

DORMER PRAMET

VÄNDSKÄRSFRÄSNING

2024



PRAMET

VÄNSKÄRSFRÄSNING – ALLMÄNT INNEHÅLL

VÄNSKÄRSFRÄSNING	Planfräsning	Negativa vändskär	SON06C	SHN06C	SHN09C	SPN13			7	
		Positiva fyrkantiga skär	SSD13F	SSE09	SSN12Z	FSB22X			25	
		Positiva åttkantiga och runda skär	SOD05	SOD06D	SOE06Z				41	
	Hörnfräsning	Negativa vändskär	STN10	STN16	SLN12	SLN16	SLN12X			65
		Positiva parallelogram (A-form) skär	SAD07D	SAD11E	SAD16E	SAP10D	SAP16D			89
		Positiva fyrkant – och trekantsvändskär	SSO09	SSD12	FTB27X					121
	Fräsning av höga kanter	Spiralformade fräsar	J(T)-SAD11E	J(T)-SAD16E	J(T)-SSAP	J(T)-CSD12X	J(T)-SLSN			133
	Kopierfräsning (knappfräsar)	Runt skärläge (RD.. insatser med 15° flank)	SRD05	SRD07	SRD10	SRD12	SRD16			159
		Skärläge med lokaliseringsplan (RC.. skär med 7° flank)	SRC10	SRC12	SRC16	SRC20				185
	Profilfräsning	Fullradie	L2-SZP	K2-SRC	K2-SLC	K2-PPH	K3-CXP			205
Hörnradie		SVC22C	SCN05C	SWN04					239	
Högmatningsfräsning	Negativa vändskär	SBN10	SSN11						251	
	Positiva vändskär	SSO12	SPD09	SZD07	SZD09				265	
Fasning	Positiva vändskär	SSD09	N-SSO09	STC	2516	2636	J(T)-SXP16		291	
Fräsning av spår	Skiv – och T-spårfräsar	S90SN	S90CN (XN)	F-SCC					313	
Andra frässkär									330	
ANVISNINGAR	Hur läser man katalogdata? (ISO 13399, ikoner, navigering)								352	
	Sortnavigatör och detaljbeskrivning								362	
	Vändskärsfräsning – Teknisk information								366	
	Bearbetningsformler, korrigeringar och tekniska detaljer								372	
	Materialgrupper för arbetsstycken (WMG)								376	

PRODUCT FAMILY		PRODUCT FAMILY		PRODUCT FAMILY		PRODUCT FAMILY	
2		S90		SOE		SSE	
2516	301	S90CN(XN)	320	SOE06Z	55	SSE09	31
2636	304	S90SN	314	SON		SSN	
F		SAD		SON06C	8	SSN11	258
FSB22X	38	SAD07D	90	SPD		SSN12Z	35
F-SCC	325	SAD11E	97	SPD09	270	SSO	
FTB27X	128	SAD16E	106	SPN		SSO09	122
J(T)		SAP		SPN13	21	SSO12	266
J(T)-CSD12X	150	SAP10D	114	SRC		STC	
J(T)-SAD11E	134	SAP16D	117	SRC10	186	STC	298
J(T)-SAD16E	139	SBN		SRC12	190	STN	
J(T)-SLSN	153	SBN10	252	SRC16	194	STN10	66
J(T)-SSAP	145	SCN		SRC20	198	STN16	70
J(T)-SXP16	307	SCN05C	243	SRD		SVC	
K2		SHN		SRD05	160	SVC22C	240
K2-PPH	222	SHN06C	13	SRD07	163	SWN	
K2-SLC	218	SHN09C	17	SRD10	168	SWN04C	246
K2-SRC	211	SLN		SRD12	174	SZD	
K3-CXP	234	SLN12	75	SRD16	180	SZD07	276
L2		SLN12X	85	SSD		SZD09	280
L2-SZP	206	SLN16	81	SSD09	292	SZD12	284
N		SOD		SSD12	125		
N-SS009	295	SOD05	42	SSD13F	26		
		SOD06D	51				






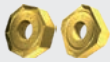

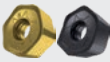
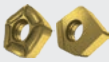




PRODUCT FAMILY		PRODUCT FAMILY		PRODUCT FAMILY		PRODUCT FAMILY	
A		O		S		T	
ADEX 07-FA	92	ODEW 06	52	SBKX 22	39	TBMR 27	129
ADEX 07-HF	93	ODKT 05IM	43	SBMR 22	39	TCMT	302
ADEX 11-FA	101	ODMT 05	333	SDET 13	27	TCMT	305
ADEX 11-FA	137	ODMT 05IM	44	SDEW 09	293	TCXT 16 STC	299
ADEX 11-HF	101	ODMT 06	52	SDEX 09	293	TNGX 10	67
ADEX 16	109	OEHT 06	56	SDGX 12	151	TNGX 10-FA	68
ADEX 16	142	OEHT 06-FA	57	SDKT 12IM	45	TNGX 16	71
ADEX 16-FA	109	OFKR 07	334	SDMT 12	126	TNGX 16-FA	72
ADEX 16-FA	142	ONMX 06	9	SDMT 12IM	46	TPCN 16	346
ADEX 16-HF	110	P		SDMT 13	28	TPKN	347
ADKT 15	330	PDKT 09	272	SDMX 12	151	TPKR	348
ADKX 15	330	PDKX 09	272	SEEN	337	TPUN	348
ADMX 07	91	PDMW 09	273	SEER	338	V	
ADMX 11	99	PDMX 09	271	SEET 09	33	VCGT 22-FA	241
ADMX 11	135	PNMQ 13	22	SEET 12	338	W	
ADMX 16	107	PNMU 13	22	SEET 12-FA	340	WNHX 04	247
ADMX 16	140	PPH	224	SEET 12-PM	339	X	
ANHX 10	254	PPHF	226	SEEW 12	340	XDET 13	29
APET 15	146	PPHT	225	SEMT 09	32	XDHW	349
APET 16-FA	119	R		SNGX 11	259	XEHT 06	58
APEW 15	146	RC	212	SNGX 13	154	XNGX 06	15
APKT 10	115	RCMT 10	187	SNHF	341	XNGX 09	19
APKT 16	118	RCMT 12	191	SNHN	341	XNGX 13	23
APMT 16	331	RCMT 16	195	SNHQ AZ	316	XNHQ	322
B		RCMT 20	199	SNHQ TRL	317	XP	235
BNGX 10	253	RDET	334	SNKT 12	36	XPHT 16	308
C		RDGT 07	164	SNMT 12	36	XPHT 16-FA	308
CCMX	326	RDGT 10	169	SNMX 17	10	Z	
CNHQ	322	RDGT 12	175	SNUN	342	ZDCW 07	277
CNHX 05	244	RDGT 12IM	44	SOHT 12	267	ZDCW 09	281
CNM	332	RDGT 16	181	SOMT 05	342	ZDEW 12	285
H		RDHT 07-FA	165	SOMT 09	123	ZP	208
HNEF 09	332	RDHT 10-FA	171	SOMT 09	296		
HNGX 06	14	RDHT 12-FA	177	SPET 12	147		
HNGX 09	18	RDHT 16-FA	182	SPET 12 AD	147		
HNMF 09	333	RDHX 05	161	SPEW 12 AD	148		
L		RDHX 07	164	SPGN	343		
LC	219	RDHX 10	170	SPGN 25 DZ	343		
LNET 16	154	RDHX 12	176	SPKN	344		
LNEX 12	86	RDHX 16	182	SPKR	345		
LNGU 12	78	RDHX 20	335	SPUN	345		
LNGU 16	82	RDMT 10	169				
LNGU 16-FA	83	RDMT 12	175				
LNGX 12	76	RDMT 12IM	45				
LNGX 12-FA	78	RDMX 10	170				
LNMU 16	82	RDMX 12	176				
		RDMX 16	181				
		REHT 16	57				
		RPET 12	335				
		RPET 15	53				
		RPEW 12	336				
		RPEX	336				



PLANFRÄSNING

INDEXABLE FACE MILLS – NAVIGATOR

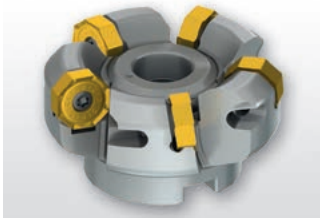
FACE MILLING

	SON06C	SHN06C	SHN09C	SPN13						
	43°		45°		45°		57°			
	APMX (mm)	4.0 (7.0)	APMX (mm)	3.0	APMX (mm)	5.0	APMX (mm)	10.0		
	DC (mm)	50 – 250	DC (mm)	25 – 125	DC (mm)	50 – 315	DC (mm)	100 – 315		
Cylindrical shank										
Weldon										
			DC = 25, 32 (mm)							
Modular										
Shell mill										
			DC = 40 – 125 (mm)							
Page	8		13		17		21			
ISO	P M K S H	P M K	H P M K	H P M K	H P M K S H					
Insert shape										
Inserts	ONMX 0605 SNMX 1705	HNGX 0604 XNGX 0604		HNGX 0906 XNGX 0906	PNM. 1308 XN.. 1308					
No. of cutting edges	16 / 8		12 / 1		12 / 1		10 / 1			
Face milling		■	■	■	■					
Chamfer milling		■	■	■						
Progressive plunging			■	■						
Ramping		▣	■	■						

SON06C



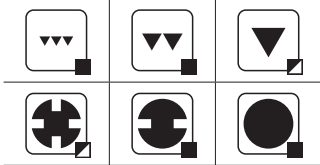
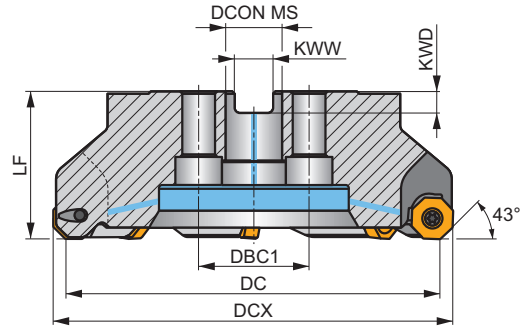
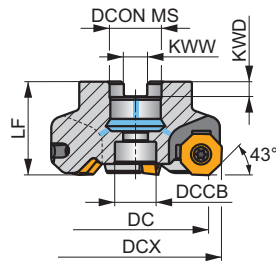
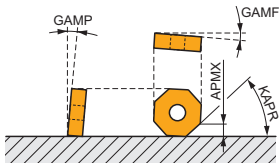
PRAMET



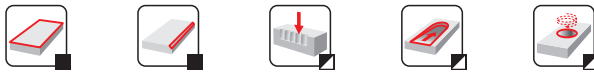
ECON ON06 43° Planfräs med Dubbelt Negativ Design och invändig kylning

Mycket ekonomisk och produktiv planfräs som kan användas med två typer av dubbelsidiga negativa vändskär. Ekonomiska åttakantiga ON..06-vändskär med 16 eggar och APMX 4 mm och produktiva fyrkantiga SN..17-skär med 8 skäreppor och ett APMX på 7 mm. Finns som dormmonterad och med differentialdelade skär. Kroppen är behandlad för längre livslängd.

KAPR	43°
APMX	4.0 (7.0) mm



0.04 - 0.25



Product	DC	DCX	DCON MS	DCCB	DBC1	LF	KWW	KWD	GAMP	GAMP			kg					
	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(°)	(°)								
50A04R-S450N06-C	50	60.8	22	16.5	-	40	10.4	6.3	-10	-5	4	✓	9400	✓	0.42	GI342	C0621	-
50A05R-S450N06-C	50	60.8	22	16.5	-	40	10.4	6.3	-10	-5	5	-	9400	✓	0.39	GI342	C0621	-
63A05R-S450N06-C	63	73.8	22	18.1	-	40	10.4	6.3	-10	-5	5	✓	8400	✓	0.71	GI342	C0621	-
63A06R-S450N06-C	63	73.8	22	18.1	-	40	10.4	6.3	-10	-5	6	✓	8400	✓	0.55	GI342	C0621	-
80A06R-S450N06-C	80	90.8	27	22.1	-	50	12.4	7	-10	-5	6	✓	7500	✓	1.27	GI342	C0622	-
80A08R-S450N06-C	80	90.8	27	22.1	-	50	12.4	7	-10	-5	8	-	7500	✓	1.19	GI342	C0622	-
100A08R-S450N06-C	100	110.8	32	30.1	-	50	14.4	8	-10	-5	8	✓	6700	✓	1.88	GI342	C0620	AC002
100A10R-S450N06-C	100	110.8	32	30.1	-	50	14.4	8	-10	-5	10	-	6700	✓	1.81	GI342	C0620	AC002
125A08R-S450N06-C	125	135.8	40	56.1	-	63	16.4	9	-10	-5	8	✓	6000	✓	3.80	GI342	C0620	AC003
125A10R-S450N06-C	125	135.8	40	56.1	-	63	16.4	9	-10	-5	10	✓	6000	✓	3.65	GI342	C0620	AC003
125A12R-S450N06-C	125	135.8	40	56.1	-	63	16.4	9	-11	-5	12	-	6000	✓	3.70	GI342	C0620	AC003
160C08R-S450N06-C	160	170.8	40	-	66.7	63	16.4	9.25	-10	-5	8	✓	5700	✓	6.48	GI342	C0623	-
160C12R-S450N06-C	160	170.8	40	-	66.7	63	16.4	9.25	-10	-5	12	✓	5700	✓	5.74	GI342	C0623	-
160C14R-S450N06-C	160	170.8	40	-	66.7	63	16.4	9.25	-11	-5	14	-	5700	✓	5.65	GI342	C0623	-
200C12R-S450N06-C	200	210.8	60	-	101.6	63	25.8	14.25	-10	-5	12	✓	4700	✓	9.06	GI342	C0624	-
200C16R-S450N06-C	200	210.8	60	-	101.6	63	25.8	14.25	-10	-5	16	-	4700	✓	9.02	GI342	C0624	-
250C14R-S450N06-C	250	260.8	60	-	101.6	63	25.8	14.25	-10	-5	14	✓	4300	✓	15.71	GI342	C0625	-
250C18R-S450N06-C	250	260.8	60	-	101.6	63	25.8	14.25	-10	-5	18	-	4300	✓	15.51	GI342	C0625	-

GI342	ONMX 0605..	ONMX 0605..-W..	SNMX 1705..

C0620	US 45013A-T20P	5.0	M 5	13	SDR T20P-T	-	-	-	-

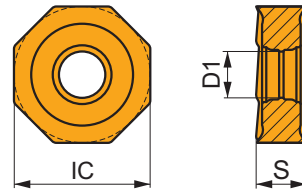
CO621	US 45013A-T20P	5.0	M 5	13	SDR T20P-T	HS 1030C	-	-	-
CO622	US 45013A-T20P	5.0	M 5	13	SDR T20P-T	HS 1230C	-	-	-
CO623	US 45013A-T20P	5.0	M 5	13	SDR T20P-T	HS 1240C	CAC 160C	HSD 0825C	HXK 5
CO624	US 45013A-T20P	5.0	M 5	13	SDR T20P-T	HS 1655C	CAC 200C	HSD 1025C	HXK 7
CO625	US 45013A-T20P	5.0	M 5	13	SDR T20P-T	HS 1655C	CAC 250C	HSD 1025C	HXK 7

AC002		KS 1635	K.FMH32
AC003		KS 2040	K.FMH40

ONMX 06

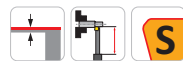
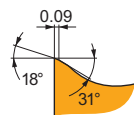
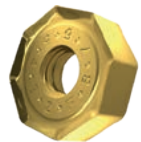


	IC (mm)	D1 (mm)	S (mm)
0605	17.000	5.70	7.08



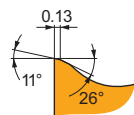
Lämplighet och startvärden för skärhastighet (vc), matning (f) och skärdjup (ap). Vi refererar till vår Dormer Pramet Calculator-app för vidare beräkningar.

Product	RE (mm)	P			M			K			N			S			H		
		vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)



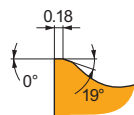
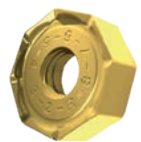
F geometrin är vass och används till finbearbetning med långa överhäng, eller tunnväggiga och slanka arbetsstycken. Utformad med mycket positiv spånvinkel, smal eggfas och eggrundning för lätt bearbetning.

ONMX 060508SR-F:8215	0.8	275	0.10	2.0	165	0.09	2.0	-	-	-	-	-	65	0.07	1.6	-	-	-
ONMX 060508SR-F:M6330	0.8	230	0.10	2.0	165	0.09	2.0	-	-	-	-	-	65	0.07	1.6	-	-	-
ONMX 060508SR-F:M8330	0.8	270	0.10	2.0	160	0.09	2.0	-	-	-	-	-	65	0.07	1.6	-	-	-
ONMX 060508SR-F:M8340	0.8	245	0.10	2.0	145	0.09	2.0	-	-	-	-	-	60	0.07	1.6	-	-	-
ONMX 060508SR-F:M9340	0.8	320	0.10	2.0	190	0.09	2.0	-	-	-	-	-	80	0.07	1.6	-	-	-



M geometrin har ett brett användningsområde och är förstaval till en lång rad bearbetningsförhållanden. Utformad med positiv spånvinkel, medelsmal eggfas och eggrundning för medelgrov bearbetning.

ONMX 060508SR-M:8215	0.8	230	0.20	2.0	135	0.18	2.0	-	-	-	-	-	55	0.14	1.6	45	0.14	1.0
ONMX 060508SR-M:M6330	0.8	195	0.20	2.0	140	0.18	2.0	-	-	-	-	-	55	0.14	1.6	-	-	-
ONMX 060508SR-M:M8330	0.8	230	0.20	2.0	135	0.18	2.0	-	-	-	-	-	55	0.14	1.6	45	0.14	1.0
ONMX 060508SR-M:M8340	0.8	210	0.20	2.0	125	0.18	2.0	-	-	-	-	-	50	0.14	1.6	-	-	-
ONMX 060508SR-M:M9325	0.8	285	0.20	2.0	-	-	-	-	-	-	-	-	-	-	-	55	0.14	1.0
ONMX 060508SR-M:M9340	0.8	255	0.20	2.0	150	0.18	2.0	-	-	-	-	-	60	0.14	1.6	-	-	-

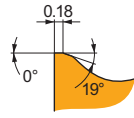
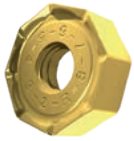


R geometrin är stark och används till grovbearbetning och under tunga arbetsförhållanden. Utformad med något positiv spånvinkel, bred eggfas och eggrundning för grov bearbetning.

ONMX 060508SR-R:8215	0.8	210	0.30	2.0	-	-	-	195	0.30	2.0	-	-	-	-	-	-	40	0.21	1.0
ONMX 060508SR-R:M5315	0.8	255	0.30	2.0	-	-	-	240	0.30	2.0	-	-	-	-	-	-	50	0.21	1.0
ONMX 060508SR-R:M8330	0.8	210	0.30	2.0	-	-	-	195	0.30	2.0	-	-	-	-	-	-	40	0.21	1.0

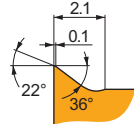
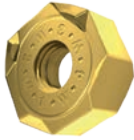
Lämplighet och startvärden för skärhastighet (vc), matning (f) och skärdjup (ap). Vi refererar till vår Dormer Pramet Calculator-app för vidare beräkningar.

Product	RE (mm)	P			M			K			N			S			H		
		vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)



R geometrin är stark och används till grovbearbetning och under tunga arbetsförhållanden. Utformad med något positiv spånvinkel, bred eggfas och eggrundning för grov bearbetning.

ONMX 060508SR-R:M8340	0.8	190	0.30	2.0	–	–	–	180	0.30	2.0	–	–	–	–	–	–	–	–	–	
ONMX 060508SR-R:M9325	0.8	250	0.30	2.0	–	–	–	235	0.30	2.0	–	–	–	–	–	–	–	50	0.21	1.0



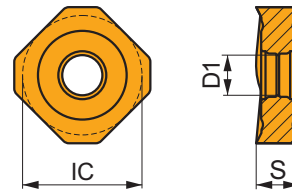
W wiper-design för förbättrad ytfinitet vid fräsning med stora fräskroppar och höga matningar.

ONMX 060508SR-W:8215	0.8	340	0.10	0.3	200	0.09	0.3	–	–	–	–	–	–	–	–	–	–	–	–
ONMX 060508SR-W:M8330	0.8	325	0.10	0.3	195	0.09	0.3	–	–	–	–	–	–	–	–	–	–	–	–

SNMX 17

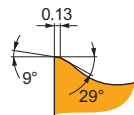
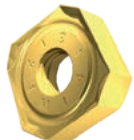


	IC (mm)	D1 (mm)	S (mm)
1705	17.000	5.70	5.56



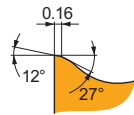
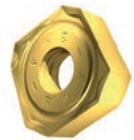
Lämplighet och startvärden för skärhastighet (vc), matning (f) och skärdjup (ap). Vi refererar till vår Dormer Pramet Calculator-app för vidare beräkningar.

Product	RE (mm)	P			M			K			N			S			H		
		vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)



M geometrin har ett brett användningsområde och är förstaval till en lång rad bearbetningsförhållanden. Utformad med positiv spånvinkel, medelbred eggfas och eggrundning för medelgrov bearbetning.

SNMX 170508SR-M:8215	0.8	265	0.20	4.0	155	0.18	4.0	–	–	–	–	–	–	65	0.14	3.2	50	0.14	1.0
SNMX 170508SR-M:M6330	0.8	225	0.20	4.0	160	0.18	4.0	–	–	–	–	–	–	65	0.14	3.2	–	–	–
SNMX 170508SR-M:M8330	0.8	265	0.20	4.0	155	0.18	4.0	–	–	–	–	–	–	65	0.14	3.2	50	0.14	1.0
SNMX 170508SR-M:M8340	0.8	240	0.20	4.0	140	0.18	4.0	–	–	–	–	–	–	60	0.14	3.2	–	–	–
SNMX 170508SR-M:M9325	0.8	325	0.20	4.0	–	–	–	–	–	–	–	–	–	–	–	–	65	0.14	1.0
SNMX 170508SR-M:M9340	0.8	295	0.20	4.0	175	0.18	4.0	–	–	–	–	–	–	70	0.14	3.2	–	–	–



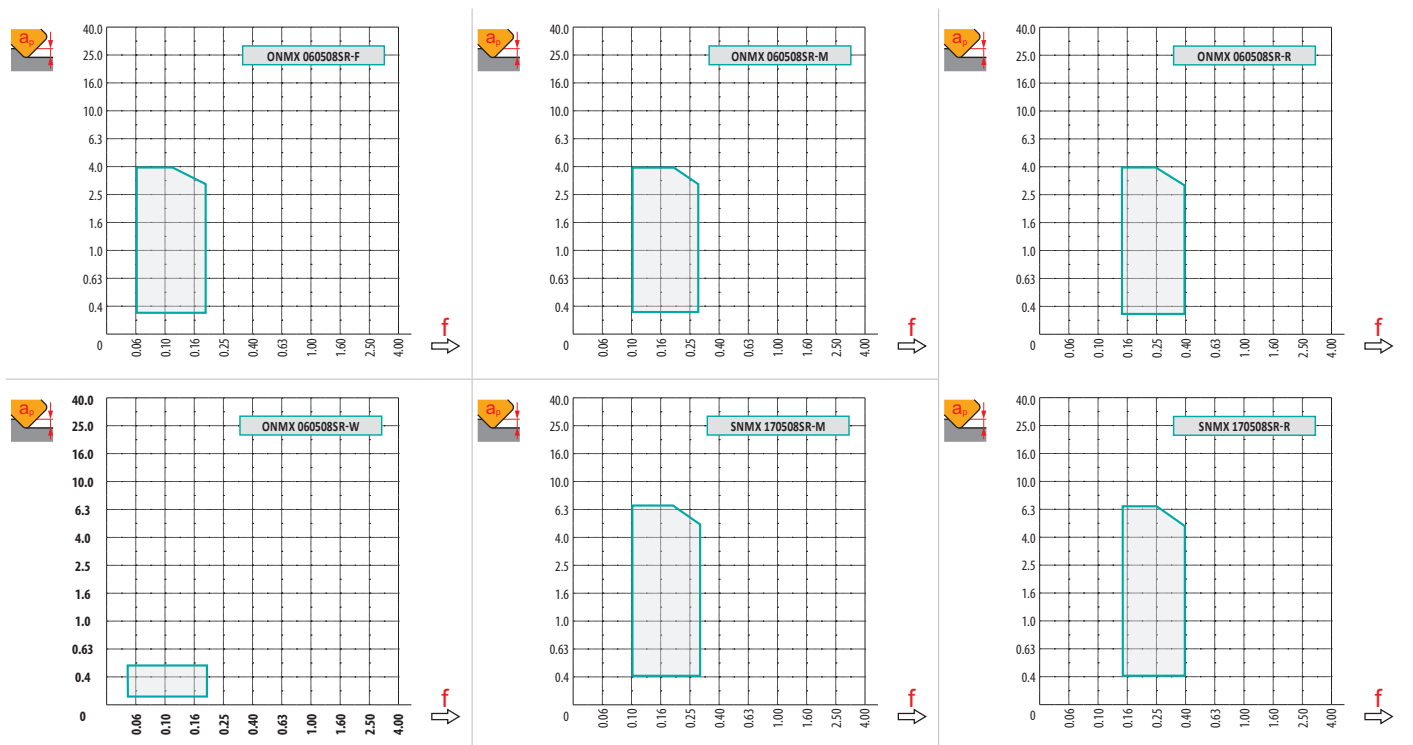
R geometrin är stark och används till grovbearbetning och under tunga förhållanden. Utformad med något positiv spånvinkel, bred eggfas och rundad egg för grovbearbetning.

SNMX 170508SR-R:8215	0.8	240	0.30	4.0	–	–	–	225	0.30	4.0	–	–	–	–	–	–	45	0.21	1.0
SNMX 170508SR-R:M5315	0.8	300	0.30	4.0	–	–	–	285	0.30	4.0	–	–	–	–	–	–	60	0.21	1.0
SNMX 170508SR-R:M8330	0.8	240	0.30	4.0	–	–	–	225	0.30	4.0	–	–	–	–	–	–	45	0.21	1.0
SNMX 170508SR-R:M8340	0.8	220	0.30	4.0	–	–	–	205	0.30	4.0	–	–	–	–	–	–	–	–	–
SNMX 170508SR-R:M9325	0.8	290	0.30	4.0	–	–	–	275	0.30	4.0	–	–	–	–	–	–	55	0.21	1.0



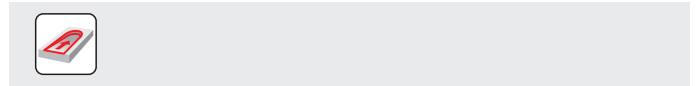
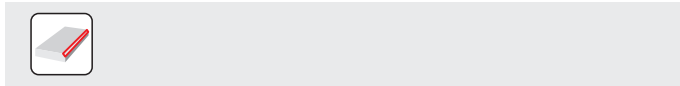
a_e / DC	5%	10%	15%	20%	25%	30%	40%	50%	60%	70%	75%	80%	90%	100%
	1.48	1.35	1.27	1.22	1.19	1.16	1.11	1.08	1.05	1.03	1.00	1.00	1.00	1.00
	2.20	1.60	1.35	1.20	1.10	0.95	0.85	0.75	0.85	0.95	1.00	1.00	1.00	1.00
	0.64	0.64	0.64	0.64	0.64	0.65	0.65	0.67	0.68	0.71	0.72	0.74	0.79	1.00

	ONMX 06-F	ONMX 06-M	ONMX 06-R	ONMX 06-W	SNMX 17-M	SNMX 17-R
	0.80	0.80	0.80	0.80	0.80	0.80
	0.75	0.75	0.75	4.30	0.70	0.70



		0.50	1.00	1.50	2.00	2.50	3.00	3.50	4.00
50		51.06	52.11	53.19	54.27	55.35	56.43	57.51	58.59
63		64.06	65.11	66.19	67.27	68.35	69.43	70.51	71.59
80		81.06	82.11	83.19	84.27	85.35	86.43	87.51	88.59
100		101.06	102.11	103.19	104.27	105.35	106.43	107.51	108.59
125		126.06	127.11	128.19	129.27	130.35	131.43	132.51	133.59
160		161.06	162.11	163.19	164.27	165.35	166.43	167.51	168.59
200		201.06	202.11	203.19	204.27	205.35	206.43	207.51	208.59
250		251.06	252.11	253.19	254.27	255.35	256.43	257.51	258.59

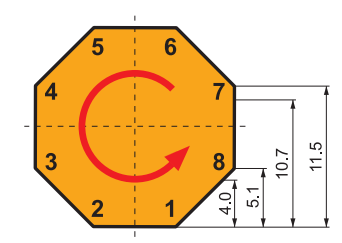
DC		S							
		0.00	1.00	2.00	3.00	4.00	5.00	6.00	7.00
50	DEF	47.24	49.40	51.56	53.73	55.90	58.06	60.23	62.40
63		60.24	62.40	64.56	66.73	68.90	71.06	73.23	75.40
80		77.24	79.40	81.56	83.73	85.90	88.06	90.23	92.40
100		97.24	99.40	101.56	103.73	105.90	108.06	110.23	112.40
125		122.24	124.40	126.56	128.73	130.90	133.06	135.23	137.40
160		157.24	159.40	161.56	163.73	165.90	168.06	170.23	172.40
200		197.24	199.40	201.56	203.73	205.90	208.06	210.23	212.40
250		247.24	249.40	251.56	253.73	255.90	258.06	260.23	262.40



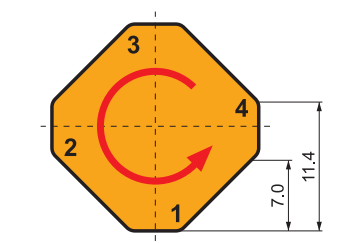
DC	X.V	f _{max}
50	1.35	0.36
63	1.39	0.40
80	1.44	0.45
100	1.48	0.51
125	1.53	0.57
160	1.58	0.64
200	1.63	0.72
250	1.68	0.80

DC	O	
	RPMX	APMX/I
50	0.3	0.4/100
63	0.2	0.25/100
80	0.2	0.2/100
100	0.1	0.1/100
125	0.1	0.05/100

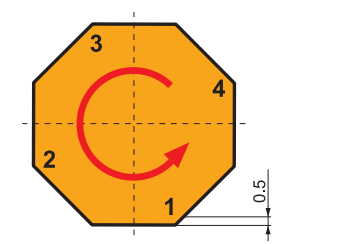
DC	S	
	RPMX	APMX/I
47.24	0.1	0.1/100
60.24	0.1	0.05/100
77.24	0.1	0.05/100



-> 4.0	16
-> 5.1	14
-> 10.7	8
-> 11.5	6



-> 7.0	8
-> 11.4	4



ONMX 06-W	
-> 0.5	8

SHN06C



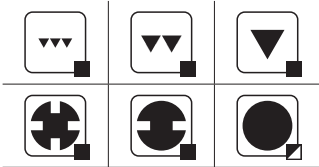
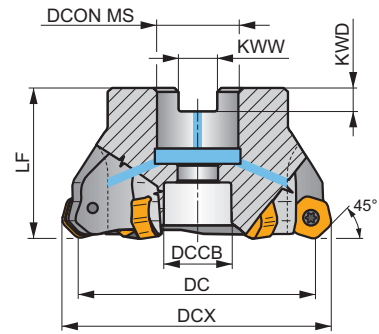
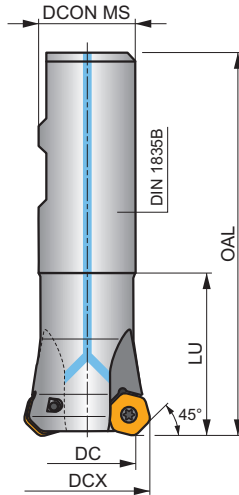
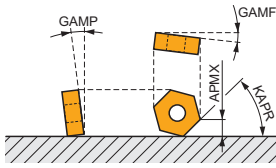
PRAMET



ECON HN06 45° planfräs med dubbelt negativ design, invändig kylning

Mycket produktiv 45° planfräs för dubbelsidiga HN..06-skär med APMX 3 mm. Ekonomiska vändskär med 12 eggar. Differentialdelade skärlägen. Finns med Weldonskaft, modulärt och dornfäste. Diametrar från 25 till 125 mm. Behandlad för lång livslängd.

KAPR	45°
APMX	3.0 mm



	0.06 - 0.15				
	0.06 - 0.15				

Product	DC	DCX	OAL	DCON MS	DCCB	LU	LF	KWW	KWD	GAMF	GAMP								
	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(°)	(°)		kg	FA10	AC001				
25N2R042B25-SHN06C-C	25	32.2	99	25	-	42	-	-	-	-7	-7	2	-	17400	✓	0.35	GI204	FA010	-
32N3R042B32-SHN06C-C	32	39.3	103	32	-	42	-	-	-	-7	-7	3	-	15400	✓	0.59	GI204	FA010	-
40A05R-S45HN06C-C	40	47.3	-	16	14	-	40	8.4	5.6	-7	-7	5	✓	13800	✓	0.37	GI204	FA012	-
50A04R-S45HN06C-C	50	57.3	-	22	18	-	40	10.4	6.3	-7	-7	4	✓	12300	✓	0.54	GI204	FA013	-
50A06R-S45HN06C-C	50	57.3	-	22	18	-	40	10.4	6.3	-7	-7	6	✓	12300	✓	0.41	GI204	FA013	-
63A06R-S45HN06C-C	63	70.3	-	22	18	-	40	10.4	6.3	-7	-7	6	✓	11000	✓	0.68	GI204	FA013	-
63A08R-S45HN06C-C	63	70.3	-	22	18	-	40	10.4	6.3	-7	-7	8	✓	11000	✓	0.68	GI204	FA013	-
80A07R-S45HN06C-C	80	86.8	-	27	38	-	50	12.4	7	-7	-7	7	✓	9700	✓	1.10	GI204	FA011	AC001
80A10R-S45HN06C-C	80	86.8	-	27	38	-	50	12.4	7	-7	-7	10	✓	9700	✓	1.10	GI204	FA011	AC001
100A08R-S45HN06C-C	100	107.1	-	32	45	-	50	14.4	8	-7	-7	8	✓	8700	✓	2.00	GI204	FA011	AC002
100A12R-S45HN06C-C	100	107.1	-	32	45	-	50	14.4	8	-7	-7	12	✓	8700	✓	1.82	GI204	FA011	AC002
125A10R-S45HN06C-C	125	132.2	-	40	56	-	63	16.4	9	-7	-7	10	✓	7800	✓	3.53	GI204	FA011	AC003

GI204	HNGX 0604AN..	XNGX 0604AN..

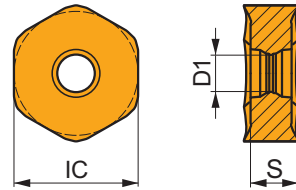
FA010	US 3007-T09P	2.0	M 3	7.3	-	-	Flag T09P	-
FA011	US 3007-T09P	2.0	M 3	7.3	D-T07P/T09P	FG-15	-	-
FA012	US 3007-T09P	2.0	M 3	7.3	D-T07P/T09P	FG-15	-	HS 0830C
FA013	US 3007-T09P	2.0	M 3	7.3	D-T07P/T09P	FG-15	-	HS 1030C

AC001	KS 1230	K.FMH27
AC002	KS 1635	K.FMH32
AC003	KS 2040	K.FMH40

HNGX 06

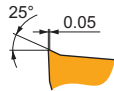


	IC	D1	S
	(mm)	(mm)	(mm)
0604	10.500	3.70	4.76



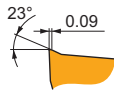
Lämplighet och startvärden för skärhastighet (vc), matning (f) och skärdjup (ap). Vi refererar till vår Dormer Pramet Calculator-app för vidare beräkningar.

Product	RE (mm)	P			M			K			N			S			H		
		vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)



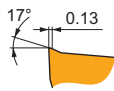
F geometri med mycket positiv design för finfräsning.

HNGX 0604ANSN-F:8215	☹	–	■	315	0.11	1.7	▣	185	0.10	1.7	■	–	–	–	–	–	–	–	–	–
HNGX 0604ANSN-F:M6330	☹	–	■	265	0.11	1.7	▣	185	0.10	1.7	■	–	–	–	–	–	–	–	–	–
HNGX 0604ANSN-F:M8330	☹	–	■	305	0.11	1.7	▣	180	0.10	1.7	■	–	–	–	–	–	–	–	–	–
HNGX 0604ANSN-F:M8340	☹	–	■	285	0.11	1.7	▣	170	0.10	1.7	■	–	–	–	–	–	–	–	–	–
HNGX 0604ANSN-F:M9340	☹	–	■	365	0.11	1.7	▣	215	0.10	1.7	■	–	–	–	–	–	–	–	–	–



M geometri med mycket positiv design för medelfin fräsning.

HNGX 0604ANSN-M:8215	☹	–	■	300	0.13	2.0	▣	180	0.13	2.0	■	285	0.13	2.0	–	–	–	–	–	–
HNGX 0604ANSN-M:M5315	☹	–	▣	425	0.13	2.0	–	–	–	–	■	400	0.13	2.0	–	–	–	–	–	–
HNGX 0604ANSN-M:M6330	☹	–	■	255	0.13	2.0	▣	180	0.13	2.0	■	–	–	–	–	–	–	–	–	–
HNGX 0604ANSN-M:M8310	☹	–	■	325	0.13	2.0	▣	165	0.13	2.0	■	305	0.13	2.0	–	–	–	–	–	–
HNGX 0604ANSN-M:M8330	☹	–	■	295	0.13	2.0	▣	175	0.13	2.0	■	280	0.13	2.0	–	–	–	–	–	–
HNGX 0604ANSN-M:M8340	☹	–	■	265	0.13	2.0	▣	155	0.13	2.0	▣	250	0.13	2.0	–	–	–	–	–	–
HNGX 0604ANSN-M:M9315	☹	–	■	410	0.13	2.0	–	–	–	–	■	385	0.13	2.0	–	–	–	–	–	–
HNGX 0604ANSN-M:M9325	☹	–	■	375	0.13	2.0	–	–	–	–	■	355	0.13	2.0	–	–	–	–	–	–
HNGX 0604ANSN-M:M9340	☹	–	■	345	0.13	2.0	▣	205	0.13	2.0	■	–	–	–	–	–	–	–	–	–



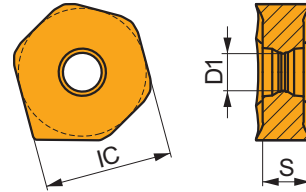
R geometri med mycket positiv design för medelfin till grovfräsning.

HNGX 0604ANSN-R:8215	☹	–	■	280	0.18	1.8	▣	165	0.18	1.8	■	265	0.18	1.8	–	–	–	–	▣	55	0.12	1.0
HNGX 0604ANSN-R:M5315	☹	–	▣	370	0.18	1.8	–	–	–	–	■	350	0.18	1.8	–	–	–	–	▣	70	0.12	1.0
HNGX 0604ANSN-R:M8310	☹	–	■	300	0.18	1.8	▣	150	0.18	1.8	■	285	0.18	1.8	–	–	–	–	▣	60	0.12	1.0
HNGX 0604ANSN-R:M8330	☹	–	■	275	0.18	1.8	▣	165	0.18	1.8	■	260	0.18	1.8	–	–	–	–	▣	55	0.12	1.0
HNGX 0604ANSN-R:M8340	☹	–	■	250	0.18	1.8	▣	150	0.18	1.8	▣	235	0.18	1.8	–	–	–	–	–	–	–	–
HNGX 0604ANSN-R:M9325	☹	–	■	345	0.18	1.8	–	–	–	–	■	325	0.18	1.8	–	–	–	–	▣	65	0.12	1.0

XNGX 06

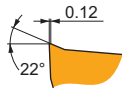


	IC	D1	S
	(mm)	(mm)	(mm)
0604	10.500	3.70	4.76



Lämplighet och startvärden för skärhastighet (vc), matning (f) och skärdjup (ap). Vi refererar till vår Dormer Pramet Calculator-app för vidare beräkningar.

