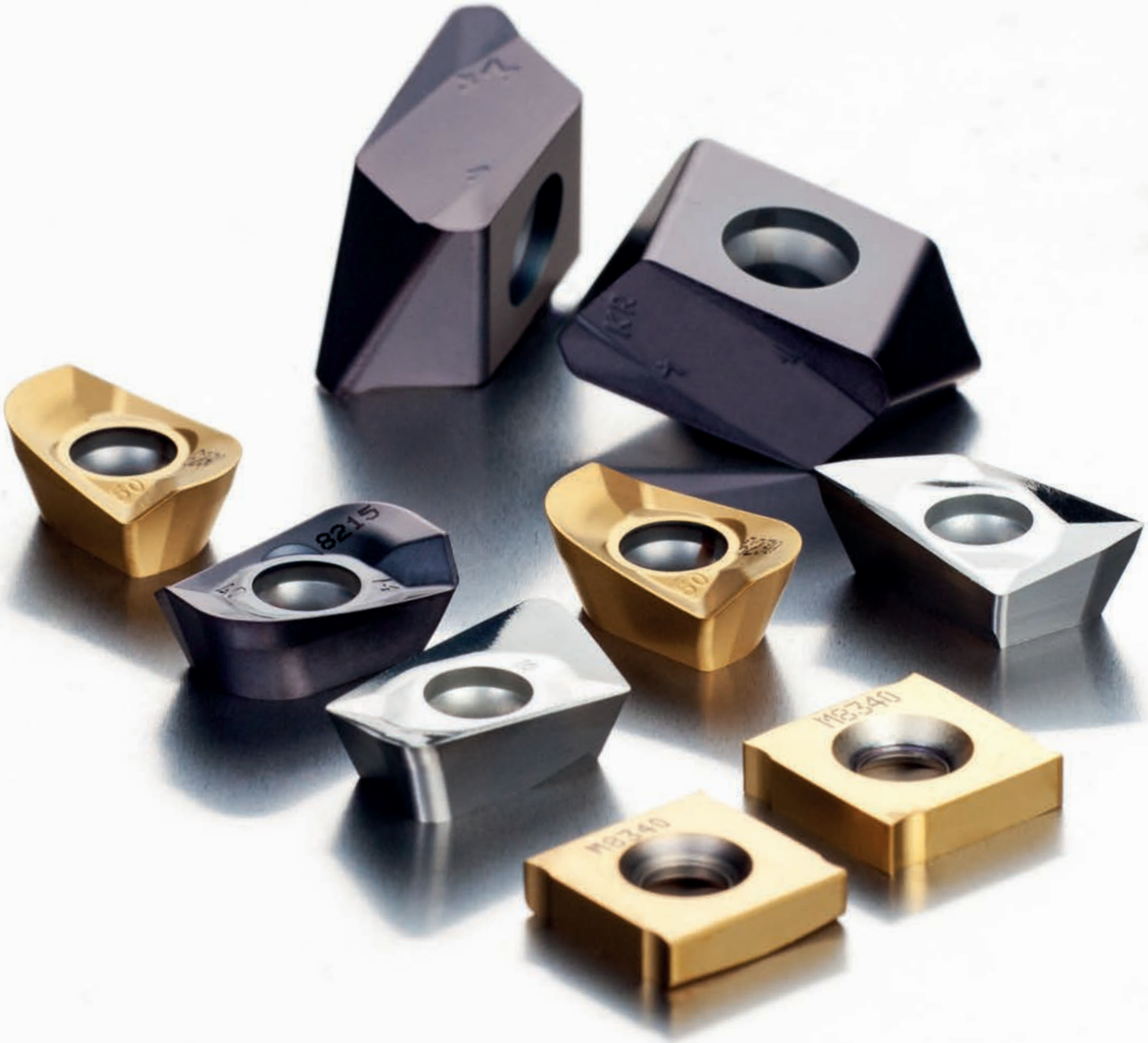
Diameter of cutter	Shim	Clamping screw	Key	Clamping screw for shim	Key for shim clamping	Arbor cover
125	SSN 150616	US 5018-T20P	SDR T20P-T	US 54511-T15P	SDR T15P-T	
160	SSN 150616	US 5018-T20P	SDR T20P-T	US 54511-T15P	SDR T15P-T	CAC 160C
200	SSN 150616	US 5018-T20P	SDR T20P-T	US 54511-T15P	SDR T15P-T	CAC 200C
250	SSN 150616	US 5018-T20P	SDR T20P-T	US 54511-T15P	SDR T15P-T	CAC 250C
315	SSN 150616	US 5018-T20P	SDR T20P-T	US 54511-T15P	SDR T15P-T	CAC 315C

Diameter of cutter	Screw for cover clamping	Key for cover clamping	Plug	Retaining ring	Screw for taper clamping
125					
160	HSD 0825C	HXK 5			
200	HSD 1025C	HXK 7			HS 1655C
250	HSD 1025C	HXK 7			HS 1655C
315	HSD 1035C	HXK 7	CACP 3150C	RRH 34	HS 1655C

● / Stock assortment ○ / Non-stock assortment / All dimensions [mm]
. / Actual assortment is given by the valid price list.

MILLING INSERTS

UP! GRADE®



PRAMET

ADMX / ADEX 16

INDEXABLE CUTTING INSERTS FOR MILLING

EXTENDED RANGE OF ADMX/ADEX 16 CUTTING INSERTS FOR PRODUCTIVE MILLING

The range of inserts extended with a new line of radii, 0.4 - 5.0, and HF geometry for high feed milling. A complete range of ADMX/ADEX 16 inserts for productive square shoulder milling

Complete range of inserts:

0,4 – 5,0 Radius 0.4 – 5.0

0,4 mm | 0,8 mm | 1,6 mm | 2,0 mm | 3,0 mm | 3,2 mm | 4,0 mm | 5,0 mm

Geometry

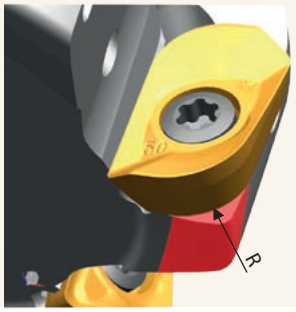
ADMX F | ADMX M | ADMX R | ADEX FA | ADEX FM | ADEX HF

NEW PRODUCTS:

- New types of **radius inserts** to machine most of the technological transi tional radii.
- **New HF geometry**. You will be able to use your existing cutters with the new inserts for high feed milling as well.

BENEFITS:

- **A complete range** of radii and geometries of inserts
- **Universal solution** to machining of material
- Highly positive geometry for **low cutting forces**
- Optimised shape of the cutting edge for **smoother operation**
- **High durability and reliability** of indexable cutting inserts
- **Perfect chip evacuation** from the cutting zone
- Excellent machined **surface quality**

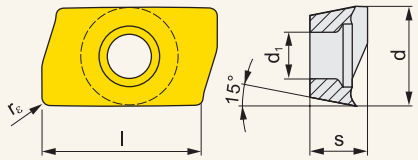


Insert	R
ADMX 160630SR-M	2,5
ADMX 160632SR-M	2,5
ADMX 160640SR-M	4,0
ADMX 160650SR-M	4,5

TIP!

When using inserts with a larger radius (over 3.0) it is necessary to modify the cutter body

ADMX 16



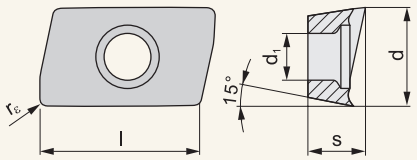
Dimensions	l	d	d_1	s		
1606	16,000	9,950	4,5	6,25		

Geometry	ISO	/ Grade								Radius	Feed/tooth		Depth of cut	
		M5315	M9315	M9325	M9340	M8340	8215	8230	8240	r_ε	f_{min}	f_{max}	$a_{p\,min}$	$a_{p\,max}$
F	ADMX 160608SR-F				●	●	●	●	●	0,8	0,07	0,15	0,3	13,0
M	ADMX 160604SR-M					●	●	●		0,4	0,17	0,30	0,3	13,0
	ADMX 160608SR-M	●	●	●	●	●	●	●	●	0,8	0,17	0,30	0,3	13,0
	ADMX 160616SR-M			●		●	●	●	●	1,6	0,17	0,30	0,3	13,0
	ADMX 160620SR-M					●		●		2,0	0,17	0,30	0,3	13,0
	ADMX 160630SR-M					●		●		3,0	0,17	0,30	0,3	13,0
	ADMX 160632SR-M			●		●	○	●	●	3,2	0,17	0,30	0,3	13,0
PL	ADMX 160640SR-M					●		●		4,0	0,17	0,30	0,3	13,0
	ADMX 160650SR-M					●		●		5,0	0,17	0,30	0,3	13,0
R	ADMX 160608PR-R	●	●	●		●	●	●	●	0,8	0,17	0,35	0,8	13,0
	ADMX 160616PR-R	●	●	●		●	●	●		1,6	0,17	0,35	0,8	13,0

● / Stock assortment ○ / Non-stock assortment / All dimensions [mm]

. / Actual assortment is given by the valid price list.

