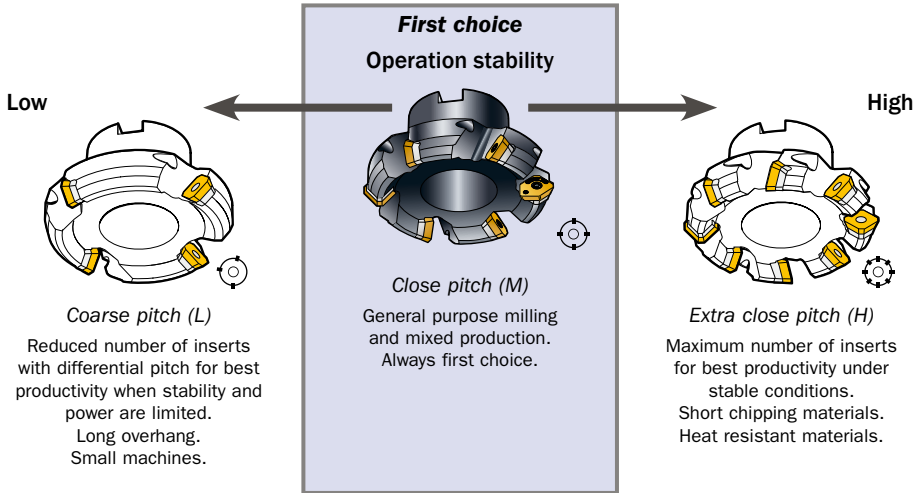
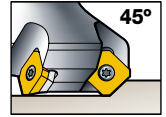
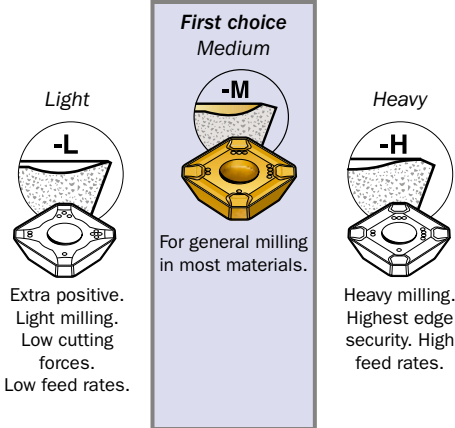


Face milling – CoroMill® 245

The allround cutter - from heavy to light milling



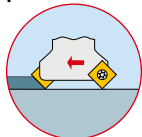
Insert geometry



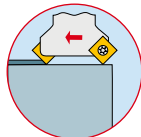
Workpiece material/Geometry

| ISO/ANSI | L | M | H | Wiper |
|-------------------------|----------|---|---|-------|
| Steel | P | | | |
| Stainless steel | M | | | |
| Cast iron | K | | | |
| Non-ferrous material | N | | | |
| Heat resistant material | S | | | |
| Hardened material | H | | | |

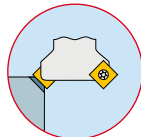
Operations:



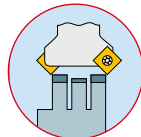
General face milling



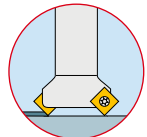
Face milling to mirror finish



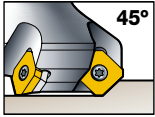
Chamfering (true 45° angle)