Product	RE (mm)	P			M			K			N			S			H		
		vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)



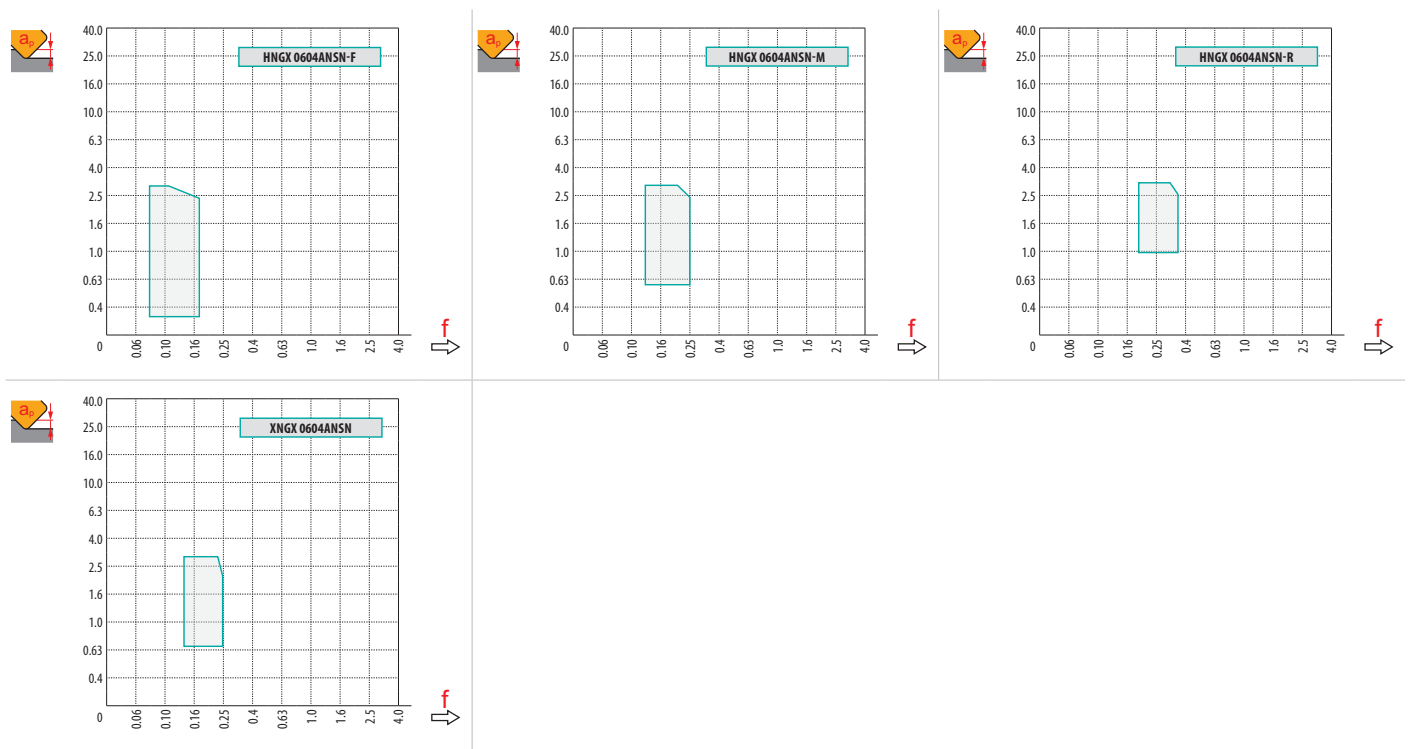
W wiper-design för bättre ytfinhet.

XNGX 0604ANSN:8215	RE		290	0.13	1.8	170	0.12	1.8	275	0.13	1.8								
---------------------------	----	--	-----	------	-----	-----	------	-----	-----	------	-----	--	--	--	--	--	--	--	--



a_e / DC	5 %	10 %	15 %	20 %	25 %	30 %	40 %	50 %	60 %	70 %	75 %	80 %	90 %	100 %
	1.48	1.35	1.27	1.22	1.19	1.16	1.11	1.08	1.05	1.03	1.00	1.00	1.00	1.00
	2.20	1.60	1.35	1.20	1.10	0.95	0.85	0.75	0.85	0.95	1.00	1.00	1.00	1.00
	0.64	0.64	0.64	0.64	0.64	0.65	0.65	0.67	0.68	0.71	0.72	0.74	0.79	1.00

	HNGX 06-F	HNGX 06-M	HNGX 06-R	XNGX 06
	-	-	-	-
	1.12	0.80	0.80	4.15



DC	X.V	f_{max}	DC	RPMX	APMX/I	a_p		
25	1.31	0.24	25	2.7°	3.0/65	0.9		
32	1.36	0.28	32	1.9°	3.0/89			
40	1.40	0.31	40	1.5°	2.5/100			
50	1.45	0.35	50	1.1°	1.9/100			
63	1.49	0.39	63	0.9°	1.4/100			
80	1.54	0.44	80	0.6°	1.0/100			
100	1.59	0.49	100	0.5°	0.8/100			
125	1.64	0.55	125	0.4°	0.6/100			

SHN09C



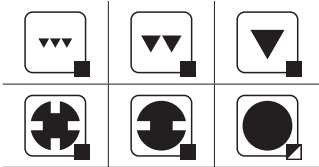
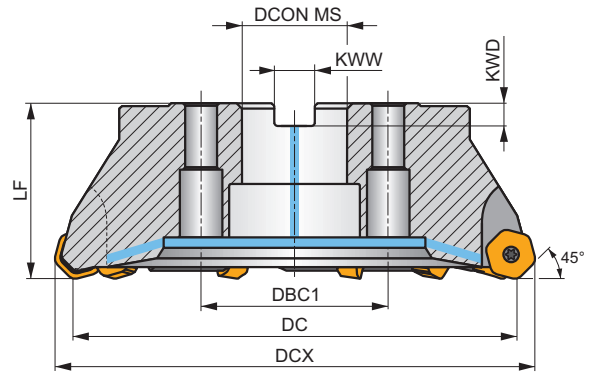
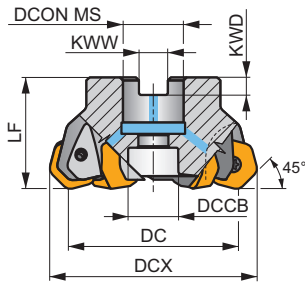
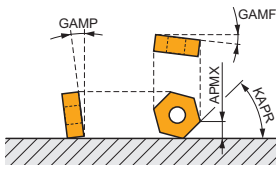
PRAMET



ECON HN09 45° planfräs med dubbelt negativ design, invändig kylning

Mycket produktiv 45° planfräs för dubbelsidiga HN..09-skär med APMX 5 mm. Ekonomiska vändskär med 12 eggar. Differentialdelade skärlägen. Finns enbart för dornmontering. Diametrar från 50 till 315 mm. Behandlad för lång livslängd.

KAPR	45°
APMX	5.0 mm



0.08 - 0.25



Product	DC	DCX	LF	DCON MS	DCCB	DBC1	KWW	KWD	GAMP	GAMP					kg			
	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(°)	(°)								
50A04R-S45HN09C-CF	50	61.7	40	22	18	-	10.4	6.3	-7	-7	4	✓	7900	✓	0.38	GI252	FA023	-
63A06R-S45HN09C-CF	63	74.7	40	22	18	-	10.4	6.3	-7	-7	6	✓	7000	✓	0.54	GI252	FA023	-
80A06R-S45HN09C-CF	80	91.7	50	27	38	-	12.4	7	-7	-7	6	✓	6200	✓	1.06	GI252	FA021	AC001
80A08R-S45HN09C-CF	80	91.7	50	27	38	-	12.4	7	-7	-7	8	✓	6200	✓	1.06	GI252	FA021	AC001
100A06R-S45HN09C-CF	100	111.7	50	32	45	-	14.4	8	-7	-7	6	✓	5600	✓	1.95	GI252	FA021	AC002
100A08R-S45HN09C-CF	100	111.7	50	32	45	-	14.4	8	-7	-7	8	✓	5600	✓	1.99	GI252	FA021	AC002
100A10R-S45HN09C-CF	100	111.7	50	32	45	-	14.4	8	-8	-7	10	-	5600	✓	1.99	GI252	FA021	AC002
125A06R-S45HN09C-CF	125	136.7	63	40	56	-	16.4	9	-7	-7	6	✓	5000	✓	3.36	GI252	FA021	AC003
125A08R-S45HN09C-CF	125	136.7	63	40	56	-	16.4	9	-7	-7	8	✓	4900	✓	3.66	GI252	FA021	AC003
125A10R-S45HN09C-CF	125	136.7	63	40	56	-	16.4	9	-7	-7	10	✓	5000	✓	3.52	GI252	FA021	AC003
125A12R-S45HN09C-CF	125	136.7	63	40	56	-	16.4	9	-8	-7	12	-	5000	✓	3.36	GI252	FA021	AC003
160C08R-S45HN09C-CF	160	171.7	63	40	-	66.7	16.4	9	-7	-7	8	✓	4400	✓	6.24	GI252	FA026	-
160C12R-S45HN09C-CF	160	171.7	63	40	-	66.7	16.4	9	-7	-7	12	✓	4400	✓	6.45	GI252	FA026	-
160C14R-S45HN09C-CF	160	171.7	63	40	-	66.7	16.4	9	-7	-7	14	✓	4400	✓	6.39	GI252	FA026	-
200C10R-S45HN09C-CF	200	211.7	63	60	-	101.6	25.7	14	-7	-7	10	✓	3900	✓	11.37	GI252	FA027	-
250C14R-S45HN09C-CF	250	261.7	63	60	-	101.6	25.7	14	-7	-7	14	✓	3500	✓	18.50	GI252	FA028	-
315C16R-S45HN09C-CF	315	326.7	80	60	-	101.6	25.7	14	-7	-7	16	✓	3100	✓	37.00	GI252	FA029	-

GI252	HNGX 0906AN..	XNGX 0906AN..

FA021	US 54511-T15P	5.0	M 4.5	11	D-T08P/T15P	FG-15	-	-	-	-	-	-	-	-
FA023	US 54511-T15P	5.0	M 4.5	11	D-T08P/T15P	FG-15	HS 1030C	-	-	-	-	-	-	-

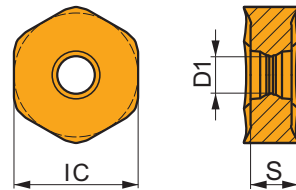
FA026	US 54511-T15P	5.0	M 4.5	11	D-T08P/T15P	FG-15	HS 1240C	CAC 160C	HSD 0825C	HXK 5	-	-
FA027	US 54511-T15P	5.0	M 4.5	11	D-T08P/T15P	FG-15	HS 1655C	CAC 200C	HSD 1025C	HXK 7	-	-
FA028	US 54511-T15P	5.0	M 4.5	11	D-T08P/T15P	FG-15	HS 1655C	CAC 250C	HSD 1025C	HXK 7	-	-
FA029	US 54511-T15P	5.0	M 4.5	11	D-T08P/T15P	FG-15	HS 1655C	CAC 315C	HSD 1035C	HXK 7	CACP 3150C	RRH 34

AC001	KS 1230	K.FMH27
AC002	KS 1635	K.FMH32
AC003	KS 2040	K.FMH40

HNGX 09

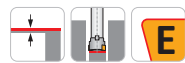
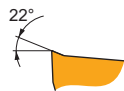


	IC	D1	S
	(mm)	(mm)	(mm)
0906	16.500	4.90	6.35



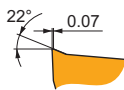
Lämplighet och startvärden för skärhastighet (vc), matning (f) och skärdjup (ap). Vi refererar till vår Dormer Pramet Calculator-app för vidare beräkningar.

Product	RE (mm)	P			M			K			N			S			H		
		vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)



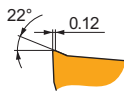
FF geometri med mycket positiv design för finfräsning.

HNGX 0906ANEN-FF:8215	●	-	■	345	0.10	1.0	▣	205	0.09	1.0	■	-	-	-	-	-	-	-	-
HNGX 0906ANEN-FF:M8330	●	-	■	335	0.10	1.0	■	200	0.09	1.0	■	-	-	-	-	-	-	-	-
HNGX 0906ANEN-FF:M9340	●	-	■	405	0.10	1.0	■	240	0.09	1.0	■	-	-	-	-	-	-	-	-



F geometri med mycket positiv design för fin till medelfin fräsning.

HNGX 0906ANSN-F:8215	⊕	-	■	300	0.12	2.1	▣	180	0.11	2.1	■	-	-	-	-	-	-	-	-
HNGX 0906ANSN-F:M6330	⊕	-	■	255	0.12	2.1	■	180	0.11	2.1	■	-	-	-	-	-	-	-	-
HNGX 0906ANSN-F:M8310	⊕	-	■	330	0.12	2.1	▣	165	0.11	2.1	■	-	-	-	-	-	-	-	-
HNGX 0906ANSN-F:M8330	⊕	-	■	300	0.12	2.1	■	180	0.11	2.1	■	-	-	-	-	-	-	-	-
HNGX 0906ANSN-F:M8340	⊕	-	■	270	0.12	2.1	■	160	0.11	2.1	■	-	-	-	-	-	-	-	-

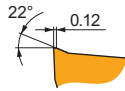


M geometri med mycket positiv design för medelfin fräsning.

HNGX 0906ANSN-M:8215	⊕	-	■	255	0.20	2.7	▣	150	0.18	2.7	■	240	0.20	2.7	-	-	-	-	-
HNGX 0906ANSN-M:M5315	⊕	-	▣	340	0.20	2.7	-	-	-	-	■	320	0.20	2.7	-	-	-	-	-

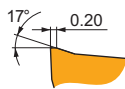
Lämplighet och startvärden för skärhastighet (vc), matning (f) och skärdjup (ap). Vi refererar till vår Dormer Pramet Calculator-app för vidare beräkningar.

Product	RE (mm)	P			M			K			N			S			H		
		vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)



M geometri med mycket positiv design för medelfin fräsning.

HNGX 0906ANSN-M:M6330	✳	–	■	220	0.20	2.7	☑	155	0.18	2.7	■	–	–	–	–	–	–	–	–
HNGX 0906ANSN-M:M8310	✳	–	■	280	0.20	2.7	☑	140	0.18	2.7	■	265	0.20	2.7	–	–	–	–	–
HNGX 0906ANSN-M:M8330	✳	–	■	255	0.20	2.7	☑	150	0.18	2.7	■	240	0.20	2.7	–	–	–	–	–
HNGX 0906ANSN-M:M8340	✳	–	■	235	0.20	2.7	☑	140	0.18	2.7	☑	220	0.20	2.7	–	–	–	–	–
HNGX 0906ANSN-M:M9315	✳	–	■	340	0.20	2.7	–	–	–	–	■	320	0.20	2.7	–	–	–	–	–
HNGX 0906ANSN-M:M9325	✳	–	■	315	0.20	2.7	–	–	–	–	■	295	0.20	2.7	–	–	–	–	–
HNGX 0906ANSN-M:M9340	✳	–	■	290	0.20	2.7	☑	170	0.18	2.7	–	–	–	–	–	–	–	–	

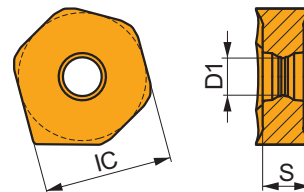


R geometri med positiv design för medelgrov till grovfräsning.

HNGX 0906ANSN-R:8215	✳	–	■	240	0.25	3.0	☑	140	0.25	3.0	■	225	0.25	3.0	–	–	–	■	45	0.13	1.0
HNGX 0906ANSN-R:M5315	✳	–	☑	305	0.25	3.0	–	–	–	–	■	285	0.25	3.0	–	–	–	☑	60	0.13	1.0
HNGX 0906ANSN-R:M8310	✳	–	■	260	0.25	3.0	☑	130	0.25	3.0	■	245	0.25	3.0	–	–	–	☑	50	0.13	1.0
HNGX 0906ANSN-R:M8330	✳	–	■	240	0.25	3.0	☑	140	0.25	3.0	■	225	0.25	3.0	–	–	–	☑	45	0.13	1.0
HNGX 0906ANSN-R:M8340	✳	–	■	220	0.25	3.0	☑	130	0.25	3.0	☑	205	0.25	3.0	–	–	–	–	–	–	
HNGX 0906ANSN-R:M9315	✳	–	■	310	0.25	3.0	–	–	–	–	■	290	0.25	3.0	–	–	–	☑	60	0.13	1.0
HNGX 0906ANSN-R:M9325	✳	–	■	295	0.25	3.0	–	–	–	–	■	280	0.25	3.0	–	–	–	☑	55	0.13	1.0

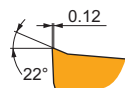
XNGX 09

	IC (mm)	D1 (mm)	S (mm)
0906	16.500	4.90	6.35



Lämplighet och startvärden för skärhastighet (vc), matning (f) och skärdjup (ap). Vi refererar till vår Dormer Pramet Calculator-app för vidare beräkningar.

Product	RE (mm)	P			M			K			N			S			H		
		vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)



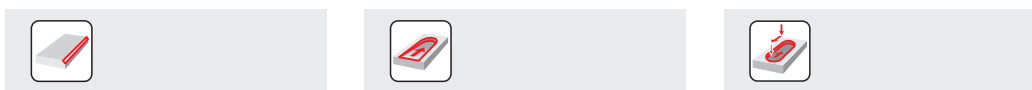
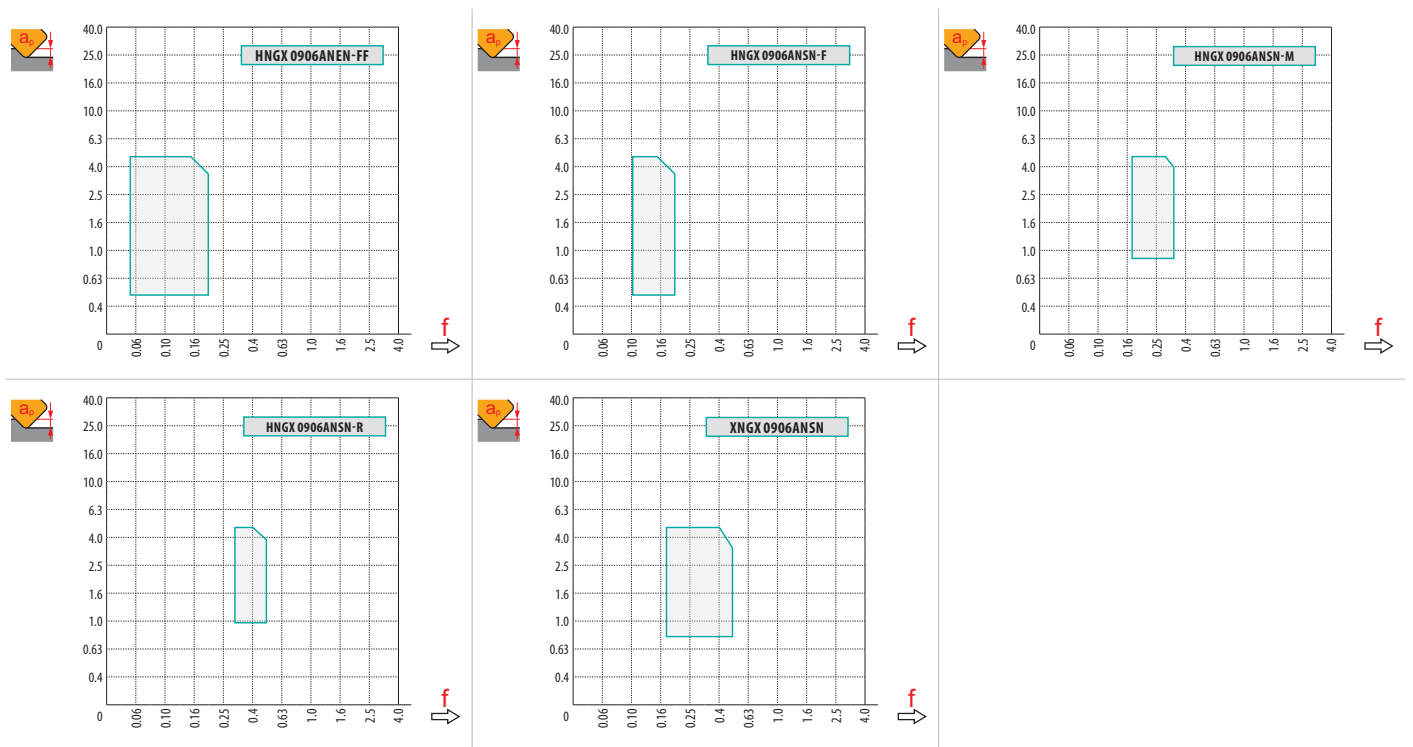
W wiper-design för bättre ytfinhet.

XNGX 0906ANSN:8215	✳	–	■	245	0.20	2.7	☑	145	0.18	2.7	■	230	0.20	2.7	–	–	–	–	–
XNGX 0906ANSN:M8330	✳	–	■	245	0.20	2.7	☑	145	0.18	2.7	■	230	0.20	2.7	–	–	–	–	–



a_e / DC	5 %	10 %	15 %	20 %	25 %	30 %	40 %	50 %	60 %	70 %	75 %	80 %	90 %	100 %
	1.48	1.35	1.27	1.22	1.19	1.16	1.11	1.08	1.05	1.03	1.00	1.00	1.00	1.00
	2.20	1.60	1.35	1.20	1.10	0.95	0.85	0.75	0.85	0.95	1.00	1.00	1.00	1.00
	0.64	0.64	0.64	0.64	0.64	0.65	0.65	0.67	0.68	0.71	0.72	0.74	0.79	1.00

	HNGX 09-FF	HNGX 09-F	HNGX 09-M	HNGX 09-R	XNGX 09
	-	-	-	-	-
	1.50	1.17	1.17	1.17	7.53



DC	X.V	f_{max}
50	1.35	0.36
63	1.39	0.40
80	1.44	0.45
100	1.48	0.51
125	1.53	0.57
160	1.58	0.64
200	1.63	0.72
250	1.68	0.80
315	1.74	0.90

DC	RPMX	APMX/II
50	2.1°	3.5/100
63	1.5°	2.5/100
80	1.1°	1.8/100
100	0.9°	1.4/100
125	0.7°	1.1/100
160	0.5°	0.7/100

a_e	1.9
-------	-----

SPN13

P M K S H

PRAMET

S

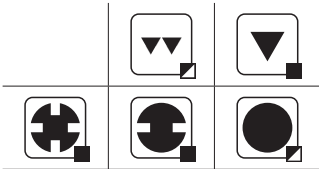
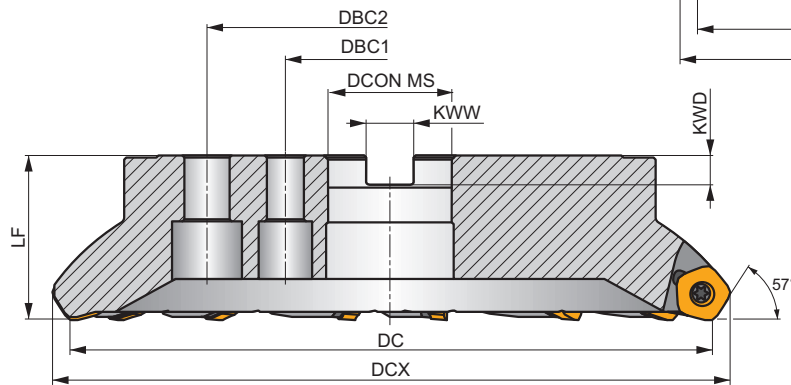
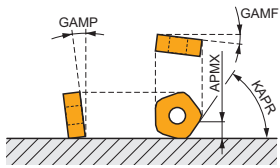
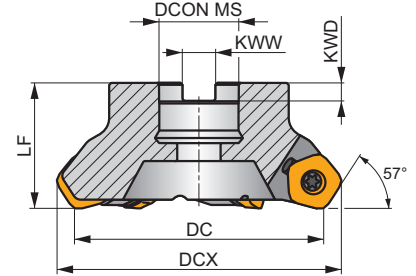


PENTA HD 57° planfräs med dubbelt negativ design, för tung planfräsning

Mycket produktiv 57° planfräs för enkelsidiga PN.. 13 och XN..13-skär med APMX 10 mm. För planfräsning. Finns endast för dormontering. Diametrar från 100 till 315 mm. Behandlad för lång livslängd.

PENTA HD

KAPR	57°
APMX	10.0 mm



h_{max} 0.20 - 0.50



Product	DC	DCX	LF	DCON MS	DBC1	DBC2	KWW	KWD	GAMP	GAMP								
	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(°)	(°)								
100A05R-S57PN13	100	115.8	50	32	-	-	14.4	8	-8.2	-4	5	-	3400	-	1.22	G1261	FA081	AC002
125A06R-S57PN13	125	140.8	63	40	-	-	16.4	9	-7	-4	6	-	3100	-	2.79	G1261	FA081	AC003
160C08R-S57PN13	160	175.8	63	40	66.7	-	16.4	9	-6	-4	8	-	2700	-	3.58	G1261	FA081	-
200C10R-S57PN13	200	215.8	63	60	101.6	-	25.7	14	-5	-4	10	-	2400	-	9.17	G1261	FA081	-
250C12R-S57PN13	250	265.8	63	60	101.6	-	25.7	14	-5	-4	12	-	2200	-	15.39	G1261	FA081	-
315C14R-S57PN13	315	330.8	80	60	101.6	177.8	25.7	14	-5	-4	14	-	1900	-	29.17	G1261	FA081	-

G1261	PNMU 1308DN..	XNGX 1308DNSN	PNMQ 1308DN..

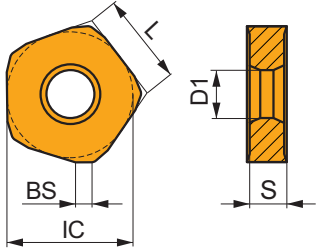
FA081	SPN 13T3DN	US 64010-T15P	SDRT15P	US 68026-T30P	15.0	M 8	26	SDRT30P-T

AC002	KS 1635	K.FMH32
AC003	KS 2040	K.FMH40

PNMU 13

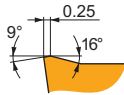


	BS	IC	D1	L	S
	(mm)	(mm)	(mm)	(mm)	(mm)
1308	3.00	24.400	10.00	13.00	7.94



Lämplighet och startvärden för skärhastighet (vc), matning (f) och skärdjup (ap). Vi refererar till vår Dormer Pramet Calculator-app för vidare beräkningar.

Product	RE (mm)	P			M			K			N			S			H		
		vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)



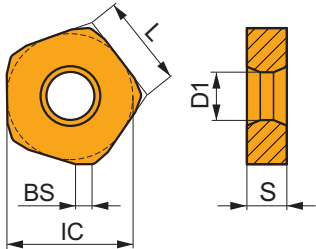
M geometri med positiv design för grovfräsning.

PNMU 1308DNSR-M:8215	✳	–	█	165	0.35	6.5	▣	95	0.32	6.5	█	155	0.35	6.5	–	–	–	▣	40	0.28	5.2	█	30	0.18	2.0
PNMU 1308DNSR-M:M8330	✳	–	█	190	0.35	6.5	▣	110	0.32	6.5	█	180	0.35	6.5	–	–	–	▣	45	0.28	5.2	█	35	0.18	2.0
PNMU 1308DNSR-M:M8345	✳	–	█	135	0.35	6.5	▣	80	0.32	6.5	–	–	–	–	–	–	–	▣	30	0.28	5.2	–	–	–	
PNMU 1308DNSR-M:M9315	✳	–	█	210	0.35	6.5	▣	–	–	–	█	195	0.35	6.5	–	–	–	–	–	–	–	▣	40	0.18	2.0
PNMU 1308DNSR-M:M9340	✳	–	█	170	0.35	6.5	▣	100	0.32	6.5	–	–	–	–	–	–	–	▣	40	0.28	5.2	–	–	–	

PNMQ 13

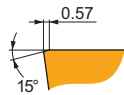


	BS	IC	D1	L	S
	(mm)	(mm)	(mm)	(mm)	(mm)
1308	3.00	24.400	10.00	13.00	7.94



Lämplighet och startvärden för skärhastighet (vc), matning (f) och skärdjup (ap). Vi refererar till vår Dormer Pramet Calculator-app för vidare beräkningar.

Product	RE (mm)	P			M			K			N			S			H		
		vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)



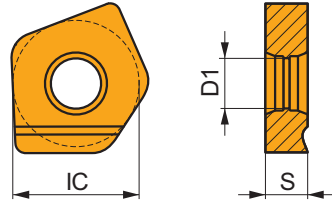
SN neutral spåninkeldesign särskilt avsedd för grovfräsning.

PNMQ 1308DNSN:M8330	✳	–	▣	165	0.60	6.5	–	–	–	–	█	155	0.60	6.5	–	–	–	–	–	–	–	▣	30	0.30	2.0
PNMQ 1308DNSN:M8345	✳	–	▣	120	0.60	6.5	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	

XNGX 13

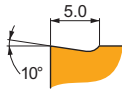


	IC	D1	S
	(mm)	(mm)	(mm)
1308	24.180	10.00	7.94



Lämplighet och startvärden för skärhastighet (vc), matning (f) och skärdjup (ap). Vi refererar till vår Dormer Pramet Calculator-app för vidare beräkningar.

Product	RE (mm)	P			M			K			N			S			H		
		vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)



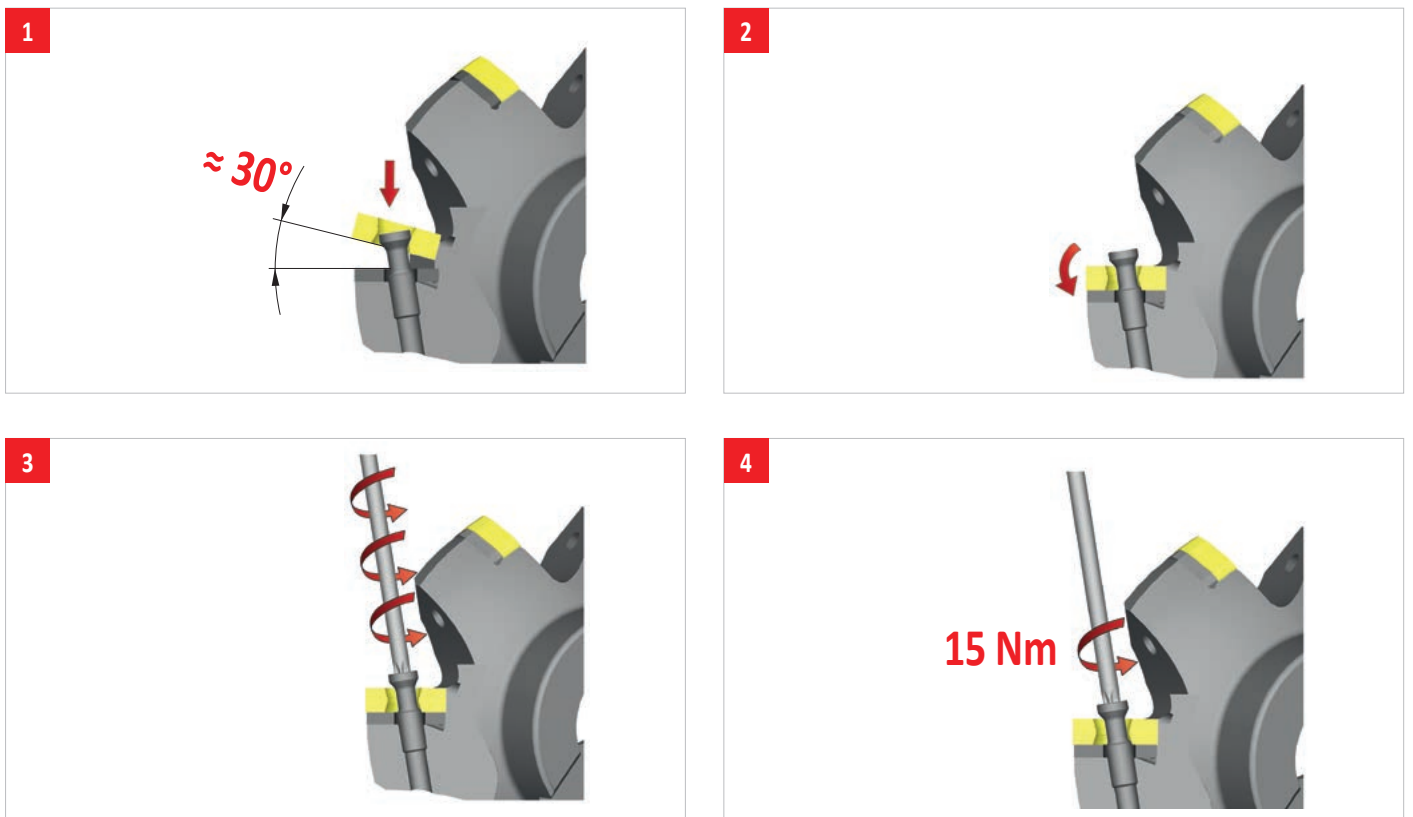
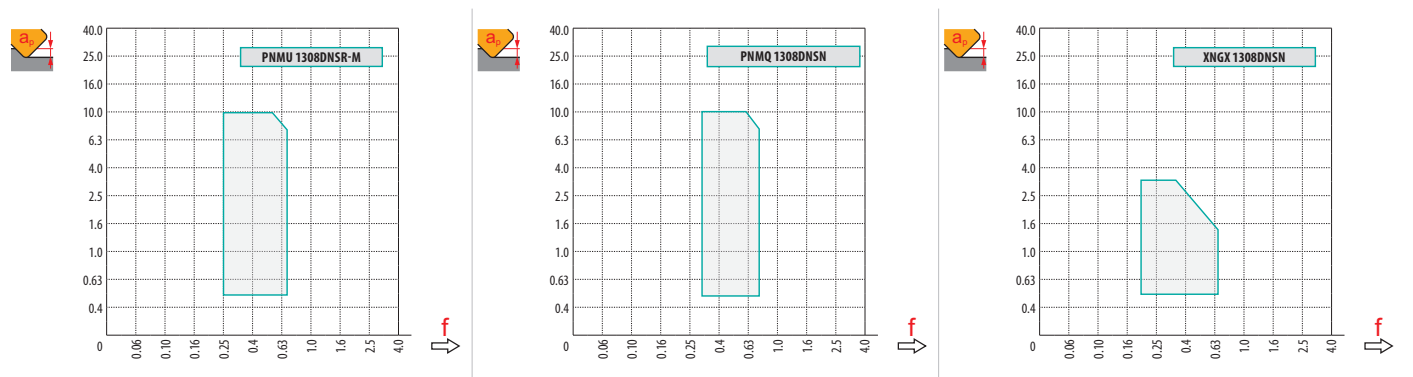
W wiper-design för bättre ytfinitet.

XNGX 1308DNSN:M8330	✳	-	■	245	0.45	2.5	■	-	-	-	■	230	0.45	2.5	■	-	-	-	■	-	-	-
----------------------------	---	---	---	-----	------	-----	---	---	---	---	---	-----	------	-----	---	---	---	---	---	---	---	---


















a_e / DC	5 %	10 %	15 %	20 %	25 %	30 %	40 %	50 %	60 %	70 %	75 %	80 %	90 %	100 %
	1.48	1.35	1.27	1.22	1.19	1.16	1.11	1.08	1.05	1.03	1.00	1.00	1.00	1.00
	2.20	1.60	1.35	1.20	1.10	0.95	0.85	0.75	0.85	0.95	1.00	1.00	1.00	1.00
	0.64	0.64	0.64	0.64	0.64	0.65	0.65	0.67	0.68	0.71	0.72	0.74	0.79	1.00

	PNMU 13-M	PNMQ 13	XNGX 13
	-	-	-
	3.00	3.00	12.71



INDEXABLE FACE MILLS – NAVIGATOR

FACE MILLING

	SSD13F	SSE09	SSN12Z	FSB22X											
	45°		45°		45°		60°								
	APMX (mm)	6.4	APMX (mm)	4.5	APMX (mm)	6.5	APMX (mm)	15.0							
	DC (mm)	32 – 250	DC (mm)	20 – 160	DC (mm)	63 – 125	DC (mm)	125 – 250							
Cylindrical shank															
Weldon		DC = 32, 40 (mm)		DC = 20 – 32 (mm)											
Modular															
Shell mill		DC = 40 – 250 (mm)		DC = 32 – 160 (mm)											
Page	26		31		35		38								
ISO	P	M	K	N	S	H	P	M	K	S	P	M	K		
Insert shape															
Inserts	SDET 13T3 SDMT 13T3 XDET 13T3		SE.T 09T3		SN.T 1205		SB.. 2207								
No. of cutting edges	4 / 4 / 1		4		4		4 / 1								
Face milling 	■		■		■		■								
Chamfer milling 	■		■		■										
Helical interpolation 	▣														
Progressive plunging 	▣														
Ramping 	▣														

SSD13F

P M K N S H

PRAMET

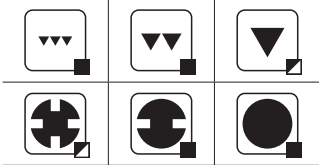
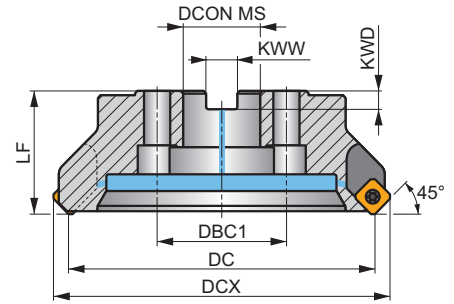
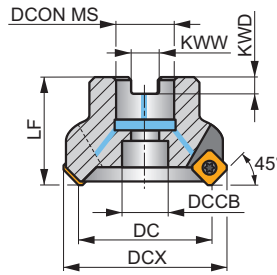
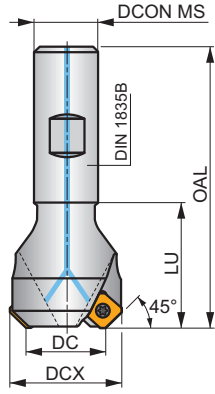
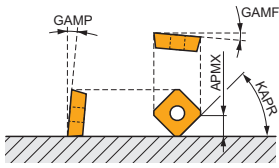
S



VER SD13 45° Planfräs med Positiv Design och Invändig kylning

Mycket mångsidig 45° planfräs för enkelsidiga SD.. 13 vändskär med ett APMX på 6,4 mm. Passar till en lång rad applikationer i alla arbetsmaterial. Finns med Weldon- och dornfäste och med differentialdelade skär. Kroppen är behandlad för längre livslängd, skärlägena har underläggsbrickor av hårdmetall, vilket ökar processsäkerheten.

KAPR	45°
APMX	6.4 mm



	0.04 - 0.28
	0.04 - 0.32



Product	DC	DCX	OAL	DCON MS	DCCB	DBC1	LU	LF	KWW	KWD	GAMF	GAMP	max.		kg	G		C		
	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(°)	(°)								
32N3R045B25-SSD13F-C	32	44.9	120	25	-	-	45	-	-	-	-15	15	3	-	16100	✓	0.43	GI341	CO610	-
40N3R045B32-SSD13F-C	40	53.5	120	32	-	-	45	-	-	-	-7	15	3	-	14400	✓	0.72	GI341	CO610	-
40A03R-S45SD13F-C	40	53.5	-	16	14	-	-	40	8.4	5.6	-7	15	3	-	14400	✓	0.27	GI341	CO611	-
50A04R-S45SD13F-C	50	63.5	-	22	18	-	-	40	10.4	6.3	-7	15	4	✓	12900	✓	0.51	GI341	CO612	-
63A05R-S45SD13F-C	63	76.4	-	22	18	-	-	40	10.4	6.3	-7	15	5	✓	11500	✓	0.53	GI341	CO612	-
80A07R-S45SD13F-C	80	93.4	-	27	22	-	-	50	12.4	7	-7	15	7	✓	10200	✓	1.21	GI341	CO613	AC001
100A08R-S45SD13F-C	100	112.9	-	32	45	-	-	50	14.4	8	-12	15	8	✓	9100	✓	1.83	GI341	CO613	AC002
100A10R-S45SD13F-C	100	112.9	-	32	45	-	-	50	14.4	8	-12	15	10	-	9100	✓	1.94	GI341	CO613	AC002
125A08R-S45SD13F-C	125	137.8	-	40	56	-	-	63	16.4	9	-12	15	8	✓	8100	✓	3.41	GI341	CO613	AC003
125A12R-S45SD13F-C	125	137.8	-	40	56	-	-	63	16.4	9	-12	15	12	-	8100	✓	3.31	GI341	CO613	AC003
160C10R-S45SD13F-C	160	172.8	-	40	-	66.7	-	63	16.4	9	-12	15	10	✓	7200	✓	6.68	GI341	CO614	-
160C14R-S45SD13F-C	160	172.8	-	40	-	66.7	-	63	16.4	9	-12	15	14	✓	7200	✓	6.62	GI341	CO614	-
200C12R-S45SD13F-C	200	212.8	-	60	-	101.6	-	63	25.7	14	-12	15	12	✓	6400	✓	9.06	GI341	CO615	-
200C16R-S45SD13F-C	200	212.8	-	60	-	101.6	-	63	25.7	14	-12	15	16	✓	6400	✓	11.85	GI341	CO615	-
250C14R-S45SD13F-C	250	262.8	-	60	-	101.6	-	63	25.7	14	-12	15	14	✓	5700	✓	19.50	GI341	CO616	-
250C20R-S45SD13F-C	250	262.8	-	60	-	101.6	-	63	25.7	14	-12	15	20	✓	5700	✓	19.20	GI341	CO616	-

G1341	SD13	SD13	XD13
SD13	SD13	SD13	XD13
SD13	SD13	SD13	XD13

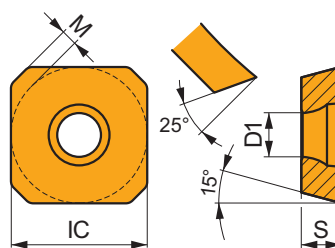
C0610	US 63513-T15P	3.0	M 3.5	13	Flag T15P	-	-	-	SDW 1103AF	MS 3507	HXK 3.5	-	-	-
C0611	US 63513-T15P	3.0	M 3.5	13	-	D-T08P/T15P	FG-15	HS 0830C	SDW 1103AF	MS 3507	HXK 3.5	-	-	-
C0612	US 63513-T15P	3.0	M 3.5	13	-	D-T08P/T15P	FG-15	HSD 1025C	SDW 1103AF	MS 3507	HXK 3.5	-	-	-
C0613	US 63513-T15P	3.0	M 3.5	13	-	D-T08P/T15P	FG-15	-	SDW 1103AF	MS 3507	HXK 3.5	-	-	-
C0614	US 63513-T15P	3.0	M 3.5	13	-	D-T08P/T15P	FG-15	HS 1240C	SDW 1103AF	MS 3507	HXK 3.5	CAC 160C	HSD 0825C	HXK 5
C0615	US 63513-T15P	3.0	M 3.5	13	-	D-T08P/T15P	FG-15	HS 1655C	SDW 1103AF	MS 3507	HXK 3.5	CAC 200C	HSD 1025C	HXK 7
C0616	US 63513-T15P	3.0	M 3.5	13	-	D-T08P/T15P	FG-15	HS 1655C	SDW 1103AF	MS 3507	HXK 3.5	CAC 250C	HSD 1025C	HXK 7

AC001	KS 1230	K.FMH27
AC002	KS 1635	K.FMH32
AC003	KS 2040	K.FMH40

SDET 13

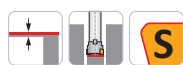
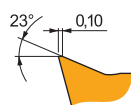


	IC	D1	M	S
	(mm)	(mm)	(mm)	(mm)
13T3	13.385	4.40	1.5	3.97



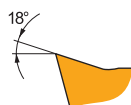
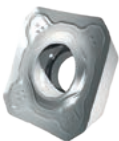
Lämplighet och startvärden för skärhastighet (vc), matning (f) och skärdjup (ap). Vi refererar till vår Dormer Pramet Calculator-app för vidare beräkningar.