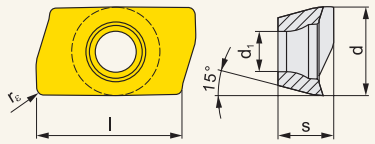
ADEX-FA



Dimensions	l	d	d_1	s		
1606	16,000	9,950	4,50	6,10		

Geometry	ISO	/ Grade															Radius	Feed/tooth		Depth of cut	
		M0315	HF7														r_ε	f_{min}	f_{max}	$a_{p\,min}$	$a_{p\,max}$
	ADEX 160604FR-FA	●	●														0,4	0,05	0,35	0,3	13,0
	ADEX 160608FR-FA	●	●														0,8	0,05	0,35	0,3	13,0
	ADEX 160616FR-FA	●	●														1,6	0,05	0,35	0,3	13,0
	ADEX 160630FR-FA		●														3,0	0,05	0,35	0,3	13,0

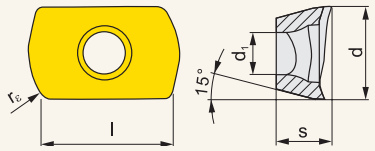
ADEX-FM



Dimensions	l	d	d_1	s		
1606	16,000	9,950	4,50	6,25		

Geometry	ISO	/ Grade															Radius	Feed/tooth		Depth of cut	
		M9325	M9340	M8340	8215	8230	8240										r_ε	f_{min}	f_{max}	$a_{p\,min}$	$a_{p\,max}$
	ADEX 160608SR-FM	●	●	●	●	●	●										0,8	0,10	0,25	0,3	13,0

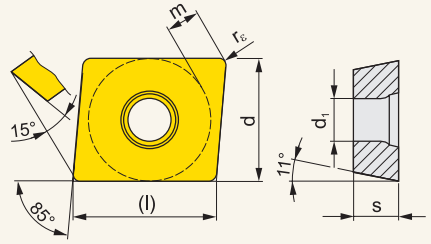
ADEX-HF



Dimensions	l	d	d_1	s		
1606	16,000	9,950	4,50	6,10		

Geometry	ISO	/ Grade				Radius	Feed/tooth		Depth of cut	
		M8340	8215	8230		r_ε	f_{min}	f_{max}	$a_{p\,min}$	$a_{p\,max}$
	**ADEX 160612SR-HF**	●	●	●		1,2	0,6	1,3	0,25	1,3

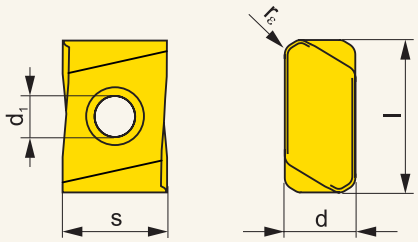
APEW



Dimensions	l	d	d_1	s		
1504	15,900	12,700	5,50	4,76		

Geometry	ISO	/ Grade				Radius	Feed/tooth		Depth of cut	
		M8340	8230	8240		r_ε	f_{min}	f_{max}	$a_{p\,min}$	$a_{p\,max}$
	APEW 150412ER		●	○		1,2	0,10	0,30	1,2	12,0
	APEW 150412SR	●	●	○		1,2	0,20	0,40	1,2	12,0

LNEX

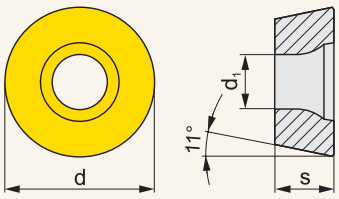


Dimensions	l	d	d_1	s		
1513	20,750	9,600	5,70	14,30		

Geometry	ISO	/ Grade				Radius	Feed/tooth		Depth of cut	
		M5326	M8326	M8346		r_ε	f_{min}	f_{max}	$a_{p\,min}$	$a_{p\,max}$
	LNEX 1513DPSR-M	●	●	●		1,6	0,30	0,90	1,6	12,0
	LNEX 1513DPSR-KR	●	●	●		1,6	0,30	0,90	1,6	12,0

INDEXABLE CUTTING INSERTS FOR MILLING

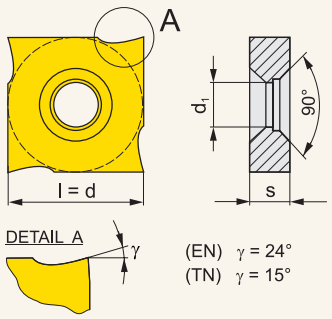
RPEW 12



Dimensions	d	d_1	s			
1204	12,000	4,40	4,76			

Geometry	ISO	/ Grade					Radius	Feed/tooth		Depth of cut	
		M8325	M8340	8215	8230	8240	r_ε	f_{min}	f_{max}	$a_{p\,min}$	$a_{p\,max}$
	**RPEW 1204M0SN**	●	●	●	●	○		0,10	0,40	0,5	3,0

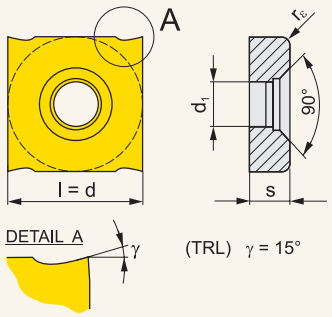
SNHQ AZ



Dimensions	l	d	s	d_1		
1102	11,000	11,000	2,30	4,30		
1103	11,000	11,000	2,70	4,30		
1203	12,700	12,700	3,20	5,00		
12T3	12,700	12,700	3,40	5,00		
1204	12,700	12,700	4,50	5,00		
1205	12,700	12,700	5,40	5,00		
1207	12,700	12,700	7,00	5,00		

Geometry	ISO	/ Grade			Radius	Feed/tooth		Depth of cut	
		M8340	8215	8230	r_ε	f_{min}	f_{max}	$a_{p\,min}$	$a_{p\,max}$
	SNHQ 1102AZTN	●		●		0,20	0,40	-	-
	SNHQ 1103AZTN	●		●		0,20	0,40	-	-
	SNHQ 1203AZEN	○	●			0,20	0,40	-	-
	SNHQ 1203AZTN	●		●		0,20	0,40	-	-
	SNHQ 12T3AZTN	●		●		0,20	0,40	-	-
	**SNHQ 12T3AZEN**	●				0,20	0,40	-	-
	SNHQ 1204AZEN	○	○			0,20	0,40	-	-
	SNHQ 1204AZTN	●		●		0,20	0,40	-	-
	SNHQ 1205AZEN	○	○			0,20	0,50	-	-
	SNHQ 1205AZTN	●		●		0,20	0,50	-	-
	SNHQ 1207AZEN	○	○			0,20	0,50	-	-
	SNHQ 1207AZTN	●		●		0,20	0,50	-	-

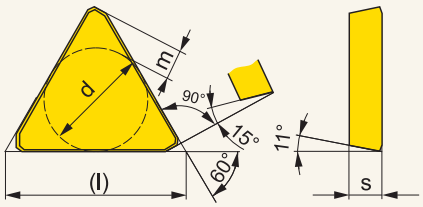
SNHQ TRL



Dimensions	l	d	s	d_1	γ°
1203	12,700	12,700	3,20	5,00	15°
12T3	12,700	12,700	3,40	5,00	15°
1204	12,700	12,700	4,50	5,00	15°
1205	12,700	12,700	5,40	5,00	15°
1207	12,700	12,700	7,00	5,00	15°

Geometry	ISO	/ Grade	Radius	Feed/tooth		Depth of cut	
		M8340	r_ε	f_{min}	f_{max}	$a_{p\,min}$	$a_{p\,max}$
	SNHQ 120305TRL	●	0,50	0,20	0,40	-	-
	SNHQ 120310TRL	●	1,00	0,20	0,40	-	-
	SNHQ 120315TRL	○	1,50	0,20	0,40	-	-
	SNHQ 12T305TRL	●	0,50	0,20	0,40	-	-
	SNHQ 12T310TRL	●	1,00	0,20	0,40	-	-
	SNHQ 12T315TRL	●	1,50	0,20	0,40	-	-
	SNHQ 120405TRL	●	0,50	0,20	0,40	-	-
	**SNHQ 120410TRL**	●	1,00	0,20	0,40	-	-
	SNHQ 120415TRL	○	1,50	0,20	0,40	-	-
	SNHQ 120505TRL	●	0,50	0,20	0,50	-	-
	SNHQ 120510TRL	○	1,00	0,20	0,50	-	-
	SNHQ 120515TRL	○	1,50	0,20	0,50	-	-
	SNHQ 120705TRL	●	0,50	0,20	0,50	-	-
	SNHQ 120710TRL	○	1,00	0,20	0,50	-	-
	SNHQ 120715TRL	○	1,50	0,20	0,50	-	-

