

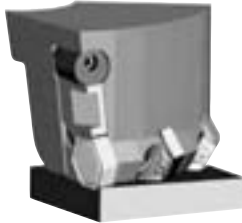
SOLID CARBIDE

INSERTS



45° HexaCut milling cutter

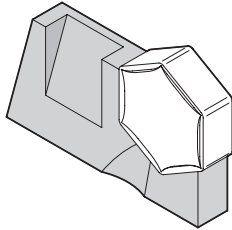
FACE MILLS



30° HexaCut milling cutter

90° MILLS

SLOTTING

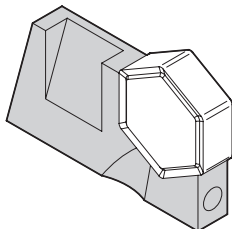


See 1.

catalog number right-hand 1 274 85 002 00  
 catalog number left-hand 1 274 85 001 00

DIE AND MOLD

CERAMIC MILLS

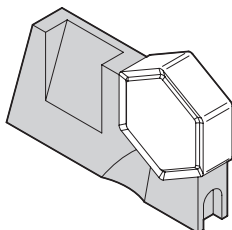


See 2.

catalog number right-hand 1 274 85 004 00  
 catalog number left-hand 1 274 85 003 00

CLASSIC MILLS

THREAD MILLS



See 3.

catalog number right-hand 1 274 85 034 00  
 catalog number left-hand 1 274 85 035 00

TECHNICAL DATA

INDEX

## Roughing face mill

For a cutting depth of  $\leq .256$  (6,5 mm) and an achievable surface finish of  $RA > 125$ .

Roughing indexable insert:  
 HNGX 090516-MR, HNGX 090508-MH, HNGX 090520-MM, HNGX 090520-ML

### 1. Roughing face mill with roughing anvil (not marked)

For a cutting depth of  $< .315$  (8 mm) and an achievable surface finish of  $RA > 125$ .

Roughing insert: HNGX 090516-MR, HNGX 090508-MH, HNGX 090520-MM, HNGX 090520-ML in all insert seats

### 2. Face mill for roughing/finishing with finishing anvil (marked ●)

a) For a cutting depth of  $< .315$  (8 mm) and an achievable surface finish of  $RA 125$ .

Roughing insert: HNGX 090516-MR, HNGX 090508-MH, HNGX 090520-MM, HNGX 090520-ML in the fixed insert seats

Roughing/finishing insert: HNGF 090504-MT in the finishing anvil

b) For a cutting depth of  $< .040$  (1 mm) and an achievable surface finish of  $RA 63$ .

Roughing insert: HNGX 090504-MM, HNGX 090520-MM, HNGX 090520-ML in the fixed insert seats

Finishing insert: HNGF 090504-MF in the finishing anvil

### 3. Face mill for roughing/finishing using finishing anvil with corrected straight cutting edge position to reduce axial force (marked ■)

a) For a cutting depth of  $< .315$  (8 mm) and an achievable surface finish of  $RA 125$ .

Use roughing insert: HNGX 090516-MR, HNGX 090508-MH, HNGX 090520-MM, HNGX 090520-ML in the fixed insert seats.

Use roughing/finishing insert: HNGF 090504-MT in the finishing anvil.