Product	RE (mm)	P			M			K			N			S			H					
		vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap			
		(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)



F geometrin är vass och används till finbearbetning med långa överhäng, eller tunnväggiga och slanka arbetsstycken. Utformad med mycket positiv spänvinkel, smal eggfas och rundad egg för lätt bearbetning.

SDET 13T3AFSN-F:M6330	☼	-	250	0.15	3.0	175	0.14	3.0	-	-	-	-	-	-	70	0.11	2.4	-	-	-
SDET 13T3AFSN-F:M8310	☼	-	315	0.15	3.0	160	0.14	3.0	295	0.15	3.0	-	-	-	-	-	-	-	-	-
SDET 13T3AFSN-F:M8330	☼	-	285	0.15	3.0	170	0.14	3.0	270	0.15	3.0	855	0.18	3.0	70	0.11	2.4	-	-	-
SDET 13T3AFSN-F:M8340	☼	-	265	0.15	3.0	155	0.14	3.0	250	0.15	3.0	-	-	-	65	0.11	2.4	-	-	-
SDET 13T3AFSN-F:M9340	☼	-	330	0.15	3.0	195	0.14	3.0	-	-	-	-	-	-	80	0.11	2.4	-	-	-



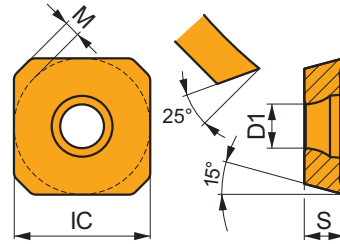
FA geometrin är vass och används till icke-järnlegeringar, passar vid bearbetning med långa överhäng och till tunnväggiga eller slanka arbetsstycken. Slipad och polerad design med mycket positiv spänvinkel.

SDET 13T3AFFN-FA:HF7	☼	-	-	-	-	-	-	-	-	-	-	360	0.12	3.0	-	-	-	-	-	-
SDET 13T3AFFN-FA:M0315	☼	-	-	-	-	-	-	-	-	-	-	840	0.12	3.0	-	-	-	-	-	-

SDMT 13

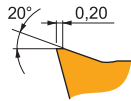


	IC (mm)	D1 (mm)	M (mm)	S (mm)
13T3	13.385	4.40	1.5	3.97



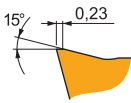
Lämplighet och startvärden för skärhastighet (vc), matning (f) och skärdjup (ap). Vi refererar till vår Dormer Pramet Calculator-app för vidare beräkningar.

Product	RE (mm)	P			M			K			N			S			H		
		vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)



M geometrin har ett brett användningsområde och är förstaval till en lång rad bearbetningsförhållanden. Utformad med positiv spånvinkel, medelstor eggfas och rundad egg för medelgrov bearbetning.

SDMT 13T3AFSN-M:8215	☹	–	■	245	0.30	3.0	▣	145	0.27	3.0	■	230	0.30	3.0	–	–	–	▣	60	0.24	2.4	■	45	0.21	1.0
SDMT 13T3AFSN-M:M6330	☹	–	■	215	0.30	3.0	■	150	0.27	3.0	–	–	–	–	–	–	–	■	60	0.24	2.4	–	–	–	
SDMT 13T3AFSN-M:M8330	☹	–	■	245	0.30	3.0	■	145	0.27	3.0	■	230	0.30	3.0	–	–	–	▣	60	0.24	2.4	▣	45	0.21	1.0
SDMT 13T3AFSN-M:M8340	☹	–	■	225	0.30	3.0	■	135	0.27	3.0	▣	210	0.30	3.0	–	–	–	■	55	0.24	2.4	–	–	–	
SDMT 13T3AFSN-M:M9325	☹	–	■	295	0.30	3.0	–	–	–	–	■	280	0.30	3.0	–	–	–	–	–	–	–	▣	55	0.21	1.0
SDMT 13T3AFSN-M:M9340	☹	–	■	265	0.30	3.0	■	155	0.27	3.0	–	–	–	–	–	–	–	■	65	0.24	2.4	–	–	–	



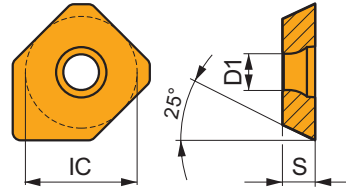
R geometrin är stark och används vid grov bearbetning under tunga förhållanden. Utformad med något positiv spånvinkel, bred eggfas och rundad egg för grovbearbetning.

SDMT 13T3AFSN-R:M5315	☹	–	▣	285	0.35	3.0	–	–	–	–	■	270	0.35	3.0	–	–	–	–	–	–	–	■	55	0.25	1.0
SDMT 13T3AFSN-R:M8310	☹	–	■	255	0.35	3.0	▣	130	0.32	3.0	■	240	0.35	3.0	–	–	–	–	–	–	–	■	50	0.25	1.0
SDMT 13T3AFSN-R:M8330	☹	–	■	240	0.35	3.0	▣	140	0.32	3.0	■	225	0.35	3.0	–	–	–	–	–	–	–	▣	45	0.25	1.0
SDMT 13T3AFSN-R:M8340	☹	–	■	220	0.35	3.0	▣	130	0.32	3.0	▣	205	0.35	3.0	–	–	–	–	–	–	–	–	–	–	
SDMT 13T3AFSN-R:M9325	☹	–	■	280	0.35	3.0	–	–	–	–	■	265	0.35	3.0	–	–	–	–	–	–	–	▣	55	0.25	1.0

XDET 13



	IC	D1	S
	(mm)	(mm)	(mm)
13T3	13.385	4.40	3.97



Lämplighet och startvärden för skärhastighet (vc), matning (f) och skärdjup (ap). Vi refererar till vår Dormer Pramet Calculator-app för vidare beräkningar.

Product	RE (mm)	P			M			K			N			S			H		
		vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)



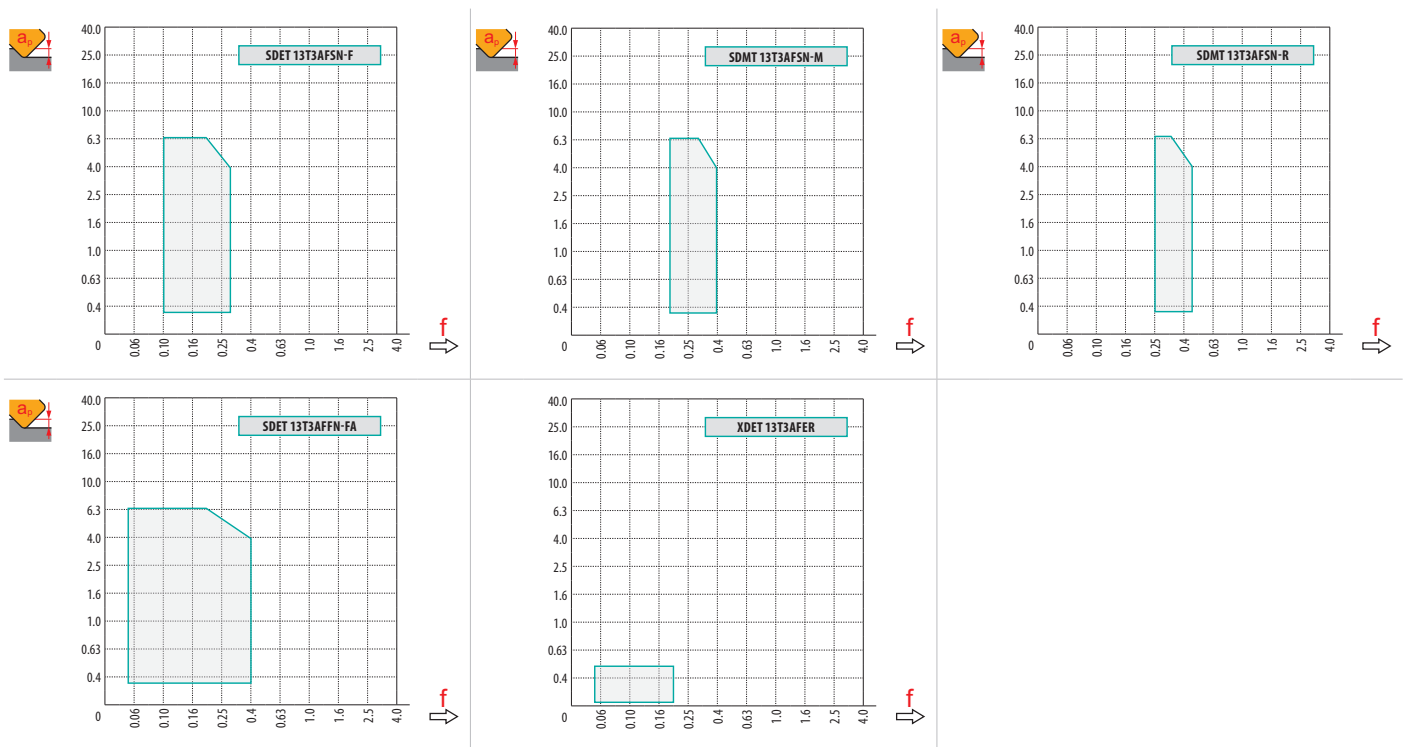
W wiper-design för bättre ytförhållanden vid bearbetning med stora fräskroppar och höga matningar.

XDET 13T3AFER:8215	☺	–	■	420	0.10	0.2	▣	250	0.09	0.2	■	395	0.10	0.2	–	–	–	–	–	–
XDET 13T3AFER:M8330	☺	–	■	395	0.10	0.2	▣	235	0.09	0.2	■	375	0.10	0.2	–	–	–	–	–	–



a_e / DC	5 %	10 %	15 %	20 %	25 %	30 %	40 %	50 %	60 %	70 %	75 %	80 %	90 %	100 %
	1.48	1.35	1.27	1.22	1.19	1.16	1.11	1.08	1.05	1.03	1.00	1.00	1.00	1.00
	2.20	1.60	1.35	1.20	1.10	0.95	0.85	0.75	0.85	0.95	1.00	1.00	1.00	1.00
	0.64	0.64	0.64	0.64	0.64	0.65	0.65	0.67	0.68	0.71	0.72	0.74	0.79	1.00

	SDET 13-F	SDMT 13-M	SDMT 13-R	SDET 13-FA	XDET 13
	-	-	-	-	-
	1.75	1.75	1.75	1.75	8.19



		f_{max}		RPMX	APMX/I		DMIN	DMAX			a_e
32	1.22	0.15	32	14.1°	6.4/27	32	60.0	89.8	1.7	1.7	1.5
40	1.26	0.16	40	11.8°	6.4/32	40	75.0	107.0	1.7	1.7	
50	1.30	0.18	50	9.8°	6.4/39	50	94.0	127.0	1.7	1.7	
63	1.34	0.20	63	7.7°	6.4/49	63	120.0	152.8	1.7	1.7	
80	1.39	0.22	80	5.2°	6.4/72	80	155.0	186.8	1.7	1.7	
100	1.43	0.24	100	4.1°	6.4/91	100	193.0	225.8	1.7	1.7	
125	1.48	0.26	125	3.2°	5.45/100	125	245.0	275.6	1.7	1.7	
160	1.53	0.29	160	1.0°	1.6/100	160	322.0	345.6	1.7	1.7	
200	1.58	0.33	200	0.4°	0.55/100	200	405.0	425.6	1.7	1.7	
250	1.63	0.36	250	0.3°	0.4/100	250	505.0	525.6	1.7	1.7	

SSE09



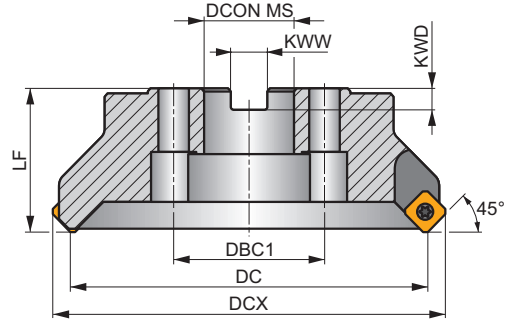
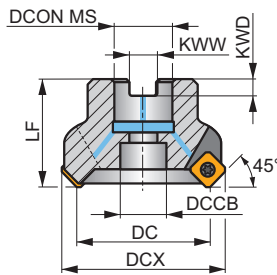
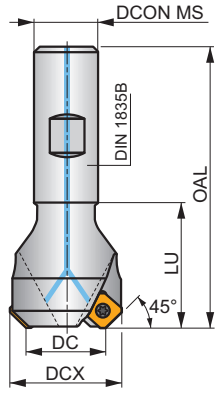
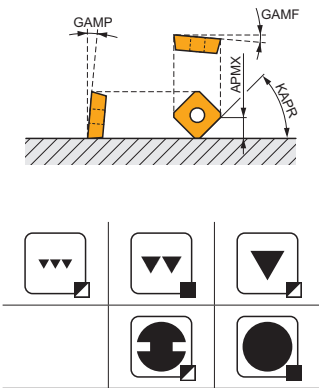
PRAMET



45° planfräs med positiv design, invändig kylning

Mycket produktiv 45° planfräs för enkelsidiga SE.. 09-skär med APMX 4,5 mm. För plan- och fasfräsning. Differentialdelade skärslägen. Finns med Weldonskaft och för dormmontering. Diametrar från 20 till 160 mm. Behandlad för lång livslängd.

KAPR	45°
APMX	4.5 mm



h_m	0.06 - 0.18
h_m	0.06 - 0.2



Product	DC	DCX	OAL	DCON MS	DCCB	DBC1	LU	LF	KWW	KWD	GAMF	GAMP			kg					
	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(°)	(°)								
20N2R032B20-SSE09-C	20	29.8	82	20	-	-	32	-	-	-	-5	20	2	-	24600	✓	0.26	G147	FA010	-
25N3R042B25-SSE09-C	25	34.8	98	25	-	-	42	-	-	-	-5	20	3	-	22000	✓	0.44	G147	FA010	-
32N4R042B32-SSE09-C	32	42	102	32	-	-	42	-	-	-	-5	20	4	-	19400	✓	0.68	G147	FA010	-
32A04R-S45SE09F-C	32	42	-	16	14	-	-	40	8.4	6.4	-5	20	4	✓	19400	✓	0.24	G147	FA012	-
40A04R-S45SE09F-C	40	53.2	-	16	14	-	-	40	8.4	6.4	-5	20	4	✓	17400	✓	0.30	G147	FA012	-
50A05R-S45SE09F-C	50	59.6	-	22	18	-	-	40	10.4	6.4	-5	20	5	✓	15600	✓	0.55	G147	FA013	-
63A05R-S45SE09F-C	63	75.8	-	22	18	-	-	40	10.4	6.4	-5	20	5	✓	13900	✓	0.66	G147	FA013	-
63A06R-S45SE09F-C	63	75.8	-	22	18	-	-	40	10.4	6.4	-5	20	6	✓	13900	✓	0.58	G147	FA013	-
80A06R-S45SE09F-C	80	89.6	-	27	38	-	-	50	12.4	7	-5	20	6	✓	12300	✓	1.14	G147	FA011	AC001
80A08R-S45SE09F-C	80	89.6	-	27	38	-	-	50	12.4	7	-5	20	8	✓	12300	✓	1.13	G147	FA011	AC001
100A08R-S45SE09F-C	100	110	-	32	45	-	-	50	14.4	8	-5	20	8	✓	11000	✓	1.83	G147	FA011	AC002
100A10R-S45SE09F-C	100	110	-	32	45	-	-	50	14.4	8	-5	20	10	✓	10900	✓	1.82	G147	FA011	AC002
125A09R-S45SE09F-C	125	134.5	-	40	60	-	-	63	16.4	9	-5	20	9	✓	9800	✓	3.87	G147	FA011	AC003
125A12R-S45SE09F-C	125	134.5	-	40	60	-	-	63	16.4	9	-5	20	12	✓	9800	✓	3.87	G147	FA011	AC003
160C10R-S45SE09F	160	169.6	-	40	-	66.7	-	63	16.4	9	-5	20	10	✓	8700	-	6.21	G147	FA014	-

G147	SEET 09T3AF.	SEMT 09T3AF.

FA010	US 3007-T09P	2.0	M 3	7.3	-	-	Flag T09P
FA011	US 3007-T09P	2.0	M 3	7.3	D-T07P/T09P	FG-15	-
FA012	US 3007-T09P	2.0	M 3	7.3	D-T07P/T09P	FG-15	HS 0830C
FA013	US 3007-T09P	2.0	M 3	7.3	D-T07P/T09P	FG-15	HS 1030C

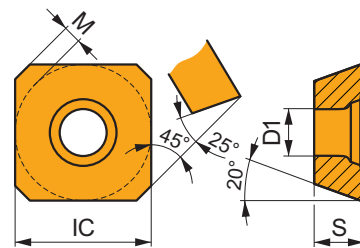
FA014	US 3007-T09P	2.0	M 3	7.3	D-T07P/T09P	FG-15	-	HS 1240C

AC001	KS 1230	K.FMH27
AC002	KS 1635	K.FMH32
AC003	KS 2040	K.FMH40

SEMT 09

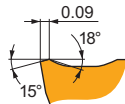
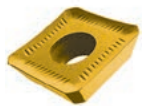


	IC	D1	M	S
	(mm)	(mm)	(mm)	(mm)
09T3	9.525	3.50	1.2	3.97



Lämplighet och startvärden för skärhastighet (vc), matning (f) och skärdjup (ap). Vi refererar till vår Dormer Pramet Calculator-app för vidare beräkningar.

Product	RE (mm)	P			M			K			N			S			H		
		vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)			



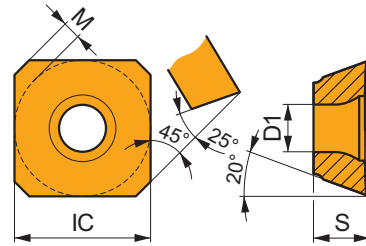
AFSN positiv design för fin till medelfin fräsning.

SEMT 09T3AFSN:8215		-		295	0.18	1.8		175	0.16	1.8		280	0.18	1.8	-	-	-	-	-	-
SEMT 09T3AFSN:M8330		-		290	0.18	1.8		170	0.16	1.8		275	0.18	1.8	-	-	-	-	-	-
SEMT 09T3AFSN:M8340		-		265	0.18	1.8		155	0.16	1.8		250	0.18	1.8	-	-	-	-	-	-
SEMT 09T3AFSN:M9325		-		365	0.18	1.8		-	-	-		345	0.18	1.8	-	-	-	-	-	-

SEET 09

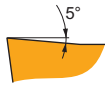


	IC	D1	M	S
	(mm)	(mm)	(mm)	(mm)
09T3	9.525	3.50	1.2	3.97



Lämplighet och startvärden för skärhastighet (vc), matning (f) och skärdjup (ap). Vi refererar till vår Dormer Pramet Calculator-app för vidare beräkningar.

Product	RE (mm)	P			M			K			N			S			H		
		vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)



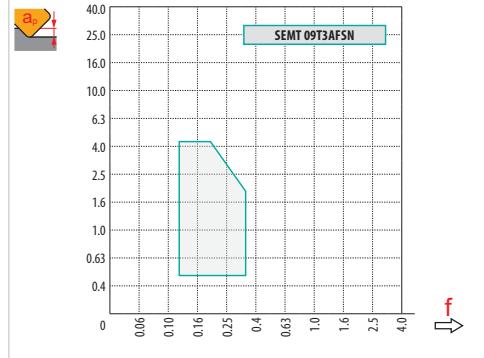
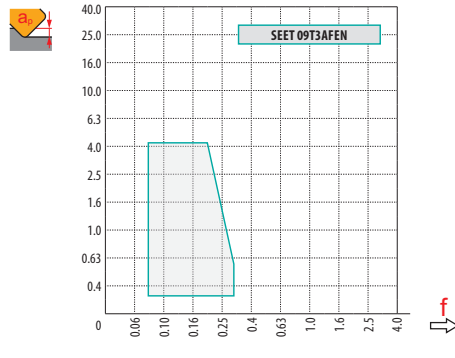
AFEN positiv design för fin till medelfin fräsning.

SEET 09T3AFEN:M6330	⌀	–	■	255	0.14	2.5	▣	180	0.13	2.5	■	–	–	–	▣	75	0.10	2.0	■	–	–	–
SEET 09T3AFEN:M8330	⌀	–	■	295	0.14	2.5	▣	175	0.13	2.5	■	–	–	–	▣	70	0.10	2.0	■	–	–	–
SEET 09T3AFEN:M8340	⌀	–	■	270	0.14	2.5	▣	160	0.13	2.5	■	–	–	–	▣	65	0.10	2.0	■	–	–	–
SEET 09T3AFEN:M9340	⌀	–	■	345	0.14	2.5	▣	205	0.13	2.5	■	–	–	–	▣	85	0.10	2.0	■	–	–	–



a_e / DC	5 %	10 %	15 %	20 %	25 %	30 %	40 %	50 %	60 %	70 %	75 %	80 %	90 %	100 %
	1.48	1.35	1.27	1.22	1.19	1.16	1.11	1.08	1.05	1.03	1.00	1.00	1.00	1.00
	2.20	1.60	1.35	1.20	1.10	0.95	0.85	0.75	0.85	0.95	1.00	1.00	1.00	1.00
	0.64	0.64	0.64	0.64	0.64	0.65	0.65	0.67	0.68	0.71	0.72	0.74	0.79	1.00

	SEET 09	SEMT 09
	-	-
	1.28	1.25



DC	X.V	f_{max}
20	1.20	0.18
25	1.24	0.20
32	1.29	0.23
40	1.33	0.25
50	1.37	0.28
63	1.41	0.32
80	1.46	0.36
100	1.50	0.40
125	1.55	0.45
160	1.60	0.51

SSN12Z



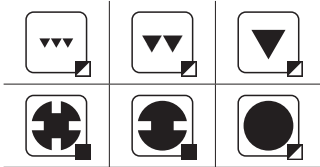
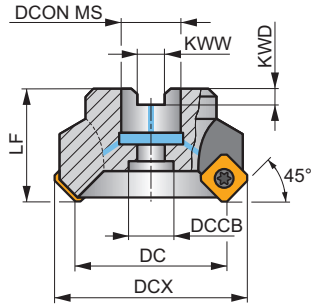
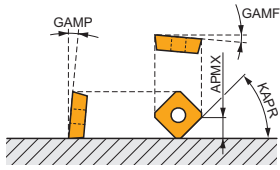
PRAMET



45° planfräs med positiv design, invändig kylning

Mycket produktiv 45° planfräs för enkelsidiga SN.. 12-skär med APMX 6,5 mm. För plan- och fasfräsning. Differentialdelade skärlägen. Finns endast för dormontering. Diametrar från 50 till 250 mm. Behandlad för lång livslängd.

KAPR	45°
APMX	6.5 mm



0.12 - 0.35



Product	DC	DCX	LF	DCON MS	DCCB	DBC1	KWW	KWD	GAMP	GAMP								
	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(°)	(°)								
63A05R-S45SN12Z-C	63	78	40	22	18	-	10.4	6.3	-5.5	7.5	5	-	8600	✓	0.62	G156	FA071	-
80A06R-S45SN12Z-C	80	95	50	27	38	-	12.4	7	-5.5	7.5	6	-	7700	✓	1.36	G156	FA071	AC001
100A07R-S45SN12Z-C	100	115	50	32	45	-	14.4	8	-5.5	7.5	7	-	6900	✓	1.70	G156	FA071	AC002
125A08R-S45SN12Z-C	125	140	63	40	56	-	16.4	9	-5.5	7.5	8	-	6100	✓	3.42	G156	FA071	AC003

G156	SNKT 1205AZ..	SNMT 1205AZ..

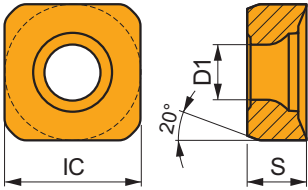
FA071	US 4511-T20	5.0	M 4.5	11	SDRT20-T

AC001	KS 1230	K.FMH27
AC002	KS 1635	K.FMH32
AC003	KS 2040	K.FMH40

SNMT 12

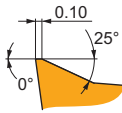


	IC (mm)	D1 (mm)	S (mm)
1205	12.700	5.20	5.56



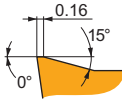
Lämplighet och startvärden för skärhastighet (vc), matning (f) och skärdjup (ap). Vi refererar till vår Dormer Pramet Calculator-app för vidare beräkningar.

Product	RE (mm)	P			M			K			N			S			H		
		vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)



M geometri med mycket positiv design för medelfin fräsning.

SNMT 1205AZSR-M:8215	☉	–	■	300	0.25	3.2	☑	180	0.23	3.2	☑	285	0.25	3.2	–	–	–	☑	75	0.18	2.6	–	–	–
SNMT 1205AZSR-M:M8330	☉	–	■	300	0.25	3.2	■	180	0.23	3.2	☑	285	0.25	3.2	–	–	–	☑	75	0.18	2.6	–	–	–
SNMT 1205AZSR-M:M8340	☉	–	■	275	0.25	3.2	■	165	0.23	3.2	☑	260	0.25	3.2	–	–	–	☑	65	0.18	2.6	–	–	–
SNMT 1205AZSR-M:M9325	☉	–	■	365	0.25	3.2	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–



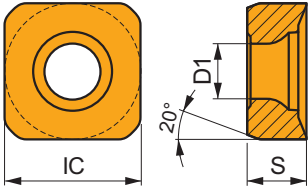
R geometri med positiv design för medelgrov till grovfräsning.

SNMT 1205AZSR-R:8215	☉	–	■	290	0.27	3.5	☑	170	0.24	3.5	☑	275	0.27	3.5	–	–	–	☑	70	0.22	2.8	–	–	–
SNMT 1205AZSR-R:M5315	☉	–	■	365	0.27	3.5	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
SNMT 1205AZSR-R:M8330	☉	–	■	290	0.27	3.5	☑	170	0.24	3.5	☑	275	0.27	3.5	–	–	–	☑	70	0.22	2.8	–	–	–
SNMT 1205AZSR-R:M8340	☉	–	■	270	0.27	3.5	☑	160	0.24	3.5	☑	255	0.27	3.5	–	–	–	☑	65	0.22	2.8	–	–	–
SNMT 1205AZSR-R:M9325	☉	–	■	355	0.27	3.5	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–

SNKT 12

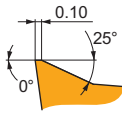


	IC (mm)	D1 (mm)	S (mm)
1205	12.700	5.20	5.56



Lämplighet och startvärden för skärhastighet (vc), matning (f) och skärdjup (ap). Vi refererar till vår Dormer Pramet Calculator-app för vidare beräkningar.

Product	RE (mm)	P			M			K			N			S			H		
		vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)



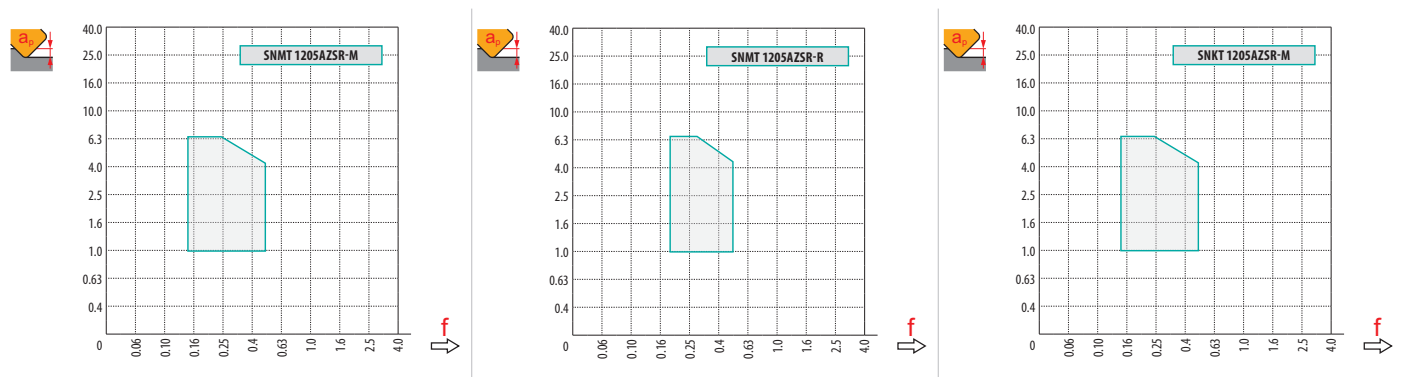
M geometri med mycket positiv design för medelfin fräsning.

SNKT 1205AZSR-M:M8330	☉	–	■	305	0.24	3.2	■	180	0.22	3.2	☑	285	0.24	3.2	–	–	–	☑	75	0.17	2.6	–	–	–
SNKT 1205AZSR-M:M8340	☉	–	■	275	0.24	3.2	■	165	0.22	3.2	☑	260	0.24	3.2	–	–	–	☑	65	0.17	2.6	–	–	–



a_e / DC	5 %	10 %	15 %	20 %	25 %	30 %	40 %	50 %	60 %	70 %	75 %	80 %	90 %	100 %
	1.48	1.35	1.27	1.22	1.19	1.16	1.11	1.08	1.05	1.03	1.00	1.00	1.00	1.00
	2.20	1.60	1.35	1.20	1.10	0.95	0.85	0.75	0.85	0.95	1.00	1.00	1.00	1.00
	0.64	0.64	0.64	0.64	0.64	0.65	0.65	0.67	0.68	0.71	0.72	0.74	0.79	1.00

	SNMT 12-M	SNMT 12-R	SNKT 12-M
	-	-	-
	0.95	1.03	1.59



		f_{max}
63	1.34	0.53
80	1.39	0.60
100	1.43	0.67
125	1.47	0.74

FSB22X



PRAMET

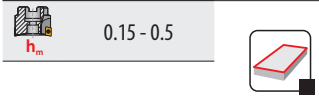
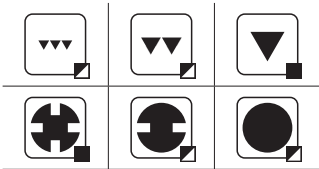
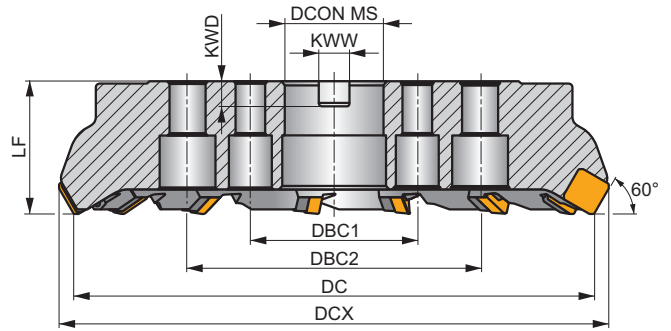
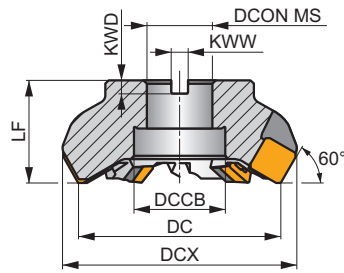
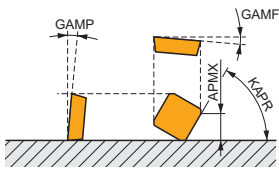


ROUGH SB 60° planfräs med positiv design, för tung planfräsning

Mycket produktiv 60° planfräs för enkelsidiga SB.. 22-skär med APMX 15 mm. Optimerad för tung planfräsning med mjuk gång. Differentialdelade skärlägen. Finns endast för dormmontering. Diametrar från 125 till 315 mm. Behandlad för lång livslängd.

ROUGH SB

KAPR	60°
APMX	15.0 mm



Product	DC	DCX	LF	DCON MS	DCCB	DBC1	DBC2	KWW	KWD	GAMF	GAMP					kg			
	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(°)	(°)								
125B07R-F60SB22X	125	144.4	63	40	56	-	-	16.4	9	-9	9	7	✓	-	-	3.73	G144	FA111	AC003
160C08R-F60SB22X	160	178.7	63	40	-	66.7	-	16.4	9	-9	9	8	✓	-	-	6.46	G144	FA114	-
200C08R-F60SB22X	200	217.9	63	60	-	101.6	-	25.7	14	-9	9	8	✓	-	-	10.59	G144	FA115	-
250C09R-F60SB22X	250	267.4	63	60	-	101.6	-	25.7	14	-9	9	9	✓	-	-	17.54	G144	FA115	-

G144	SBKX 2207DZ..	SBMR 2207DZ..

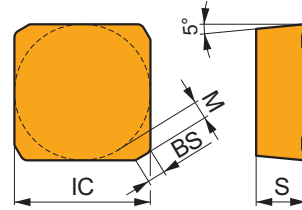
FA111	LNx 220616	US 6013-T20P	SDR T20P-T	KU SBMR 2207	DS 01Z	KL 04	-
FA114	LNx 220616	US 6013-T20P	SDR T20P-T	KU SBMR 2207	DS 01Z	KL 04	HS 1240
FA115	LNx 220616	US 6013-T20P	SDR T20P-T	KU SBMR 2207	DS 01Z	KL 04	HS 1655

AC003	KS 2040	K.FMH40

SBMR 22

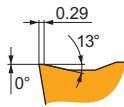
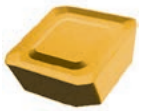


	IC (mm)	M (mm)	S (mm)	BS (mm)
2207	22.000	2.8	8.00	1.99



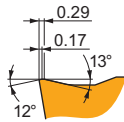
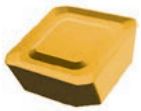
Lämplighet och startvärden för skärhastighet (vc), matning (f) och skärdjup (ap). Vi refererar till vår Dormer Pramet Calculator-app för vidare beräkningar.

Product	RE (mm)	P			M			K			N			S			H		
		vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)



DZSR stabil design för grovfräsning.

SBMR 2207DZSR:M8326	☉	-	140	0.38	8.5	-	-	-	130	0.38	8.5	-	-	-	-	-	-	-	-
SBMR 2207DZSR:M8346	☉	-	120	0.38	8.5	70	0.38	8.5	-	-	-	-	-	-	-	-	-	-	



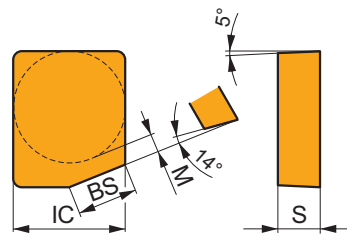
R geometri med stabil design för grovfräsning.

SBMR 2207DZSR-R:M5326	☉	-	160	0.44	9.8	-	-	-	150	0.44	9.8	-	-	-	-	-	-	-
SBMR 2207DZSR-R:M8326	☉	-	135	0.44	9.8	-	-	-	125	0.44	9.8	-	-	-	-	-	-	-
SBMR 2207DZSR-R:M8346	☉	-	115	0.44	9.8	65	0.40	9.8	-	-	-	-	-	-	-	-	-	

SBKX 22

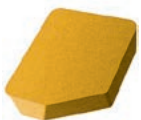


	IC (mm)	M (mm)	S (mm)	BS (mm)
2207	22.000	3.2	8.00	11.84



Lämplighet och startvärden för skärhastighet (vc), matning (f) och skärdjup (ap). Vi refererar till vår Dormer Pramet Calculator-app för vidare beräkningar.

Product	RE (mm)	P			M			K			N			S			H		
		vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)



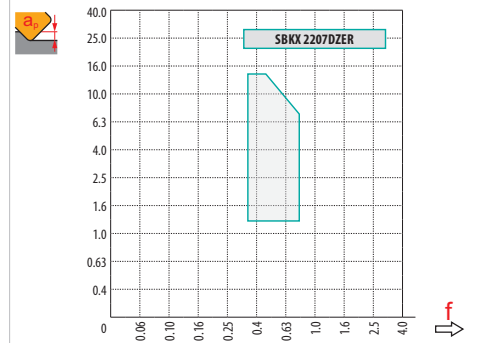
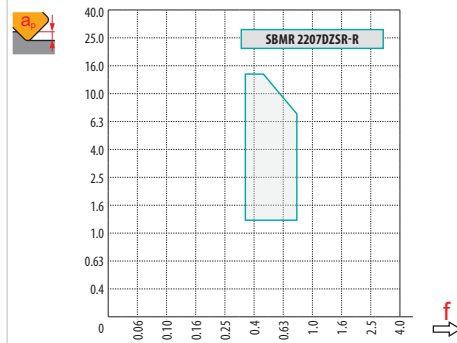
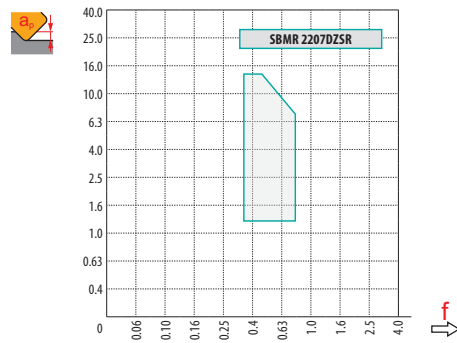
DZER wiper-design med neutral spånvinkel för bättre ytfinit.

SBKX 2207DZER:M8326	☉	-	100	0.60	8.5	-	-	-	95	0.60	8.5	-	-	-	-	-	-	-
---------------------	---	---	-----	------	-----	---	---	---	----	------	-----	---	---	---	---	---	---	---



















a_e / DC	5 %	10 %	15 %	20 %	25 %	30 %	40 %	50 %	60 %	70 %	75 %	80 %	90 %	100 %
	1.48	1.35	1.27	1.22	1.19	1.16	1.11	1.08	1.05	1.03	1.00	1.00	1.00	1.00
	2.20	1.60	1.35	1.20	1.10	0.95	0.85	0.75	0.85	0.95	1.00	1.00	1.00	1.00
	0.64	0.64	0.64	0.64	0.64	0.65	0.65	0.67	0.68	0.71	0.72	0.74	0.79	1.00

	SBMR 22	SBMR 22-R	SBKX 22
	-	-	-
	1.99	1.99	11.84



INDEXABLE FACE MILLS – NAVIGATOR

FACE MILLING

	SOD05	SOD06D	SOE06Z			
	45°	45°	43°			
	APMX (mm) 2.7 (10.0)	APMX (mm) 3.1 (8.6)	APMX (mm) 3.3 (9.9)			
	DCX (mm) 32 – 125	DC (mm) 63 – 160	DC (mm) 50 – 200			
Cylindrical shank	 DC = 32, 40 (mm)					
Weldon						
Modular						
Shell mill	 DC = 40 – 125 (mm)					
Page	42	51	55			
ISO	P M K N	P M K S H	P M N S			
Insert shape						
Inserts	OD.. 0505 RD.. 1205 SD.. 1205	OD.. 0605 RPE. 1505	OEHT 0604 REHT 1604 XEHT 0604			
No. of cutting edges	8 / 8 / 4	8 / 8	8 / 8 / 1			
Face milling 	■	■	■			
Chamfer milling 	■	■	■			
Helical interpolation 	■		▣			
Progressive plunging 	■		▣			
Ramping 	■		▣			
Shape surfaces milling (copy milling) 	■		▣			
Shallow shoulder milling 	■					
Shallow slot milling 	■					
Plunge milling 	■					

SOD05



PRAMET

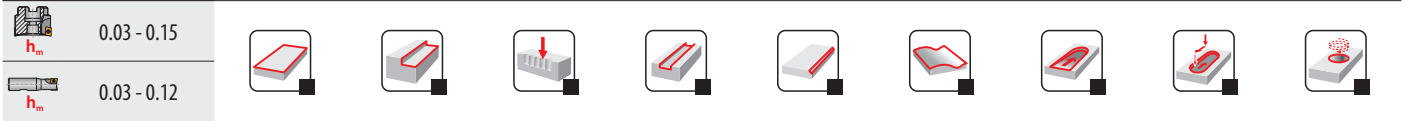
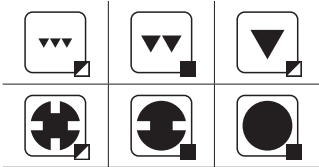
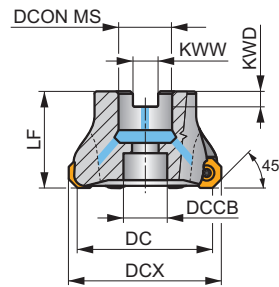
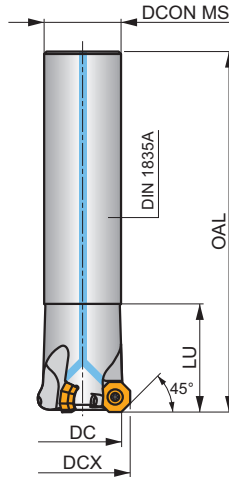
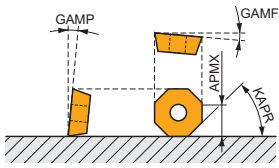
S



Universell planfräs med positiv design, invändig kylning

Highly productive universal face mill utilising single-sided positive inserts with APMX up to 2.7 (10) mm. Unique insert seat fits OD.. 05, RD.. 12 and SD.. 12 style inserts, suited for wide range of applications. Differential tooth pitch. Arbor and cylindrical style. Body treated for longer tool life.