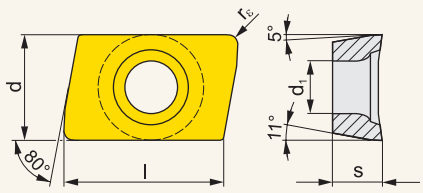
TPKN SR



Dimensions	(l)	d	s	m
1603	16,500	9,530	3,18	2,45
2204	22,000	12,700	4,76	3,55

Geometry	ISO	/ Grade								Radius	Feed/tooth		Depth of cut	
		M5315	M9325	M8340	8230	8240	H10	S26	S45	r_ε	f_{min}	f_{max}	$a_{p\,min}$	$a_{p\,max}$
	**TPKN 1603PDSR**			●	●	●		●			0,20	0,25	1,0	16,0
	TPKN 2204PDSR	●	●	●	●	●	●	●	○		0,20	0,30	1,0	22,0

XPHT



Dimensions	l	d	d_1	s
1604	15,875	9,525	4,40	4,76

Geometry	ISO	/ Grade									Radius	Feed/tooth		Depth of cut	
		M9325	M9340	M8340	8215	8230	HF7				r_ε	f_{min}	f_{max}	$a_{p\,min}$	$a_{p\,max}$
	**XPHT 160412E**			●	●	●					1,20	0,05	0,30	1,2	15,0
	XPHT 160412S	●	●		●	●					1,20	0,10	0,30	1,2	15,0
	**XPHT 160408F-FA**						●				0,80	0,05	0,30	0,8	15,0

● / Stock assortment ○ / Non-stock assortment / All dimensions [mm]
. / Actual assortment is given by the valid price list.

TURNING INSERTS

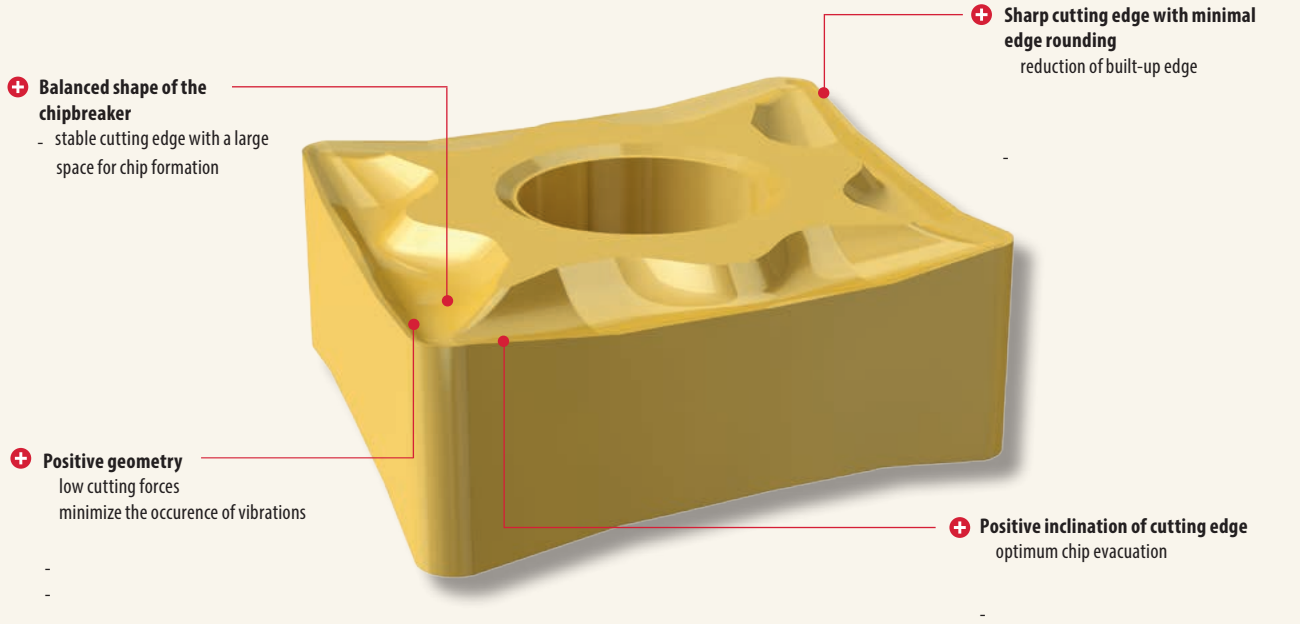
UP! GRADE®

NF

NEGATIVE INSERTS WITH NF CHIPBREAKER

NEW CUTTING INSERTS WITH POSITIVE NF GEOMETRY FOR TURNING OF STAINLESS STEEL

Double-sided cutting insert for finishing and medium turning of stainless steel, low carbon steel, and conditionally also superalloys.
Sharp and positive geometry and positive inclination of cutting edge.



NEW PRODUCTS:

- Sharp and **positive** chipbreaker, specially designed for stainless steel
- **Positive inclination of cutting edge** for optimum chip evacuation from the cutting zone
- **FIRST choice** for finishing and medium turning of stainless steels

BENEFITS:

- Excellent **chip formation ability**
- **Low cutting forces** increase suitability in unstable machine set-ups
- High **productivity**
- High **durability and reliability** as a result of combination materials
- Quality of the machined surface

TIP!

- Inserts with the NF chip breakers are suitable for the **machining of slim shafts** thanks to low values of radial cutting force.

TURNING INSERTS

UP! GRADE®

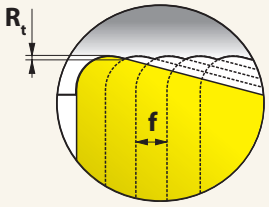
W-MR

NEGATIVE CUTTING INSERTS WITH NEW WIPER EDGE GEOMETRY

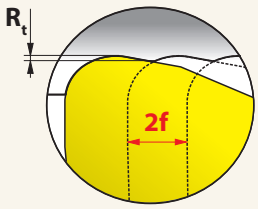
NEW WIPER INSERTS WITH W-MR CHIPBREAKER

Double-sided inserts with the W-MR geometry have a positive chipbreaker and a new wiper edge geometry to achieve lower roughness in turning.
They increase productivity by using higher feeds while retaining the same roughness as with standard inserts.

1. Double feed = same roughness

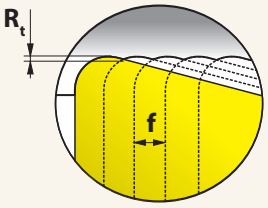


Standard insert

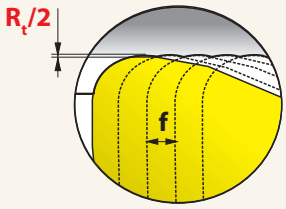


New W-MR geometry

2. Same feed = half value of roughness



Standard insert



New W-MR geometry

NEW PRODUCTS:

- **New wiper edge geometry**
- Positive chipbreaker
- Available for the CNMG, DNMG and WNMG inserts
- For turning of steel, stainless steel and cast iron

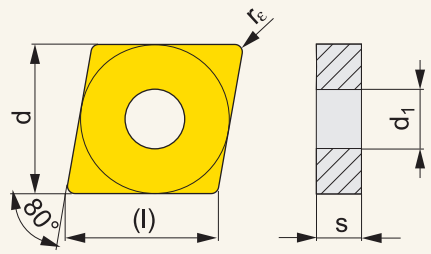
BENEFITS:

- **Productivity** - higher feeds due to the new wiper edge
- **Low roughness**, quality look of the machined surface
- Often eliminates the need for finishing operations
- Lower cutting forces
- High **durability** as a result of the combination with UP!GRADE materials
- **Stability and operational reliability**

TIP!

- Cutting inserts with the W-MR geometry are suitable for **longitudinal and face turning**
- If used properly, can **eliminate grinding**
- For optimum results, use **cooling**

CNMG



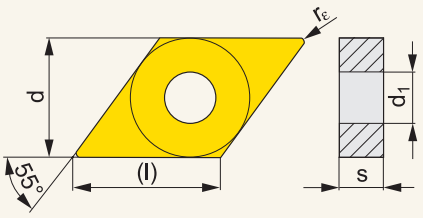
Dimensions	(l)	d	d_1	s		
0903	9,7	9,525	3,81	3,18		
1204	12,9	12,700	5,16	4,76		
1606	16,1	15,875	6,35	6,35		
1906	19,3	19,050	7,94	6,35		
2509	25,8	25,400	9,12	9,52		

