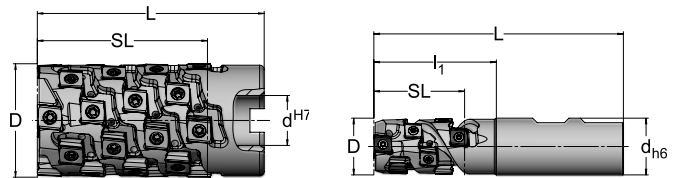


SHELL END MILLS **CW90****NEWT**ool

Fine tooth pitch thanks to tangential insert design  
Soft cutting tool  
Extremely smooth running thanks to the division of the cut



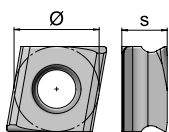
CW90 Shank end mills										
Article	D	d <sub>h6</sub>	L	I <sub>1</sub>	SL	zz	z <sub>eff</sub>	lc	kg	INS
02C.2511.001	25	25	110	54	40.0	12	2	yes	0.37	CN..07T3.L
02C.3212.001	32	25	126	70	54.0	24	3	yes	0.54	CN..07T3.L
02C.4014.001	40	32	140	73	60.0	27	3	yes	1.02	CN..07T3.L

CW90 Plug-in milling cutters										
Article	D	d <sup>H7</sup>	L	SL	zz	z <sub>eff</sub>	lc	kg	INS	
02C.5075.001	50	22	75	47,5	20	4	ja	0,95	CN..1005.L	
02C.5010.001	50	22	100	75	32	4	ja	1,45	CN..1005.L	
02C.6310.001	63	32	100	66	28	4	ja	1,90	CN..1005.L	
02C.6313.001	63	32	130	94,5	40	4	ja	2,50	CN..1005.L	
02C.8009.001	80	32	90	66	35	4	ja	2,85	CN..1005.L	
02C.8011.001	80	32	110	85	45	5	ja	3,55	CN..1005.L	

Use the multiring systems for length ratios of more than 1.5 x D

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

## INS SHAPE CN



		CN			
AS	Ø	s			
4	07	10	T3	05	
	7.5	10.4	4	5.6	

Matching of machining parameters  
with the AV material groups

				Steel						
Article		Designation		A22	A21	A20	A19	A18	A17	A16
CN..07T3..	CN.07T3.008.11 SKY77	CNHQ 07T306 SL-28W	$h_{max}$	0.15	0.15	0.15	0.13	0.12	0.12	0.10
			$v_c$	220-280	200-260	180-240	180-210	140-180	110-140	80-110
	CN.07T3.008.11 AV1055	CNHQ 07T306 SL-28W	$h_{max}$	-	-	-	-	-	0.12	0.10
			$v_c$	-	-	-	-	-	110-140	80-110
CN..1005..	CN.1005.002.01 SKY77	CNHQ 100510 SL-25V	$h_{max}$	0.25	0.23	0.20	0.20	0.14	0.14	0.12
			$v_c$	220-280	200-260	180-240	180-210	140-180	110-140	80-110
	CN.1005.002.02 SKY77	CNHQ 100510 SL-28V	$h_{max}$	0.22	0.20	0.18	0.18	0.12	0.12	0.10
			$v_c$	220-280	200-260	180-240	180-210	140-180	110-140	80-110
	CN.1005.002.02 AV1077	CNHQ 100510 SL-28V	$h_{max}$	-	-	-	0.20	0.14	0.14	0.12
			$v_c$	-	-	-	190-230	160-200	130-160	80-130

				Cast iron					
Article		Designation		D21	D20	D19	D18	D17	D16
CN..07T3..	CN.07T3.008.11 SKY77	CNHQ 07T306 SL-28W	$h_{max}$	0.16	0.16	0.15	0.12	0.12	0.11
			$v_c$	220-280	200-240	170-200	150-190	120-160	120-150
	CN.07T3.008.11 NERO <sup>2</sup> 77	CNHQ 07T306 SL-28W	$h_{max}$	0.16	0.16	0.13	0.13	0.12	0.10
			$v_c$	340-380	280-340	240-280	210-240	180-210	140-180
CN..1005..	CN.1005.002.01 SKY77	CNHQ 100510 SL-25V	$h_{max}$	0.25	0.25	0.20	0.15	0.14	0.11
			$v_c$	220-280	200-240	170-200	150-190	120-160	120-150
	CN.1005.002.01 CAN <sup>2</sup> 77	CNHQ 100510 SL-25V	$h_{max}$	0.25	0.25	0.20	0.15	0.14	0.11
			$v_c$	340-380	280-340	240-280	210-240	180-210	140-180
	CN.1005.002.02 SKY77	CNHQ 100510 SL-28V	$h_{max}$	0.25	0.25	0.20	0.16	0.16	0.13
			$v_c$	220-280	200-240	170-200	150-190	120-160	120-150

				Stainless steels				NF metals		
Article		Designation		C12	C11	C10	C09	E82	E81	E80
CN..07T3..	CN.07T3.008.11 SKY77	CNHQ 07T306 SL-28W	$h_{max}$	0.11	0.10	-	-	0.22	0.18	0.15
			$v_c$	120-200	100-170	-	-	650-1000	450-650	280-450
	CN.07T3.008.11 AV1055	CNHQ 07T306 SL-28W	$h_{max}$	0.11	0.10	0.08	0.08	-	-	-
			$v_c$	120-220	100-170	90-120	60-100	-	-	-
CN..1005..	CN.1005.002.02 SKY77	CNHQ 100510 SL-28V	$h_{max}$	-	-	-	-	0.28	0.22	0.18
			$v_c$	-	-	-	-	650-1000	450-650	280-450
	CN.1005.002.02 AV1077	CNHQ 100510 SL-28V	$h_{max}$	0.18	0.15	-	-	-	-	-
			$v_c$	120-200	140-170	-	-	-	-	-

Parameters vibration-/surface-dependent