Intermittent machining



Long overhang



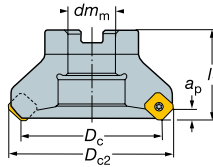
45°

Face milling – CoroMill® 245

Diameter 50 – 250 mm



Max cutting depth (a_p)
insert size 12 = 6 mm
insert size 18 = 10 mm



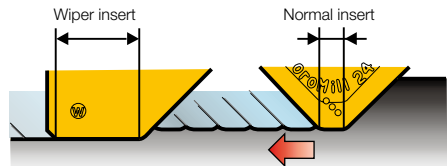
| D_c | Ordering code | | Ordering code | | Ordering code | | Dimensions. mm | | | | |
|-------|----------------------------------|----|---------------------------------|----|---------------------------------------|----|----------------|----------|-------|-----------|----|
| | Coarse pitch (L) Differential | | Close pitch (M) Even | | Extra close pitch (H) Even | | dm_m | D_{c2} | l_1 | n_{max} | |
| 50 | R245-050Q22-12L | 3 | R245-050Q22-12M | 4 | R245-050Q22-12H | 5 | 22 | 62.5 | 40 | 16250 | 12 |
| 63 | 063Q22-12L | 4 | 063Q22-12M | 5 | 063Q22-12H | 6 | 22 | 75.5 | 40 | 14400 | |
| 80 | 080Q27-12L | 4 | 080Q27-12M | 6 | 080Q27-12H | 8 | 27 | 92.5 | 50 | 12700 | |
| 100 | 100Q32-12L | 5 | 100Q32-12M | 7 | 100Q32-12H | 10 | 32 | 112.5 | 50 | 11300 | |
| 125 | 125Q40-12L | 6 | 125Q40-12M | 8 | 125Q40-12H | 12 | 40 | 137.5 | 63 | 10100 | |
| 160 | 160Q40-12L | 7 | 160Q40-12M | 10 | 160Q40-12H | 16 | 40 | 172.5 | 63 | 8900 | |
| 200 | 200Q60-12L | 8 | 200Q60-12M | 12 | 200Q60-12H | 20 | 60 | 212.5 | 63 | 7950 | |
| 250 | 250Q60-12L | 10 | 250Q60-12M | 14 | 250Q60-12H | 24 | 60 | 262.5 | 63 | 7100 | |
| D_c | | | Close pitch (M) Differential | | Extra close pitch (H) Differential | | dm_m | D_{c2} | l_1 | n_{max} | 18 |
| 80 | – | | R245-080Q32-18M | 4 | R245-080Q32-18H | 5 | 32 | 98.8 | 50 | 6100 | |
| 100 | – | | 100Q32-18M | 4 | 100Q32-18H | 6 | 32 | 118.8 | 50 | 5400 | |
| 125 | – | | 125Q40-18M | 5 | 125Q40-18H | 7 | 40 | 138.8 | 63 | 4900 | |
| 160 | – | | 160Q40-18M | 6 | 160Q40-18H | 9 | 40 | 178.8 | 63 | 4300 | |
| 200 | – | | 200Q60-18M | 8 | 200Q60-18H | 12 | 60 | 218.8 | 63 | 3800 | |
| 250 | – | | 250Q60-18M | 10 | 250Q60-18H | 14 | 60 | 268.8 | 63 | 3400 | |

Ordering example: 2 pcs R245-050Q22-12M

Wiper insert



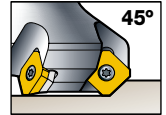
A wiper insert will improve surface finish at high feed rates and the long parallel land of the insert allows increased feed per revolution by up to four times the normal feed, still maintaining surface quality. It is normally enough to use only one wiper insert in the cutter.