Chipbreaker	ISO	/ Grade															Radius	Feed/rev.		Depth of cut	
		T5305	T5315	T7335	T9310	T9315	T9325	T9335	6630	6640	T8315	T8330	HF7	TT310			r_ε	f_{min}	f_{max}	$a_{p\,min}$	$a_{p\,max}$
	CNMG 120404E-FF										●						0,4	0,06	0,15	0,4	1,5
	CNMG 120408E-FF										●						0,8	0,08	0,20	0,8	1,5
	CNMG 090304E-FM					●	●					●					0,4	0,10	0,30	0,5	6,3
	CNMG 090308E-FM					●	●					●					0,8	0,10	0,45	0,8	3,0
	CNMG 120404E-FM			●	●	●	●				●	●		●			0,4	0,10	0,30	0,5	3,0
	CNMG 120408E-FM			●	●	●	●				●	●		●			0,8	0,15	0,45	0,8	3,0
	CNMG 120412E-FM					●	●										1,2	0,15	0,45	1,2	4,0
	CNMG 120412E-KR	●	●														1,2	0,25	0,70	1,2	7,0
	CNMG 090308E-M					●	●	●									0,8	0,15	0,60	0,8	4,0
	CNMG 120404E-M		●		●	●	●	●									0,4	0,17	0,30	0,8	6,0
	CNMG 120408E-M	●	●		●	●	●	●	●	●		●					0,8	0,17	0,60	0,8	6,0
	CNMG 120412E-M	●	●		●	●	●	●	●								1,2	0,17	0,80	1,2	6,0
	CNMG 120416E-M	●					●	●									1,6	0,17	0,80	1,6	6,0
	CNMG 160608E-M				●	●	●	●	●								0,8	0,17	0,60	0,8	7,0
	CNMG 160612E-M					●	●	●									1,2	0,17	0,60	1,2	7,0
	CNMG 160616E-M						●	●									1,6	0,17	0,60	1,6	7,0
	CNMG 190608E-M					●	●	●	●								0,8	0,17	0,60	0,8	8,0
	CNMG 190612E-M				●	●	●	●	●	●							1,2	0,17	0,80	1,2	8,0
	CNMG 190616E-M				●	●	●	●									1,6	0,17	0,80	1,6	8,0
	CNMG 090304E-NF			●			●				●	●					0,4	0,10	0,30	0,4	3,0
	CNMG 090308E-NF			●			●				●	●					0,8	0,13	0,30	0,8	3,0
	CNMG 120404E-NF			●		●	●				●	●	●				0,4	0,13	0,30	0,4	3,0
	CNMG 120408E-NF			●		●	●				●	●	●				0,8	0,15	0,35	0,8	3,5
	CNMG 120412E-NF			●		●	●					●					1,2	0,15	0,35	1,2	4,0
	CNMG 120404E-NM			●			●					●					0,4	0,15	0,30	0,5	3,0
	CNMG 120408E-NM			●			●					●					0,8	0,20	0,40	0,8	3,0
	CNMG 120412E-NM			●			●					●					1,2	0,20	0,40	1,2	3,5
	CNMG 160608E-NM			●			●					●					0,8	0,25	0,50	0,8	5,0

● / Stock assortment ○ / Non-stock assortment / All dimensions [mm]
. / Actual assortment is given by the valid price list.

Chipbreaker	ISO	/ Grade															Radius	Feed/rev.		Depth of cut	
		T5305	T5315	T7335	T9310	T9315	T9325	T9335	6630	6640	T8315	T8330	HF7	TT310			r_ε	f_{min}	f_{max}	$a_{p\,min}$	$a_{p\,max}$
	CNMG 160612E-NM			●			●										1,2	0,25	0,50	1,2	5,0
	CNMG 190612E-NM			●			●					●					1,2	0,30	0,50	1,2	8,0
	CNMG 120408E-R	●				●	●	●	●	●							0,8	0,25	0,60	2,0	6,0
	CNMG 120412E-R	●				●	●	●	●								1,2	0,25	0,70	2,0	6,0
	CNMG 120416E-R																1,6	0,30	0,80	2,0	6,0
	CNMG 160608E-R																0,8	0,25	0,60	3,0	7,0
	CNMG 160612E-R	●				●	●		●								1,2	0,25	0,70	3,0	7,0
	CNMG 160616E-R	●															1,6	0,25	0,70	3,0	7,0
	CNMG 190608E-R																0,8	0,25	0,60	3,0	8,0
	CNMG 190612E-R	●					●	●	●	●							1,2	0,25	0,70	3,0	8,0
	CNMG 190616E-R	●				●	●	●	●	●							1,6	0,25	0,70	2,0	9,0
	CNMG 120408E-RM	●	●		●	●	●	●			●	●					0,8	0,20	0,50	1,0	7,0
	CNMG 120412E-RM	●	●		●	●	●	●			●	●					1,2	0,25	0,70	1,5	7,0
	CNMG 120416E-RM	●	●		●	●	●	●				●					1,6	0,30	0,75	2,0	7,0
	CNMG 160608E-RM	●	●			●	●	●				●					0,8	0,20	0,50	1,0	8,0
	CNMG 160612E-RM	●	●		●	●	●	●				●					1,2	0,25	0,70	1,5	8,0
	CNMG 160616E-RM	●	●		●	●	●	●									1,6	0,30	0,80	2,0	8,0
	CNMG 190608E-RM	●	●			●	●	●									0,8	0,20	0,50	1,0	10,0
	CNMG 190612E-RM	●	●		●	●	●	●				●					1,2	0,25	0,70	1,5	10,0
	CNMG 190616E-RM	●	●		●	●	●	●									1,6	0,30	0,80	2,0	10,0
	CNMG 250924E-RM					●	●	●									2,4	0,40	1,00	2,5	15,0
	CNMG 120404EL-SI			●			●					●					0,4	0,20	0,30	0,8	5,0
	CNMG 120408EL-SI			●			●					●					0,8	0,20	0,50	0,8	5,0
	CNMG 120404ER-SI			●			●		●			●					0,4	0,20	0,30	0,8	5,0
	CNMG 120408ER-SI			●			●		●			●					0,8	0,20	0,50	0,8	5,0
	CNMG 120408W-F		●			●	●										0,8	0,15	0,60	0,8	4,4
	CNMG 120408W-M		●			●	●										0,8	0,15	0,60	0,8	4,0
	CNMG 120412W-M		●			●	●										1,2	0,20	0,90	1,2	4,0
	CNMG 120404W-MR					●	●										0,4	0,20	0,60	0,5	4,0
	CNMG 120408W-MR		●			●	●										0,8	0,20	0,70	0,8	5,0
	CNMG 120412W-MR		●			●	●										1,2	0,25	0,75	1,2	5,0

DNMG



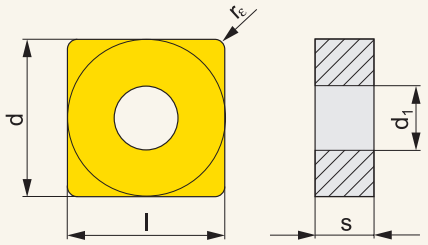
Dimensions	(l)	d	d_1	s		
1104	11,6	9,525	3,81	4,76		
1504	15,5	12,700	5,16	4,76		
1506	15,5	12,700	5,16	6,35		

Chipbreaker	ISO	/ Grade															Radius	Feed/rev.		Depth of cut	
		T5305	T5315	T7335	T9310	T9315	T9325	T9335	6630	T8315	T8330	HF7	TT310				r_ε	f_{min}	f_{max}	$a_{p\,min}$	$a_{p\,max}$
	DNMG 110402E-FF									●							0,2	0,06	0,12	0,2	1,5
	DNMG 110404E-FF									●							0,4	0,06	0,20	0,4	1,5
	DNMG 110408E-FF									●							0,8	0,08	0,25	0,8	1,5
	DNMG 150404E-FF									●							0,4	0,06	0,20	0,4	1,5
	DNMG 150604E-FF									●							0,4	0,06	0,20	0,4	1,5
	DNMG 150608E-FF									●							0,8	0,08	0,25	0,8	1,5
	DNMG 110404E-FM				●	●	●			●	●						0,4	0,10	0,24	0,4	3,0
	DNMG 110408E-FM				●	●	●			●	●						0,8	0,10	0,35	0,8	3,0
	DNMG 150404E-FM					●	●				●						0,4	0,10	0,24	0,5	3,0
	DNMG 150408E-FM					●	●				●						0,8	0,15	0,45	0,8	3,0
	DNMG 150604E-FM			●	●	●	●			●	●		●				0,4	0,10	0,24	0,5	3,0
	DNMG 150608E-FM			●	●	●	●			●	●		●				0,8	0,15	0,45	0,8	3,0
	DNMG 150612E-FM					●	●				●						1,2	0,15	0,45	1,2	3,0
	DNMG 110404E-M		●			●	●	●									0,4	0,12	0,24	0,5	3,0
	DNMG 110408E-M		●			●	●	●									0,8	0,15	0,48	0,8	3,0
	DNMG 110412E-M					●	●	●									1,2	0,17	0,72	1,2	3,3
	DNMG 150404E-M					●	●	●									0,4	0,12	0,24	0,5	3,0
	DNMG 150408E-M					●	●	●									0,8	0,15	0,48	0,8	4,5
	DNMG 150412E-M						●	●									1,2	0,17	0,72	1,2	4,5
	DNMG 150604E-M		●			●	●	●									0,4	0,12	0,24	0,5	3,0
	DNMG 150608E-M		●		●	●	●	●	●								0,8	0,15	0,48	0,8	4,5
	DNMG 150612E-M		●		●	●	●	●									1,2	0,17	0,72	1,2	4,5
	DNMG 110404E-NF			●		●	●				●						0,4	0,10	0,24	0,4	3,0
	DNMG 110408E-NF			●		●	●				●						0,8	0,13	0,30	0,8	3,0
	DNMG 150404E-NF			●		●	●				●						0,4	0,13	0,24	0,4	3,0
	DNMG 150408E-NF			●		●	●				●						0,8	0,15	0,30	0,8	3,0
	DNMG 150604E-NF			●		●	●			●	●	●					0,4	0,13	0,24	0,4	3,0
	DNMG 150608E-NF			●		●	●			●	●	●					0,8	0,15	0,30	0,8	3,0
	DNMG 150612E-NF					●	●				●						1,2	0,15	0,35	1,2	3,5

● / Stock assortment ○ / Non-stock assortment / All dimensions [mm]
. / Actual assortment is given by the valid price list.