KAPR	45°
APMX	2.7 (10.0) mm



Product	DCX	DC	OAL	DCON MS	DCCB	LU	LF	KAPR	KWW	KWD	GAMP	GAMP	max.	kg	FA040	FA041	FA042	FA043	FA049	
	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(°)	(mm)	(mm)	(°)	(°)								
32N3R045A25-SOD05-C	32	24.7	130	25	-	45	-	45	-	-	-10	8	3	-	17700	✓	0.41	GI326	FA049	-
40N3R045A32-SOD05-C	40	32.6	150	32	-	45	-	45	-	-	-7	8	3	-	15800	✓	0.86	GI326	FA040	-
40A03R-S450D05-C	40	32.7	-	16	14	-	40	45	8.4	5.6	-10	8	3	-	15800	✓	0.18	GI326	FA042	-
50A04R-S450D05-C	50	42.6	-	22	18	-	40	45	10.4	6.3	-7	8	4	-	14100	✓	0.28	GI326	FA043	-
50A05R-S450D05-C	50	42.6	-	22	18	-	40	45	10.4	6.3	-7	8	5	-	14100	✓	0.28	GI326	FA043	-
63A05R-S450D05-C	63	55.6	-	22	18	-	40	45	10.4	6.3	-7	8	5	✓	12600	✓	0.39	GI326	FA043	-
63A06R-S450D05-C	63	55.6	-	22	18	-	40	45	10.4	6.3	-7	8	6	✓	12600	✓	0.50	GI326	FA043	-
80A06R-S450D05-C	80	72.6	-	27	38	-	50	45	12.4	7	-7	8	6	✓	11100	✓	0.73	GI326	FA041	AC001
80A08R-S450D05-C	80	72.6	-	27	38	-	50	45	12.4	7	-7	8	8	✓	11100	✓	0.66	GI326	FA041	AC001
100A07R-S450D05-C	100	92.6	-	32	45	-	50	45	14.4	8	-7	8	7	✓	10000	✓	1.09	GI326	FA041	AC002
125A08R-S450D05-C	125	117.6	-	40	56	-	63	45	16.4	9	-7	8	8	✓	8900	✓	2.20	GI326	FA041	AC003

GI326	OD.. 0505..	RD.. 1205..	SDKT 1205..	SDMT 1205..SN

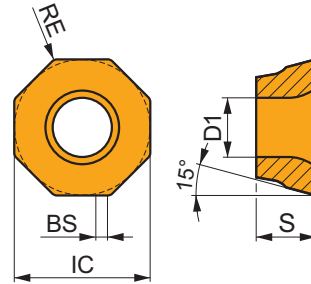
FA040	US 45014-T20P	5.0	M 5	13	Flag T20P	-	-	-
FA041	US 45014-T20P	5.0	M 5	13	-	SDR T20P-T	-	-
FA042	US 45014-T20P	5.0	M 5	13	-	SDR T20P-T	HS 90835	-
FA043	US 45014-T20P	5.0	M 5	13	-	SDR T20P-T	HS 1030C	-
FA049	US 45011-T20P	5.0	M 5	11	Flag T20P	-	-	-

AC001	KS 1230	K.FMH27
AC002	KS 1635	K.FMH32
AC003	KS 2040	K.FMH40

ODKT 05IM

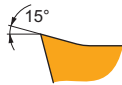
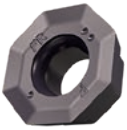


	IC	D1	S	BS
	(mm)	(mm)	(mm)	(mm)
0505	12.700	5.50	5.56	1.00



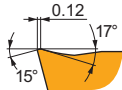
Lämplighet och startvärden för skärhastighet (vc), matning (f) och skärdjup (ap). Vi refererar till vår Dormer Pramet Calculator-app för vidare beräkningar.

Product	RE (mm)	P			M			K			N			S			H		
		vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)



F geometri, 45° planfräskär med mycket positiv design för finfräsning.

ODKT 0505ADFR-F:M8310	● 0.8	■ 275	■ 0.15	■ 2.5	■ 140	■ 0.14	■ 2.5	■ -	■ -	■ -	■ -	■ -	■ -	■ -	■ -	■ -	■ -	■ -	■ -
------------------------------	-------	-------	--------	-------	-------	--------	-------	-----	-----	-----	-----	-----	-----	-----	-----	-----	-----	-----	-----



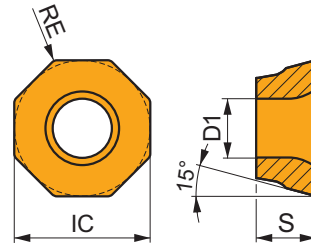
FM geometri, 45° planfräskär med positiv design för fin till medelfin fräsning.

ODKT 0505ADSR-FM:M6330	● 0.8	■ 190	■ 0.25	■ 2.5	■ 135	■ 0.23	■ 2.5	■ -	■ -	■ -	■ -	■ -	■ -	■ -	■ -	■ -	■ -	■ -	■ -
ODKT 0505ADSR-FM:M8310	● 0.8	■ 240	■ 0.25	■ 2.5	■ 120	■ 0.23	■ 2.5	■ 225	■ 0.25	■ 2.5	■ -	■ -	■ -	■ -	■ -	■ -	■ -	■ -	■ -
ODKT 0505ADSR-FM:M8330	● 0.8	■ 225	■ 0.25	■ 2.5	■ 135	■ 0.23	■ 2.5	■ 210	■ 0.25	■ 2.5	■ -	■ -	■ -	■ -	■ -	■ -	■ -	■ -	■ -
ODKT 0505ADSR-FM:M8345	● 0.8	■ 160	■ 0.25	■ 2.5	■ 95	■ 0.23	■ 2.5	■ -	■ -	■ -	■ -	■ -	■ -	■ -	■ -	■ -	■ -	■ -	■ -
ODKT 0505ADSR-FM:M9340	● 0.8	■ 245	■ 0.25	■ 2.5	■ 145	■ 0.23	■ 2.5	■ -	■ -	■ -	■ -	■ -	■ -	■ -	■ -	■ -	■ -	■ -	■ -

ODMT 05IM

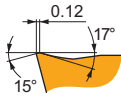


	IC (mm)	D1 (mm)	S (mm)
0505	12.700	5.50	5.56



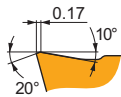
Lämplighet och startvärden för skärhastighet (vc), matning (f) och skärdjup (ap). Vi refererar till vår Dormer Pramet Calculator-app för vidare beräkningar.

Product	RE (mm)	P			M			K			N			S			H		
		vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)



FM geometri, 45° planfräskär med positiv design för fin till medelfin fräsning.

ODMT 0505ADSR-FM:M8340	0.8	200	0.25	2.5	120	0.23	2.5	190	0.25	2.5	-	-	-	-	-	-	-	-	-
ODMT 0505ADSR-FM:M9340	0.8	245	0.25	2.5	145	0.23	2.5	-	-	-	-	-	-	-	-	-	-	-	-



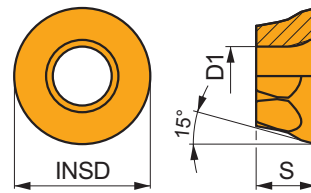
R geometri, 45° planfräskär med positiv design för instabila förhållanden.

ODMT 050508SN-R:M8330	0.8	190	0.25	2.5	-	-	-	180	0.25	2.5	-	-	-	-	-	-	-	-	-
ODMT 050508SN-R:M9340	0.8	210	0.25	2.5	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-

RDGT 12IM

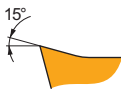


	INSD (mm)	D1 (mm)	S (mm)
1205	12.700	5.50	5.56



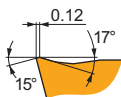
Lämplighet och startvärden för skärhastighet (vc), matning (f) och skärdjup (ap). Vi refererar till vår Dormer Pramet Calculator-app för vidare beräkningar.

Product	RE (mm)	P			M			K			N			S			H		
		vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)



F geometri med mycket positiv design för finfräsning.

RDGT 120500FN-F:M8310	-	210	0.20	1.5	105	0.18	1.5	-	-	-	-	-	-	-	-	-	-	-	-
------------------------------	---	-----	------	-----	-----	------	-----	---	---	---	---	---	---	---	---	---	---	---	---

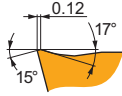


FM geometri med positiv design för fin till medelfin fräsning.

RDGT 120500SN-FM:M8330	-	190	0.20	1.5	110	0.18	1.5	180	0.20	1.5	-	-	-	-	-	-	-	-	-
-------------------------------	---	-----	------	-----	-----	------	-----	-----	------	-----	---	---	---	---	---	---	---	---	---

Lämplighet och startvärden för skärhastighet (vc), matning (f) och skärdjup (ap). Vi refererar till vår Dormer Pramet Calculator-app för vidare beräkningar.

Product	RE (mm)	P			M			K			N			S			H		
		vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)



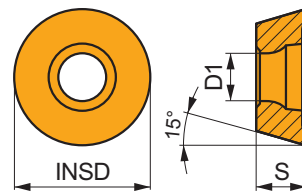
FM geometri med positiv design för fin till medelfin fräsning.

RDGT 120500SN-FM:M8345	●	-	■	140	0.20	1.5	■	80	0.18	1.5	■	-	-	-	■	-	-	-	■	-	-	-
------------------------	---	---	---	-----	------	-----	---	----	------	-----	---	---	---	---	---	---	---	---	---	---	---	---

RDMT 12IM

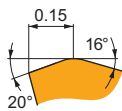


	INSD (mm)	D1 (mm)	S (mm)
1205	12.700	5.50	5.56



Lämplighet och startvärden för skärhastighet (vc), matning (f) och skärdjup (ap). Vi refererar till vår Dormer Pramet Calculator-app för vidare beräkningar.

Product	RE (mm)	P			M			K			N			S			H		
		vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)



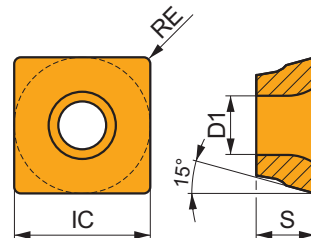
R geometri, kopier- och profilfräskär med positiv design för instabila förhållanden.

RDMT 120500SN-R:M8330	●	-	■	175	0.30	1.5	■	-	-	-	■	165	0.30	1.5	■	-	-	-	■	-	-	-
RDMT 120500SN-R:M8340	●	-	■	160	0.30	1.5	■	-	-	-	■	150	0.30	1.5	■	-	-	-	■	-	-	-

SDKT 12IM

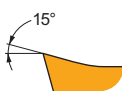


	IC (mm)	D1 (mm)	S (mm)
1205	12.700	5.50	5.56



Lämplighet och startvärden för skärhastighet (vc), matning (f) och skärdjup (ap). Vi refererar till vår Dormer Pramet Calculator-app för vidare beräkningar.

Product	RE (mm)	P			M			K			N			S			H		
		vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)

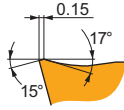
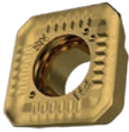


F geometri, 90° hörnfräskär med mycket positiv design för finfräsning.

SDKT 1205PDFR-F:8215	●	0.8	■	285	0.10	4.0	■	170	0.09	4.0	■	-	-	-	■	855	0.12	4.0	■	-	-	-
----------------------	---	-----	---	-----	------	-----	---	-----	------	-----	---	---	---	---	---	-----	------	-----	---	---	---	---

Lämplighet och startvärden för skärhastighet (vc), matning (f) och skärdjup (ap). Vi refererar till vår Dormer Pramet Calculator-app för vidare beräkningar.

Product	RE (mm)	P			M			K			N			S			H		
		vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)



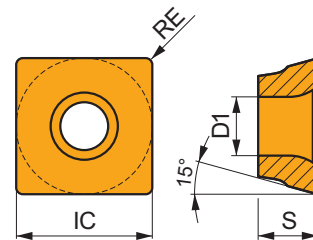
FM geometri, 90° hörnfräskär med positiv design för fin till medelfin fräsning.

SDKT 1205AESN-FM:M8330	0.8	280	0.15	4.0	165	0.15	4.0	265	0.15	4.0	-	-	-	-	-	-	-	-	-
SDKT 1205AESN-FM:M8345	-	205	0.15	4.0	120	0.15	4.0	-	-	-	-	-	-	-	-	-	-	-	-
SDKT 1205PDSR-FM:M8330	0.8	255	0.15	4.0	150	0.15	4.0	240	0.15	4.0	-	-	-	-	-	-	-	-	-
SDKT 1205PDSR-FM:M8345	0.8	185	0.15	4.0	110	0.15	4.0	-	-	-	-	-	-	-	-	-	-	-	-

SDMT 12IM

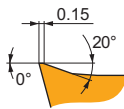
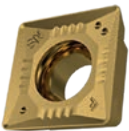


	IC (mm)	D1 (mm)	S (mm)
1205	12.700	5.50	5.56



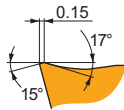
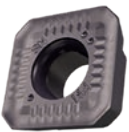
Lämplighet och startvärden för skärhastighet (vc), matning (f) och skärdjup (ap). Vi refererar till vår Dormer Pramet Calculator-app för vidare beräkningar.

Product	RE (mm)	P			M			K			N			S			H		
		vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)



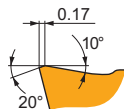
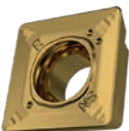
F geometri, 90° hörnfräskär med positiv design för fin till medelfin fräsning.

SDMT 120508SN-F:M8310	0.8	265	0.15	4.0	135	0.15	4.0	-	-	-	-	-	-	-	-	-	-	-	-
SDMT 120508SN-F:M8330	0.8	245	0.15	4.0	145	0.15	4.0	-	-	-	735	0.18	4.0	-	-	-	-	-	-



FM geometri, 90° hörnfräskär med positiv design för medelfin fräsning.




SDMT 120508SN-FM:M8345	0.8	175	0.15	4.0	105	0.15	4.0	-	-	-	-	-	-	-	-	-	-	-	-
------------------------	-----	-----	------	-----	-----	------	-----	---	---	---	---	---	---	---	---	---	---	---	---









R geometri, 90° hörnfräskär med positiv design för instabila förhållanden.




SDMT 120508SN-R:M8330	0.8	225	0.20	4.0	-	-	-	210	0.20	4.0	-	-	-	-	-	-	-	-	-
SDMT 120508SN-R:M8345	0.8	165	0.20	4.0	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-
SDMT 1205AESN-R:M8330	-	265	0.20	4.0	-	-	-	250	0.20	4.0	-	-	-	-	-	-	-	-	-
SDMT 1205AESN-R:M8340	-	240	0.20	4.0	-	-	-	225	0.20	4.0	-	-	-	-	-	-	-	-	-

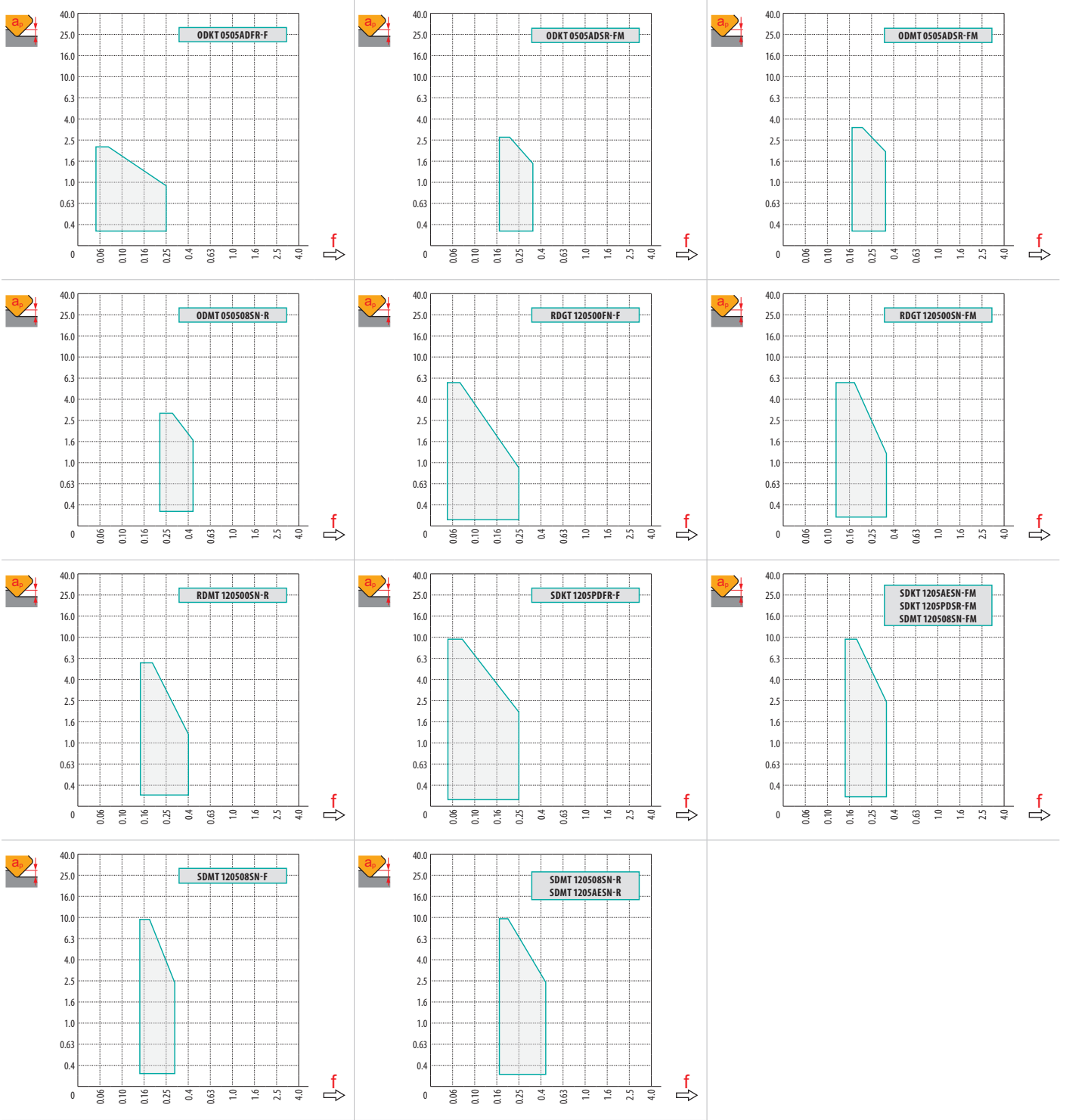


a_e / DCX	5 %	10 %	15 %	20 %	25 %	30 %	40 %	50 %	60 %	70 %	75 %	80 %	90 %	100 %
	1.48	1.35	1.27	1.22	1.19	1.16	1.11	1.08	1.05	1.03	1.00	1.00	1.00	1.00
	2.20	1.60	1.35	1.20	1.10	0.95	0.85	0.75	0.85	0.95	1.00	1.00	1.00	1.00
	0.64	0.64	0.64	0.64	0.64	0.65	0.65	0.67	0.68	0.71	0.72	0.74	0.79	1.00

	ODKT 05-F	ODKT 05-FM	ODMT 05-FM	ODMT 05-R
	0.4	0.8	0.8	0.8
	1.00	1.00	–	–

	RDGT 12-F	RDGT 12-FM	RDGT 12-R
	6.35	6.35	6.35
	–	–	–

	SDKT 12-F	SDKT 12-FM	SDMT 12-F	SDMT 12-R
	0.8	0.8	0.8	0.8
	2.30	2.30	–	–



		R												
		0.25	0.50	0.60	0.70	0.80	1.00	1.25	1.50	2.00	3.00	4.00	5.00	6.00
32		23.43	24.80	25.23	25.62	25.99	26.63	27.33	27.94	28.94	30.39	31.31	31.83	32.00
40		31.43	32.80	33.23	33.62	33.99	34.63	35.33	35.94	36.94	38.39	39.31	39.83	40.00
50		41.43	42.80	43.23	43.62	43.99	44.63	45.33	45.94	46.94	48.39	49.31	49.83	50.00
63		54.43	55.80	56.23	56.62	56.99	57.63	58.33	58.94	59.94	61.39	62.31	62.83	63.00
80		71.43	72.80	73.23	73.62	73.99	74.63	75.33	75.94	76.94	78.39	79.31	79.83	80.00
100		91.43	92.80	93.23	93.62	93.99	94.63	95.33	95.94	96.94	98.39	99.31	99.83	100.00
125		116.43	117.80	118.23	118.62	118.99	119.63	120.33	120.94	121.94	123.39	124.31	124.83	125.00



		f_{max}
32	1.36	0.28
40	1.40	0.31
50	1.43	0.33
63	1.47	0.37
80	1.52	0.42
100	1.57	0.47
125	1.62	0.52



S



10.0



S

a_p	1.0	5.0	10.0
	0.35	0.21	0.15



O

	RPMX	APMX/I
50	4.1°	7.05/100
63	2.7°	4.6/100
80	1.8°	3/100
100	1.7°	2.85/100
125	0.7°	1.1/100

R

	RPMX	APMX/I
50	3.8°	6.2/95
63	2.5°	4.25/100
80	1.7°	2.85/100
100	1.6°	2.65/100
125	0.3°	0.4/100



O

	DMIN	DMAX		
50	78.0	100.0	4.5	4.5
63	105.0	126.0	4.5	4.5
80	138.0	160.0	4.5	4.5
100	178.0	200.0	4.5	4.5
125	229.0	250.0	4.0	4.5

R

	DMIN	DMAX		
50	78.0	100.0	4.5	4.5
63	105.0	126.0	4.5	4.5
80	138.0	160.0	4.5	4.5
100	178.0	200.0	4.5	4.5
125	230.0	250.0	4.0	4.5



2.4

2.3



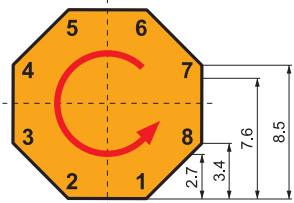
	μm	3	5	10	15	20	30	40	50	60	80	100
32		0.620	0.800	1.131	1.386	1.600	1.960	2.263	2.530	2.771	3.200	3.578
40		0.693	0.894	1.265	1.549	1.789	2.191	2.530	2.828	3.098	3.578	4.000
50		0.775	1.000	1.414	1.732	2.000	2.449	2.828	3.162	3.464	4.000	4.472
63		0.869	1.122	1.587	1.944	2.245	2.750	3.175	3.550	3.888	4.490	5.020
80		0.980	1.265	1.789	2.191	2.530	3.098	3.578	4.000	4.382	5.060	5.657
100		1.095	1.414	2.000	2.449	2.828	3.464	4.000	4.472	4.899	5.657	6.325
125		1.225	1.581	2.236	2.739	3.162	3.873	4.472	5.000	5.477	6.325	7.071

	μm	3	5	10	15	20	30	40	50	60	80	100
6.0		0.379	0.490	0.693	0.849	0.980	1.200	1.386	1.549	1.697	1.960	2.191

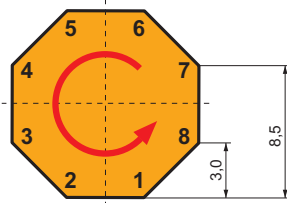


ODKT 05

ODMT 05



a_p	
→ 2.7	8
→ 3.4	7
→ 7.6	4
→ 8.5	2

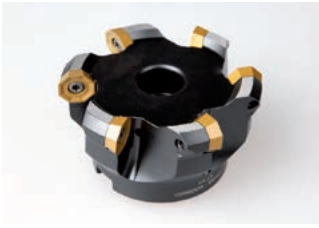


a_p	
→ 3.0	8
→ 8.5	4

SOD06D



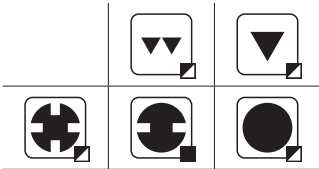
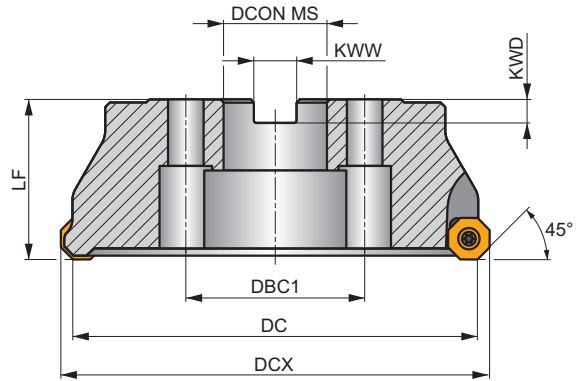
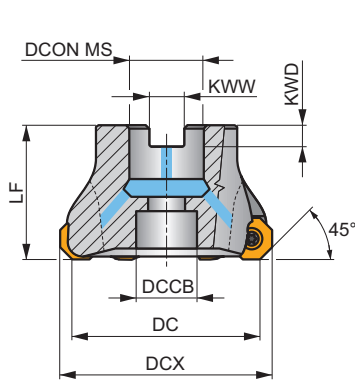
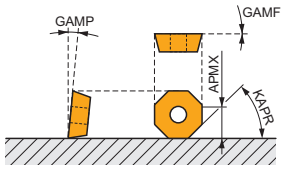
PRAMET



Universell planfräs med positiv design, invändig kylning

Highly productive universal face mill utilising single sided positive inserts with APMX of up to 3.1 (8.6) mm. Unique insert seat fits OD.. 06 and RP.. 15 style inserts, suited for face milling and chamfering. Arbor style only with differential tooth pitch. Body treated for longer tool life.

KAPR	45°
APMX	3.1 (8.6) mm



0.12 - 0.22



Product	DC (mm)	DCX (mm)	LF (mm)	DCON MS (mm)	DCCB (mm)	DBC1 (mm)	KWW (mm)	KWD (mm)	GAMF (°)	GAMP (°)						
63A05R-S450D06D	63	72.5	40	22	18	-	10.4	6.3	0	5	5	✓	8800	✓	0.55	GI059 FA071
80A06R-S450D06D	80	89.5	50	27	20	-	12.4	7	0	5	6	✓	7800	✓	1.19	GI059 FA071
100A07R-S450D06D	100	109.5	50	32	27	-	14.4	8	0	5	7	✓	7000	✓	2.07	GI059 FA071
125A08R-S450D06D	125	134.5	63	40	33	-	16.4	9	0	5	8	✓	6300	✓	4.05	GI059 FA071
160C09R-S450D06D	160	169.5	63	40	56	66.7	16.4	9	0	5	9	✓	5500	-	6.49	GI059 FA071

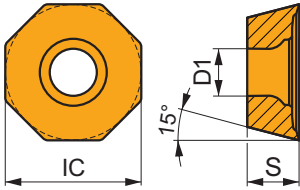
	GI059		OD.. 0605ZZ..		RP.. 1505MO..
--	-------	--	---------------	--	---------------

	FA071		US 4511-T20		5.0		M 4.5		11		SDR T20-T
--	-------	--	-------------	--	-----	--	-------	--	----	--	-----------

ODMT 06

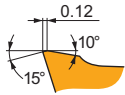


	IC (mm)	D1 (mm)	S (mm)
0605	15.875	5.50	5.56



Lämplighet och startvärden för skärhastighet (vc), matning (f) och skärdjup (ap). Vi refererar till vår Dormer Pramet Calculator-app för vidare beräkningar.

Product	RE (mm)	P			M			K			N			S			H		
		vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)



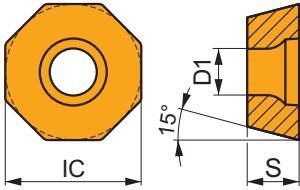
ZZN något positiv design, 45° planfränskär för medelfin fräsning.

ODMT 0605ZSN:M5315	☼	–	☑	255	0.24	3.0	–	–	–	■	240	0.24	3.0	–	–	–	–	–	–
ODMT 0605ZSN:M8330	☼	–	■	200	0.24	3.0	–	–	–	■	190	0.24	3.0	–	–	–	–	–	–
ODMT 0605ZSN:M8340	☼	–	■	185	0.24	3.0	–	–	–	☑	175	0.24	3.0	–	–	–	–	–	–
ODMT 0605ZSN:M9325	☼	–	■	245	0.24	3.0	–	–	–	■	230	0.24	3.0	–	–	–	–	–	–

ODEW 06

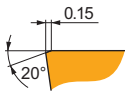


	IC (mm)	D1 (mm)	S (mm)
0605	15.875	5.50	5.56



Lämplighet och startvärden för skärhastighet (vc), matning (f) och skärdjup (ap). Vi refererar till vår Dormer Pramet Calculator-app för vidare beräkningar.

Product	RE (mm)	P			M			K			N			S			H		
		vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)



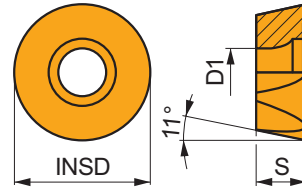
ZZN vändskär 45° med neutral spånvinkel för medelfin planfräsning.

ODEW 0605ZSN:M8330	☼	–	☑	210	0.26	2.5	–	–	–	■	195	0.26	2.5	–	–	–	–	–	☑	40	0.13	1.0
---------------------------	---	---	---	-----	------	-----	---	---	---	---	-----	------	-----	---	---	---	---	---	---	----	------	-----

RPET 15

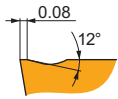


	INSD	D1	S
	(mm)	(mm)	(mm)
1505	15.785	5.50	5.56



Lämplighet och startvärden för skärhastighet (vc), matning (f) och skärdjup (ap). Vi refererar till vår Dormer Pramet Calculator-app för vidare beräkningar.

Product	RE (mm)	P			M			K			N			S			H		
		vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)



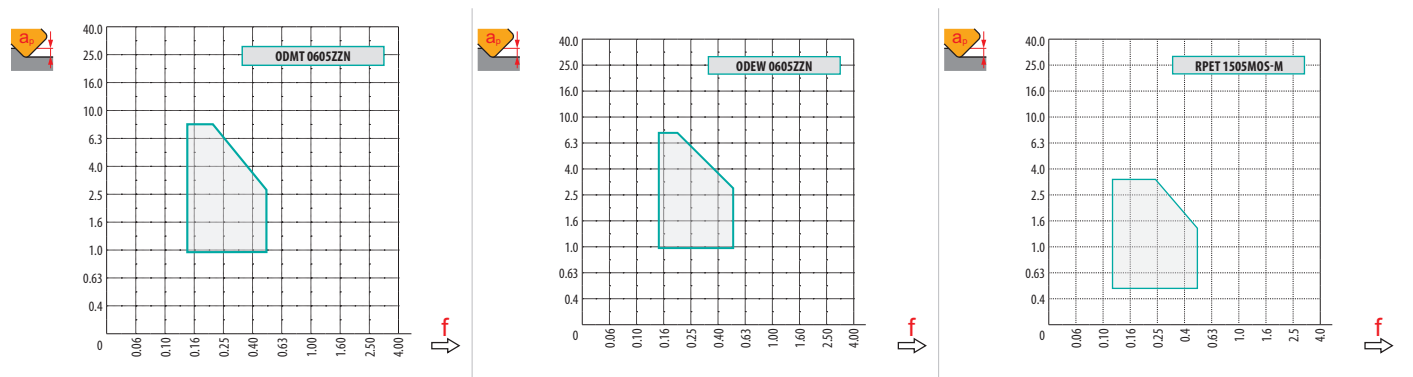
M geometri, kopier- och profilfräskär med positiv design för fin till grov fräsning.

RPET 1505MOS-M:M8330	✳	-	230	0.40	1.0	135	0.36	1.0	215	0.40	1.0	-	-	-	55	0.28	0.8	-	-	-
-----------------------------	---	---	-----	------	-----	-----	------	-----	-----	------	-----	---	---	---	----	------	-----	---	---	---



a_e / DC	5%	10%	15%	20%	25%	30%	40%	50%	60%	70%	75%	80%	90%	100%
	1.48	1.35	1.27	1.22	1.19	1.16	1.11	1.08	1.05	1.03	1.00	1.00	1.00	1.00
	2.20	1.60	1.35	1.20	1.10	0.95	0.85	0.75	0.85	0.95	1.00	1.00	1.00	1.00
	0.64	0.64	0.64	0.64	0.64	0.65	0.65	0.67	0.68	0.71	0.72	0.74	0.79	1.00

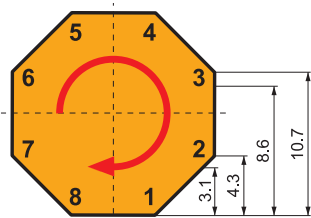
	ODMT 06	ODEW 06	RPET 15-M
	-	-	7.89
	1.73	5.92	-



	R									
		0.00	0.50	0.75	1.25	1.50	2.00	2.50	3.00	4.00
63		56.63	62.17	63.36	65.18	65.91	67.16	68.19	69.05	70.41
80		73.63	79.17	80.36	82.18	82.91	84.16	85.19	86.05	87.41
100		93.63	99.17	100.36	102.18	102.91	104.16	105.19	106.05	107.41
125		118.63	124.17	125.36	127.18	127.91	129.16	130.19	131.05	132.41
160		153.63	159.17	160.36	162.18	162.91	164.16	165.19	166.05	167.41



		f_{max}
63	1.49	0.78
80	1.54	0.88
100	1.59	0.98
125	1.64	1.10
160	1.70	1.24



→ 3.1	8
→ 4.3	7
→ 8.6	4
→ 10.7	2

SOE06Z

P M N S

PRAMET

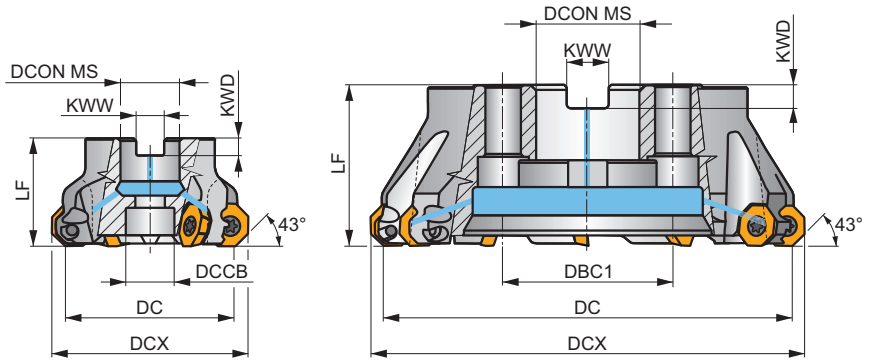
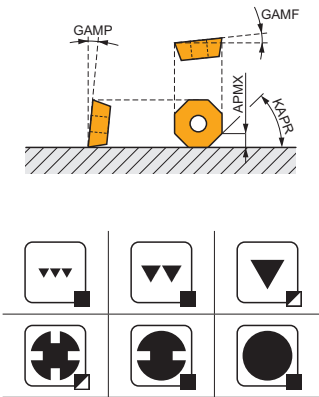
S



Universell planfräs med positiv design, invändig kylning

Mycket produktiv universell planfräs för OE..06, RE..16 och XE..06-skär med APMX 4 mm. Invändig kylning. För en mängd olika applikationer. Finns endast för dormontering. Behandlad för lång livslängd.

KAPR	43°
APMX	3.3 (9.9) mm



0.06 - 0.20



Product	DC	DCX	LF	DCON MS	DCCB	DBC1	KWW	KWD	GAMP	GAMP						
	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(°)	(°)			kg			
50A04R-S450E06Z-C	50	60.2	40	22	18	-	10.4	6.3	6	10	4	✓	10700	✓	0.47	GI283 FA053 -
50A05R-S450E06Z-C	50	60	40	22	18	-	10.4	6.3	1	10	5	✓	10700	✓	0.47	GI283 FA053 -
56A05R-S450E06Z-C	56	66	40	22	18	-	10.4	6.3	6	10	5	✓	10100	✓	0.52	GI283 FA053 -
63A04R-S450E06Z-C	63	73.2	40	22	18	-	10.4	6.3	6	10	4	✓	9600	✓	0.58	GI283 FA053 -
63A06R-S450E06Z-C	63	73	40	22	18	-	10.4	6.3	1	10	6	✓	9600	✓	0.60	GI283 FA053 -
70A06R-S450E06Z-C	70	80	40	22	18	-	10.4	6.3	6	10	6	✓	9100	✓	0.69	GI283 FA053 -
80A05R-S450E06Z-C	80	90.2	50	27	38	-	12.4	7	6	10	5	✓	8500	✓	1.02	GI283 FA051 AC001
80A06R-S450E06Z-C	80	90.2	50	27	38	-	12.4	7	6	10	6	✓	8500	✓	1.03	GI283 FA051 AC001
90A07R-S450E06Z-C	90	100	50	32	45	-	14.4	8	6	10	7	✓	8000	✓	1.59	GI283 FA051 AC002
100A06R-S450E06Z-C	100	110.2	50	32	45	-	14.4	8	6	10	6	✓	7600	✓	1.85	GI283 FA051 AC002
100A08R-S450E06Z-C	100	109.9	50	32	45	-	14.4	8	1	10	8	✓	7600	✓	1.87	GI283 FA051 AC002
125A07R-S450E06Z-C	125	135.2	63	40	56	-	16.4	9	6	10	7	✓	6800	✓	3.31	GI283 FA051 AC003
125A09R-S450E06Z-C	125	134.9	63	40	56	-	16.4	9	1	10	9	✓	6800	✓	3.35	GI283 FA051 AC003
160C09R-S450E06Z-C	160	170.2	63	40	-	66.7	16.4	9	6	10	9	✓	6000	✓	6.08	GI283 FA056 -
160C12R-S450E06Z-C	160	169.9	63	40	-	66.7	16.4	9	1	10	12	✓	6000	✓	7.06	GI283 FA056 -
200C11R-S450E06Z-C	200	210.2	63	60	-	101.6	25.7	14	6	10	11	✓	5300	✓	10.80	GI283 FA057 -
200C14R-S450E06Z-C	200	209.9	63	60	-	101.6	25.7	14	1	10	14	✓	5300	✓	11.15	GI283 FA057 -

GI283	OEHT 0604AE..	REHT 1604M0..	XEHT 0604AE..

FA051	US 5011-T20P	5.0	M 5	11	SDR T20P-T	-	-	-	-
FA053	US 5011-T20P	5.0	M 5	11	SDR T20P-T	HS 1030C	-	-	-

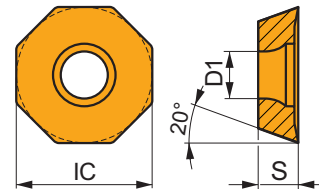
FA056	US 5011-T20P	5.0	M 5	11	SDR T20P-T	HS 1240C	CAC 160C	HSD 0825C	HXK 5
FA057	US 5011-T20P	5.0	M 5	11	SDR T20P-T	HS 1655C	CAC 200C	HSD 1025C	HXK 7

AC001	KS 1230	K.FMH27
AC002	KS 1635	K.FMH32
AC003	KS 2040	K.FMH40

OEHT 06

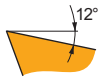
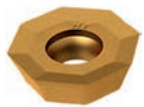


	IC	D1	S
	(mm)	(mm)	(mm)
0604	16.050	5.50	4.76



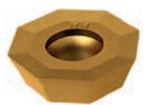
Lämplighet och startvärden för skärhastighet (vc), matning (f) och skärdjup (ap). Vi refererar till vår Dormer Pramet Calculator-app för vidare beräkningar.

Product	RE (mm)	P			M			K			N			S			H		
		vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)



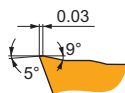
MF geometri, 45° planfräskär med vass positiv design för fin till medelfin fräsning och potentiellt extra fin fräsning.

OEHT 0604AEER-MF:M6330	☺	-	255	0.12	2.2	180	0.11	2.2	-	-	-	-	-	-	75	0.10	1.8	-	-	-
OEHT 0604AEER-MF:M8330	☺	-	295	0.12	2.2	175	0.11	2.2	-	-	-	885	0.14	2.2	70	0.10	1.8	-	-	-
OEHT 0604AEER-MF:M8340	☺	-	275	0.12	2.2	165	0.11	2.2	-	-	-	-	-	-	65	0.10	1.8	-	-	-



MM geometri, 45° planfräskär med vass positiv design för fin till medelfin fräsning.