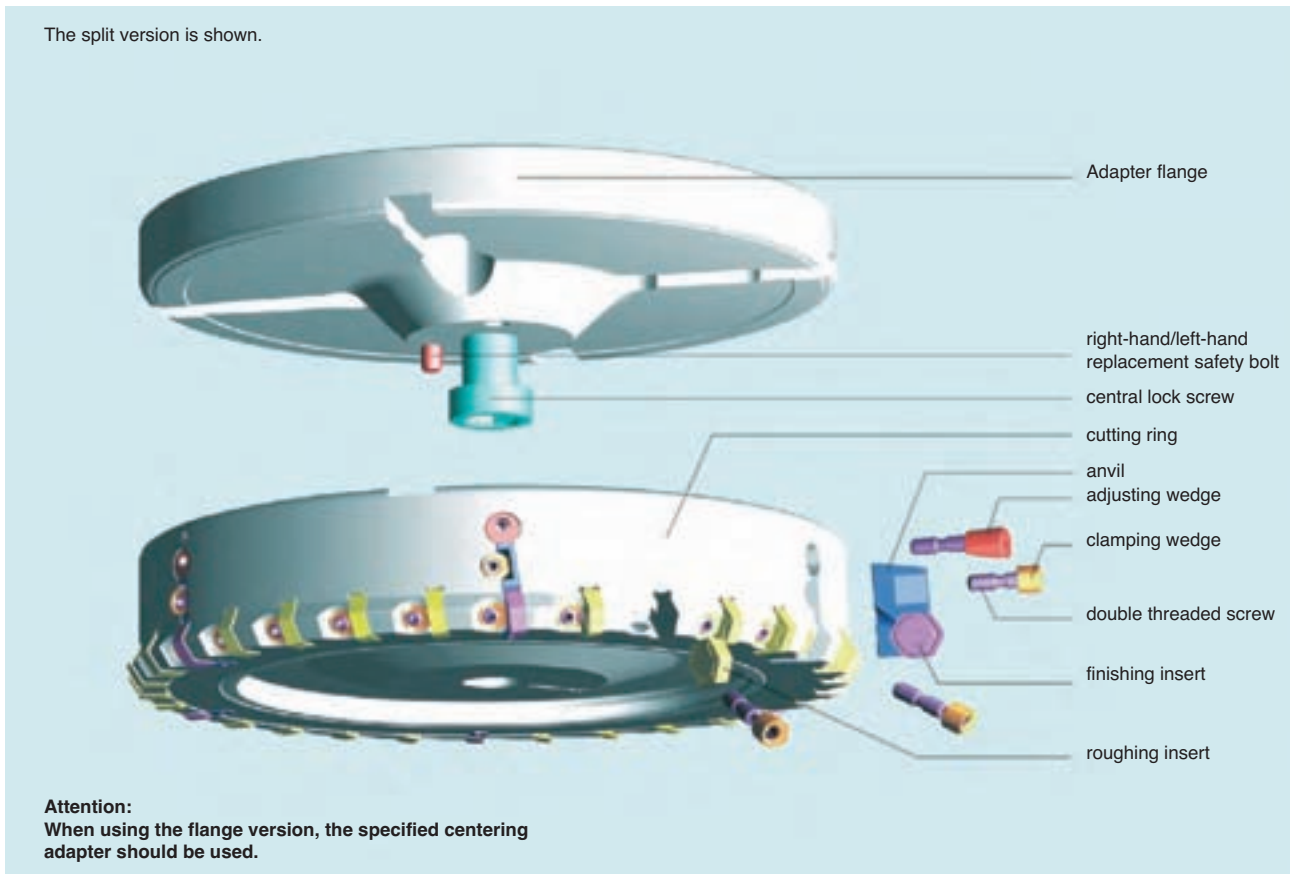
b) For a cutting depth of  $< .040$  (1 mm) and an achievable surface finish of  $RA 63$ . Use roughing insert: HNGX 090504-MM, HNGX 090520-MM, HNGX 090520-ML in the fixed insert seats.

Use finishing insert: HNGF 090504-MF in the finishing anvil.

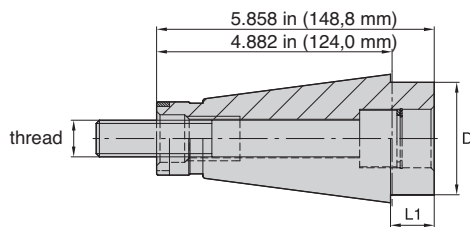
Note regarding 2 and 3. Loading order is always four roughing inserts and one finishing insert, which is inserted axially  $\approx .0015$  (0,03 mm) in front of the roughing inserts.

Recommended combination of standard indexable inserts and geometries			▼ = Roughing indexable insert				▼▼ = Finishing indexable insert		
Operation	κr	ap max	HNGX 090516 -MR 222.78.316 Z = 12	HNGX 090508 -MH 222.78.208 Z = 12	HNGX 090520 -ML 222.78.460 Z = 12	HNGX 090520 -MM 222.78.260 Z = 12	HNGX 090504 -MM 222.78.254 Z = 12	HNGF 090504 -MT 222.78.154 Z = 6+6	HNGF 090504 -MF 222.78.104 Z = 12
▼	45°	6	■	OR	■	OR	■		
▼▼	30°	8	■	OR	■	OR	■		
▼▼▼	30°	1			■	OR	■	OR	■
▼/▼▼	30°	8	■	OR	■	OR	■	OR	■

NOTE: Z = number of cutting edges



### Centering plug



D	catalog number	L1	taper
60	1 229 75 290 00	22 mm	50
2,5	50CP40A	1.00"	50