Chipbreaker	ISO	/ Grade														Radius	Feed/rev.		Depth of cut	
		T5305	T5315	T7335	T9310	T9315	T9325	T9335	6630	T8315	T8330	HF7	TT310			r_ε	f_{min}	f_{max}	$a_{p\,min}$	$a_{p\,max}$
	DNMG 110404E-NM			●			●				●					0,4	0,15	0,24	0,5	3,0
	DNMG 110408E-NM			●			●				●					0,8	0,20	0,40	0,8	3,0
	DNMG 150604E-NM			●			●				●					0,4	0,15	0,24	0,5	3,0
	DNMG 150608E-NM			●			●				●					0,8	0,20	0,40	0,8	3,0
	DNMG 150612E-NM			●			●									1,2	0,20	0,40	1,2	3,5
	DNMG 150608E-R	●					●		●							0,8	0,25	0,48	2,0	4,5
	DNMG 150612E-R	●				●	●		●							1,2	0,25	0,70	2,0	4,5
	DNMG 110408E-RM					●	●	●								0,8	0,20	0,48	1,0	3,3
	DNMG 110412E-RM					●	●	●								1,2	0,25	0,60	1,5	3,3
	DNMG 150412E-RM					●	●	●								1,2	0,25	0,70	1,5	4,5
	DNMG 150608E-RM	●	●		●	●	●	●		●	●					0,8	0,20	0,48	1,0	4,5
	DNMG 150612E-RM	●	●		●	●	●	●			●					1,2	0,25	0,70	1,5	4,5
	DNMG 150616E-RM		●			●	●	●								1,6	0,30	0,75	2,0	4,5
	DNMG 110404EL-SI			●			●				●					0,4	0,20	0,24	0,8	3,3
	DNMG 110408EL-SI			●			●				●					0,8	0,20	0,48	0,8	3,3
	DNMG 150408EL-SI			●			●				●					0,8	0,20	0,48	0,8	4,5
	DNMG 150604EL-SI			●			●		●		●					0,4	0,20	0,24	0,8	4,5
	DNMG 150608EL-SI			●			●		●		●					0,8	0,20	0,48	0,8	4,5
	DNMG 110404ER-SI			●			●				●					0,4	0,20	0,24	0,8	3,3
	DNMG 110408ER-SI			●			●				●					0,8	0,20	0,48	0,8	3,3
	DNMG 150408ER-SI			●			●				●					0,8	0,20	0,48	0,8	4,5
	DNMG 150604ER-SI			●			●		●		●					0,4	0,20	0,24	0,8	4,5
	DNMG 150608ER-SI			●			●		●		●					0,8	0,20	0,48	0,8	4,5
	DNMG 150608W-MR					●	●									0,8	0,20	0,55	0,8	4,0
	DNMG 150612W-MR					●	●									1,2	0,20	0,60	1,2	4,0

SNMG



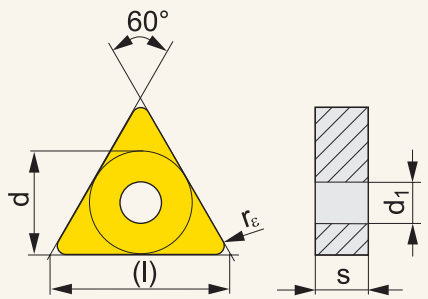
Dimensions	l	d	d_1	s
1204	12,700	12,700	5,16	4,76
1506	15,875	15,875	6,35	6,35
1906	19,050	19,050	7,94	6,35
2509	25,400	25,400	9,12	9,52

Chipbreaker	ISO	/ Grade														Radius	Feed/rev.		Depth of cut	
		T5305	T5315	T7335	T9310	T9315	T9325	T9335	6630	6640	T8315	T8330	HF7	TT310						
																r_ε	f_{min}	f_{max}	$a_{p\,min}$	$a_{p\,max}$
	SNMG 120404E-FM					●	●				●	●				0,4	0,10	0,30	0,5	3,0
	SNMG 120408E-FM				●	●	●				●	●		●		0,8	0,15	0,45	0,8	3,0
	SNMG 120412E-FM					●	●					●				1,2	0,15	0,45	1,2	3,0
	SNMG 120416E-FM					●	●					●				1,6	0,15	0,45	1,6	8,4
	SNMG 120408E-KR	●	●													0,8	0,20	0,50	0,8	7,0
	SNMG 120412E-KR	●	●													1,2	0,25	0,70	1,2	7,0
	SNMG 120408E-M	●	●		●	●	●	●	●							0,8	0,15	0,60	0,8	6,0
	SNMG 120412E-M					●	●	●								1,2	0,17	0,80	1,2	6,0
	SNMG 120416E-M					●	●	●								1,6	0,17	0,80	1,6	6,0
	SNMG 150612E-M					●	●	●	●							1,2	0,17	0,80	1,2	8,0
	SNMG 190612E-M					●	●	●	●							1,2	0,17	0,80	1,2	8,0
	SNMG 190616E-M					●	●	●								1,6	0,17	0,80	1,6	8,0
	SNMG 120404E-NF			●		●	●					●				0,4	0,13	0,30	0,4	3,0
	SNMG 120408E-NF			●		●	●				●	●	●			0,8	0,15	0,35	0,8	3,5
	SNMG 120408E-NM			●			●					●				0,8	0,20	0,50	0,8	3,0
	SNMG 120412E-NM			●			●									1,2	0,20	0,50	1,2	3,5
	SNMG 120408E-R	●					●	●	●	●						0,8	0,25	0,60	2,0	6,0
	SNMG 120412E-R	●					●	●	●							1,2	0,25	0,70	2,0	6,0
	SNMG 120416E-R						●									1,6	0,30	0,80	2,0	6,0
	SNMG 150612E-R	●					●									1,2	0,25	0,70	2,0	7,0
	SNMG 150616E-R						●									1,6	0,25	0,70	2,0	7,0
	SNMG 190612E-R						●		●	●						1,2	0,25	0,70	2,0	9,0
	SNMG 190616E-R						●		●							1,6	0,30	0,80	2,0	9,0
	SNMG 120408E-RM	●	●		●	●	●	●			●	●				0,8	0,20	0,50	1,0	7,0
	SNMG 120412E-RM	●	●		●	●	●	●								1,2	0,25	0,70	1,5	7,0
	SNMG 120416E-RM	●	●		●	●	●	●				●				1,6	0,30	0,75	2,0	7,0
	SNMG 150612E-RM	●	●		●	●	●	●								1,2	0,25	0,70	1,5	8,0
	SNMG 150616E-RM	●	●			●	●	●								1,6	0,30	0,80	2,0	8,0

● / Stock assortment ○ / Non-stock assortment / All dimensions [mm]
. / Actual assortment is given by the valid price list.

Chipbreaker	ISO	/ Grade															Radius	Feed/rev.		Depth of cut	
		T5305	T5315	T7335	T9310	T9315	T9325	T9335	6630	6640	T8315	T8330	HF7	TT310			r_ε	f_{min}	f_{max}	$a_{p\,min}$	$a_{p\,max}$
	SNMG 190612E-RM	●	●		●	●	●	●									1,2	0,25	0,70	1,5	10,0
	SNMG 190616E-RM	●	●		●	●	●	●									1,6	0,30	0,80	2,0	10,0
	SNMG 250924E-RM					●	●	●									2,4	0,40	1,20	2,4	15,0

TNMG



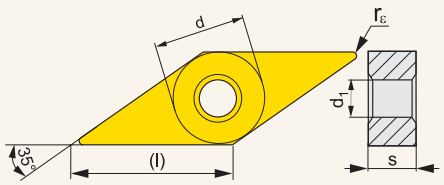
Dimensions	(l)	d	d_1	s		
1604	16,5	9,525	3,81	4,76		
2204	22,0	12,700	5,16	4,76		
2706	27,5	15,875	6,35	6,35		
3309	33,0	19,050	7,94	9,52		