OEHT 0604AEER-MM:M6330	☺	-	245	0.16	2.2	170	0.14	2.2	-	-	-	-	-	-	70	0.11	1.8	-	-	-
OEHT 0604AEER-MM:M8330	☺	-	280	0.16	2.2	165	0.14	2.2	-	-	-	840	0.19	2.2	70	0.11	1.8	-	-	-
OEHT 0604AEER-MM:M8340	☺	-	255	0.16	2.2	150	0.14	2.2	-	-	-	-	-	-	60	0.11	1.8	-	-	-
OEHT 0604AEER-MM:M8345	☺	-	205	0.16	2.2	120	0.14	2.2	-	-	-	-	-	-	50	0.11	1.8	-	-	-
OEHT 0604AEER-MM:M9340	☺	-	320	0.16	2.2	190	0.14	2.2	-	-	-	-	-	-	80	0.11	1.8	-	-	-



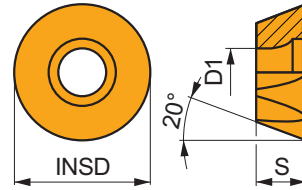
M geometri, 45° planfräskär med något positiv design för fin till medelfin fräsning.

OEHT 0604AESR-M:M6330	☺	-	210	0.24	3.2	150	0.22	3.2	-	-	-	-	-	-	60	0.17	2.6	-	-	-
OEHT 0604AESR-M:M8310	☺	-	265	0.24	3.2	135	0.22	3.2	-	-	-	-	-	-	-	-	-	-	-	-
OEHT 0604AESR-M:M8330	☺	-	245	0.24	3.2	145	0.22	3.2	-	-	-	-	-	-	60	0.17	2.6	-	-	-
OEHT 0604AESR-M:M8340	☺	-	220	0.24	3.2	130	0.22	3.2	-	-	-	-	-	-	55	0.17	2.6	-	-	-
OEHT 0604AESR-M:M9325	☺	-	295	0.24	3.2	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-

REHT 16

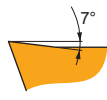
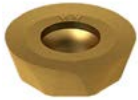


	INSD	D1	S
	(mm)	(mm)	(mm)
1604	16.000	5.50	4.76



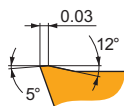
Lämplighet och startvärden för skärhastighet (vc), matning (f) och skärdjup (ap). Vi refererar till vår Dormer Pramet Calculator-app för vidare beräkningar.

Product	RE	P			M			K			N			S			H		
		vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)



MM geometri, kopier- och profilfräskär med något positiv design för fin till medelfin fräsning.

REHT 1604MOEN-MM:M6330	☼	–	255	0.20	2.0	180	0.18	2.0	–	–	–	–	–	–	–	75	0.14	1.6	–	–	–
REHT 1604MOEN-MM:M8340	☼	–	270	0.20	2.0	160	0.18	2.0	–	–	–	–	–	–	–	65	0.14	1.6	–	–	–
REHT 1604MOEN-MM:M9340	☼	–	330	0.20	2.0	195	0.18	2.0	–	–	–	–	–	–	–	80	0.14	1.6	–	–	–



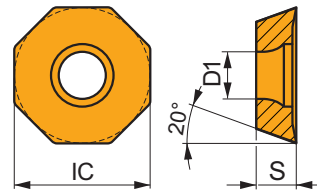
M geometri, kopier- och profilfräskär med positiv design för fin till medelfin fräsning.

REHT 1604MOSN-M:M8310	☼	–	285	0.30	2.0	145	0.27	2.0	–	–	–	–	–	–	–	–	–	–	–	–	–
REHT 1604MOSN-M:M8330	☼	–	270	0.30	2.0	160	0.27	2.0	–	–	–	–	–	–	–	65	0.21	1.6	–	–	–
REHT 1604MOSN-M:M8340	☼	–	245	0.30	2.0	145	0.27	2.0	–	–	–	–	–	–	–	60	0.21	1.6	–	–	–

OEHT 06-FA

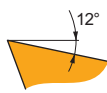
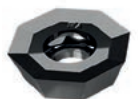


	IC	D1	S
	(mm)	(mm)	(mm)
0604	16.050	5.50	4.76



Lämplighet och startvärden för skärhastighet (vc), matning (f) och skärdjup (ap). Vi refererar till vår Dormer Pramet Calculator-app för vidare beräkningar.

Product	RE	P			M			K			N			S			H		
		vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)



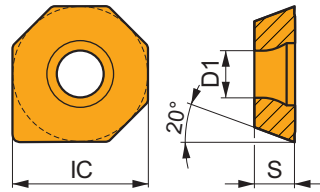
FA geometri, 45° planfräskär med mycket positiv design för fin till medelfin fräsning.

OEHT 0604AEFR-FA:HF7	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	330	0.18	2.0	–	–	–
OEHT 0604AEFR-FA:M0315	●	–	–	–	–	–	–	–	–	–	–	–	–	–	–	765	0.18	2.0	–	–	–

XEHT 06

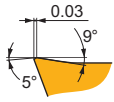


	IC	D1	S
	(mm)	(mm)	(mm)
0604	16.050	5.50	4.76



Lämplighet och startvärden för skärhastighet (vc), matning (f) och skärdjup (ap). Vi refererar till vår Dormer Pramet Calculator-app för vidare beräkningar.

Product	RE (mm)	P			M			K			N			S			H		
		vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)



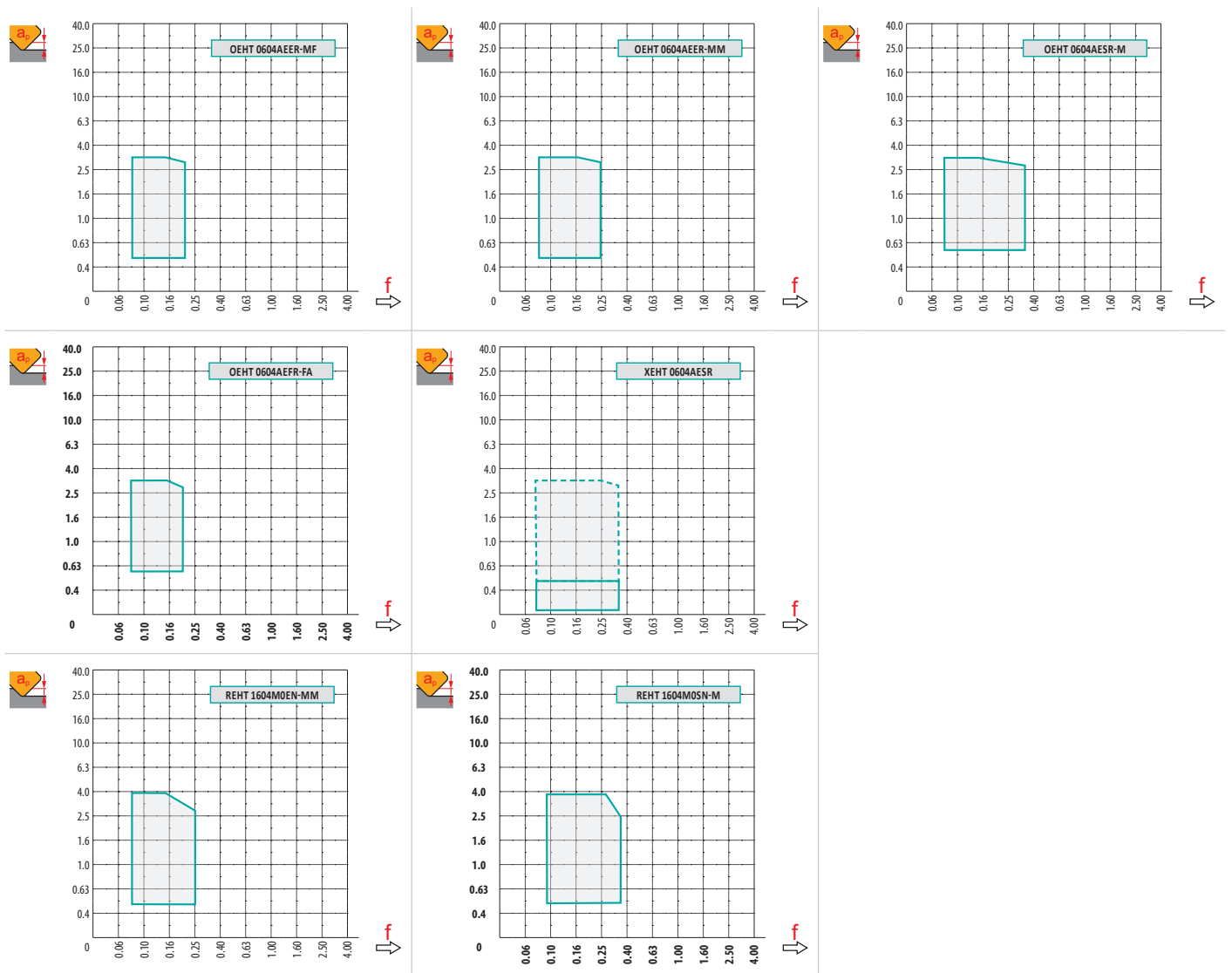
W något positiv wiper-design för bättre ytfinhet.

XEHT 0604AESR:M8310	●	–	■	265	0.24	3.2	▣	135	0.22	3.2	■	–	–	–	■	–	–	–	■	–	–	–
XEHT 0604AESR:M8330	⚙	–	■	245	0.24	3.2	▣	145	0.22	3.2	■	–	–	–	■	–	–	–	■	–	–	–

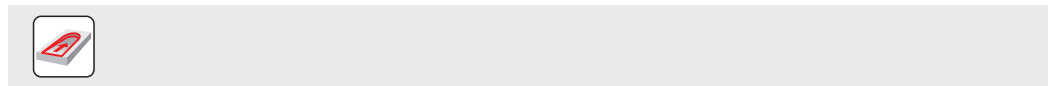
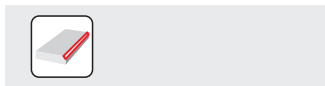


a_e / DC	5 %	10 %	15 %	20 %	25 %	30 %	40 %	50 %	60 %	70 %	75 %	80 %	90 %	100 %
	1.48	1.35	1.27	1.22	1.19	1.16	1.11	1.08	1.05	1.03	1.00	1.00	1.00	1.00
	2.20	1.60	1.35	1.20	1.10	0.95	0.85	0.75	0.85	0.95	1.00	1.00	1.00	1.00
	0.64	0.64	0.64	0.64	0.64	0.65	0.65	0.67	0.68	0.71	0.72	0.74	0.79	1.00

	OEHT 06-MF	OEHT 06-MM	OEHT 06-M	OEHT 06-FA	XEHT 06	REHT 16-MM	REHT 16-M
	-	-	-	-	-	8.00	8.00
	1.36	1.36	1.36	1.36	9.91	-	-



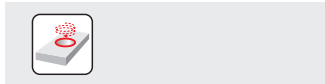
	R									
		0.00	0.50	0.75	1.25	1.50	2.00	2.50	3.00	4.00
50		43.90	49.47	50.66	52.49	53.23	54.48	55.52	56.39	57.76
56		49.80	55.37	56.56	58.39	59.13	60.38	61.42	62.29	63.66
63		56.90	62.47	63.66	65.49	66.23	67.48	68.52	69.39	70.76
70		63.80	69.37	70.56	72.39	73.13	74.38	75.42	76.29	77.66
80		73.90	79.47	80.66	82.49	83.23	84.48	85.52	86.39	87.76
90		83.80	89.37	90.56	92.39	93.13	94.38	95.42	96.29	97.66
100		93.90	99.47	100.66	102.49	103.23	104.48	105.52	106.39	107.76
125		118.90	124.47	125.66	127.49	128.23	129.48	130.52	131.39	132.76
160		153.90	159.47	160.66	162.49	163.23	164.48	165.52	166.39	167.76
200		193.90	199.47	200.66	202.49	203.23	204.48	205.52	206.39	207.76



		f_{max}
50	1.43	0.33
56	1.45	0.35
63	1.47	0.37
70	1.49	0.39
80	1.52	0.42
90	1.55	0.44
100	1.57	0.47
125	1.62	0.52
160	1.68	0.59
200	1.73	0.66

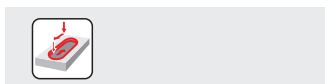
O		
	RPMX	APMX/I
50	4.9°	8.4/100
56	4.2°	7.2/100
63	3.6°	6.1/100
70	3.1°	5.3/100
80	2.6°	4.4/100
90	2.3°	3.9/100
100	2.0°	3.3/100
125	1.5°	2.5/100

R		
	RPMX	APMX/I
59.9	4.6°	7.9/100
65.8	4.0°	6.8/100
72.9	3.0°	5.1/100
79.8	2.7°	4.6/100
89.9	2.2°	3.7/100
99.8	2.0°	3.3/100
109.9	1.8°	3.0/100
134.9	1.3°	2.1/100



O				
	DMIN	DMAX		
50	91.5	120.0	5.9	5.9
56	103.2	131.5	5.9	5.9
63	117.4	146.0	5.9	5.9
70	131.2	159.5	5.9	5.9
80	151.4	180.0	5.9	5.9
90	171.2	199.5	5.9	5.9
100	191.4	220.0	5.9	5.9
125	241.3	270.0	5.9	5.9

R				
	DMIN	DMAX		
59.9	91.5	119.5	5.9	5.9
65.8	103.5	131.0	5.9	5.9
72.9	118.0	145.5	5.9	5.9
79.8	131.5	159.0	5.9	5.9
89.9	151.5	179.5	5.9	5.9
99.8	171.5	199.0	5.9	5.9
109.9	191.5	219.5	5.9	5.9
134.9	241.5	269.5	5.9	5.9



	O	R
	3.1	3.0

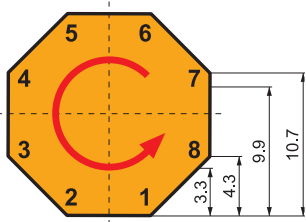


R

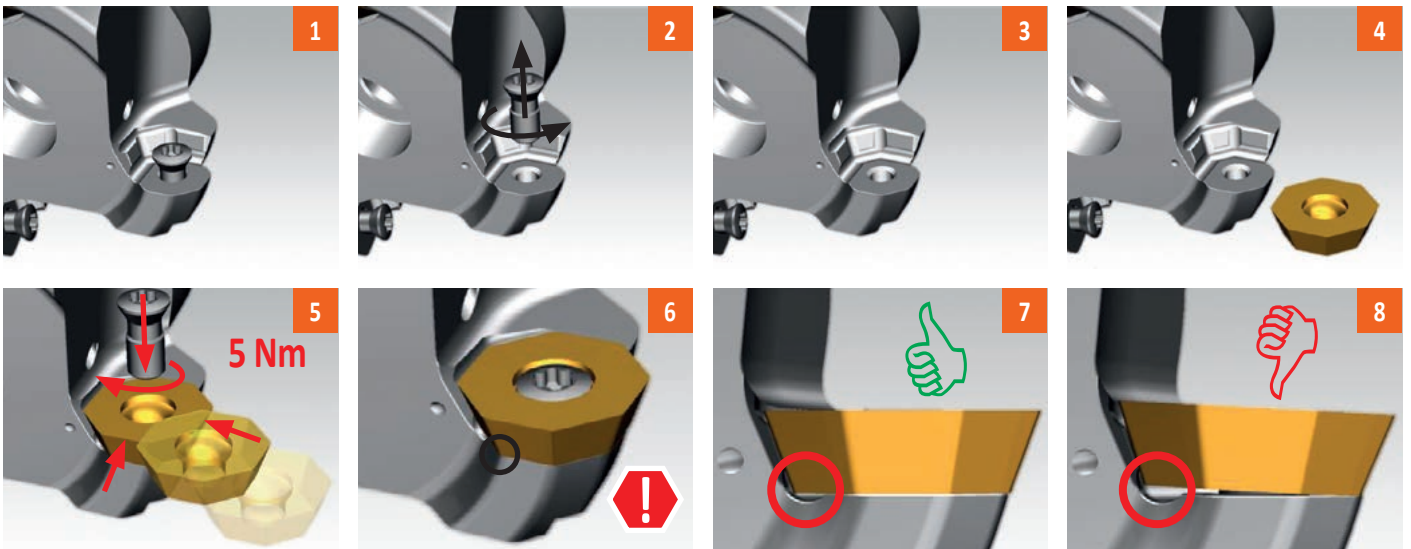
DCX	μm	3	5	10	15	20	30	40	50	60	80	100
59.9		0.848	1.095	1.548	1.896	2.189	2.681	3.096	3.461	3.792	4.378	4.895
65.8		0.889	1.147	1.622	1.987	2.294	2.810	3.245	3.628	3.974	4.589	5.130
72.9		0.935	1.207	1.708	2.091	2.415	2.958	3.415	3.818	4.183	4.830	5.400
79.8		0.979	1.263	1.787	2.188	2.527	3.095	3.573	3.995	4.376	5.053	5.650
89.9		1.039	1.341	1.896	2.322	2.682	3.285	3.793	4.240	4.645	5.364	5.997
99.8		1.094	1.413	1.998	2.447	2.826	3.461	3.996	4.468	4.894	5.651	6.318

RE	μm	3	5	10	15	20	30	40	50	60	80	100
8.0		0.438	0.566	0.800	0.980	1.131	1.386	1.600	1.789	1.960	2.263	2.530

i



-> 3.3	8
-> 4.3	7
-> 9.9	4
-> 10.7	2





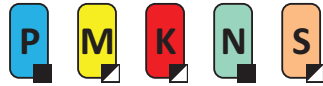
HÖRNFRÄSNING

INDEXABLE FACE MILLS – NAVIGATOR

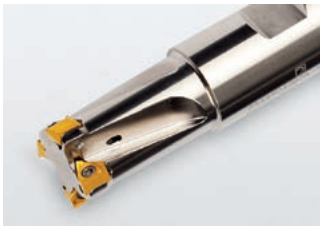
FACE MILLING

	STN10		STN16		SLN12		SLN16		SLN12X									
	90°		90°		90°		90°		90°									
	APMX (mm)	5.0	APMX (mm)	10.0	APMX (mm)	9.0	APMX (mm)	13.0	APMX (mm)	10.0								
	DC (mm)	18 – 80	DC (mm)	25 – 175	DC (mm)	25 – 125	DC (mm)	63 – 175	DC (mm)	25 – 125								
Cylindrical shank		DC = 18 – 35 (mm)		DC = 25 – 35 (mm)		DC = 25, 32 (mm)				DC = 25 – 40 (mm)								
Weldon		DC = 20 – 32 (mm)		DC = 25 – 40 (mm)		DC = 25 – 40 (mm)				DC = 25 – 40 (mm)								
Modular		DC = 20 – 32 (mm)		DC = 25 – 40 (mm)		DC = 25 – 40 (mm)												
Shell mill		DC = 40 – 80 (mm)		DC = 40 – 175 (mm)		DC = 40 – 125 (mm)				DC = 40 – 125 (mm)								
Page	66		70		75		81		85									
ISO	P	M	K	N	P	M	K	N	P	M	K	N	H	P	M	K	N	H
Insert shape																		
Inserts	TNGX 1004		TNGX 1606		LNG 1205		LN.U 1607		LNEX 1210									
No. of cutting edges	6		6		4		4		4									
Face milling	■		■		■		■		■									
Chamfer milling	▣		▣		▣		▣		▣									
Helical interpolation	■		■		■		■		■									
Progressive plunging	▣		■		■		■		■									
Ramping	▣		■		▣		■		■									
Shape surfaces milling (copy milling)	▣		■		▣		■		▣									
Shallow shoulder milling	■		■		▣		■		■									
Shallow slot milling	■		■		▣		▣		■									

STN10



PRAMET

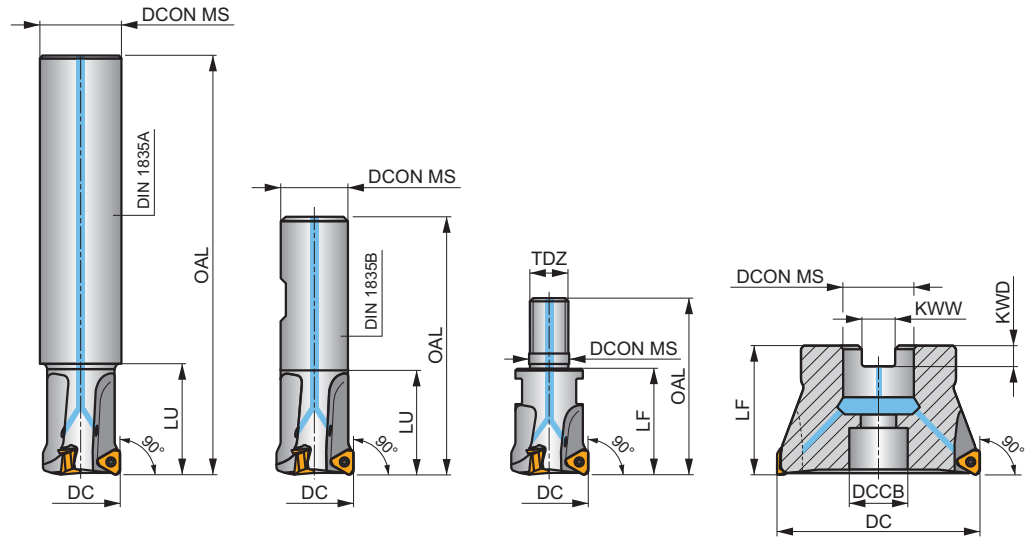
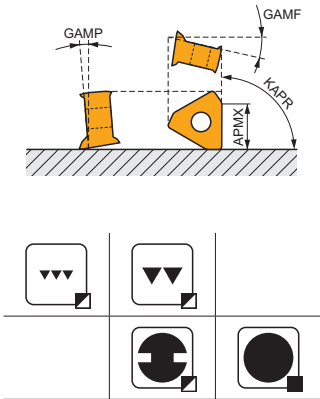


ECON TN10 Rak hörnfräs med invändig kylning

90° hörn- och planfräs för dubbelsidiga TNGX 10-skär med sex eggar och APMX 5 mm. Passar för en rad olika applikationer. Finns med cyl. skaft, Weldon-skaft, modult eller dornfäste (med eller utan differentiell tanddelning). Behandlad för lång livslängd.

ECON TN

KAPR	90°
APMX	5.0 mm



Product	DC (mm)	OAL (mm)	DCON MS (mm)	DCCB (mm)	LU (mm)	LF (mm)	TDZ	KWW (mm)	KWD (mm)	GAMF (°)	GAMP (°)	max.	kg	G1292	SQ300	-			
																	(mm)	(mm)	(mm)
18A2R050A20-STN10-C	18	180	20	-	50	-	-	-	-	-17.1	-11	2	-	29100	✓	0.39	GI292	SQ300	-
20A2R029A20-STN10-C	20	150	20	-	29	-	-	-	-	-16.5	-11	2	-	27600	✓	0.35	GI292	SQ300	-
20A3R029A20-STN10-C	20	150	20	-	29	-	-	-	-	-16.5	-11	3	-	27600	✓	0.34	GI292	SQ300	-
22A3R050A25-STN10-C	22	180	25	-	50	-	-	-	-	-16.5	-11	3	-	26300	✓	0.58	GI292	SQ300	-
25A3R034A25-STN10-C	25	170	25	-	34	-	-	-	-	-16	-11	3	-	24700	✓	0.58	GI292	SQ300	-
25A4R034A25-STN10-C	25	170	25	-	34	-	-	-	-	-16	-11	4	✓	24700	✓	0.58	GI292	SQ300	-
30A4R050A32-STN10-C	30	200	32	-	50	-	-	-	-	-16	-11	4	✓	22500	✓	1.06	GI292	SQ300	-
32A4R037A32-STN10-C	32	195	32	-	37	-	-	-	-	-16	-11	4	✓	21800	✓	1.08	GI292	SQ300	-
32A5R037A32-STN10-C	32	195	32	-	37	-	-	-	-	-16	-11	5	✓	21800	✓	1.08	GI292	SQ300	-
35A5R080A32-STN10-C	35	200	32	-	80	-	-	-	-	-16	-11	5	✓	20800	✓	1.07	GI292	SQ300	-
20A2R032B20-STN10-C	20	90	20	-	32	-	-	-	-	-16.5	-11	2	-	27600	✓	0.20	GI292	SQ300	-
20A3R032B20-STN10-C	20	90	20	-	32	-	-	-	-	-16.5	-11	3	-	27600	✓	0.19	GI292	SQ300	-
25A3R042B25-STN10-C	25	100	25	-	42	-	-	-	-	-16	-11	3	-	24700	✓	0.31	GI292	SQ300	-
25A4R042B25-STN10-C	25	100	25	-	42	-	-	-	-	-16	-11	4	✓	24700	✓	0.31	GI292	SQ300	-
32A4R042B32-STN10-C	32	110	32	-	42	-	-	-	-	-16	-11	4	✓	21800	✓	0.57	GI292	SQ300	-
32A5R042B32-STN10-C	32	110	32	-	42	-	-	-	-	-16	-11	5	✓	21800	✓	0.56	GI292	SQ300	-
20A2R026M10-STN10-C	20	45	10.5	-	-	26	M10	-	-	-16.5	-11	2	-	-	✓	0.06	GI292	SQ300	-
20A3R026M10-STN10-C	20	45	10.5	-	-	26	M10	-	-	-16.5	-11	3	-	-	✓	0.06	GI292	SQ300	-
25A3R033M12-STN10-C	25	55	12.5	-	-	33	M12	-	-	-16	-11	3	-	-	✓	0.10	GI292	SQ300	-
25A4R033M12-STN10-C	25	55	12.5	-	-	33	M12	-	-	-16	-11	4	✓	-	✓	0.10	GI292	SQ300	-
32A4R043M16-STN10-C	32	66	17	-	-	43	M16	-	-	-16	-11	4	✓	-	✓	0.21	GI292	SQ300	-
32A5R043M16-STN10-C	32	66	17	-	-	43	M16	-	-	-16	-11	5	✓	-	✓	0.21	GI292	SQ300	-
40A04R-S90TN10-C	40	-	16	14	-	40	-	8.4	5.6	-15	-11	4	✓	19500	✓	0.34	GI292	SQ302	-
40A06R-S90TN10-C	40	-	16	14	-	40	-	8.4	5.6	-15	-11	6	✓	19500	✓	0.34	GI292	SQ302	-
50A05R-S90TN10-C	50	-	22	18	-	40	-	10.4	6.3	-15	-11	5	✓	17400	✓	0.48	GI292	SQ303	-
50A07R-S90TN10-C	50	-	22	18	-	40	-	10.4	6.3	-15	-11	7	✓	17400	✓	0.49	GI292	SQ303	-
63A06R-S90TN10-C	63	-	22	18	-	40	-	10.4	6.3	-15	-11	6	✓	15500	✓	0.63	GI292	SQ303	-

Product	DC	OAL	D CONIMS	DCB	LU	LF	TDZ	KWW	KWD	GAMF	GAMP	max.		kg	GI292	SQ303	AC001		
	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(°)	(°)								
63A09R-S90TN10-C	63	-	22	18	-	40	-	10.4	6.3	-15	-11	9	✓	15500	✓	0.63	GI292	SQ303	-
80A10R-S90TN10-C	80	-	27	38	-	50	-	12.4	7	-15	-11	10	✓	13800	✓	1.03	GI292	SQ301	AC001

	TNGX 1004..
--	-------------

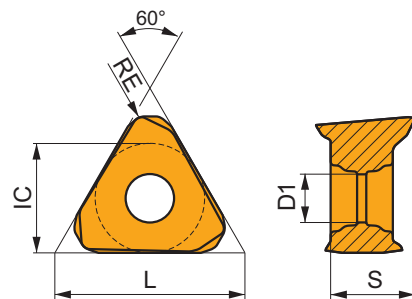
SQ300	US 52506-T07P	0.8	M 2.5	6	-	-	Flag T07P	-
SQ301	US 52506-T07P	0.8	M 2.5	6	D-T07P/T09P	FG-15	-	-
SQ302	US 52506-T07P	0.8	M 2.5	6	D-T07P/T09P	FG-15	-	HS 0830C
SQ303	US 52506-T07P	0.8	M 2.5	6	D-T07P/T09P	FG-15	-	HS 1030C

AC001	KS 1230	K.FMH27
-------	---------	---------

TNGX 10

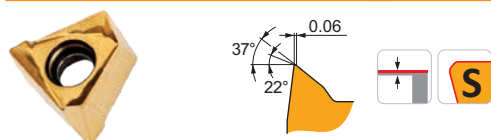


IC	D1	L	S	
(mm)	(mm)	(mm)	(mm)	
1004	6.000	2.80	10.39	4.69



Lämplighet och startvärden för skärhastighet (vc), matning (f) och skärdjup (ap). Vi refererar till vår Dormer Pramet Calculator-app för vidare beräkningar.

Product	RE (mm)	P			M			K			N			S			H		
		vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap			

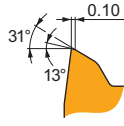
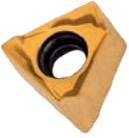


F geometri med mycket positiv design för finfräsning.

TNGX 100402SR-F:M8330	●	0.2	205	0.09	2.0	120	0.08	2.0	190	0.09	2.0	-	-	-	-	-	-
TNGX 100402SR-F:M8340	●	0.2	190	0.09	2.0	110	0.08	2.0	180	0.09	2.0	-	-	-	-	-	-
TNGX 100404SR-F:8215	●	0.4	225	0.09	2.0	135	0.08	2.0	210	0.09	2.0	-	-	-	-	-	-
TNGX 100404SR-F:M6330	●	0.4	190	0.09	2.0	135	0.08	2.0	-	-	-	-	-	-	-	-	-
TNGX 100404SR-F:M8330	●	0.4	220	0.09	2.0	130	0.08	2.0	205	0.09	2.0	-	-	-	-	-	-
TNGX 100404SR-F:M8340	●	0.4	200	0.09	2.0	120	0.08	2.0	190	0.09	2.0	-	-	-	-	-	-
TNGX 100404SR-F:M9340	●	0.4	270	0.09	2.0	160	0.08	2.0	-	-	-	-	-	-	-	-	-
TNGX 100408SR-F:8215	●	0.8	270	0.09	2.0	160	0.08	2.0	255	0.09	2.0	-	-	-	-	-	-
TNGX 100408SR-F:M6330	●	0.8	225	0.09	2.0	160	0.08	2.0	-	-	-	-	-	-	-	-	-
TNGX 100408SR-F:M8330	●	0.8	260	0.09	2.0	155	0.08	2.0	245	0.09	2.0	-	-	-	-	-	-
TNGX 100408SR-F:M8340	●	0.8	240	0.09	2.0	140	0.08	2.0	225	0.09	2.0	-	-	-	-	-	-
TNGX 100408SR-F:M9340	●	0.8	320	0.09	2.0	190	0.08	2.0	-	-	-	-	-	-	-	-	-

Lämplighet och startvärden för skärhastighet (vc), matning (f) och skärdjup (ap). Vi refererar till vår Dormer Pramet Calculator-app för vidare beräkningar.

Product	RE (mm)	P			M			K			N			S			H		
		vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)



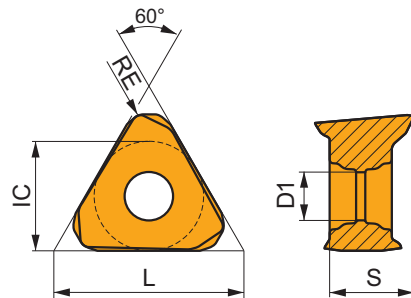
M geometri med positiv design för fin till medelfin fräsning.

TNGX 100404SR-M:8215	● 0.4	205	0.13	2.0	120	0.12	2.0	190	0.13	2.0	—	—	—	50	0.09	1.6	—	—	—
TNGX 100404SR-M:M6330	● 0.4	175	0.13	2.0	125	0.12	2.0	—	—	—	—	—	—	50	0.09	1.6	—	—	—
TNGX 100404SR-M:M8330	● 0.4	205	0.13	2.0	120	0.12	2.0	190	0.13	2.0	—	—	—	50	0.09	1.6	—	—	—
TNGX 100404SR-M:M8340	● 0.4	185	0.13	2.0	110	0.12	2.0	175	0.13	2.0	—	—	—	45	0.09	1.6	—	—	—
TNGX 100404SR-M:M9340	● 0.4	240	0.13	2.0	140	0.12	2.0	—	—	—	—	—	—	60	0.09	1.6	—	—	—
TNGX 100408SR-M:8215	● 0.8	245	0.13	2.0	145	0.12	2.0	230	0.13	2.0	—	—	—	60	0.09	1.6	—	—	—
TNGX 100408SR-M:M6330	● 0.8	210	0.13	2.0	150	0.12	2.0	—	—	—	—	—	—	60	0.09	1.6	—	—	—
TNGX 100408SR-M:M8310	● 0.8	270	0.13	2.0	135	0.12	2.0	255	0.13	2.0	—	—	—	—	—	—	—	—	—
TNGX 100408SR-M:M8330	● 0.8	245	0.13	2.0	145	0.12	2.0	230	0.13	2.0	—	—	—	60	0.09	1.6	—	—	—
TNGX 100408SR-M:M8340	● 0.8	220	0.13	2.0	130	0.12	2.0	205	0.13	2.0	—	—	—	55	0.09	1.6	—	—	—
TNGX 100408SR-M:M8345	● 0.8	180	0.13	2.0	105	0.12	2.0	—	—	—	—	—	—	45	0.09	1.6	—	—	—
TNGX 100408SR-M:M9340	● 0.8	285	0.13	2.0	170	0.12	2.0	—	—	—	—	—	—	70	0.09	1.6	—	—	—
TNGX 100412SR-M:M8330	● 1.2	255	0.13	2.0	150	0.12	2.0	240	0.13	2.0	—	—	—	60	0.09	1.6	—	—	—
TNGX 100412SR-M:M8340	● 1.2	230	0.13	2.0	135	0.12	2.0	215	0.13	2.0	—	—	—	55	0.09	1.6	—	—	—
TNGX 100416SR-M:M8310	● 1.6	300	0.13	2.0	150	0.12	2.0	285	0.13	2.0	—	—	—	—	—	—	—	—	—
TNGX 100416SR-M:M8330	● 1.6	270	0.13	2.0	160	0.12	2.0	255	0.13	2.0	—	—	—	65	0.09	1.6	—	—	—
TNGX 100416SR-M:M8340	● 1.6	245	0.13	2.0	145	0.12	2.0	230	0.13	2.0	—	—	—	60	0.09	1.6	—	—	—

TNGX 10-FA

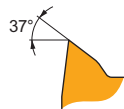
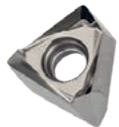


	IC (mm)	D1 (mm)	L (mm)	S (mm)
1004	6.000	2.80	10.39	4.69



Lämplighet och startvärden för skärhastighet (vc), matning (f) och skärdjup (ap). Vi refererar till vår Dormer Pramet Calculator-app för vidare beräkningar.

Product	RE (mm)	P			M			K			N			S			H		
		vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)



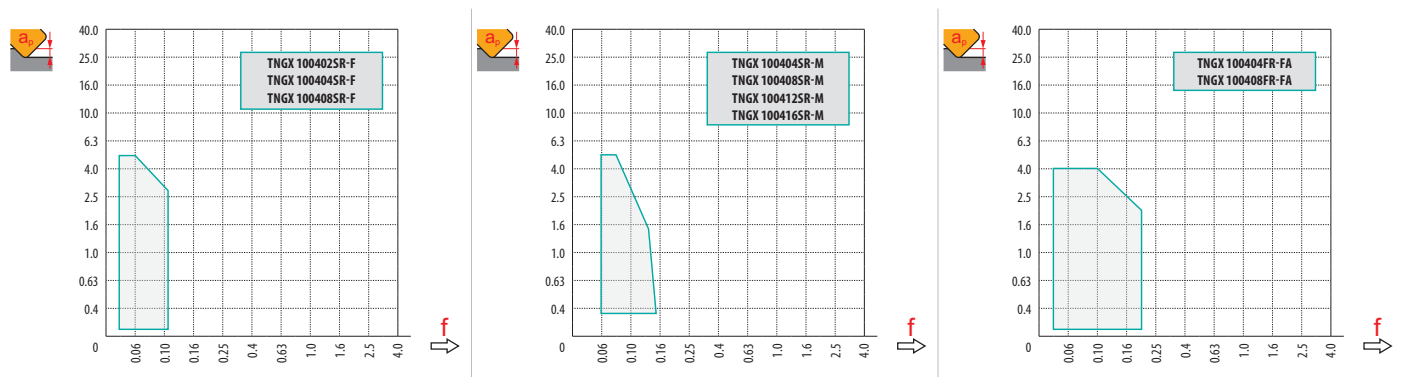
FA geometri med mycket positiv design för fin till medelfin fräsning.

TNGX 100404FR-FA:HF7	● 0.4	—	—	—	—	—	—	—	—	—	345	0.10	1.5	—	—	—	—	—	—
TNGX 100404FR-FA:M0315	● 0.4	—	—	—	—	—	—	—	—	—	780	0.10	1.5	—	—	—	—	—	—
TNGX 100408FR-FA:HF7	● 0.8	—	—	—	—	—	—	—	—	—	345	0.10	1.5	—	—	—	—	—	—
TNGX 100408FR-FA:M0315	● 0.8	—	—	—	—	—	—	—	—	—	780	0.10	1.5	—	—	—	—	—	—



a_e / DC	5%	10%	15%	20%	25%	30%	40%	50%	60%	70%	75%	80%	90%	100%
	1.48	1.35	1.27	1.22	1.19	1.16	1.11	1.08	1.05	1.03	1.00	1.00	1.00	1.00
	2.20	1.60	1.35	1.20	1.10	0.95	0.85	0.75	0.85	0.95	1.00	1.00	1.00	1.00
	0.64	0.64	0.64	0.64	0.64	0.65	0.65	0.67	0.68	0.71	0.72	0.74	0.79	1.00

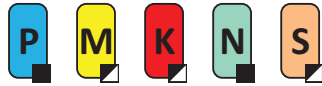
	TNGX 10-F			TNGX 10-M				TNGX 10-FA	
	0.2	0.4	0.8	0.4	0.8	1.2	1.6	0.4	0.8
	1.53	1.34	0.92	1.34	0.92			1.33	0.93



	1.5
	1.0 3.0 5.0
	0.10 0.08 0.04
	0.2

DC	RPMX	APMX/l	DC	DMIN	DMAX	SMAX DMIN	SMAX DMAX
	18	1.80°				3.05/100	18
20	1.60°	2.70/100	20	37	40	1.2	1.2
22	1.20°	2.00/100	22	41	44	1.0	1.0
25	1.00°	1.70/100	25	47	50	1.0	1.0
30	0.90°	1.45/100	30	57	60	1.0	1.0
32	0.80°	1.30/100	32	61	64	1.0	1.0
35	0.65°	1.00/100	35	67	70	0.9	0.9
40	0.60°	0.90/100	40	77	80	0.9	0.9
50	0.50°	0.70/100	50	97	100	0.9	0.9
63	0.40°	0.50/100	63	123	126	0.9	0.9
80	0.25°	0.30/100	80	157	160	0.9	0.9

STN16



PRAMET

S

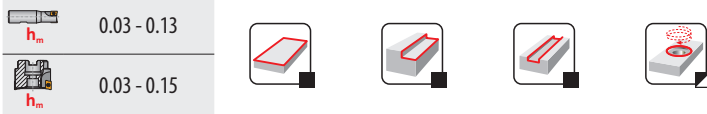
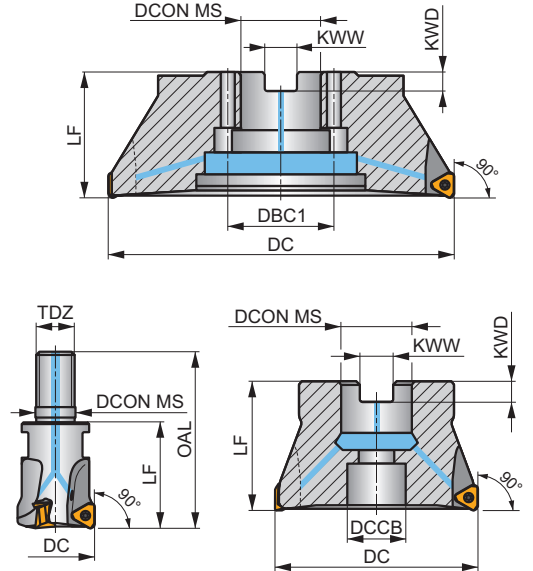
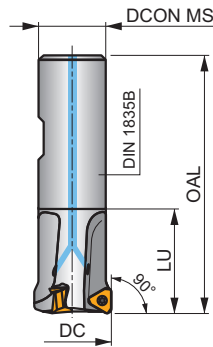
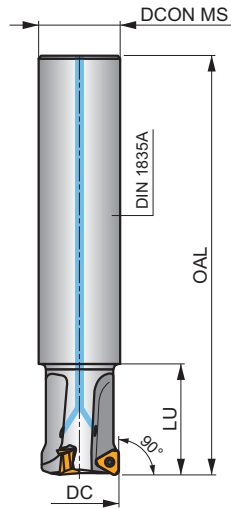
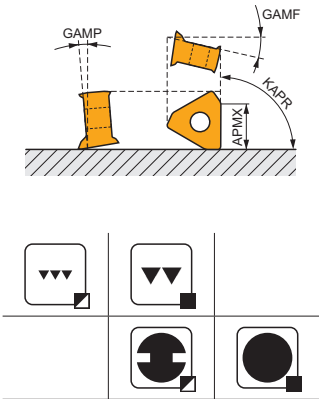


ECON TN16 Rak hörnfräs med invändig kylning

90° hörn- och planfräs för dubbelsidiga TNGX 16-skär med sex eggar och APMX 10 mm. Passar för en rad olika applikationer. Finns med cyl. skaft, Weldon-skaft, modulärt eller dornfäste (med ojämn tanddelning). Behandlad för lång livslängd.