| | |
|----------|----------|
| P | N |
| M | S |
| K | H |

Face milling – CoroMill® 245

Inserts and grades –
cutting data recommendations – starting values



| ISO/ANSI | L = Light M = Medium H = Heavy | GOOD CONDITIONS | | | First choice AVERAGE CONDITIONS | | | DIFFICULT CONDITIONS | | |
|----------|--------------------------------------|--------------------|-------|---------------------------|------------------------------------|-------------|--------------------|----------------------|-------|-------|
| | | | | | | | | | | |
| P | L/M/H | Ordering code | v_c | f_z | Ordering code | v_c | f_z | Ordering code | v_c | f_z |
| | L | R245-12T3E-PL 530 | 305 | 0.11 | R245-12T3E-PL 4230 | 275 | 0.14 | R245-12T3M-PL 4240 | 225 | 0.17 |
| | M | R245-12T3M-PM 4020 | 290 | 0.24 | R245-12T3M-PM 4230 | 250 | 0.21 | R245-12T3M-PM 4240 | 225 | 0.24 |
| | | R245-18T6M-PM 4020 | 275 | 0.28 | R245-18T6M-PM 4230 | 225 | 0.28 | R245-18T6M-PM 4240 | 190 | 0.28 |
| H | R245-12T3M-PH 4020 | 250 | 0.35 | R245-12T3M-PH 4230 | 205 | 0.35 | R245-12T3M-PH 4240 | 175 | 0.35 | |
| M | L/M/H | Ordering code | v_c | f_z | Ordering code | v_c | f_z | Ordering code | v_c | f_z |
| | L | R245-12T3E-ML 1025 | 295 | 0.08 | R245-12T3E-ML 2030 | 230 | 0.14 | R245-12T3E-ML 2040 | 220 | 0.14 |
| | M/H | R245-12T3K-MM 2030 | 200 | 0.23 | R245-12T3K-MM 2030 | 200 | 0.23 | R245-12T3K-MM 2040 | 190 | 0.23 |
| | | R245-18T6M-MM 2030 | 185 | 0.28 | R245-18T6M-MM 2040 | 175 | 0.28 | R245-18T6M-MM 2040 | 175 | 0.28 |
| K | L/M/H | Ordering code | v_c | f_z | Ordering code | v_c | f_z | Ordering code | v_c | f_z |
| | L | R245-12T3E-KL 3220 | 255 | 0.14 | R245-12T3M-KL 3220 | 215 | 0.17 | R245-12T3M-KL 1020 | 230 | 0.18 |
| | M | R245-12T3M-KM 3220 | 225 | 0.24 | R245-12T3M-KM K20W | 185 | 0.24 | R245-12T3M-KM 1020 | 210 | 0.24 |
| | | R245-18T6M-KM K20W | 175 | 0.28 | R245-18T6M-KM 1020 | 200 | 0.28 | R245-18T6M-KM 1020 | 200 | 0.28 |
| H | R245-12T3M-KH 3220 | 190 | 0.35 | R245-12T3M-KH K20W | 160 | 0.35 | R245-12T3M-KH 1020 | 180 | 0.35 | |
| N | L/M/H | Ordering code | v_c | f_z | Ordering code | v_c | f_z | Ordering code | v_c | f_z |
| | L | R245-12T3E CD10 | 1695 | 0.14 | R245-12T3E-AL H10 | 760 | 0.24 | R245-12T3E-KL H13A | 700 | 0.11 |
| | M/H | R245-12T3E CD10 | 1695 | 0.14 | R245-12T3E-AL H10 | 760 | 0.24 | R245-12T3M-KM H13A | 610 | 0.24 |
| S | L/M/H | Ordering code | v_c | f_z | Ordering code | v_c | f_z | Ordering code | v_c | f_z |
| | L | R245-12T3E-ML 1025 | 40 | 0.08 | R245-12T3E-ML 2030 | 35 | 0.14 | R245-12T3E-ML 2040 | 35 | 0.14 |
| | M/H | R245-12T3E-ML 2030 | 35 | 0.14 | R245-12T3K-MM 2030 | 30 | 0.23 | R245-12T3K-MM 2040 | 30 | 0.23 |
| H | L/M/H | Ordering code | v_c | f_z | Ordering code | v_c | f_z | Ordering code | v_c | f_z |
| | L | R245-12T3E CB50 | 145 | 0.14 | R245-12T3E-PL 1025 | 40 | 0.08 | R245-12T3M-KM 3040 | 35 | 0.24 |
| | M/H | R245-12T3E CB50 | 145 | 0.14 | R245-12T3M-PM 4020 | 45 | 0.24 | R245-12T3M-KH 3040 | 30 | 0.35 |