Chipbreaker	ISO	/ Grade															Radius	Feed/rev.		Depth of cut	
		T5305	T5315	T7335	T9310	T9315	T9325	T9335	6630	T8315	T8330	HF7	TT310				r_ε	f_{min}	f_{max}	$a_{p\,min}$	$a_{p\,max}$
	TNMG 160404E-FF									●							0,4	0,06	0,20	0,4	1,5
	TNMG 160408E-FF									●							0,8	0,08	0,25	0,8	1,5
	TNMG 160404E-FM			●	●	●	●			●	●		●				0,4	0,10	0,24	0,5	3,0
	TNMG 160408E-FM			●	●	●	●			●	●		●				0,8	0,15	0,45	0,8	3,0
	TNMG 160412E-FM					●	●				●						1,2	0,15	0,45	1,2	3,0
	TNMG 160408E-KR	●	●														0,8	0,20	0,40	0,8	4,0
	TNMG 160404E-M		●			●	●	●									0,4	0,17	0,24	0,8	3,0
	TNMG 160408E-M	●	●		●	●	●	●	●								0,8	0,15	0,48	0,8	5,0
	TNMG 160412E-M		●			●	●	●									1,2	0,17	0,72	1,2	5,3
	TNMG 220408E-M	●	●		●	●	●	●	●								0,8	0,17	0,48	1,0	6,0
	TNMG 220412E-M	●	●			●	●	●	●								1,2	0,17	0,72	1,2	6,0
	TNMG 160404E-NF			●		●	●			●	●	●					0,4	0,13	0,24	0,4	3,0
	TNMG 160408E-NF			●		●	●			●	●	●					0,8	0,15	0,30	0,8	3,0
	TNMG 160404E-NM			●			●				●						0,4	0,15	0,24	0,5	3,0
	TNMG 160408E-NM			●			●				●						0,8	0,20	0,40	1,0	3,0
	TNMG 220408E-NM			●			●				●						0,8	0,20	0,40	1,0	3,5
	TNMG 220412E-NM			●			●										1,2	0,20	0,40	1,2	3,5
	TNMG 160408E-R					●	●	●									0,8	0,25	0,48	2,0	5,0
	TNMG 160412E-R						●	●									1,2	0,25	0,70	2,0	5,0
	TNMG 220408E-R						●										0,8	0,25	0,48	2,0	6,0
	TNMG 220412E-R						●										1,2	0,25	0,70	2,0	6,0
	TNMG 220416E-R						●										1,6	0,25	0,80	2,0	6,0
	TNMG 160408E-RM	●	●		●	●	●	●									0,8	0,20	0,48	1,0	5,3
	TNMG 160412E-RM	●	●			●	●	●			●						1,2	0,25	0,65	1,5	5,3
	TNMG 220408E-RM	●	●		●	●	●	●									0,8	0,20	0,48	1,0	7,0
	TNMG 220412E-RM	●	●		●	●	●	●									1,2	0,25	0,65	1,5	7,0

● / Stock assortment ○ / Non-stock assortment / All dimensions [mm]
. / Actual assortment is given by the valid price list.

Chipbreaker	ISO	/ Grade														Radius	Feed/rev.		Depth of cut	
		T5305	T5315	T7335	T9310	T9315	T9325	T9335	6630	T8315	T8330	HF7	TT1310			r_ε	f_{min}	f_{max}	$a_{p\,min}$	$a_{p\,max}$
	**TNMG 220416E-RM**	●	●			●	●	●								1,6	0,30	0,75	2,0	7,0
	TNMG 270616E-RM					●	●	●								1,6	0,35	0,75	2,0	8,9
	TNMG 270624E-RM						●	●								2,4	0,35	0,80	3,0	8,9
	TNMG 330924E-RM							●								2,4	0,45	0,90	3,0	10,9
	**TNMG 160404EL-SI**			●			●		●		●					0,4	0,20	0,24	0,8	5,0
	TNMG 160408EL-SI			●			●		●		●					0,8	0,20	0,48	0,8	5,0
	**TNMG 160404ER-SI**			●			●		●		●					0,4	0,20	0,24	0,8	5,0
	TNMG 160408ER-SI			●			●		●		●					0,8	0,20	0,48	0,8	5,0

VNMG

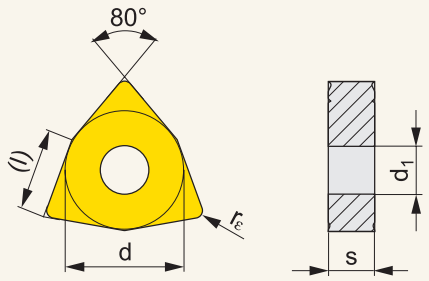


Dimensions	(l)	d	d_1	s		
1604	16,6	9,525	3,81	4,76		

Chipbreaker	ISO	/ Grade									Radius	Feed/rev.		Depth of cut	
		T5305	T5315	T7335	T9310	T9315	T9325	T9335	T8315	T8330	r_ε	f_{min}	f_{max}	$a_{p\,min}$	$a_{p\,max}$
	VNMG 160404E-FF								●		0,4	0,06	0,20	0,4	1,5
	VNMG 160404E-FM				●	●	●			●	0,4	0,10	0,20	0,5	3,0
	VNMG 160408E-FM				●	●	●			●	0,8	0,15	0,35	0,8	3,0
	VNMG 160412E-FM					●	●			●	1,2	0,15	0,45	1,2	3,0
	VNMG 160404E-M		●			●	●	●			0,4	0,12	0,20	0,8	3,0
	VNMG 160408E-M	●	●		●	●	●	●			0,8	0,15	0,40	0,8	3,0
	VNMG 160412E-M						●	●			1,2	0,17	0,60	1,2	4,0
	VNMG 160404E-NF			●		●	●		●	●	0,4	0,10	0,20	0,4	2,5
	VNMG 160408E-NF			●		●	●		●	●	0,8	0,13	0,30	0,8	3,0
	VNMG 160404E-NM			●			●			●	0,4	0,15	0,20	0,5	3,0
	VNMG 160408E-NM			●			●			●	0,8	0,20	0,40	0,8	3,0

● / Stock assortment ○ / Non-stock assortment / All dimensions [mm]
. / Actual assortment is given by the valid price list.

WNMG



Dimensions	(l)	d	d_1	s		
0604	6,5	9,525	3,81	4,76		
06T3	6,5	9,525	3,81	3,97		
0804	8,7	12,700	5,16	4,76		

Chipbreaker	ISO	/ Grade														Radius	Feed/rev.		Depth of cut	
		T5305	T5315	T7335	T9310	T9315	T9325	T9335	6630	T8315	T8330	HF7	TT310			r_ε	f_{min}	f_{max}	$a_{p\,min}$	$a_{p\,max}$
	WNMG 060402E-FF									●						0,2	0,06	0,15	0,2	1,5
	WNMG 060404E-FF									●						0,4	0,06	0,20	0,4	1,5
	WNMG 080404E-FF									●						0,4	0,06	0,20	0,4	1,5
	WNMG 080408E-FF									●						0,8	0,08	0,25	0,8	1,5
	WNMG 06T304E-FM						●				●					0,4	0,10	0,30	0,5	3,0
	WNMG 06T308E-FM						●				●					0,8	0,10	0,35	0,8	3,0
	WNMG 060404E-FM					●	●			●	●		●			0,4	0,10	0,30	0,5	3,0
	WNMG 060408E-FM					●	●				●		●			0,8	0,10	0,35	0,8	3,0
	WNMG 060412E-FM					●										1,2	0,15	0,45	1,2	3,0
	WNMG 080404E-FM			●	●	●	●			●	●					0,4	0,10	0,30	0,5	3,0
	WNMG 080408E-FM			●	●	●	●			●	●					0,8	0,15	0,45	0,8	3,0
	WNMG 080412E-FM			●	●	●	●				●					1,2	0,15	0,45	1,2	4,0
	WNMG 080412E-KR	●	●													1,2	0,25	0,60	1,2	5,5
	WNMG 060404E-M		●			●	●	●								0,4	0,17	0,30	0,8	3,0
	WNMG 060408E-M		●		●	●	●	●								0,8	0,15	0,60	0,8	4,0
	WNMG 080404E-M		●			●	●	●								0,4	0,17	0,30	0,8	3,0
	WNMG 080408E-M	●	●		●	●	●	●	●		●					0,8	0,15	0,60	0,8	5,6
	WNMG 080412E-M	●	●		●	●	●	●								1,2	0,17	0,80	1,2	5,6
	WNMG 060404E-NF			●		●	●			●	●					0,4	0,10	0,30	0,4	3,0
	WNMG 060408E-NF					●	●				●					0,8	0,13	0,30	0,8	3,0
	WNMG 080404E-NF			●		●	●			●	●	●				0,4	0,13	0,30	0,4	3,0
	WNMG 080408E-NF			●		●	●			●	●	●				0,8	0,15	0,35	0,8	3,5
	WNMG 080412E-NF			●		●	●				●					1,2	0,15	0,35	1,2	4,0
	WNMG 060404E-NM			●			●				●					0,4	0,15	0,30	0,5	3,0
	WNMG 060408E-NM			●			●				●					0,8	0,20	0,40	0,8	3,0
	WNMG 060412E-NM			●			●									1,2	0,20	0,50	1,2	3,5
	WNMG 080404E-NM			●			●				●					0,4	0,15	0,30	0,5	3,0