ECON TN

KAPR	90°
APMX	10.0 mm



Product	DC (mm)	OAL (mm)	DCON MS (mm)	DCCB (mm)	DBC1 (mm)	LU (mm)	LF (mm)	TDZ (mm)	KWW (mm)	KWD (mm)	GAMP (°)	GAMP (°)	max.	kg	C382	C384	C386	C388	C390
25A2R034A25-STN16-C	25	170	25	-	-	34	-	-	-	-	-18.5	-9.5	2	-	20000	✓	0.54	GI340	C0382
32A2R034A32-STN16-C	32	195	32	-	-	34	-	-	-	-	-16	-9.5	2	-	17500	✓	1.05	GI340	C0382
25A2R080A25-STN16-C	25	170	25	-	-	80	-	-	-	-	-18.5	-9.5	2	-	20000	✓	0.48	GI340	C0382
32A2R080A32-STN16-C	32	195	32	-	-	80	-	-	-	-	-16	-9.5	2	-	17500	✓	0.96	GI340	C0382
32A3R034A32-STN16-C	32	195	32	-	-	34	-	-	-	-	-16	-9.5	3	-	17500	✓	1.04	GI340	C0382
35A3R034A32-STN16-C	35	195	32	-	-	34	-	-	-	-	-16	-9.5	3	-	17000	✓	1.07	GI340	C0382
25A2R042B25-STN16-C	25	110	25	-	-	42	-	-	-	-	-18.5	-9.5	2	-	20000	✓	0.29	GI340	C0382
32A3R042B32-STN16-C	32	110	32	-	-	42	-	-	-	-	-16	-9.5	3	-	17500	✓	0.52	GI340	C0382
40A4R050B32-STN16-C	40	120	32	-	-	50	-	-	-	-	-16	-9.5	4	-	16000	✓	0.68	GI340	C0382
25A2R033M12-STN16-C	25	55	12.5	-	-	-	33	M12	-	-	-18.5	-9.5	2	-	20000	✓	0.10	GI340	C0382
32A2R043M16-STN16-C	32	66	17	-	-	-	43	M16	-	-	-16	-9.5	2	-	17500	✓	0.18	GI340	C0382
32A3R043M16-STN16-C	32	66	17	-	-	-	43	M16	-	-	-16	-9.5	3	-	17500	✓	0.17	GI340	C0382
40A3R043M16-STN16-C	40	66	17	-	-	-	43	M16	-	-	-16	-9.5	3	-	16000	✓	0.20	GI340	C0382
40A4R043M16-STN16-C	40	66	17	-	-	-	43	M16	-	-	-16	-9.5	4	-	16000	✓	0.21	GI340	C0382
40A03R-S90TN16-C	40	40	16	12.4	-	-	40	-	8.4	5.6	-16	-9.5	3	-	16000	✓	0.32	GI340	C0384
40A04R-S90TN16-C	40	40	16	12.4	-	-	40	-	8.4	5.6	-16	-9.5	4	-	16000	✓	0.31	GI340	C0384
50A04R-S90TN16-C	50	40	22	18.1	-	-	40	-	10.4	6.3	-16	-9.5	4	✓	14000	✓	0.34	GI340	C0386
50A05R-S90TN16-C	50	40	22	18.1	-	-	40	-	10.4	6.3	-16	-9.5	5	✓	14000	✓	0.32	GI340	C0386
63A04R-S90TN16-C	63	40	22	18.1	-	-	40	-	10.4	6.3	-16	-9.5	4	✓	12500	✓	0.47	GI340	C0386
63A06R-S90TN16-C	63	40	22	18.1	-	-	40	-	10.4	6.3	-16	-9.5	6	✓	12500	✓	0.48	GI340	C0386
80A05R-S90TN16-C	80	50	27	22.1	-	-	50	-	12.4	7	-16	-9.5	5	✓	11000	✓	1.15	GI340	C0388
80A07R-S90TN16-C	80	50	27	22.1	-	-	50	-	12.4	7	-16	-9.5	7	✓	11000	✓	1.17	GI340	C0388
100A06R-S90TN16-C	100	50	32	45.1	-	-	50	-	14.4	8	-16	-9.5	6	✓	10000	✓	1.79	GI340	C0390
100A08R-S90TN16-C	100	50	32	45.1	-	-	50	-	14.4	8	-16	-9.5	8	✓	10000	✓	1.66	GI340	C0390
115A06R-S90TN16-C	115	50	32	45.1	-	-	50	-	14.4	8	-16	-9.5	6	✓	9500	✓	2.21	GI340	C0390
125A07R-S90TN16-C	125	63	40	56.1	-	-	63	-	16.4	9	-16	-9.5	7	✓	9000	✓	3.05	GI340	C0390
125A09R-S90TN16-C	125	63	40	56.1	-	-	63	-	16.4	9	-16	-9.5	9	✓	9000	✓	3.14	GI340	C0390

Product	DC	OAL	D CONIMS	DCB	DBC1	LU	LF	TDZ	KWW	KWD	GAMF	GAMP	max.		kg	GI340	C0394	
	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(°)	(°)						
140A08R-S90TN16-C	140	63	40	56.1	-	-	63	-	16.4	9	-16	-9.5	8	✓	8500	✓	3.69	GI340 C0394
160C10R-S90TN16-C	160	63	40	-	66.7	-	63	-	16.4	9.2	-16	-9.5	10	✓	8000	✓	5.16	GI340 C0394
175C10R-S90TN16-C	175	63	40	-	66.7	-	63	-	16.4	9.2	-16	-9.5	10	✓	7500	✓	6.89	GI340 C0394

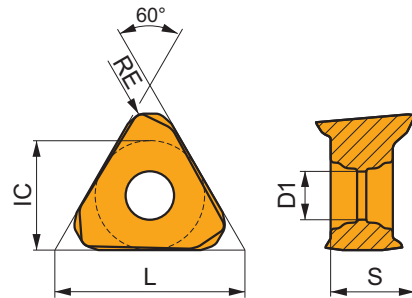
GI340	TNGX 1606..
-------	-------------

C0382	US 44010-T15P	3.5	M 4	10	-	-	Flag T15P	-	-	-	-
C0384	US 44010-T15P	3.5	M 4	10	D-T08P/T15P	FG-15	-	HS 90835	-	-	-
C0386	US 44010-T15P	3.5	M 4	10	D-T08P/T15P	FG-15	-	HS 1030C	-	-	-
C0388	US 44010-T15P	3.5	M 4	10	D-T08P/T15P	FG-15	-	HS 1230C	-	-	-
C0390	US 44010-T15P	3.5	M 4	10	D-T08P/T15P	FG-15	-	-	-	-	-
C0394	US 44010-T15P	3.5	M 4	10	D-T08P/T15P	FG-15	-	HS 1240C	HSD 0825C	CAC 160C	-

TNGX 16

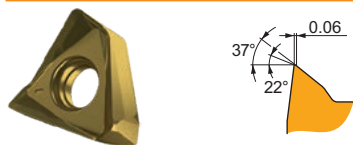


	IC	D1	L	S
	(mm)	(mm)	(mm)	(mm)
1606	9.525	4.40	16.50	6.58



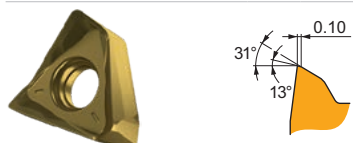
Lämplighet och startvärden för skärhastighet (vc), matning (f) och skärdjup (ap). Vi refererar till vår Dormer Pramet Calculator-app för vidare beräkningar.

Product	RE (mm)	P			M			K			N			S			H		
		vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)



F geometri med mycket positiv design för finfräsning.

TNGX 160604SR-F:M8330	● 0.4	■ 205	■ 0.10	■ 3.0	■ 120	■ 0.09	■ 3.0	■ 190	■ 0.10	■ 3.0	-	-	-	-	-	-	-	-
TNGX 160604SR-F:M8340	● 0.4	■ 190	■ 0.10	■ 3.0	■ 110	■ 0.09	■ 3.0	■ 180	■ 0.10	■ 3.0	-	-	-	-	-	-	-	-
TNGX 160608SR-F:8215	● 0.8	■ 250	■ 0.10	■ 3.0	■ 150	■ 0.09	■ 3.0	■ 235	■ 0.10	■ 3.0	-	-	-	-	-	-	-	-
TNGX 160608SR-F:M6330	● 0.8	■ 215	■ 0.10	■ 3.0	■ 150	■ 0.09	■ 3.0	-	-	-	-	-	-	-	-	-	-	-
TNGX 160608SR-F:M8310	● 0.8	■ 280	■ 0.10	■ 3.0	■ 140	■ 0.09	■ 3.0	■ 265	■ 0.10	■ 3.0	-	-	-	-	-	-	-	-
TNGX 160608SR-F:M8330	● 0.8	■ 245	■ 0.10	■ 3.0	■ 145	■ 0.09	■ 3.0	■ 230	■ 0.10	■ 3.0	-	-	-	-	-	-	-	-
TNGX 160608SR-F:M8340	● 0.8	■ 225	■ 0.10	■ 3.0	■ 135	■ 0.09	■ 3.0	■ 210	■ 0.10	■ 3.0	-	-	-	-	-	-	-	-

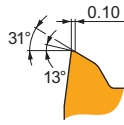
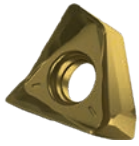


M geometri med positiv design för fin till medelfin fräsning.

TNGX 160604SR-M:8215	● 0.4	■ 180	■ 0.18	■ 3.0	■ 105	■ 0.16	■ 3.0	■ 170	■ 0.18	■ 3.0	-	-	-	■ 45	■ 0.13	■ 2.4	-	-	-
TNGX 160604SR-M:M6330	● 0.4	■ 155	■ 0.18	■ 3.0	■ 110	■ 0.16	■ 3.0	-	-	-	-	-	-	■ 45	■ 0.13	■ 2.4	-	-	-
TNGX 160604SR-M:M8310	● 0.4	■ 205	■ 0.15	■ 3.0	■ 100	■ 0.14	■ 3.0	■ 190	■ 0.15	■ 3.0	-	-	-	-	-	-	-	-	-
TNGX 160604SR-M:M8330	● 0.4	■ 180	■ 0.18	■ 3.0	■ 105	■ 0.16	■ 3.0	■ 170	■ 0.18	■ 3.0	-	-	-	■ 45	■ 0.13	■ 2.4	-	-	-

Lämplighet och startvärden för skärhastighet (vc), matning (f) och skärdjup (ap). Vi refererar till vår Dormer Pramet Calculator-app för vidare beräkningar.

Product	RE (mm)	P			M			K			N			S			H		
		vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)



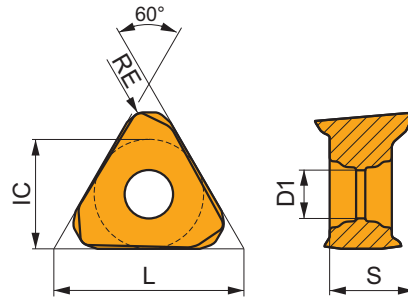
M geometri med positiv design för fin till medelfin fräsning.

TNGX 160604SR-M:M8340	● 0.4	■ 165	■ 0.18	■ 3.0	■ 95	■ 0.16	■ 3.0	■ 155	■ 0.18	■ 3.0	■ —	■ —	■ —	■ 40	■ 0.13	■ 2.4	■ —	■ —	■ —
TNGX 160608SR-M:8215	● 0.8	■ 215	■ 0.18	■ 3.0	■ 125	■ 0.16	■ 3.0	■ 200	■ 0.18	■ 3.0	■ —	■ —	■ —	■ 50	■ 0.13	■ 2.4	■ —	■ —	■ —
TNGX 160608SR-M:M6330	● 0.8	■ 185	■ 0.18	■ 3.0	■ 130	■ 0.16	■ 3.0	■ —	■ —	■ —	■ —	■ —	■ —	■ 55	■ 0.13	■ 2.4	■ —	■ —	■ —
TNGX 160608SR-M:M8310	● 0.8	■ 245	■ 0.15	■ 3.0	■ 120	■ 0.14	■ 3.0	■ 230	■ 0.15	■ 3.0	■ —	■ —	■ —	■ —	■ —	■ —	■ —	■ —	■ —
TNGX 160608SR-M:M8330	● 0.8	■ 215	■ 0.18	■ 3.0	■ 125	■ 0.16	■ 3.0	■ 200	■ 0.18	■ 3.0	■ —	■ —	■ —	■ 50	■ 0.13	■ 2.4	■ —	■ —	■ —
TNGX 160608SR-M:M8340	● 0.8	■ 195	■ 0.18	■ 3.0	■ 115	■ 0.16	■ 3.0	■ 185	■ 0.18	■ 3.0	■ —	■ —	■ —	■ 45	■ 0.13	■ 2.4	■ —	■ —	■ —
TNGX 160608SR-M:M8345	● 0.8	■ 155	■ 0.18	■ 3.0	■ 90	■ 0.16	■ 3.0	■ —	■ —	■ —	■ —	■ —	■ —	■ 35	■ 0.13	■ 2.4	■ —	■ —	■ —
TNGX 160608SR-M:M9325	● 0.8	■ 285	■ 0.15	■ 3.0	■ —	■ —	■ —	■ 270	■ 0.15	■ 3.0	■ —	■ —	■ —	■ —	■ —	■ —	■ —	■ —	■ —
TNGX 160608SR-M:M9340	● 0.8	■ 245	■ 0.18	■ 3.0	■ 145	■ 0.16	■ 3.0	■ —	■ —	■ —	■ —	■ —	■ —	■ 60	■ 0.13	■ 2.4	■ —	■ —	■ —
TNGX 160612SR-M:M8330	● 1.2	■ 230	■ 0.18	■ 3.0	■ 135	■ 0.16	■ 3.0	■ 215	■ 0.18	■ 3.0	■ —	■ —	■ —	■ 55	■ 0.13	■ 2.4	■ —	■ —	■ —
TNGX 160612SR-M:M8340	● 1.2	■ 205	■ 0.18	■ 3.0	■ 120	■ 0.16	■ 3.0	■ 190	■ 0.18	■ 3.0	■ —	■ —	■ —	■ 50	■ 0.13	■ 2.4	■ —	■ —	■ —
TNGX 160616SR-M:M8310	● 1.6	■ 275	■ 0.15	■ 3.0	■ 140	■ 0.14	■ 3.0	■ 260	■ 0.15	■ 3.0	■ —	■ —	■ —	■ —	■ —	■ —	■ —	■ —	■ —
TNGX 160616SR-M:M8330	● 1.6	■ 240	■ 0.18	■ 3.0	■ 140	■ 0.16	■ 3.0	■ 225	■ 0.18	■ 3.0	■ —	■ —	■ —	■ 60	■ 0.13	■ 2.4	■ —	■ —	■ —
TNGX 160616SR-M:M8340	● 1.6	■ 220	■ 0.18	■ 3.0	■ 130	■ 0.16	■ 3.0	■ 205	■ 0.18	■ 3.0	■ —	■ —	■ —	■ 55	■ 0.13	■ 2.4	■ —	■ —	■ —

TNGX 16-FA

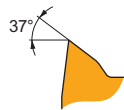
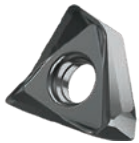


	IC (mm)	D1 (mm)	L (mm)	S (mm)
1606	9.525	4.40	16.50	6.58



Lämplighet och startvärden för skärhastighet (vc), matning (f) och skärdjup (ap). Vi refererar till vår Dormer Pramet Calculator-app för vidare beräkningar.

Product	RE (mm)	P			M			K			N			S			H		
		vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)



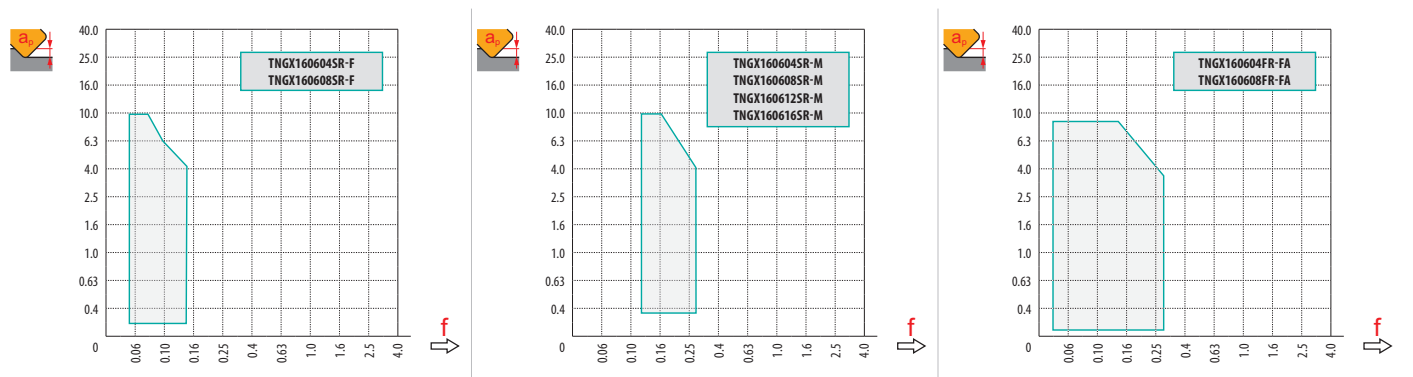
FA geometri med mycket positiv design för fin till medelfin fräsning.

TNGX 160604FR-FA:HF7	● 0.4	■ —	■ —	■ —	■ —	■ —	■ —	■ —	■ —	■ —	■ 255	■ 0.14	■ 2.0	■ —	■ —	■ —	■ —	■ —	■ —
TNGX 160604FR-FA:M0315	● 0.4	■ —	■ —	■ —	■ —	■ —	■ —	■ —	■ —	■ —	■ 585	■ 0.14	■ 2.0	■ —	■ —	■ —	■ —	■ —	■ —
TNGX 160608FR-FA:HF7	● 0.8	■ —	■ —	■ —	■ —	■ —	■ —	■ —	■ —	■ —	■ 300	■ 0.14	■ 2.0	■ —	■ —	■ —	■ —	■ —	■ —
TNGX 160608FR-FA:M0315	● 0.8	■ —	■ —	■ —	■ —	■ —	■ —	■ —	■ —	■ —	■ 690	■ 0.14	■ 2.0	■ —	■ —	■ —	■ —	■ —	■ —



a_e / DC	5 %	10 %	15 %	20 %	25 %	30 %	40 %	50 %	60 %	70 %	75 %	80 %	90 %	100 %
	1.48	1.35	1.27	1.22	1.19	1.16	1.11	1.08	1.05	1.03	1.00	1.00	1.00	1.00
	2.20	1.60	1.35	1.20	1.10	0.95	0.85	0.75	0.85	0.95	1.00	1.00	1.00	1.00
	0.64	0.64	0.64	0.64	0.64	0.65	0.65	0.67	0.68	0.71	0.72	0.74	0.79	1.00

	TNGX 16-F		TNGX 16-M				TNGX 16-FA	
	0.4	0.8	0.4	0.8	1.2	1.6	0.4	0.8
	2.10	1.9	2.10	1.90	1.73	1.14	2.10	1.90

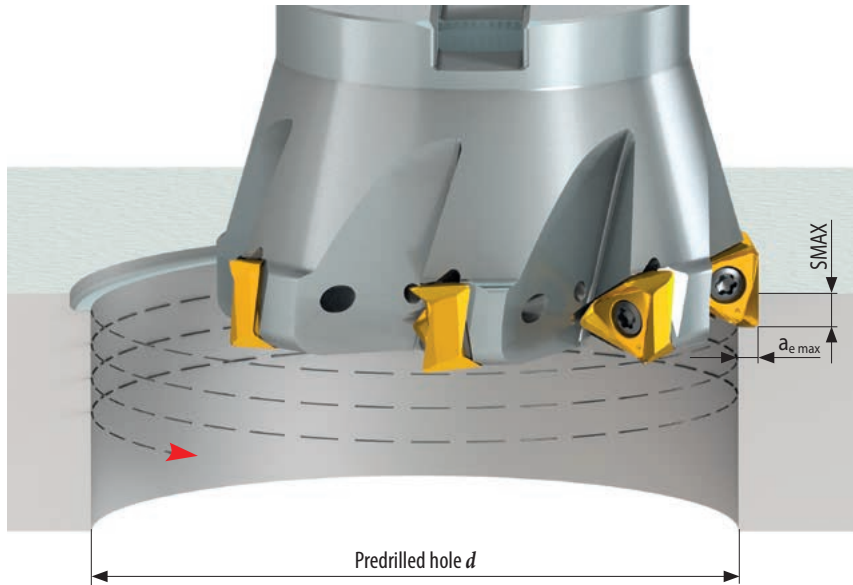


	3.0	4.5	6.0
	0.18	0.14	0.10



DC	min	d _{min} = DC *		min	d = 1.25 DC		min	d = 1.5 DC		min	d = 1.75 DC		min	d ≥ 2 DC	
		S _{MAX}	a _{e max}		S _{MAX}	a _{e max}		S _{MAX}	a _{e max}		S _{MAX}	a _{e max}		S _{MAX}	a _{e max}
25	25	0.14	1.3	31	0.22	2.2	38	0.33	3.0	44	0.60	4.0	50	0.70	5.0
32	32	0.16	1.5	40	0.33	2.8	48	0.44	4.0	56	0.70	5.0	64	0.90	6.5
40	40	0.22	2.0	50	0.38	3.5	60	0.55	5.0	70	0.90	6.5	80	1.15	8.0
50	50	0.27	2.5	63	0.50	4.5	75	0.70	6.5	88	1.00	8.0	100	1.40	10.0
63	63	0.33	3.2	80	0.60	5.5	95	0.90	8.0	110	1.45	10.0	125	1.80	12.5
80	80	0.55	4.0	100	1.00	7.0	120	1.45	10.0	140	2.15	13.0	160	2.60	16.0
100	100	0.70	5.0	125	1.20	9.0	150	1.80	12.5	175	2.70	16.5	200	3.30	20.0
115	115	0.85	6.0	145	1.50	10.0	175	1.90	14.5	200	2.80	19.0	230	3.80	23.0
125	125	0.90	6.5	155	1.60	11.0	190	2.30	15.5	220	3.10	20.0	250	4.10	25.0
140	140	1.00	7.0	175	1.80	12.5	210	2.60	17.5	245	3.70	23.0	280	4.60	28.0
160	160	1.20	8.0	200	2.00	14.0	240	2.90	20.0	280	4.30	26.0	320	5.30	32.0
175	175	1.30	8.8	220	2.20	15.5	265	3.20	22.0	305	4.70	29.0	350	5.80	35.0

* Check feed rate reduction when hole diameter is between d_{min} - 1.5 DC.



SLN12



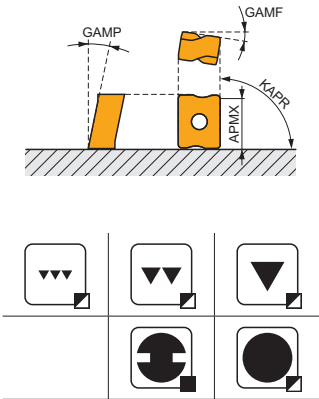
PRAMET



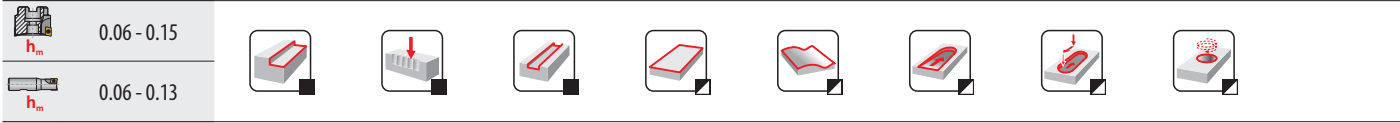
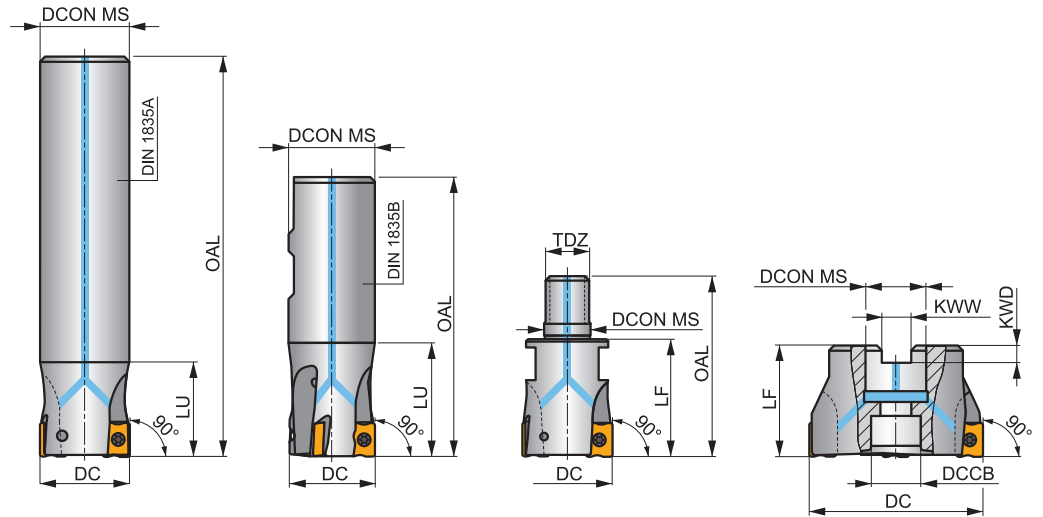
ECON LN12 Rak hörnfräs med invändig kylning

90° hörn- och planfräs för dubbelsidiga LN.. 12-skär med APMX 9 mm. Passar för en rad olika applikationer. Finns med cyl. skaft, Weldon-skaft, modulärt eller dornfäste (med differentiell tanddelning). Behandlad för lång livslängd.

KAPR	90°
APMX	9.0 mm



ECON LN



Product	DC (mm)	OAL (mm)	DCON MS (mm)	DCCB (mm)	LU (mm)	LF (mm)	TDZ (mm)	KWW (mm)	KWD (mm)	GAMF (°)	GAMP (°)	max.	kg	G1205	SQ340	AC001	AC002	AC003	
																			19500
25A2R034A25-SLN12-C	25	170	25	-	34	-	-	-	-	-23	-8	2	-	19500	✓	0.58	G1205	SQ340	-
25A2R080A25-SLN12-C	25	170	25	-	80	-	-	-	-	-23	-8	2	-	19500	✓	0.54	G1205	SQ340	-
32A2R034A32-SLN12-C	32	195	32	-	34	-	-	-	-	-15	-6	2	-	17300	✓	1.05	G1205	SQ340	-
32A2R090A32-SLN12-C	32	195	32	-	90	-	-	-	-	-15	-6	2	-	17300	✓	0.98	G1205	SQ340	-
25A2R042B25-SLN12-C	25	99	25	-	42	-	-	-	-	-23	-8	2	-	19500	✓	0.30	G1205	SQ340	-
32A3R042B32-SLN12-C	32	103	32	-	42	-	-	-	-	-15	-6	3	-	17300	✓	0.50	G1205	SQ340	-
40A4R050B32-SLN12-C	40	111	32	-	50	-	-	-	-	-15	-6	4	✓	15500	✓	0.62	G1205	SQ340	-
25A2R033M12-SLN12-C	25	55	12.5	-	-	33	-	-	-	-22	-6	2	-	✓	0.11	G1205	SQ340	-	
32A2R043M16-SLN12-C	32	66	17	-	-	43	-	-	-	-15	-6	2	-	✓	0.22	G1205	SQ340	-	
32A3R043M16-SLN12-C	32	66	17	-	-	43	-	-	-	-15	-6	3	-	✓	0.22	G1205	SQ340	-	
40A3R043M16-SLN12-C	40	66	17	-	-	43	-	-	-	-15	-6	3	-	✓	0.28	G1205	SQ340	-	
40A04R-S90LN12-C	40	-	16	14	-	40	-	8.4	5.6	-15	-6	4	✓	15500	✓	0.33	G1205	SQ342	-
50A04R-S90LN12-C	50	-	22	18	-	40	-	10.4	6.3	-14.5	-6	4	✓	13800	✓	0.47	G1205	SQ343	-
50A05R-S90LN12-C	50	-	22	18	-	40	-	10.4	6.3	-14.5	-6	5	✓	13800	✓	0.40	G1205	SQ343	-
63A04R-S90LN12-C	63	-	22	18	-	40	-	10.4	6.3	-14	-6	4	✓	12300	✓	0.55	G1205	SQ343	-
63A06R-S90LN12-C	63	-	22	18	-	40	-	10.4	6.3	-14	-6	6	✓	12300	✓	0.50	G1205	SQ343	-
80A05R-S90LN12-C	80	-	27	38	-	50	-	12.4	7	-14	-6	5	✓	10900	✓	1.16	G1205	SQ341	AC001
80A07R-S90LN12-C	80	-	27	38	-	50	-	12.4	7	-14	-6	7	✓	10900	✓	1.11	G1205	SQ341	AC001
100A06R-S90LN12-C	100	-	32	45	-	50	-	14.4	8	-14	-6	6	✓	9800	✓	1.78	G1205	SQ341	AC002
100A08R-S90LN12-C	100	-	32	45	-	50	-	14.4	8	-14	-6	8	✓	9800	✓	1.93	G1205	SQ341	AC002
110A06R-S90LN12-C	110	-	32	45	-	50	-	14.4	8	-14	-6	6	✓	9300	✓	2.09	G1205	SQ341	AC002
125A07R-S90LN12-C	125	-	40	56	-	63	-	16.4	9	-14	-6	7	✓	8700	✓	3.40	G1205	SQ341	AC003
125A09R-S90LN12-C	125	-	40	56	-	63	-	16.4	9	-14	-6	9	✓	8700	✓	3.35	G1205	SQ341	AC003



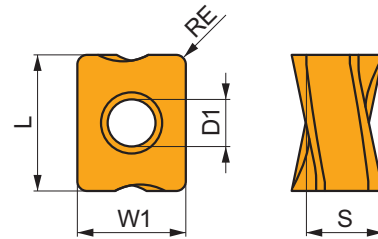
SQ340	US 44012-T15P	3.5	M 4	12	-	-	-	Flag T15P
SQ341	US 44012-T15P	3.5	M 4	12	D-T08P/T15P	FG-15	-	-
SQ342	US 44012-T15P	3.5	M 4	12	D-T08P/T15P	FG-15	-	HS 0830C
SQ343	US 44012-T15P	3.5	M 4	12	D-T08P/T15P	FG-15	-	HS 1030C

AC001	KS 1230	K.FMH27
AC002	KS 1635	K.FMH32
AC003	KS 2040	K.FMH40

LNGX 12

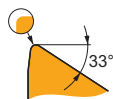
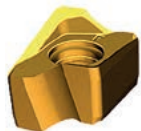


	W1	D1	L	S
	(mm)	(mm)	(mm)	(mm)
1205	9.500	4.50	12.00	5.96



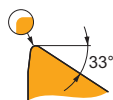
Lämplighet och startvärden för skärhastighet (vc), matning (f) och skärdjup (ap). Vi refererar till vår Dormer Pramet Calculator-app för vidare beräkningar.

Product	RE (mm)	P			M			K			N			S			H		
		vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)



F geometri med mycket positiv design för finfräsning.

LNGX 120504ER-F:8215	● 0.4	200	0.15	1.5	-	-	-	190	0.15	1.5	-	-	-	-	-	-	-	-	-
LNGX 120504ER-F:M8330	● 0.4	200	0.15	1.5	-	-	-	190	0.15	1.5	-	-	-	-	-	-	-	-	-
LNGX 120504ER-F:M8340	● 0.4	180	0.15	1.5	-	-	-	170	0.15	1.5	-	-	-	-	-	-	-	-	-
LNGX 120508ER-F:8215	⊕ 0.8	240	0.15	1.5	-	-	-	225	0.15	1.5	-	-	-	-	-	-	-	-	-
LNGX 120508ER-F:M8310	⊕ 0.8	260	0.15	1.5	-	-	-	245	0.15	1.5	-	-	-	-	-	-	-	-	-
LNGX 120508ER-F:M8330	⊕ 0.8	235	0.15	1.5	-	-	-	220	0.15	1.5	-	-	-	-	-	-	-	-	-
LNGX 120508ER-F:M8340	⊕ 0.8	215	0.15	1.5	-	-	-	200	0.15	1.5	-	-	-	-	-	-	-	-	-

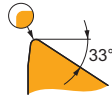


M geometri med positiv design för fin till medelfin fräsning.

LNGX 120504ER-M:M8330	● 0.4	185	0.15	3.0	-	-	-	175	0.15	3.0	-	-	-	-	-	-	-	-	-
LNGX 120504ER-M:M8340	⊕ 0.4	170	0.15	3.0	-	-	-	160	0.15	3.0	-	-	-	-	-	-	-	-	-
LNGX 120508ER-M:8215	⊕ 0.8	220	0.15	3.0	-	-	-	205	0.15	3.0	-	-	-	-	-	-	-	-	-
LNGX 120508ER-M:M8310	⊕ 0.8	240	0.15	3.0	-	-	-	225	0.15	3.0	-	-	-	-	-	-	-	-	-
LNGX 120508ER-M:M8330	⊕ 0.8	220	0.15	3.0	-	-	-	205	0.15	3.0	-	-	-	-	-	-	-	-	-
LNGX 120508ER-M:M8340	⊕ 0.8	200	0.15	3.0	-	-	-	190	0.15	3.0	-	-	-	-	-	-	-	-	-
LNGX 120508ER-M:M9315	⊕ 0.8	300	0.15	3.0	-	-	-	285	0.15	3.0	-	-	-	-	-	-	-	-	-
LNGX 120508ER-M:M9325	⊕ 0.8	280	0.15	3.0	-	-	-	265	0.15	3.0	-	-	-	-	-	-	-	-	-
LNGX 120508ER-M:M9340	⊕ 0.8	250	0.15	3.0	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-
LNGX 120510ER-M:M8330	⊕ 1.0	230	0.15	3.0	-	-	-	215	0.15	3.0	-	-	-	-	-	-	-	-	-
LNGX 120512ER-M:M8330	⊕ 1.2	230	0.15	3.0	-	-	-	215	0.15	3.0	-	-	-	-	-	-	-	-	-

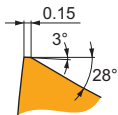
Lämplighet och startvärden för skärhastighet (vc), matning (f) och skärdjup (ap). Vi refererar till vår Dormer Pramet Calculator-app för vidare beräkningar.

Product	RE (mm)	P			M			K			N			S			H		
		vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)



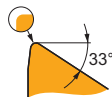
M geometri med positiv design för fin till medelfin fräsning.

LNGX 120512ER-M:M8340	1.2	210	0.15	3.0	-	-	-	195	0.15	3.0	-	-	-	-	-	-	-	-	-
LNGX 120516ER-M:M8330	1.6	240	0.15	3.0	-	-	-	225	0.15	3.0	-	-	-	-	-	-	-	-	-
LNGX 120516ER-M:M8340	1.6	220	0.15	3.0	-	-	-	205	0.15	3.0	-	-	-	-	-	-	-	-	-
LNGX 120520ER-M:M8310	2.0	280	0.15	3.0	-	-	-	265	0.15	3.0	-	-	-	-	-	-	-	-	-
LNGX 120520ER-M:M8330	2.0	255	0.15	3.0	-	-	-	240	0.15	3.0	-	-	-	-	-	-	-	-	-
LNGX 120520ER-M:M8340	2.0	230	0.15	3.0	-	-	-	215	0.15	3.0	-	-	-	-	-	-	-	-	-



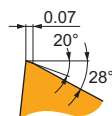
R geometri med positiv design för mindre stabila förhållanden.

LNGX 120508SR-R:8215	0.8	205	0.20	3.5	-	-	-	190	0.20	3.5	-	-	-	-	-	-	-	-	-
LNGX 120508SR-R:M5315	0.8	265	0.20	3.5	-	-	-	250	0.20	3.5	-	-	-	-	-	-	-	-	-
LNGX 120508SR-R:M8310	0.8	220	0.20	3.5	-	-	-	205	0.20	3.5	-	-	-	-	-	-	-	-	-
LNGX 120508SR-R:M8330	0.8	205	0.20	3.5	-	-	-	190	0.20	3.5	-	-	-	-	-	-	-	-	-
LNGX 120508SR-R:M8340	0.8	185	0.20	3.5	-	-	-	175	0.20	3.5	-	-	-	-	-	-	-	-	-
LNGX 120508SR-R:M9315	0.8	265	0.20	3.5	-	-	-	250	0.20	3.5	-	-	-	-	-	-	-	-	-
LNGX 120508SR-R:M9325	0.8	250	0.20	3.5	-	-	-	235	0.20	3.5	-	-	-	-	-	-	-	-	-
LNGX 120508SR-R:M9340	0.8	225	0.20	3.5	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-
LNGX 120516SR-R:8215	1.6	225	0.20	3.5	-	-	-	210	0.20	3.5	-	-	-	-	-	-	-	-	-
LNGX 120516SR-R:M8330	1.6	225	0.20	3.5	-	-	-	210	0.20	3.5	-	-	-	-	-	-	-	-	-
LNGX 120516SR-R:M8340	1.6	205	0.20	3.5	-	-	-	190	0.20	3.5	-	-	-	-	-	-	-	-	-
LNGX 120516SR-R:M9325	1.6	275	0.20	3.5	-	-	-	260	0.20	3.5	-	-	-	-	-	-	-	-	-



MF geometri med mycket positiv design för finfräsning.

LNGX 120504ER-MF:M6330	0.4	175	0.15	1.0	125	0.14	1.0	-	-	-	-	-	-	-	-	-	-	-	-
LNGX 120504ER-MF:M9340	0.4	240	0.15	1.0	140	0.14	1.0	-	-	-	-	-	-	-	-	-	-	-	-
LNGX 120508ER-MF:M6330	0.8	210	0.15	1.0	150	0.14	1.0	-	-	-	-	-	-	-	-	-	-	-	-
LNGX 120508ER-MF:M8340	0.8	225	0.15	1.0	135	0.14	1.0	-	-	-	-	-	-	-	-	-	-	-	-
LNGX 120508ER-MF:M9340	0.8	285	0.15	1.0	170	0.14	1.0	-	-	-	-	-	-	-	-	-	-	-	-



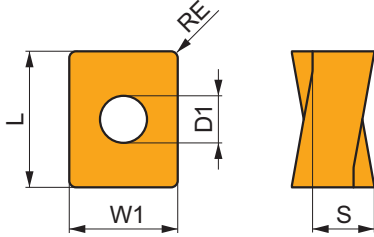
MM geometri med positiv design för fin till medelfin fräsning.

LNGX 120508SR-MM:M6330	0.8	190	0.15	2.8	135	0.14	2.8	-	-	-	-	-	-	-	-	-	-	-	-
LNGX 120508SR-MM:M8340	0.8	200	0.15	2.8	120	0.14	2.8	-	-	-	-	-	-	-	-	-	-	-	-
LNGX 120508SR-MM:M8345	0.8	160	0.15	2.8	95	0.14	2.8	-	-	-	-	-	-	-	-	-	-	-	-
LNGX 120508SR-MM:M9340	0.8	255	0.15	2.8	150	0.14	2.8	-	-	-	-	-	-	-	-	-	-	-	-

LNGU 12



	W1 (mm)	D1 (mm)	L (mm)	S (mm)
1205	9.500	4.50	12.00	5.96



Lämplighet och startvärden för skärhastighet (vc), matning (f) och skärdjup (ap). Vi refererar till vår Dormer Pramet Calculator-app för vidare beräkningar.

Product	RE (mm)	P			M			K			N			S			H		
		vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)



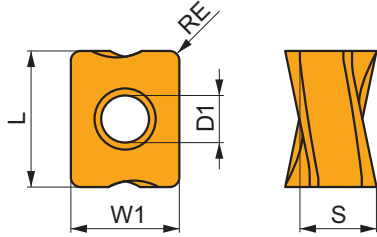
M geometri med positiv design för medelgrov fräsning.