Chipbreaker	ISO	/ Grade														Radius	Feed/rev.		Depth of cut	
		T5305	T5315	T7335	T9310	T9315	T9325	T9335	6630	T8315	T8330	HF7	TT310			r_ε	f_{min}	f_{max}	$a_{p\,min}$	$a_{p\,max}$
	WNMG 080408E-NM			●			●				●					0,8	0,20	0,50	0,8	3,0
	WNMG 080412E-NM			●			●									1,2	0,20	0,50	1,2	3,5
	WNMG 080408E-R	●				●	●	●	●							0,8	0,25	0,60	2,0	5,6
	WNMG 080412E-R	●				●	●									1,2	0,25	0,70	2,0	5,6
	WNMG 060412E-RM					●	●	●								1,2	0,25	0,60	1,3	4,0
	WNMG 080408E-RM	●	●		●	●	●	●		●	●					0,8	0,20	0,55	1,0	5,0
	WNMG 080412E-RM	●	●		●	●	●	●		●						1,2	0,25	0,70	1,5	5,0
	WNMG 080416E-RM	●	●		●	●	●	●			●					1,6	0,30	0,75	2,0	5,0
	WNMG 060404EL-SI						●				●					0,4	0,20	0,30	0,8	4,2
	WNMG 080404EL-SI						●				●					0,4	0,20	0,30	0,8	5,0
	WNMG 080408EL-SI						●				●					0,8	0,20	0,50	0,8	5,0
	WNMG 060404ER-SI						●				●					0,4	0,20	0,30	0,8	4,2
	WNMG 080404ER-SI						●				●					0,4	0,20	0,30	0,8	5,0
	WNMG 080408ER-SI						●				●					0,8	0,20	0,50	0,8	5,0
	WNMG 060408W-F					●	●									0,8	0,15	0,60	0,8	4,2
	WNMG 080404W-F					●	●									0,4	0,15	0,30	0,4	4,4
	WNMG 060408W-M				●	●	●									0,8	0,15	0,60	0,8	3,0
	WNMG 060412W-M		●			●	●									1,2	0,20	0,90	1,2	3,0
	WNMG 080408W-M					●	●									0,8	0,15	0,60	0,8	4,0
	WNMG 080412W-M		●			●	●									1,2	0,20	0,90	1,2	4,0
	WNMG 060408W-MR					●	●									0,8	0,20	0,70	0,8	3,0
	WNMG 080404W-MR					●	●									0,4	0,20	0,60	0,5	4,0
	WNMG 080408W-MR		●			●	●									0,8	0,20	0,70	0,8	4,0
	WNMG 080412W-MR		●			●	●									1,2	0,25	0,75	1,2	4,0

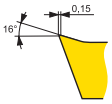
TECHNICAL SECTION

GEOMETRY OF CUTTING INSERTS FOR MILLING

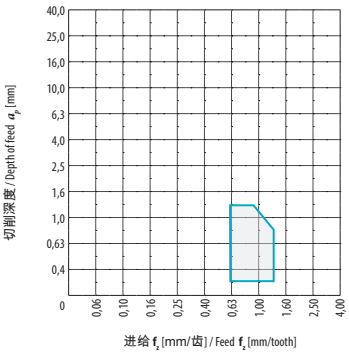
ADEX 16-HF

Geometry | Photo | Workpiece material group (Frézování / Milling: P M K N S H) | Application diagram | Description | / Aplied to inserts: **ADEX 160612SR-HF**

Profile of cutting edge



Finishing ■ ■ ■
Medium ■ ◪ ■
Roughing ◪ □ ◪



- Special geometry for HFC technologies
- Suitable for machining of material groups P, M, K
- Mainly suited for light to medium machining

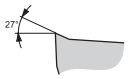
/ Range of cutting conditions:

f_z	0,6 ÷ 1,3 [ ] / [mm/tooth]
a_p	0,25 ÷ 1,3 [mm]

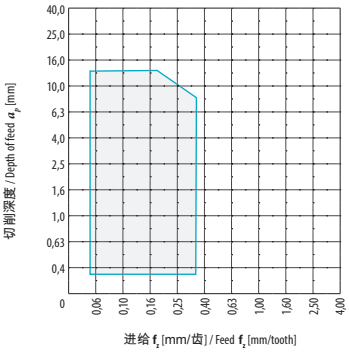
ADEX 16-FA

Geometry | Photo | Workpiece material group (Frézování / Milling: P M K N S H) | Application diagram | Description | / Aplied to inserts: **ADEX 160604FR-FA, ADEX 160608FR-FA, ADEX 160616FR-FA, ADEX 160630FR-FA**

Profile of cutting edge



Finishing ■
Medium ■
Roughing ■



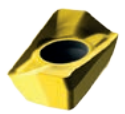
- Highly positive geometry with a sharp cutting edge
- The main area of application is turning of material group N
- Polished face of the cutting insert to reduce sticking of the machined material
- Available in radii 04; 08; 16 and 30

/ Range of cutting conditions:

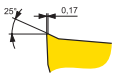
f_z	0,05 ÷ 0,35 [ ] / [mm/tooth]
a_p	0,3 ÷ 13,0 [mm]

ADMX 16-M

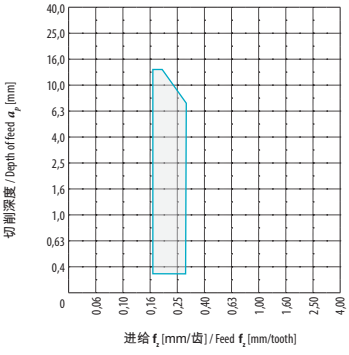
Geometry | Photo | Workpiece material group (Frézování / Milling: P M K N S H) | Application diagram | Description | / Aplied to inserts: **ADMX 160604SR-M, ADMX 160608SR-M, ADMX 160616SR-M, ADMX 160620SR-M, ADMX 160630SR-M, ADMX 160632SR-M, ADMX 160640SR-M, ADMX 160650SR-M**



Profile of cutting edge



Finishing ■ ■ ■ ◪
Medium ■ ■ ■ □
Roughing ◪ ◪ ◪ □



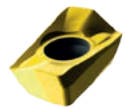
- Highly positive geometry with a central peripheral land
- Suitable for machining of material groups P, M, K and S
- Mainly suited for light to medium machining
- Available in radii 04; 08; 16; 20; 30; 32; 40 and 50

/ Range of cutting conditions:

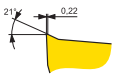
f_z	0,17 ÷ 0,30 [mm/齿] / [mm/tooth]
a_p	0,3 ÷ 13,0 [mm]

ADMX16-R

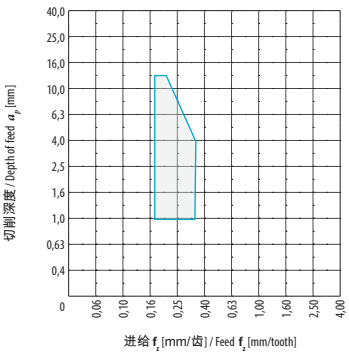
Geometry | Photo | Workpiece material group (Frézování / Milling: P M K N S H) | Application diagram | Description | / Aplied to inserts: **ADMX 160608PR-R, ADMX 160616PR-R**



Profil hlavního břitu
Profil hlavného ostria



Finishing ■ ◪ ■ ◪ ◪
Medium ■ ◪ ■ □ ◪
Roughing ■ ◪ ■ □



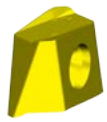
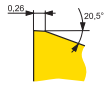
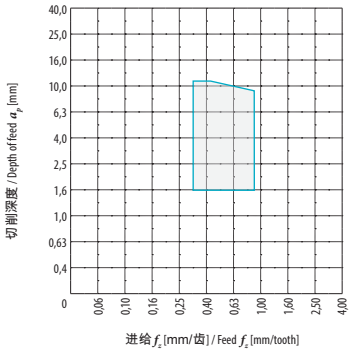
- Positive geometry with a double peripheral chamfered edge
- Suitable for machining material groups P, M, K, and also S and H
- Geometry also suited to medium and heavier machining conditions
- Available in radii 08 and 16

进给 / Range of cutting conditions:

f_z	0,17 ÷ 0,35 [mm/]
a_p	0,8 ÷ 13,0 [mm]

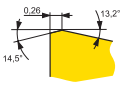
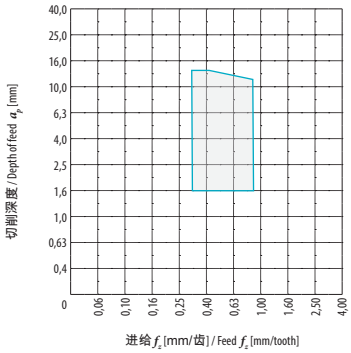
■ / Main application ◪ / Other applications □ / Conditional application

GEOMETRY OF CUTTING INSERTS FOR MILLING

Geometry	Photo	Workpiece material group (Frézování / Milling) P M K N S H	Application diagram	Description	/ Aplied to inserts: LNEX 1513DPSR-M
LNEX 15-M	 Profile of cutting edge 	Finishing: P ■ M ■ K ■ N ■ S H Medium: P ■ M ■ K ■ N ■ S H Roughing: P ■ M ■ K ■ N ■ S H		- Positive cutting geometry with a stable cutting edge - Semi-roughing to heavy roughing milling operations - Main area of application - machining of material groups K and P - Especially suited for medium to heavy cutting conditions	