LNGU 120525ER-M:M8330	✱ 2.5	■ 255	■ 0.15	■ 3.0	■ -	■ -	■ -	■ 240	■ 0.15	■ 3.0	■ -	■ -	■ -	■ -	■ -	■ -	■ -	■ -	■ -
LNGU 120525ER-M:M8340	✱ 2.5	■ 230	■ 0.15	■ 3.0	■ -	■ -	■ -	■ 215	■ 0.15	■ 3.0	■ -	■ -	■ -	■ -	■ -	■ -	■ -	■ -	■ -
LNGU 120530ER-M:M8330	✱ 3.0	■ 255	■ 0.15	■ 3.0	■ -	■ -	■ -	■ 240	■ 0.15	■ 3.0	■ -	■ -	■ -	■ -	■ -	■ -	■ -	■ -	■ -
LNGU 120530ER-M:M8340	✱ 3.0	■ 230	■ 0.15	■ 3.0	■ -	■ -	■ -	■ 215	■ 0.15	■ 3.0	■ -	■ -	■ -	■ -	■ -	■ -	■ -	■ -	■ -

LNGX 12-FA

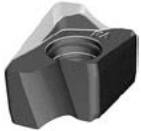


	W1 (mm)	D1 (mm)	L (mm)	S (mm)
1205	9.500	4.50	12.00	5.96



Lämplighet och startvärden för skärhastighet (vc), matning (f) och skärdjup (ap). Vi refererar till vår Dormer Pramet Calculator-app för vidare beräkningar.

Product	RE (mm)	P			M			K			N			S			H		
		vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)



FA geometri med mycket positiv design för fin till medelfin fräsning.

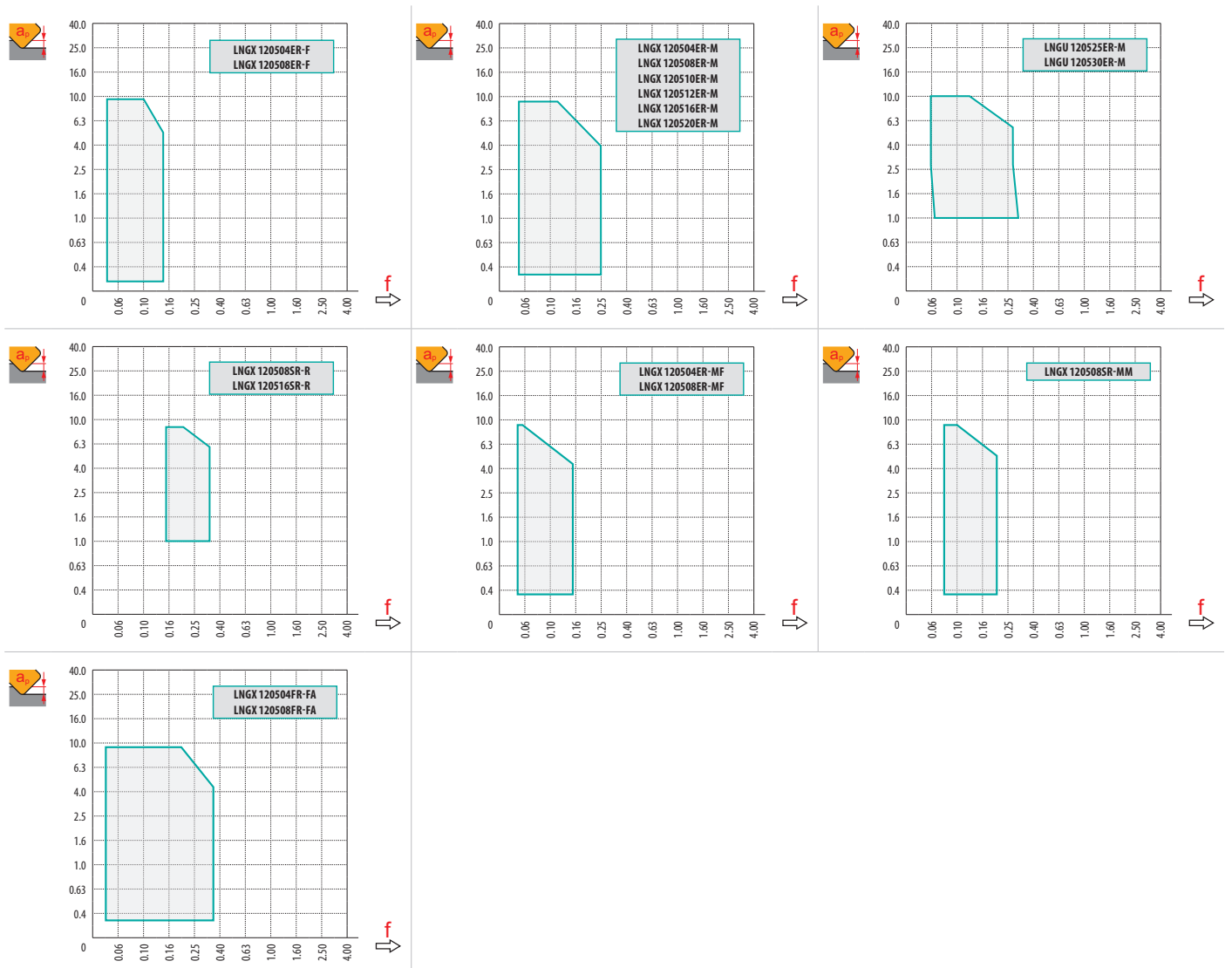
LNGX 120504FR-FA:HF7	● 0.4	■ -	■ -	■ -	■ -	■ -	■ -	■ -	■ -	■ -	■ 270	■ 0.30	■ 2.0	■ -	■ -	■ -	■ -	■ -	■ -
LNGX 120508FR-FA:HF7	● 0.8	■ -	■ -	■ -	■ -	■ -	■ -	■ -	■ -	■ -	■ 315	■ 0.30	■ 2.0	■ -	■ -	■ -	■ -	■ -	■ -
LNGX 120508FR-FA:M0315	● 0.8	■ -	■ -	■ -	■ -	■ -	■ -	■ -	■ -	■ -	■ 720	■ 0.30	■ 2.0	■ -	■ -	■ -	■ -	■ -	■ -

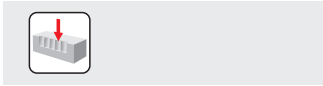


a_e / DC	5 %	10 %	15 %	20 %	25 %	30 %	40 %	50 %	60 %	70 %	75 %	80 %	90 %	100 %
	1.48	1.35	1.27	1.22	1.19	1.16	1.11	1.08	1.05	1.03	1.00	1.00	1.00	1.00
	2.20	1.60	1.35	1.20	1.10	0.95	0.85	0.75	0.85	0.95	1.00	1.00	1.00	1.00
	0.64	0.64	0.64	0.64	0.64	0.65	0.65	0.67	0.68	0.71	0.72	0.74	0.79	1.00

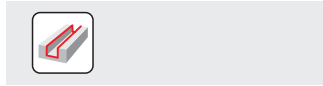
	LNGX 12-F		LNGX 12-M						LNGU 12-M	
	0.4	0.8	0.4	0.8	1.0	1.2	1.6	2.0	2.5	3.0
	2.29	1.89	2.29	1.89	1.69	1.49	1.09	0.68	0.87	0.36

	LNGX 12-R		LNGX 12-MF		LNGX 12-MM	LNGX 12-FA	
	0.8	1.6	0.4	0.8	0.8	0.4	0.8
	1.88	1.08	2.28	1.88	1.88	2.30	1.89

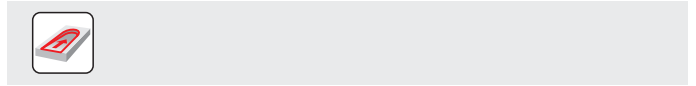




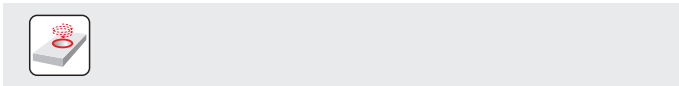
max
3.5



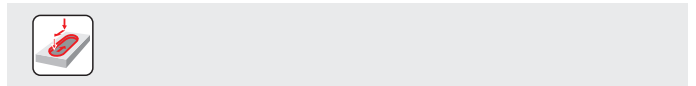
	1.0	5.0	9.0
	0.19	0.13	0.08



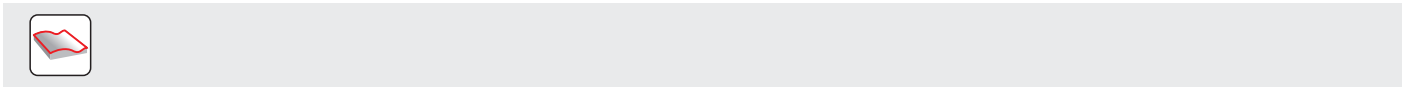
LNGX 12		
	RPMX	APMX/II
25	1.3°	2.1/100
32	0.7°	1.1/100
40	0.5°	0.7/100
50	0.4°	0.5/100
63	0.2°	0.3/100
80	0.2°	0.2/100



LNGX 12				
	DMIN	DMAX		
25	35.0	50.0	0.7	1.7
32	49.0	64.0	0.6	1.2
40	65.0	80.0	0.6	1.0
50	85.0	100.0	0.7	1.0
63	111.0	126.0	0.6	0.8
80	145.0	160.0	0.7	0.8



0.2



		3	5	10	15	20	30	40	50	60	80	100
25		0.548	0.707	1.000	1.225	1.414	1.732	2.000	2.236	2.449	2.828	3.162
32		0.620	0.800	1.131	1.386	1.600	1.960	2.263	2.530	2.771	3.200	3.578
40		0.693	0.894	1.265	1.549	1.789	2.191	2.530	2.828	3.098	3.578	4.000
50		0.775	1.000	1.414	1.732	2.000	2.449	2.828	3.162	3.464	4.000	4.472
63		0.869	1.122	1.587	1.944	2.245	2.750	3.175	3.550	3.888	4.490	5.020
80	0.980	1.265	1.789	2.191	2.530	3.098	3.578	4.000	4.382	5.060	5.657	

		3	5	10	15	20	30	40	50	60	80	100
1.6		0.196	0.253	0.358	0.438	0.506	0.620	0.716	0.800	0.876	1.012	1.131
2.0		0.219	0.283	0.400	0.490	0.566	0.693	0.800	0.894	0.980	1.131	1.265
2.5		0.245	0.316	0.447	0.548	0.632	0.775	0.894	1.000	1.095	1.265	1.414
3.0		0.268	0.346	0.490	0.600	0.693	0.849	0.980	1.095	1.200	1.386	1.549

SLN16

P **K** **N** **H**

PRAMET

S

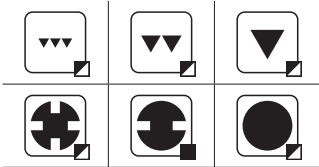
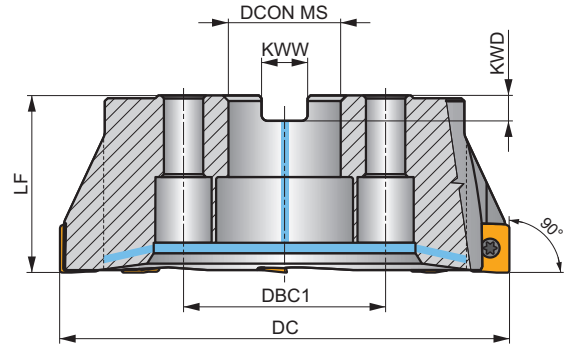
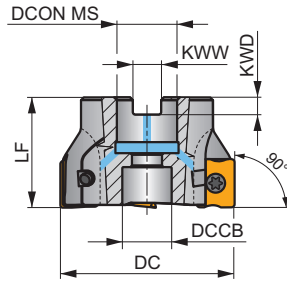
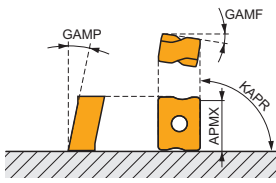


ECON LN16 hörnfräs, med invändig kylning

90° hörnfräs för dubbelsidiga LN.. 16-skär med APMX 13 mm. Passar för en rad olika applikationer. Finns med dornfäste, med differentiell tanddelning. Behandlad för lång livslängd.

ECON LN

KAPR	90°
APMX	13.0 mm



0.08 - 0.2



Product	DC	LF	DCON MS	DCCB	DBC1	KWW	KWD	GAMF	GAMP			kg					
	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(°)	(°)								
63A04R-S90LN16-C	63	40	22	18	-	10.4	6.3	-10.5	-6	4	✓	7600	✓	0.46	GI207	SQ353	-
63A05R-S90LN16-C	63	40	22	18	-	10.4	6.3	-10.5	-6	5	✓	7600	✓	0.46	GI207	SQ353	-
80A04R-S90LN16-C	80	50	27	38	-	12.4	7	-10.5	-6	4	✓	6800	✓	0.98	GI207	SQ351	AC001
80A06R-S90LN16-C	80	50	27	38	-	12.4	7	-10.5	-6	6	✓	6800	✓	0.89	GI207	SQ351	AC001
100A05R-S90LN16-C	100	50	32	45	-	14.4	8	-10.5	-6	5	✓	6100	✓	0.98	GI207	SQ351	AC002
100A07R-S90LN16-C	100	50	32	45	-	14.4	8	-10.5	-6	7	✓	6100	✓	1.78	GI207	SQ351	AC002
125A06R-S90LN16-C	125	63	40	56	-	16.4	9	-10.5	-6	6	✓	5400	✓	3.39	GI207	SQ351	AC003
125A08R-S90LN16-C	125	63	40	56	-	16.4	9	-10.5	-6	8	✓	5400	✓	3.28	GI207	SQ351	AC003
140A06R-S90LN16-C	140	63	40	56	-	16.4	9	-10.5	-6	6	✓	5100	✓	3.91	GI207	SQ351	AC003
160C08R-S90LN16-C	160	63	40	-	66.7	16.4	9	-10.5	-6	8	✓	4700	✓	6.19	GI207	SQ356	-
175C08R-S90LN16-C	175	63	40	-	66.7	16.4	9	-10.5	-6	8	✓	4500	✓	7.11	GI207	SQ356	-

GI207	LNMU 1607..	LNGU 1607..

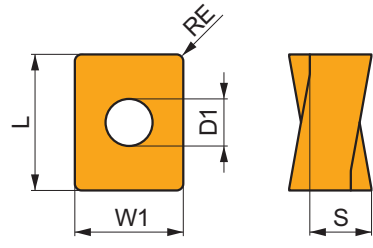
SQ351	US 45012-T20P	5.0	M 5	12	SDR T20P-T	-	-	-	-
SQ353	US 45012-T20P	5.0	M 5	12	SDR T20P-T	HS 1030C	-	-	-
SQ356	US 45012-T20P	5.0	M 5	12	SDR T20P-T	HS 1240C	CAC 160C	HSD 0825C	HXK 5

AC001	KS 1230	K.FMH27
AC002	KS 1635	K.FMH32
AC003	KS 2040	K.FMH40

LNGU 16

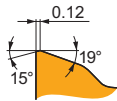
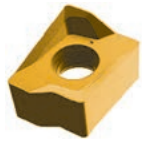


	W1	D1	L	S
	(mm)	(mm)	(mm)	(mm)
1607	13.200	5.70	16.60	7.50



Lämplighet och startvärden för skärhastighet (vc), matning (f) och skärdjup (ap). Vi refererar till vår Dormer Pramet Calculator-app för vidare beräkningar.

Product	RE (mm)	P			M			K			N			S			H		
		vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
		(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)



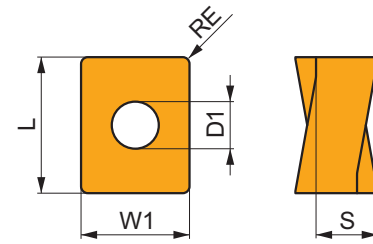
M geometri med mycket positiv design för medelfin fräsning.

LNGU 160708SR-M:8215	0.8	200	0.18	5.0	—	—	—	190	0.18	5.0	—	—	—	—	—	—	40	0.12	1.0
LNGU 160708SR-M:M8340	0.8	180	0.18	5.0	—	—	—	170	0.18	5.0	—	—	—	—	—	—	—	—	—
LNGU 160708SR-M:M9315	0.8	265	0.18	5.0	—	—	—	250	0.18	5.0	—	—	—	—	—	—	50	0.12	1.0
LNGU 160708SR-M:M9325	0.8	250	0.18	5.0	—	—	—	235	0.18	5.0	—	—	—	—	—	—	50	0.12	1.0

LNMU 16



	W1	D1	L	S
	(mm)	(mm)	(mm)	(mm)
1607	13.200	5.70	16.60	7.50



Lämplighet och startvärden för skärhastighet (vc), matning (f) och skärdjup (ap). Vi refererar till vår Dormer Pramet Calculator-app för vidare beräkningar.

Product	RE (mm)	P			M			K			N			S			H		
		vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
		(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)

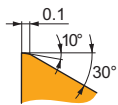


F geometri med mycket positiv design för finfräsning.

LNMU 160708ER-F:M8330	0.8	230	0.16	1.7	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
LNMU 160708ER-F:M8340	0.8	210	0.16	1.7	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—

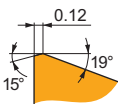
Lämplighet och startvärden för skärhastighet (vc), matning (f) och skärdjup (ap). Vi refererar till vår Dormer Pramet Calculator-app för vidare beräkningar.

Product	RE (mm)	P			M			K			N			S			H		
		vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)



M geometri med positiv design för medelgrov fräsning.

LNMU 160708SR-M:8215	0.8	200	0.18	5.0	-	-	-	190	0.18	5.0	-	-	-	-	-	-	-	-
LNMU 160708SR-M:M6330	0.8	170	0.18	5.0	-	-	-	-	-	-	-	-	-	-	-	-	-	-
LNMU 160708SR-M:M8330	0.8	200	0.18	5.0	-	-	-	190	0.18	5.0	-	-	-	-	-	-	-	-
LNMU 160708SR-M:M8340	0.8	180	0.18	5.0	-	-	-	170	0.18	5.0	-	-	-	-	-	-	-	-
LNMU 160708SR-M:M9325	0.8	250	0.18	5.0	-	-	-	235	0.18	5.0	-	-	-	-	-	-	-	-
LNMU 160720SR-M:M8330	2.0	230	0.18	5.0	-	-	-	215	0.18	5.0	-	-	-	-	-	-	-	-
LNMU 160720SR-M:M8340	2.0	210	0.18	5.0	-	-	-	195	0.18	5.0	-	-	-	-	-	-	-	-
LNMU 160730SR-M:M8330	3.0	230	0.18	5.0	-	-	-	215	0.18	5.0	-	-	-	-	-	-	-	-
LNMU 160730SR-M:M8340	3.0	210	0.18	5.0	-	-	-	195	0.18	5.0	-	-	-	-	-	-	-	-
LNMU 160740SR-M:M8340	4.0	210	0.18	5.0	-	-	-	195	0.18	5.0	-	-	-	-	-	-	-	-



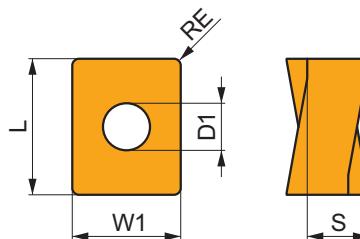
R geometri med positiv, stabil design för medelgrov fräsning.

LNMU 160708SR-R:M5315	0.8	265	0.18	6.3	-	-	-	250	0.18	6.3	-	-	-	-	-	50	0.12	1.0
LNMU 160708SR-R:M8330	0.8	195	0.18	6.3	-	-	-	185	0.18	6.3	-	-	-	-	-	35	0.12	1.0
LNMU 160708SR-R:M8340	0.8	175	0.18	6.3	-	-	-	165	0.18	6.3	-	-	-	-	-	-	-	-
LNMU 160708SR-R:M9315	0.8	260	0.18	6.3	-	-	-	245	0.18	6.3	-	-	-	-	-	50	0.12	1.0
LNMU 160708SR-R:M9325	0.8	240	0.18	6.3	-	-	-	225	0.18	6.3	-	-	-	-	-	45	0.12	1.0
LNMU 160716SR-R:M8330	1.6	215	0.18	6.3	-	-	-	200	0.18	6.3	-	-	-	-	-	40	0.12	1.1
LNMU 160716SR-R:M8340	1.6	195	0.18	6.3	-	-	-	185	0.18	6.3	-	-	-	-	-	-	-	-
LNMU 160716SR-R:M9315	1.6	285	0.18	6.3	-	-	-	270	0.18	6.3	-	-	-	-	-	55	0.12	1.1
LNMU 160716SR-R:M9325	1.6	265	0.18	6.3	-	-	-	250	0.18	6.3	-	-	-	-	-	50	0.12	1.1

LNGU 16-FA



	W1 (mm)	D1 (mm)	L (mm)	S (mm)
1607	13.200	5.70	16.60	7.50



Lämplighet och startvärden för skärhastighet (vc), matning (f) och skärdjup (ap). Vi refererar till vår Dormer Pramet Calculator-app för vidare beräkningar.

Product	RE (mm)	P			M			K			N			S			H		
		vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)



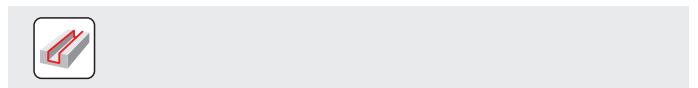
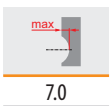
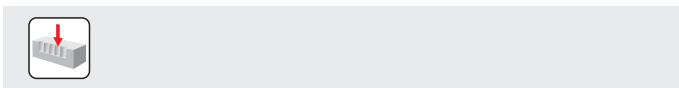
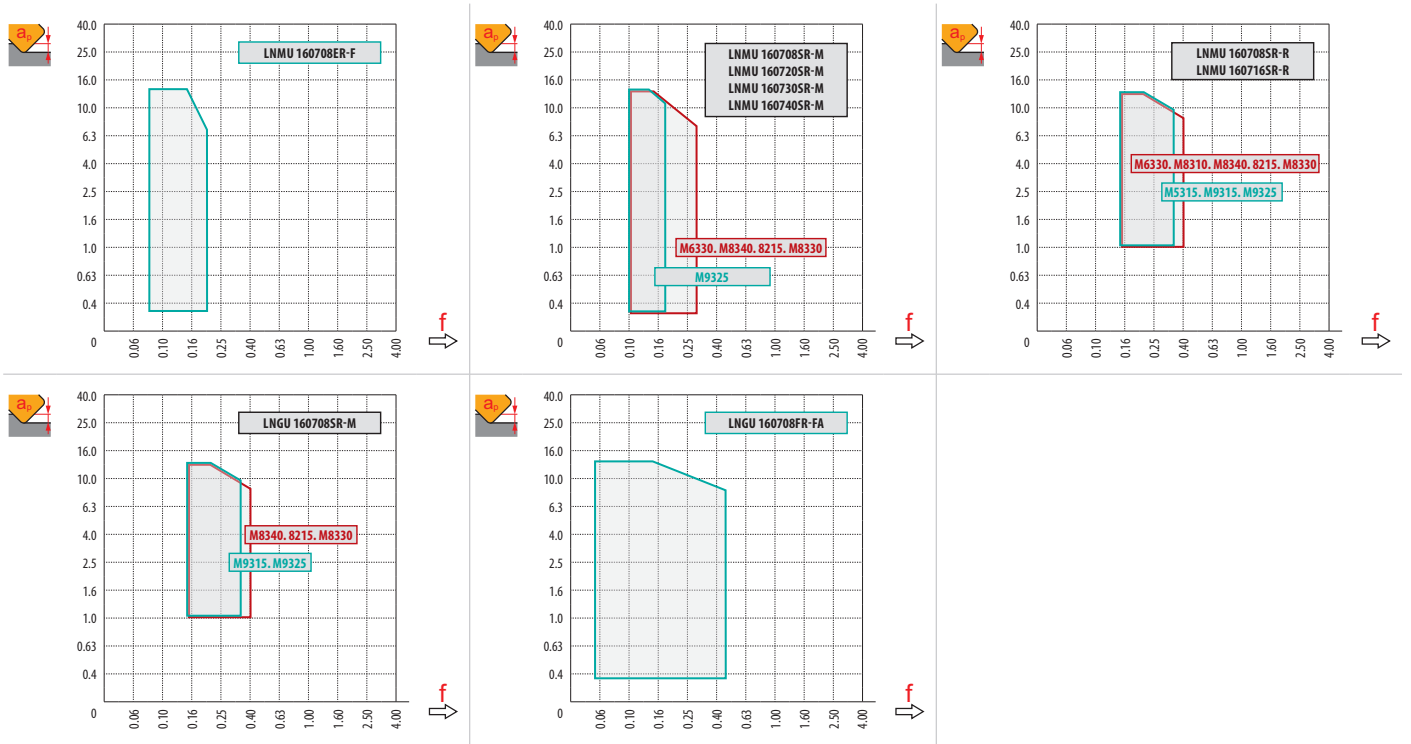
FA geometri med mycket positiv design för fin till medelfin fräsning.

LNGU 160708FR-FA:HF7	0.8	-	-	-	-	-	-	-	-	-	300	0.30	3.0	-	-	-	-	-
----------------------	-----	---	---	---	---	---	---	---	---	---	-----	------	-----	---	---	---	---	---



a_e / DC	5%	10%	15%	20%	25%	30%	40%	50%	60%	70%	75%	80%	90%	100%
	1.48	1.35	1.27	1.22	1.19	1.16	1.11	1.08	1.05	1.03	1.00	1.00	1.00	1.00
	2.20	1.60	1.35	1.20	1.10	0.95	0.85	0.75	0.85	0.95	1.00	1.00	1.00	1.00
	0.64	0.64	0.64	0.64	0.64	0.65	0.65	0.67	0.68	0.71	0.72	0.74	0.79	1.00

	LNMU 16-F	LNMU 16-M			LNMU 16-R		LNGU 16-M	LNGU 16-FA	
	0.8	0.8	2.0	3.0	4.0	0.8	1.6	0.8	0.8
	3.30	3.30	2.11	1.12	0.10	3.30	2.50	3.24	3.30



	1.0	6.0	13.0
	0.31	0.24	0.13

SLN12X



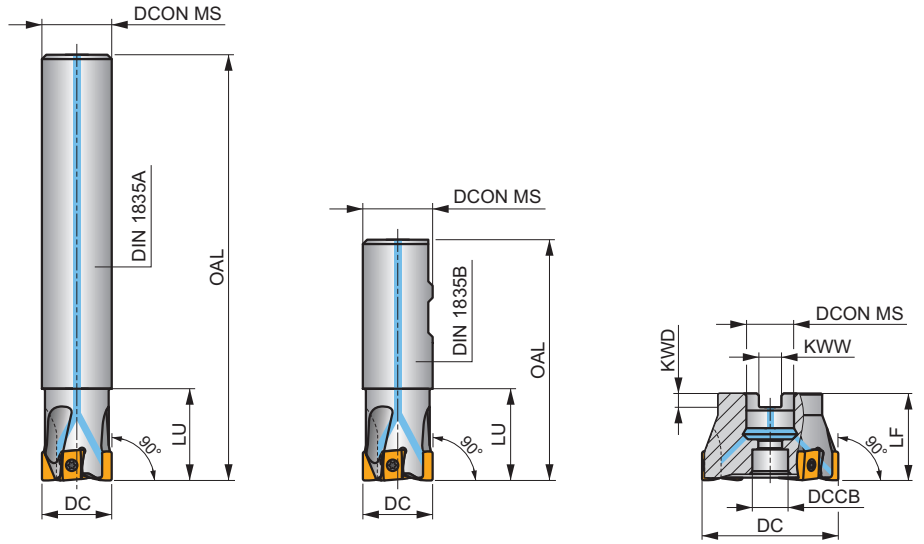
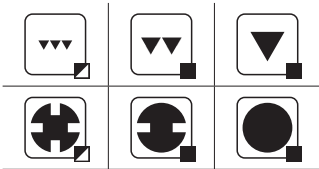
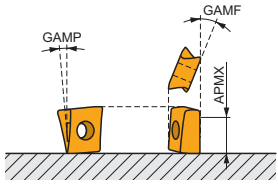
PRAMET



PROD LN12 90° Tangentiell hörnfräs med invändig kylning

Högproduktiv 90° hörnfräs för tangentiella LNX 12 vändskär med 4 skäreppor och ett APMX på 10 mm. Passar till en rad applikationer. Finns med cylindriskt, Weldon- och dornfäste. Robust skärkropp för lång livslängd och styrka.

KAPR	90°
APMX	10.0 mm



	0.06 - 0.18
	0.06 - 0.20



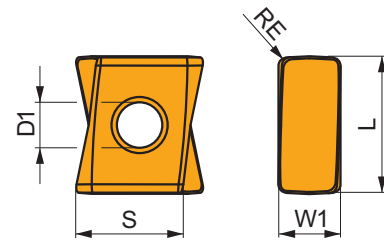
Product	DC	OAL	DCON MS	DCCB	LU	LF	KWW	KWD	GAMP	GAMP						
	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(°)	(°)						
25A2R042A25-SLN12X-C	25	170	25	-	42	-	-	-	-30	-5	2	-	17300	✓	0.55	G1206 C0382
25A2R080A25-SLN12X-C	25	170	25	-	80	-	-	-	-30	-5	2	-	17300	✓	0.50	G1206 C0382
32A3R042A32-SLN12X-C	32	195	32	-	42	-	-	-	-22.5	-5	3	-	15300	✓	1.08	G1206 SQ340
32A3R090A32-SLN12X-C	32	195	32	-	90	-	-	-	-22.5	-5	3	-	15300	✓	1.02	G1206 SQ340
40A4R050A32-SLN12X-C	40	195	32	-	50	-	-	-	-22.5	-5	4	-	13700	✓	1.17	G1206 SQ340
25A2R042B25-SLN12X-C	25	100	25	-	42	-	-	-	-30	-5	2	-	17300	✓	0.29	G1206 C0382
32A3R042B32-SLN12X-C	32	110	32	-	42	-	-	-	-22.5	-5	3	-	15300	✓	0.58	G1206 SQ340
40A4R050B32-SLN12X-C	40	120	32	-	50	-	-	-	-22.5	-5	4	-	13700	✓	0.73	G1206 SQ340
40A03R-S90LN12X-C	40	-	16	12.4	-	40	8.4	5.6	-22.5	-5	3	-	13700	✓	0.15	G1206 SQ345
40A04R-S90LN12X-C	40	-	16	12.4	-	40	8.4	5.6	-22.5	-5	4	✓	13700	✓	0.23	G1206 SQ345
50A05R-S90LN12X-C	50	-	22	16.5	-	40	10.4	6.3	-19.5	-5	5	-	12300	✓	0.34	G1206 SQ343
50A06R-S90LN12X-C	50	-	22	16.5	-	40	10.4	6.3	-19.5	-5	6	-	12300	✓	0.34	G1206 SQ343
52A05R-S90LN12X-C	52	-	22	16.5	-	40	10.4	6.3	-19.5	-5	5	-	12300	✓	0.37	G1206 SQ343
63A06R-S90LN12X-C	63	-	22	16.5	-	40	10.4	6.3	-19.5	-5	6	✓	10900	✓	0.61	G1206 SQ343
63A08R-S90LN12X-C	63	-	22	16.5	-	40	10.4	6.3	-19.5	-5	8	-	10900	✓	0.50	G1206 SQ343
66A06R-S90LN12X-C	66	-	22	16.5	-	40	10.4	6.3	-19.5	-5	6	✓	10900	✓	0.54	G1206 SQ343
80A07R-S90LN12X-C	80	-	27	38.1	-	50	12.4	7	-19.5	-5	7	✓	9700	✓	1.00	G1206 SQ341
80A10R-S90LN12X-C	80	-	27	38.1	-	50	12.4	7	-19.5	-5	10	-	9700	✓	0.98	G1206 SQ341
100A08R-S90LN12X-C	100	-	32	45.1	-	50	14.4	8	-17.5	-5	8	✓	8700	✓	1.90	G1206 SQ341
100A11R-S90LN12X-C	100	-	32	45.1	-	50	14.4	8	-17.5	-5	11	-	8700	✓	1.88	G1206 SQ341
125A12R-S90LN12X-C	125	-	40	56.1	-	63	16.4	9	-17.5	-5	12	✓	7800	✓	3.39	G1206 SQ341

C0382	US 44010-T15P	3.5	M 4	10	–	–	–	Flag T15P	–
SQ340	US 44012-T15P	3.5	M 4	12	–	–	–	Flag T15P	–
SQ341	US 44012-T15P	3.5	M 4	12	D-T08P/T15P	FG-15	–	–	–
SQ343	US 44012-T15P	3.5	M 4	12	D-T08P/T15P	FG-15	–	–	HS 1030C
SQ345	US 44012-T15P	3.5	M 4	12	D-T08P/T15P	FG-15	–	–	HS 90835

LNEX 12

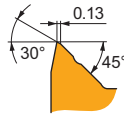


	W1	D1	L	S
	(mm)	(mm)	(mm)	(mm)
1210	6.000	4.40	13.30	10.26



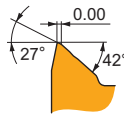
Lämplighet och startvärden för skärhastighet (vc), matning (f) och skärdjup (ap). Vi refererar till vår Dormer Pramet Calculator-app för vidare beräkningar.

Product	RE (mm)	P			M			K			N			S			H					
		vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap			
		(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)



F geometrin är vass och används till lätt och medelgrov bearbetning och vid långa överhäng. Utformad med mycket positiv spånvinkel, smal eggfas och rundad egg för medelgrov bearbetning.

LNEX 121008SR-F:M6330	✳	0.8	■	220	0.17	3.0	■	155	0.15	3.0	■	–	–	–	–	–	–	–	–	–	–	–		
LNEX 121008SR-F:M8310	✳	0.8	■	280	0.17	3.0	■	140	0.15	3.0	■	265	0.17	3.0	–	–	–	–	–	–	■	55	0.11	1.0
LNEX 121008SR-F:M8330	✳	0.8	■	260	0.17	3.0	■	155	0.15	3.0	■	245	0.17	3.0	–	–	–	–	–	–	■	50	0.11	1.0
LNEX 121008SR-F:M8340	✳	0.8	■	235	0.17	3.0	■	140	0.15	3.0	■	220	0.17	3.0	–	–	–	–	–	–	–	–	–	–
LNEX 121012SR-F:M6330	✳	1.2	■	230	0.17	3.0	■	165	0.15	3.0	■	–	–	–	–	–	–	–	–	–	–	–	–	
LNEX 121012SR-F:M8310	✳	1.2	■	295	0.17	3.0	■	150	0.15	3.0	■	280	0.17	3.0	–	–	–	–	–	–	■	55	0.11	1.0
LNEX 121012SR-F:M8330	✳	1.2	■	270	0.17	3.0	■	160	0.15	3.0	■	255	0.17	3.0	–	–	–	–	–	–	■	50	0.11	1.0



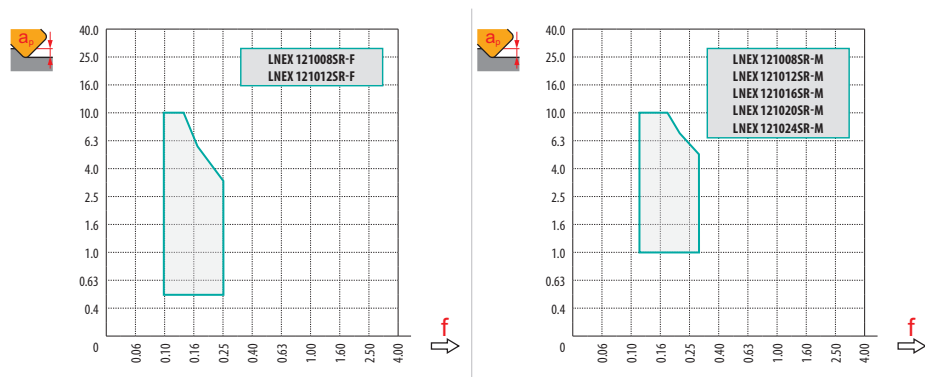
M geometrin har ett brett användningsområde och är förstaval till en lång rad bearbetningsförhållanden. Utformad med positiv spånvinkel, medelstor eggfas och rundad egg för medelfin till medelgrov bearbetning.

LNEX 121008SR-M:M6330	✳	0.8	■	210	0.20	3.5	■	–	–	–	■	–	–	–	–	–	–	–	–	–	–	–	–	
LNEX 121008SR-M:M8310	✳	0.8	■	265	0.20	3.5	■	–	–	–	■	250	0.20	3.5	–	–	–	–	–	–	■	50	0.16	1.0
LNEX 121008SR-M:M8330	✳	0.8	■	245	0.20	3.5	■	–	–	–	■	230	0.20	3.5	–	–	–	–	–	–	■	45	0.16	1.0
LNEX 121008SR-M:M8340	✳	0.8	■	220	0.20	3.5	■	–	–	–	■	205	0.20	3.5	–	–	–	–	–	–	–	–	–	–
LNEX 121008SR-M:M9315	✳	0.8	■	320	0.20	3.5	■	–	–	–	■	300	0.20	3.5	–	–	–	–	–	–	■	60	0.16	1.0
LNEX 121008SR-M:M9325	✳	0.8	■	300	0.20	3.5	■	–	–	–	■	285	0.20	3.5	–	–	–	–	–	–	■	60	0.16	1.0
LNEX 121008SR-M:M9340	✳	0.8	■	270	0.20	3.5	■	–	–	–	■	–	–	–	–	–	–	–	–	–	–	–	–	
LNEX 121012SR-M:M8310	✳	1.2	■	280	0.20	3.5	■	–	–	–	■	265	0.20	3.5	–	–	–	–	–	–	■	55	0.16	1.0
LNEX 121012SR-M:M8330	✳	1.2	■	255	0.20	3.5	■	–	–	–	■	240	0.20	3.5	–	–	–	–	–	–	■	50	0.16	1.0
LNEX 121012SR-M:M8340	✳	1.2	■	235	0.20	3.5	■	–	–	–	■	220	0.20	3.5	–	–	–	–	–	–	–	–	–	–
LNEX 121016SR-M:M8310	✳	1.6	■	295	0.20	3.5	■	–	–	–	■	280	0.20	3.5	–	–	–	–	–	–	■	55	0.16	1.0
LNEX 121016SR-M:M8330	✳	1.6	■	270	0.20	3.5	■	–	–	–	■	255	0.20	3.5	–	–	–	–	–	–	■	50	0.16	1.0
LNEX 121016SR-M:M8340	✳	1.6	■	245	0.20	3.5	■	–	–	–	■	230	0.20	3.5	–	–	–	–	–	–	–	–	–	–
LNEX 121020SR-M:M8330	✳	2.0	■	285	0.20	3.5	■	–	–	–	■	270	0.20	3.5	–	–	–	–	–	–	■	55	0.16	1.0
LNEX 121020SR-M:M8340	✳	2.0	■	255	0.20	3.5	■	–	–	–	■	240	0.20	3.5	–	–	–	–	–	–	–	–	–	–
LNEX 121024SR-M:M8330	✳	2.4	■	285	0.20	3.5	■	–	–	–	■	270	0.20	3.5	–	–	–	–	–	–	■	55	0.16	1.0
LNEX 121024SR-M:M8340	✳	2.4	■	255	0.20	3.5	■	–	–	–	■	240	0.20	3.5	–	–	–	–	–	–	–	–	–	–



a_e / DC	5 %	10 %	15 %	20 %	25 %	30 %	40 %	50 %	60 %	70 %	75 %	80 %	90 %	100 %
	1.48	1.35	1.27	1.22	1.19	1.16	1.11	1.08	1.05	1.03	1.00	1.00	1.00	1.00
	2.20	1.60	1.35	1.20	1.10	0.95	0.85	0.75	0.85	0.95	1.00	1.00	1.00	1.00
	0.64	0.64	0.64	0.64	0.64	0.65	0.65	0.67	0.68	0.71	0.72	0.74	0.79	1.00

	LNEX 12-F		LNEX 12-M				
	0.8	1.2	0.8	1.2	1.6	2.0	2.4
	2.25	1.73	2.25	1.73	1.33	1.15	0.79









		2.0	3.0	4.0	5.0
2.5		0.30	0.20	0.20	0.15

	RPMX	APMX/I
25	0.80°	1.40/100
32	0.60°	1.00/100
40	0.35°	0.60/100
50	0.30°	0.50/100
52	0.30°	0.50/100
63	0.20°	0.35/100

	DMIN	DMAX		
25	44.0	48.0	0.6	0.7
32	58.0	62.0	0.8	1.0
40	74.0	78.0	0.7	0.8
50	94.0	98.0	0.7	0.8
52	98.0	102.0	0.7	0.8
63	120.0	124.0	0.3	0.4





























		3	5	10	15	20	30	40	50	60	80	100
25		0.548	0.707	1.000	1.225	1.414	1.732	2.000	2.236	2.449	2.828	3.162
32		0.620	0.800	1.131	1.386	1.600	1.960	2.263	2.530	2.771	3.200	3.578
40		0.693	0.894	1.265	1.549	1.789	2.191	2.530	2.828	3.098	3.578	4.000
50		0.775	1.000	1.414	1.732	2.000	2.449	2.828	3.162	3.464	4.000	4.472
52		0.869	1.122	1.587	1.944	2.245	2.750	3.175	3.550	3.888	4.490	5.020
63		0.980	1.265	1.789	2.191	2.530	3.098	3.578	4.000	4.382	5.060	5.657

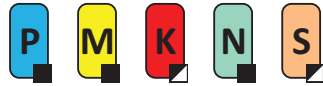
		3	5	10	15	20	30	40	50	60	80	100
0.8		0.155	0.200	0.283	0.346	0.400	0.490	0.566	0.632	0.693	0.800	0.894
1.2		0.170	0.219	0.310	0.379	0.438	0.537	0.620	0.693	0.759	0.876	0.980
1.6		0.196	0.253	0.358	0.438	0.506	0.620	0.716	0.800	0.876	1.012	1.131
2.0		0.219	0.283	0.400	0.490	0.566	0.693	0.800	0.894	0.980	1.131	1.265
2.4		0.245	0.316	0.447	0.548	0.632	0.775	0.894	1.000	1.095	1.265	1.414

INDEXABLE FACE MILLS – NAVIGATOR

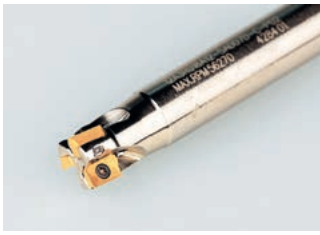
FACE MILLING

	SAD07D	SAD11E	SAD16E	SAP10D	SAP16D		
	90°		90°		90°		
	APMX (mm) 5.0	APMX (mm) 9.0	APMX (mm) 13.0	APMX (mm) 9.0	APMX (mm) 13.0		
	DC (mm) 10 – 32	DC (mm) 16 – 125	DC (mm) 25 – 175	DC (mm) 10 – 25	DC (mm) 25 – 125		
Cylindrical shank	 DC = 10 – 25 (mm)	 DC = 16 – 35 (mm)	 DC = 25, 32 (mm)				
Weldon		 DC = 16 – 32 (mm)	 DC = 25 – 40 (mm)	 DC = 10 – 25 (mm)	 DC = 25 – 40 (mm)		
Modular	 DC = 12 – 32 (mm)	 DC = 16 – 40 (mm)	 DC = 32, 40 (mm)				
Shell mill		 DC = 40 – 125 (mm)	 DC = 40 – 175 (mm)		 DC = 40 – 125 (mm)		
Page	90	97	106	114	117		
ISO	P M K N S	P M K N S H	P M K N S H	P M K N S	P M K N S		
Insert shape							
Inserts	AD.X 0702	AD.X 11T3	AD.X 1606	APKT 1003	APT 1604		
No. of cutting edges	2	2	2	2	2		
Face milling 	■	■	■	■	■		
Chamfer milling 	■	■	■	■	■		
Helical interpolation 	■	■	■	■	■		
Progressive plunging 	■	■	■	■	■		
Ramping 	■	■	■	■	■		
Shape surfaces milling (copy milling) 	■	■	■	■	■		
Shallow shoulder milling 	▣	▣	▣	▣	▣		
Shallow slot milling 	▣	■	■				

SAD07D



PRAMET

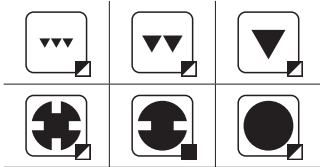
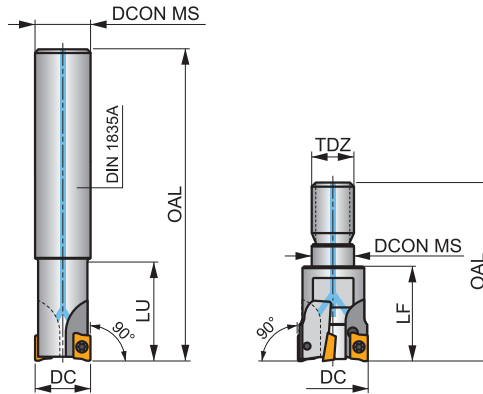
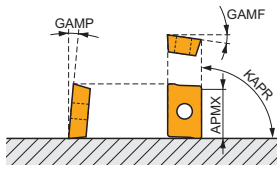


FORCE AD07 Rak hörnfräs med invändig kylning

90° hörn- och planfräs för positiva AD.. 07-skär med APMX 5 mm. Passar för en rad olika applikationer, bl a rampning, trochoidalfräsning och dykfräsning. Finns med cyl. skaft och modulärt skaft och med differentiell tanddelning. Behandlad för lång livslängd.