进给 / Range of cutting conditions:

f_z	0,3 ÷ 0,7 [ ] / [mm/tooth] steel 0,3 ÷ 0,9 [ ] / [mm/tooth] cast iron	
a_p	1,6 ÷ 12,0 [mm]	

Geometry	Photo	Workpiece material group (Frézování / Milling) P M K N S H	Application diagram	Description	/ Aplied to inserts: LNEX 1513DPSR-KR
LNEX 15-KR	 Profile of cutting edge 	Finishing: P ■ M ■ K ■ N ■ S H Medium: P ◪ M ■ K ■ N ■ S H Roughing: P ◪ M ■ K ■ N ■ S H		- Stable cutting geometry with a negative peripheral land - Semi-roughing to heavy roughing milling operations - Main area of application - machining of material groups K - Another area of application - machining of material groups P - Especially suited for heavy to medium cutting conditions	

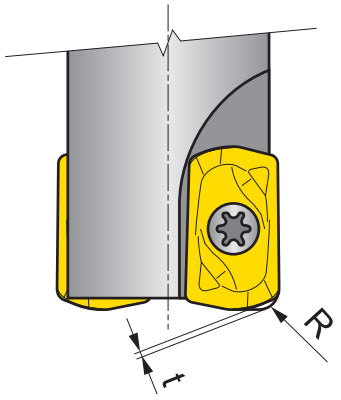
进给 / Range of cutting conditions:

f_z	0,3 ÷ 0,7 [ ] pro ocel / [mm/tooth] steel 0,3 ÷ 0,9 [ ] pro litinu / [mm/tooth] cast iron	
a_p	1,6 ÷12,0 [mm]	

TECHNICAL INFORMATION

ADEX 16-HF

INFORMATION FOR CNC PROGRAMMING



Insert	R [mm]	t [mm]
ADEX 160612SR-HF	2,59	0,56

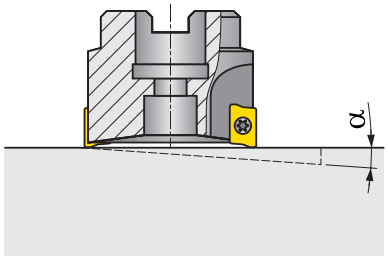
■ / Main application ◪ / Other applications □ / Conditional application

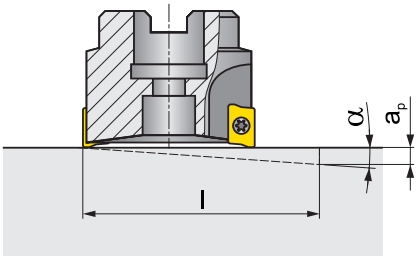
PRAMET

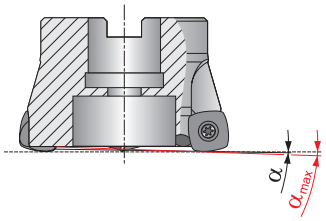
ADEX 16-HF

RAMPING

SHELL CUTTER BODIES

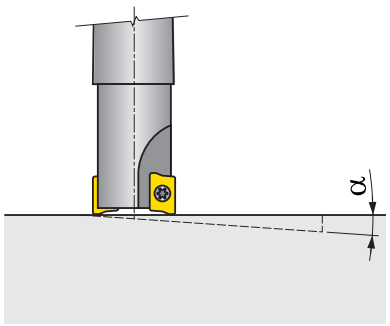


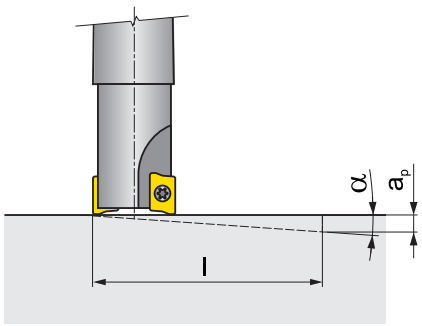


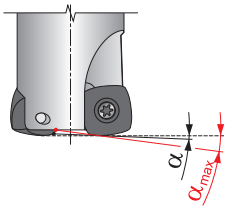


TOOL	Insert	Diameter of cutter [mm]	α_{max} [°]	a_p/l [mm]
S90AD16E	ADEX 160612SR-HF	40	1,2** (4,5)*	1,3/65
		50	0,8** (3,0)*	1,3/100
		63	0,5** (2,0)*	0,8/100
		80	0,4** (1,5)*	0,6/100

SHANK TOOLS







TOOL	Insert	Diameter of cutter [mm]	α_{max} [°]	a_p/l [mm]
SAD16E	ADEX 160612SR-HF	25	4,0** (8,0)*	1,3/19
		32	2,0** (7,5)*	1,3/38
		40	1,2** (4,5)*	1,3/65

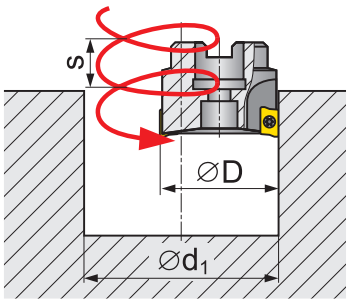
*) / Valid for conventional milling

**) / Valid for high feed milling

ADEX 16-HF

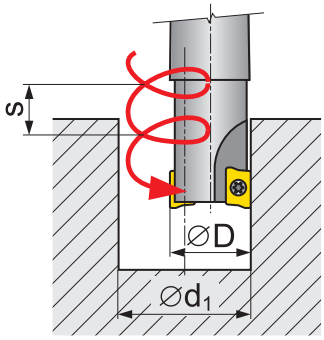
MILLING BY HELICAL INTERPOLATION

SHELL CUTTER BODIES



TOOL	Insert	Diameter of cutter	d_{min}	d_{max}	S_{max}
		[mm]			
S90AD16E	ADEX 160612SR-HF	40	72	–	1,3
			–	78	1,3
		50	92	–	1,3
			–	98	1,3
		63	118	–	1,3
			–	124	1,3
		80	136	–	1,3
			–	158	1,3

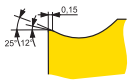
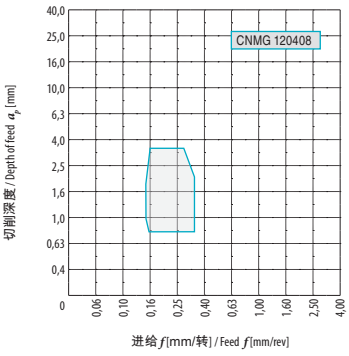
SHANK TOOLS



TOOL	Insert	Diameter of cutter	d_{min}	d_{max}	S_{max}
		[mm]			
SAD16E	ADEX 160612SR-HF	25	42	–	1,3
			–	48	1,3
		32	55	–	1,3
			–	62	1,3
		40	72	–	1,3
			–	78	1,3

GEOMETRY OF CUTTING INSERTS FOR TURNING

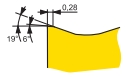
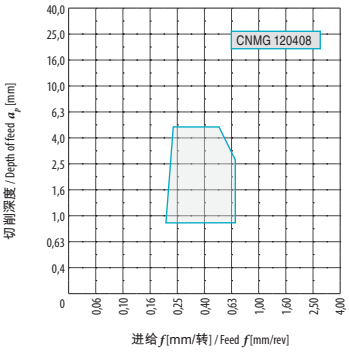
NF

Chipbreaker	Photo	Workpiece material group (Soustružení Turning)	Application diagram	Description	/ Aplied to inserts:
NF	 Profile of cutting edge 	P M K N S H Finishing ■ ■ □ ◪ Medium ■ ■ □ ◪ Roughing		- Finishing and medium turning operations - Main area of application - machining of material groups M and P (low carbon steels) - Another area of application - machining of material groups S - Conditional application - machining of material groups N - Continual cut	CNMG, DNMG, SNMG, TNMG, WNMG, VNMG

/ Range of cutting conditions:

f	0,1 ÷ 0,35 [mm/] / [mm/rev]
a_p	0,4 ÷ 4,0 [mm]

W-MR

Chipbreaker	Photo	Workpiece material group (Soustružení Turning)	Application diagram	Description	/ Aplied to inserts:
W-MR	 Profile of cutting edge 	P M K N S H Finishing ■ ■ ■ Medium ■ ■ ■ Roughing ■ ■ ■		- Positive cutting geometry - Semi-roughing to finishing turning operations - WIPER geometry for high productive turning - Main area of application - machining of material groups P, M and K materials - Continual and slightly interrupted cut	CNMG, WNMG, DNMG

/ Range of cutting conditions:

f	0,2 ÷ 0,75 [mm/] / [mm/rev]
a_p	0,5 ÷ 5,0 [mm]

■ / Main application ◪ / Other applications □ / Conditional application

NOTES

NOTES

SIMPLY RELIABLE

As a professional you can judge the quality of work by just looking at the chip. Our chip is a clean and uncomplicated shape that in itself tells a story. It is a clear and consistent signal and that's why we use it as a symbol for being **simply reliable**.

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