FORCE AD

KAPR	90°
APMX	5.0 mm



h_m 0.03 - 0.08



Product	DC	OAL	DCON MS	LU	LF	TDZ	GAMF	GAMP							
	(mm)	(mm)	(mm)	(mm)	(mm)	(°)	(°)								
10A2R016A08-SAD07D-C	10	100	8	16	-	-	-12	8	2	-	61600	✓	0.05	G1276	SQ010
10A2R016A10-SAD07D-C	10	80	10	16	-	-	-12	8	2	-	61600	✓	0.05	G1276	SQ010
10A2R018A08-SAD07D-CF	10	100	8	18	-	-	-12	8	2	-	61600	✓	0.06	G1276	SQ010
10A2R018A10-SAD07D-CF	10	80	10	18	-	-	-12	8	2	-	61600	✓	0.05	G1276	SQ010
12A2R018A10-SAD07D-C	12	120	10	18	-	-	-10	8	2	-	56300	✓	0.09	G1276	SQ010
12A2R018A12-SAD07D-C	12	90	12	18	-	-	-10	8	2	-	56300	✓	0.09	G1276	SQ010
12A3R018A12-SAD07D-C	12	90	12	18	-	-	-10	8	3	-	56200	✓	0.09	G1276	SQ010
12A3R020A12-SAD07D-CF	12	90	12	20	-	-	-10	8	3	-	56200	✓	0.09	G1276	SQ010
14A3R018A12-SAD07D-C	14	140	12	18	-	-	-9	8	3	-	52100	✓	0.13	G1276	SQ010
14A3R018A14-SAD07D-C	14	90	14	18	-	-	-9	8	3	-	52100	✓	0.11	G1276	SQ010
14A3R020A12-SAD07D-CF	14	140	12	20	-	-	-9	8	3	-	52100	✓	0.14	G1276	SQ010
14A3R020A14-SAD07D-CF	14	90	14	20	-	-	-9	8	3	-	52100	✓	0.11	G1276	SQ010
16A3R019A14-SAD07D-C	16	160	14	19	-	-	-8	8	3	-	48700	✓	0.21	G1276	SQ011
16A3R019A16-SAD07D-C	16	110	16	19	-	-	-8	8	3	-	48700	✓	0.18	G1276	SQ011
16A4R019A16-SAD07D-C	16	110	16	19	-	-	-8	8	4	-	48700	✓	0.18	G1276	SQ011
18A4R019A16-SAD07D-C	18	180	16	19	-	-	-7.5	8	4	✓	45900	✓	0.28	G1276	SQ011
18A4R019A18-SAD07D-C	18	110	18	19	-	-	-7.5	8	4	✓	45900	✓	0.22	G1276	SQ011
20A4R020A18-SAD07D-C	20	200	18	20	-	-	-7	8	4	✓	43600	✓	0.37	G1276	SQ011
20A4R020A20-SAD07D-C	20	125	20	20	-	-	-7	8	4	✓	43600	✓	0.29	G1276	SQ011
20A5R020A20-SAD07D-C	20	125	20	20	-	-	-7	8	5	✓	43600	✓	0.30	G1276	SQ011
25A5R024A25-SAD07D-C	25	140	25	24	-	-	-6.5	8	5	✓	39000	✓	0.51	G1276	SQ011
25A6R024A25-SAD07D-C	25	140	25	24	-	-	-6.5	8	6	✓	39000	✓	0.51	G1276	SQ011
12A2R020M06-SAD07D-C	12	35	6.5	-	20	M6	-10	8	2	-	-	✓	0.04	G1276	SQ010
14A3R020M08-SAD07D-C	14	38	8.5	-	20	M8	-9	8	3	-	-	✓	0.04	G1276	SQ010
14A3R023M08-SAD07D-CF	14	41	8.5	-	23	M8	-9	8	3	-	-	✓	0.05	G1276	SQ010
16A4R023M08-SAD07D-C	16	41	8.5	-	23	M8	-8	8	4	✓	-	✓	0.05	G1276	SQ011
20A5R030M10-SAD07D-C	20	49	10.5	-	30	M10	-7	8	5	✓	-	✓	0.08	G1276	SQ011

Product	DC	OAL	DCONIMS	LU	LF	TDZ	GAMF	GAMP								
	(mm)	(mm)	(mm)	(mm)	(mm)		(°)	(°)								
25A6R035M12-SAD07D-C	25	57	12.5	-	35	M12	-6.5	8	6	✓	-	✓	0.13	GI276	SQ011	
32A8R043M16-SAD07D-C	32	66	17	-	43	M16	-6	8	8	✓	-	✓	0.24	GI276	SQ011	

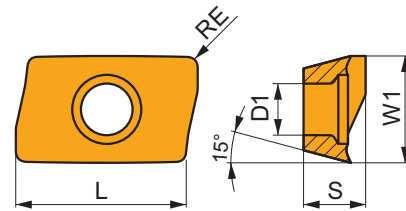
GI276	ADMX 0702..	ADEX 0702..

SQ010	US 62003A-T06P	0.6	M 2	3	Flag T06P
SQ011	US 62004A-T06P	0.6	M 2	4	Flag T06P

ADMX 07

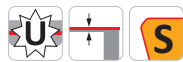
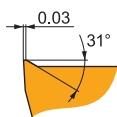


	W1	D1	L	S
	(mm)	(mm)	(mm)	(mm)
0702	4.482	2.20	6.95	2.48



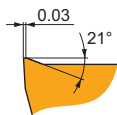
Lämplighet och startvärden för skärhastighet (vc), matning (f) och skärdjup (ap). Vi refererar till vår Dormer Pramet Calculator-app för vidare beräkningar.

Product	RE (mm)	P			M			K			N			S			H		
		vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
		(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)



F geometri med mycket vass positiv design för finfräsning.

ADMX 070202SR-F:M8330	● 0.2	220	0.07	2.0	130	0.06	2.0	-	-	-	660	0.08	2.0	55	0.05	1.6	-	-	-
ADMX 070204SR-F:M6330	● 0.4	200	0.07	2.0	140	0.06	2.0	-	-	-	-	-	-	60	0.05	1.6	-	-	-
ADMX 070204SR-F:M8330	● 0.4	235	0.07	2.0	140	0.06	2.0	-	-	-	705	0.08	2.0	55	0.05	1.6	-	-	-
ADMX 070204SR-F:M8340	● 0.4	215	0.07	2.0	125	0.06	2.0	-	-	-	-	-	-	50	0.05	1.6	-	-	-
ADMX 070208SR-F:M8310	● 0.8	320	0.07	2.0	160	0.06	2.0	-	-	-	-	-	-	-	-	-	-	-	-
ADMX 070208SR-F:M8330	● 0.8	280	0.07	2.0	165	0.06	2.0	-	-	-	840	0.08	2.0	70	0.05	1.6	-	-	-
ADMX 070208SR-F:M8340	● 0.8	255	0.07	2.0	150	0.06	2.0	-	-	-	-	-	-	60	0.05	1.6	-	-	-

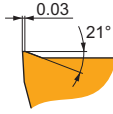


M geometri med positiv design för fin till medelfin fräsning.

ADMX 070202SR-M:M8330	● 0.2	205	0.09	2.2	120	0.08	2.2	190	0.09	2.2	615	0.11	2.2	50	0.06	1.8	-	-	-
ADMX 070202SR-M:M8340	● 0.2	185	0.09	2.2	110	0.08	2.2	175	0.09	2.2	-	-	-	45	0.06	1.8	-	-	-
ADMX 070204SR-M:8215	● 0.4	225	0.09	2.2	135	0.08	2.2	210	0.09	2.2	675	0.11	2.2	55	0.06	1.8	-	-	-
ADMX 070204SR-M:M6330	● 0.4	190	0.09	2.2	135	0.08	2.2	-	-	-	-	-	-	55	0.06	1.8	-	-	-
ADMX 070204SR-M:M8310	● 0.4	245	0.09	2.2	120	0.08	2.2	230	0.09	2.2	-	-	-	-	-	-	-	-	-
ADMX 070204SR-M:M8330	● 0.4	220	0.09	2.2	130	0.08	2.2	205	0.09	2.2	660	0.11	2.2	55	0.06	1.8	-	-	-
ADMX 070204SR-M:M8340	● 0.4	200	0.09	2.2	120	0.08	2.2	190	0.09	2.2	-	-	-	50	0.06	1.8	-	-	-
ADMX 070204SR-M:M9340	● 0.4	265	0.09	2.2	155	0.08	2.2	-	-	-	-	-	-	65	0.06	1.8	-	-	-
ADMX 070208SR-M:8215	● 0.8	270	0.09	2.2	160	0.08	2.2	255	0.09	2.2	810	0.11	2.2	65	0.06	1.8	-	-	-

Lämplighet och startvärden för skärhastighet (vc), matning (f) och skärdjup (ap). Vi refererar till vår Dormer Pramet Calculator-app för vidare beräkningar.

Product	RE (mm)	P			M			K			N			S			H		
		vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)



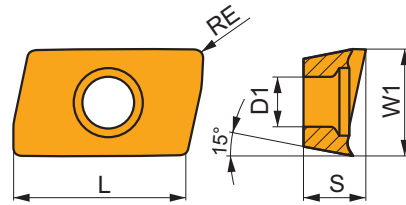
M geometri med positiv design för fin till medelfin fräsning.

ADMX 070208SR-M:M6330	0.8	225	0.09	2.2	160	0.08	2.2	—	—	—	—	—	—	65	0.06	1.8	—	—	—
ADMX 070208SR-M:M8310	0.8	290	0.09	2.2	145	0.08	2.2	275	0.09	2.2	—	—	—	—	—	—	—	—	—
ADMX 070208SR-M:M8330	0.8	260	0.09	2.2	155	0.08	2.2	245	0.09	2.2	780	0.11	2.2	65	0.06	1.8	—	—	—
ADMX 070208SR-M:M8340	0.8	240	0.09	2.2	140	0.08	2.2	225	0.09	2.2	—	—	—	60	0.06	1.8	—	—	—
ADMX 070208SR-M:M9340	0.8	315	0.09	2.2	185	0.08	2.2	—	—	—	—	—	75	0.06	1.8	—	—	—	—
ADMX 070216SR-M:M8330	1.6	290	0.09	2.2	170	0.08	2.2	275	0.09	2.2	870	0.11	2.2	70	0.06	1.8	—	—	—
ADMX 070220SR-M:M8310	2.0	340	0.09	2.2	170	0.08	2.2	320	0.09	2.2	—	—	—	—	—	—	—	—	—
ADMX 070220SR-M:M8330	2.0	300	0.09	2.2	180	0.08	2.2	285	0.09	2.2	900	0.11	2.2	75	0.06	1.8	—	—	—
ADMX 070220SR-M:M8340	2.0	275	0.09	2.2	165	0.08	2.2	260	0.09	2.2	—	—	—	65	0.06	1.8	—	—	—

ADEX 07-FA

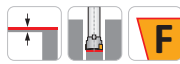
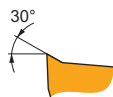


	W1 (mm)	D1 (mm)	L (mm)	S (mm)
0702	4.497	2.20	6.95	2.48



Lämplighet och startvärden för skärhastighet (vc), matning (f) och skärdjup (ap). Vi refererar till vår Dormer Pramet Calculator-app för vidare beräkningar.

Product	RE (mm)	P			M			K			N			S			H		
		vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)



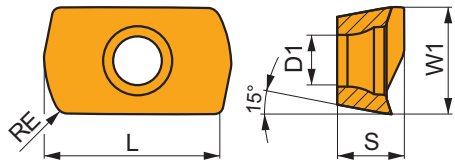
FA geometri med mycket positiv design för fin till medelfin fräsning.

ADEX 070204FR-FA:HF7	0.4	—	—	—	—	—	—	—	—	—	240	0.18	3.0	—	—	—	—	—	—
ADEX 070204FR-FA:M0315	0.4	—	—	—	—	—	—	—	—	—	555	0.18	3.0	—	—	—	—	—	—
ADEX 070208FR-FA:HF7	0.8	—	—	—	—	—	—	—	—	—	285	0.18	3.0	—	—	—	—	—	—

ADEX 07-HF

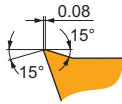


	W1 (mm)	D1 (mm)	L (mm)	S (mm)
0702	4.439	2.20	6.45	2.48



Lämplighet och startvärden för skärhastighet (vc), matning (f) och skärdjup (ap). Vi refererar till vår Dormer Pramet Calculator-app för vidare beräkningar.

Product	RE (mm)	P			M			K			N			S			H		
		vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)



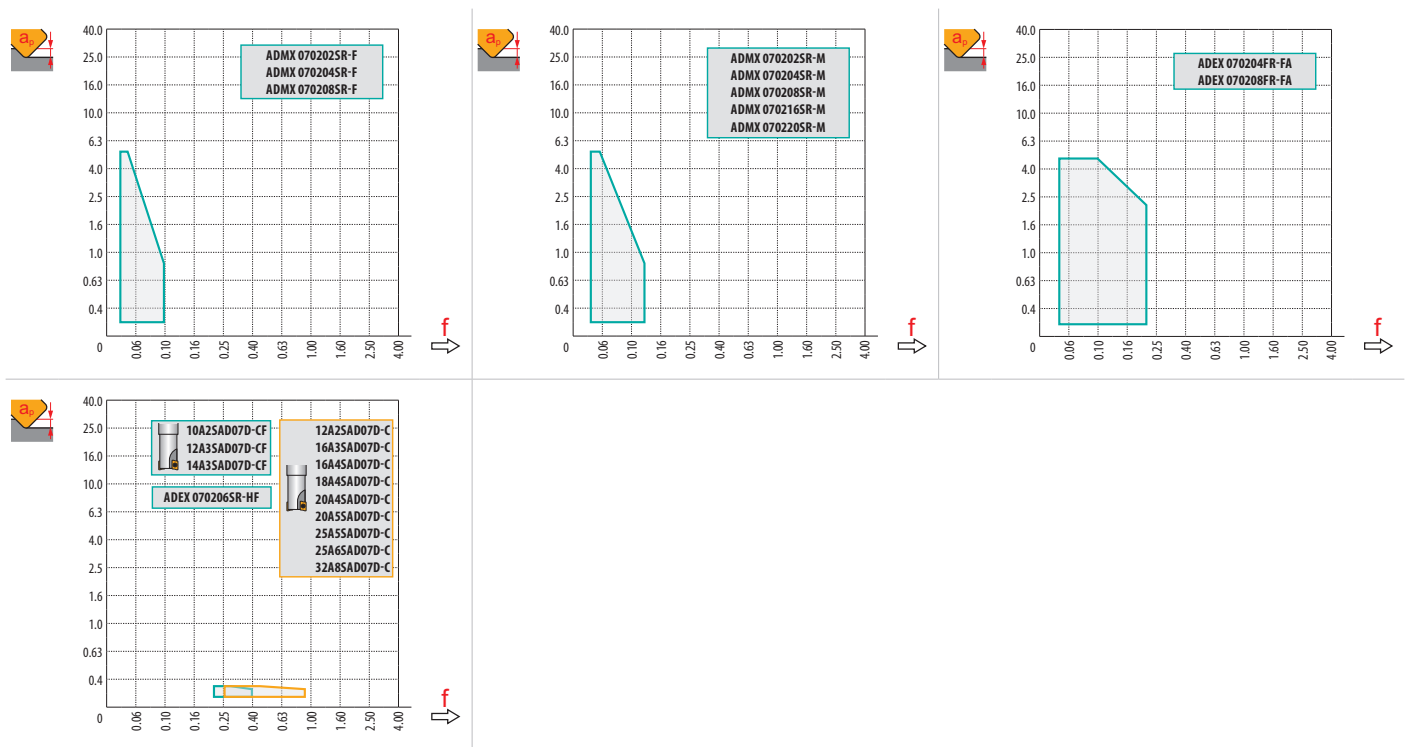
HF geometri med mycket positiv design för högmatningsfräsning.

ADEX 070206SR-HF:M6330	0.6	200	0.60	0.3	140	0.54	0.3	-	-	-	-	-	-	-	-	-	-	-
ADEX 070206SR-HF:M8330	0.6	225	0.60	0.3	135	0.54	0.3	-	-	-	-	-	-	-	-	-	-	-
ADEX 070206SR-HF:M8340	0.6	215	0.60	0.3	125	0.54	0.3	-	-	-	-	-	-	-	-	-	-	-



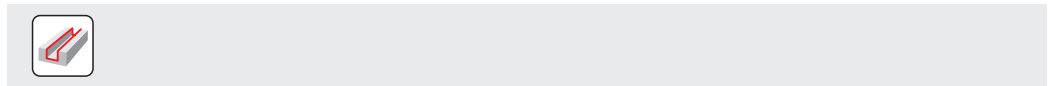
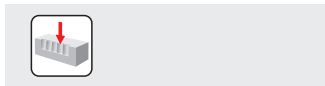
a_e / DC	5%	10%	15%	20%	25%	30%	40%	50%	60%	70%	75%	80%	90%	100%
	1.48	1.35	1.27	1.22	1.19	1.16	1.11	1.08	1.05	1.03	1.00	1.00	1.00	1.00
	2.20	1.60	1.35	1.20	1.10	0.95	0.85	0.75	0.85	0.95	1.00	1.00	1.00	1.00
	0.64	0.64	0.64	0.64	0.64	0.65	0.65	0.67	0.68	0.71	0.72	0.74	0.79	1.00

	ADMX 07-F	ADMX 07-M						ADEX 07-HF	ADEX 07-FA		
	0.2	0.4	0.8	0.2	0.4	0.8	1.6	2.0	0.6	0.4	0.8
	1.38	0.89	0.54	1.38	0.89	0.54	0.7	0.33	-	0.94	0.55



ADEX 07-HF					
		0	0.1	0.2	0.3
10		5.6	7.8	8.7	9.4
12		7.6	9.8	10.7	11.4
14		9.6	11.8	12.7	13.4
16		11.6	13.8	14.7	15.4
18		13.6	15.8	16.7	17.4
20		15.6	17.8	18.7	19.4
25		20.6	22.8	23.7	24.4
32		27.6	29.8	30.7	31.4

HFC			
	0.1	0.2	0.3
	0.9	0.8	0.6



3.0

	1.0	3.0	5.0
	0.13	0.08	0.05

	HFC		
	0.1	0.2	0.3
	0.7	0.6	0.4



	RPMX	APMX/I
10	5.2°	5.0/56
12	3.4°	5.0/86
14	2.5°	4.2/100
16	1.9°	3.2/100
18	1.7°	2.8/100
20	1.5°	2.5/100
25	1.1°	1.8/100
32	0.8°	1.2/100

HFC		
	RPMX	APMX/I
10	3.5°	0.3/6
12	2.2°	0.3/9
14	1.6°	0.3/12
16	1.3°	0.3/15
18	1.1°	0.3/17
20	0.9°	0.3/21
25	0.7°	0.3/26
32	0.5°	0.3/36



	DMIN	DMAX		
			DMIN	DMAX
10	12.0	20.0	0.5	2.8
12	16.0	24.0	0.7	2.2
14	20.0	28.0	0.8	1.9
16	24.0	32.0	0.8	1.6
18	28.0	36.0	0.9	1.6
20	32.0	40.0	0.9	1.6
25	42.0	50.0	1.0	1.5
32	56.0	64.0	1.0	1.4

HFC				
	DMIN	DMAX		
			DMIN	DMAX
10	12	20	0.30	0.30
12	16	24	0.30	0.30
14	20	28	0.30	0.30
16	24	32	0.30	0.30
18	28	36	0.30	0.30
20	32	40	0.30	0.30
25	42	50	0.30	0.30
32	56	64	0.30	0.30

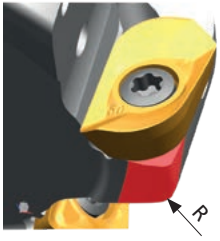


0.5

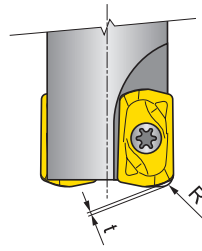
	HFC
	0.3



		3	5	10	15	20	30	40	50	60	80	100
10		0.346	0.447	0.632	0.775	0.894	1.095	1.265	1.414	1.549	1.789	2.000
12		0.379	0.490	0.693	0.849	0.980	1.200	1.386	1.549	1.697	1.960	2.191
14		0.410	0.529	0.748	0.917	1.058	1.296	1.497	1.673	1.833	2.117	2.366
16		0.438	0.566	0.800	0.980	1.131	1.386	1.600	1.789	1.960	2.263	2.530
18		0.465	0.600	0.849	1.039	1.200	1.470	1.697	1.897	2.078	2.400	2.683
20		0.490	0.632	0.894	1.095	1.265	1.549	1.789	2.000	2.191	2.530	2.828
25		0.548	0.707	1.000	1.225	1.414	1.732	2.000	2.236	2.449	2.828	3.162
32		0.620	0.800	1.131	1.386	1.600	1.960	2.263	2.530	2.771	3.200	3.578



ADMX 07	R
ADMX 070216SR-M	1
ADMX 070220SR-M	1.5
ADEX 070206SR-HF	1



ADEX 07	R	t
ADEX 070206SR-HF	0.8	0.18

SAD11E



PRAMET

S

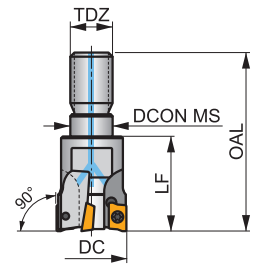
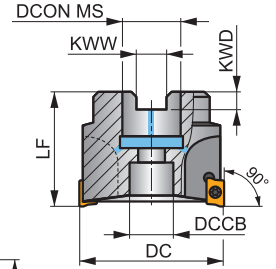
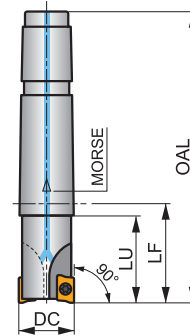
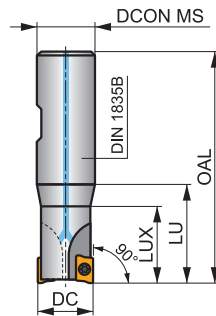
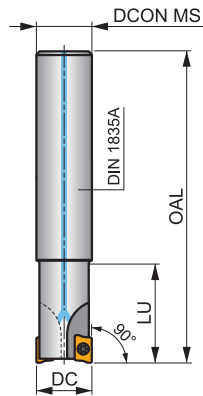
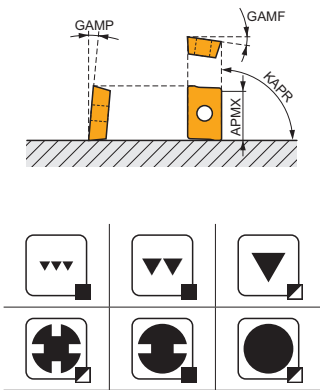


FORCE AD11 Rak hörnfräs med invändig kylning

90° hörn- och planfräs för positiva AD.. 11-skär med APMX 9 mm. Passar för en rad olika applikationer, bl a rampning, trochoidalfräsning och dykfräsning. Finns med cyl. skaft, Weldon-skaft, morse-kona, modulärt eller dornfäste (med differentiell tanddelning). Behandlad för lång livslängd.

FORCE AD

KAPR	90°
APMX	9.0 mm



	0.06 – 0.13
	0.08 – 0.16



Product	DC	OAL	DCON MS	DCCB	LU	LUX	LF	TDZ	CZC MS	KWW	KWD	GAMF	GAMP	max.			kg	Tools		
	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(°)	(°)	mm	mm	mm				
16A2R024A14-SAD11E-C	16	160	14	-	24	-	-	-	-	-	-	-12.8	4	2	-	30100	✓	0.19	GI169 SQ025	-
16A2R024A16-SAD11E-C	16	135	16	-	24	-	-	-	-	-	-	-12.8	4	2	-	30100	✓	0.19	GI169 SQ025	-
16A2R050A16-SAD11E-C	16	135	16	-	50	-	-	-	-	-	-	-12.8	4	2	-	30100	✓	0.20	GI169 SQ025	-
18A2R029A20-SAD11E-C	18	150	20	-	29	-	-	-	-	-	-	-12	4.5	2	-	28400	✓	0.35	GI169 SQ025	-
20A2R029A20-SAD11E-C	20	150	20	-	29	-	-	-	-	-	-	-11.5	5	2	-	27000	✓	0.33	GI169 SQ020	-
20A2R070A20-SAD11E-C	20	150	20	-	70	-	-	-	-	-	-	-11.5	5	2	-	27000	✓	0.32	GI169 SQ020	-
20A3R029A18-SAD11E-C	20	200	18	-	29	-	-	-	-	-	-	-11.5	5	3	-	27000	✓	0.36	GI169 SQ025	-
20A3R029A20-SAD11E-C	20	150	20	-	29	-	-	-	-	-	-	-11.5	5	3	-	27000	✓	0.31	GI169 SQ025	-
22A3R029A20-SAD11E-C	22	200	20	-	29	-	-	-	-	-	-	-11.5	5	3	-	25600	✓	0.45	GI169 SQ025	-
25A3R034A25-SAD11E-C	25	170	25	-	34	-	-	-	-	-	-	-10.2	5	3	-	24100	✓	0.42	GI169 SQ020	-
25A3R080A25-SAD11E-C	25	170	25	-	80	-	-	-	-	-	-	-10.2	5	3	-	24100	✓	0.52	GI169 SQ020	-
25A4R034A25-SAD11E-C	25	170	25	-	34	-	-	-	-	-	-	-10.2	5	4	-	24100	✓	0.56	GI169 SQ025	-
25A4R040A25-SAD11E-C	25	250	25	-	40	-	-	-	-	-	-	-10.2	5	4	-	24100	✓	0.85	GI169 SQ025	-
30A3R080A32-SAD11E-C	30	200	32	-	80	-	-	-	-	-	-	-9.3	7	3	-	22000	✓	0.98	GI169 SQ020	-
32A3R090A32-SAD11E-C	32	195	32	-	90	-	-	-	-	-	-	-9	5	3	-	21300	✓	0.99	GI169 SQ020	-
32A5R034A32-SAD11E-C	32	195	32	-	34	-	-	-	-	-	-	-9	8	5	-	21300	✓	1.03	GI169 SQ025	-
35A5R025A32-SAD11E-C	35	200	32	-	25	-	-	-	-	-	-	-9	8	5	-	20300	✓	1.11	GI169 SQ020	-
16A2R027B16-SAD11E-C	16	75	16	-	27	-	-	-	-	-	-	-12.8	4	2	-	30100	✓	0.11	GI169 SQ025	-
20A2R032B20-SAD11E-C	20	82	20	-	32	-	-	-	-	-	-	-11.5	5	2	-	27000	✓	0.13	GI169 SQ020	-
20A3R032B20-SAD11E-C	20	82	20	-	32	-	-	-	-	-	-	-11.5	5	3	-	27000	✓	0.13	GI169 SQ025	-
25A3R042B25-SAD11E-C	25	98	25	-	42	-	-	-	-	-	-	-10.2	5	3	-	24100	✓	0.29	GI169 SQ020	-
25A4R042B25-SAD11E-C	25	98	25	-	42	-	-	-	-	-	-	-10.2	5	4	-	24100	✓	0.31	GI169 SQ025	-
32A4R042B32-SAD11E-C	32	102	32	-	42	-	-	-	-	-	-	-9	8	4	-	21300	✓	0.27	GI169 SQ020	-
32A5R042B32-SAD11E-C	32	102	32	-	42	-	-	-	-	-	-	-9	8	5	-	21300	✓	0.32	GI169 SQ025	-
16A2R030E02-SAD11E-C	16	94	-	-	25	-	30	-	2	-	-	-12.8	4	2	-	30100	✓	0.13	GI169 SQ025	-
20A3R035E03-SAD11E-C	20	116	-	-	30	-	35	-	3	-	-	-11.5	5	3	-	27000	✓	0.27	GI169 SQ025	-
25A4R043E03-SAD11E-C	25	124	-	-	38	-	43	-	3	-	-	-10.2	5	4	-	24100	✓	0.31	GI169 SQ025	-

Product	DC	OAL	D CON MS	DCCB	LU	LUX	LF	TDZ	CZC MS	KWW	KWD	GAMF	GAMP								
	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)			(mm)	(mm)	(°)	(°)								
16A2R024M08-SAD11E-C	16	38	8.5	-	-	-	24	M8	-	-	-	-12.8	4	2	-	-	✓	0.04	GI169	SQ025	-
20A2R026M10-SAD11E-C	20	45	11	-	-	-	26	M10	-	-	-	-11.5	5	2	-	-	✓	0.06	GI169	SQ020	-
20A3R026M10-SAD11E-C	20	45	10.5	-	-	-	26	M10	-	-	-	-11.5	5	3	-	-	✓	0.06	GI169	SQ025	-
25A3R033M12-SAD11E-C	25	55	12.5	-	-	-	33	M12	-	-	-	-10.2	5	3	-	-	✓	0.10	GI169	SQ020	-
25A4R033M12-SAD11E-C	25	55	12.5	-	-	-	33	M12	-	-	-	-10.2	5	4	-	-	✓	0.09	GI169	SQ025	-
32A4R043M16-SAD11E-C	32	66	17	-	-	-	43	M16	-	-	-	-9	8	4	-	-	✓	0.20	GI169	SQ020	-
32A5R043M16-SAD11E-C	32	66	17	-	-	-	43	M16	-	-	-	-9	8	5	-	-	✓	0.20	GI169	SQ025	-
40A4R043M16-SAD11E-C	40	66	17	-	-	-	43	M16	-	-	-	-8.1	11	4	-	-	✓	0.27	GI169	SQ020	-
40A6R043M16-SAD11E-C	40	66	17	-	-	-	43	M16	-	-	-	-8.1	11	6	-	-	✓	0.21	GI169	SQ020	-
40A04R-S90AD11E-C	40	-	16	14	-	-	40	-	-	8.4	5.6	-8.1	11	4	✓	19100	✓	0.16	GI169	SQ022	-
40A05R-S90AD11E-C	40	-	16	14	-	-	40	-	-	8.4	5.6	-8.1	11	5	✓	19000	✓	0.31	GI169	SQ022	-
40A06R-S90AD11E-C	40	-	16	14	-	-	40	-	-	8.4	5.6	-8.1	11	6	✓	19100	✓	0.20	GI169	SQ022	-
50A05R-S90AD11E-C	50	-	22	18	-	-	40	-	-	10.4	6.3	-7.2	12	5	✓	17000	✓	0.31	GI169	SQ023	-
50A07R-S90AD11E-C	50	-	22	18	-	-	40	-	-	10.4	6.3	-7.2	12	7	✓	17000	✓	0.44	GI169	SQ023	-
63A06R-S90AD11E-C	63	-	22	18	-	-	40	-	-	10.4	6.3	-6.5	12	6	✓	15200	✓	0.54	GI169	SQ023	-
63A09R-S90AD11E-C	63	-	22	18	-	-	40	-	-	10.4	6.3	-6.5	12	9	✓	15200	✓	0.61	GI169	SQ023	-
80A10R-S90AD11E-C	80	-	27	38	-	-	50	-	-	12.4	7	-6	12	10	✓	13500	✓	1.04	GI169	SQ021	AC001
100A11R-S90AD11E-C	100	-	32	45	-	-	50	-	-	14.4	8	-5.5	12	11	✓	12100	✓	1.89	GI169	SQ021	AC002
125A12R-S90AD11E-C	125	-	40	56	-	-	63	-	-	16.4	9	-5.2	12	12	✓	10800	✓	2.97	GI169	SQ021	AC003

GI169	ADMX 11T3..	ADEX 11T3..

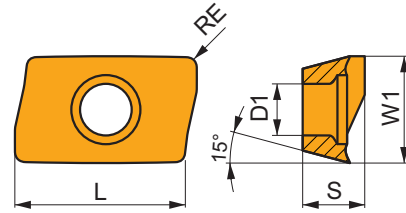
SQ020	US 62506-T07P	1.2	M 2.5	6	-	-	Flag T07P	-
SQ021	US 62506-T07P	1.2	M 2.5	6	D-T07P/T09P	FG-15	-	-
SQ022	US 62506-T07P	1.2	M 2.5	6	D-T07P/T09P	FG-15	-	HS 0830C
SQ023	US 62506-T07P	1.2	M 2.5	6	D-T07P/T09P	FG-15	-	HS 1030C
SQ025	US 62505-T07P	1.2	M 2.5	5	-	-	Flag T07P	-

AC001		KS 1230	K.FMH27
AC002		KS 1635	K.FMH32
AC003		KS 2040	K.FMH40

ADMX 11

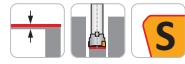
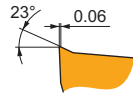
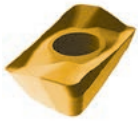


	W1 (mm)	D1 (mm)	L (mm)	S (mm)
11T3	6.530	2.90	11.00	3.97



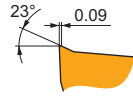
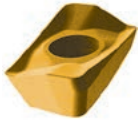
Lämplighet och startvärden för skärhastighet (vc), matning (f) och skärdjup (ap). Vi refererar till vår Dormer Pramet Calculator-app för vidare beräkningar.

Product	RE (mm)	P			M			K			N			S			H		
		vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)



F geometri med mycket vass positiv design för finfräsning.

ADMX 11T304SR-F:8215	● 0.4	245	0.10	2.0	145	0.09	2.0	230	0.10	2.0	735	0.12	2.0	60	0.08	1.6	-	-	-
ADMX 11T304SR-F:M8330	● 0.4	240	0.10	2.0	140	0.09	2.0	225	0.10	2.0	720	0.12	2.0	60	0.08	1.6	-	-	-
ADMX 11T304SR-F:M8340	● 0.4	220	0.10	2.0	130	0.09	2.0	205	0.10	2.0	-	-	-	55	0.08	1.6	-	-	-
ADMX 11T304SR-F:M9340	● 0.4	285	0.10	2.0	170	0.09	2.0	-	-	-	-	-	70	0.08	1.6	-	-	-	
ADMX 11T308SR-F:8215	⊕ 0.8	290	0.10	2.0	170	0.09	2.0	275	0.10	2.0	870	0.12	2.0	70	0.08	1.6	-	-	-
ADMX 11T308SR-F:M8330	⊕ 0.8	285	0.10	2.0	170	0.09	2.0	270	0.10	2.0	855	0.12	2.0	70	0.08	1.6	-	-	-
ADMX 11T308SR-F:M8340	⊕ 0.8	260	0.10	2.0	155	0.09	2.0	245	0.10	2.0	-	-	-	65	0.08	1.6	-	-	-
ADMX 11T308SR-F:M9340	⊕ 0.8	340	0.10	2.0	200	0.09	2.0	-	-	-	-	-	85	0.08	1.6	-	-	-	

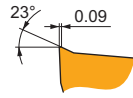
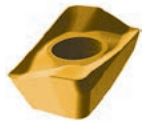


M geometri med positiv design för fin till medelfin fräsning.

ADMX 11T302SR-M:M8330	● 0.2	190	0.15	4.0	110	0.14	4.0	180	0.15	4.0	-	-	-	45	0.12	3.2	-	-	-
ADMX 11T302SR-M:M8340	⊕ 0.2	170	0.15	4.0	100	0.14	4.0	160	0.15	4.0	-	-	-	40	0.12	3.2	-	-	-
ADMX 11T304SR-M:8215	● 0.4	205	0.15	4.0	120	0.14	4.0	190	0.15	4.0	-	-	-	50	0.12	3.2	-	-	-
ADMX 11T304SR-M:M8310	● 0.4	220	0.15	4.0	110	0.14	4.0	205	0.15	4.0	-	-	-	-	-	-	-	-	-
ADMX 11T304SR-M:M8330	⊕ 0.4	205	0.15	4.0	120	0.14	4.0	190	0.15	4.0	-	-	-	50	0.12	3.2	-	-	-
ADMX 11T304SR-M:M8340	⊕ 0.4	185	0.15	4.0	110	0.14	4.0	175	0.15	4.0	-	-	-	45	0.12	3.2	-	-	-
ADMX 11T304SR-M:M9325	● 0.4	255	0.15	4.0	-	-	-	240	0.15	4.0	-	-	-	-	-	-	-	-	-
ADMX 11T304SR-M:M9340	● 0.4	235	0.15	4.0	140	0.14	4.0	-	-	-	-	-	55	0.12	3.2	-	-	-	
ADMX 11T308SR-M:8215	⊕ 0.8	245	0.15	4.0	145	0.14	4.0	230	0.15	4.0	-	-	-	60	0.12	3.2	-	-	-
ADMX 11T308SR-M:M5315	⊕ 0.8	335	0.15	4.0	-	-	-	315	0.15	4.0	-	-	-	-	-	-	-	-	-
ADMX 11T308SR-M:M8310	⊕ 0.8	265	0.15	4.0	135	0.14	4.0	250	0.15	4.0	-	-	-	-	-	-	-	-	-
ADMX 11T308SR-M:M8330	⊕ 0.8	245	0.15	4.0	145	0.14	4.0	230	0.15	4.0	-	-	-	60	0.12	3.2	-	-	-
ADMX 11T308SR-M:M8340	⊕ 0.8	220	0.15	4.0	130	0.14	4.0	205	0.15	4.0	-	-	-	55	0.12	3.2	-	-	-
ADMX 11T308SR-M:M9315	⊕ 0.8	330	0.15	4.0	-	-	-	310	0.15	4.0	-	-	-	-	-	-	-	-	-
ADMX 11T308SR-M:M9325	⊕ 0.8	305	0.15	4.0	-	-	-	285	0.15	4.0	-	-	-	-	-	-	-	-	-
ADMX 11T308SR-M:M9340	⊕ 0.8	275	0.15	4.0	165	0.14	4.0	-	-	-	-	-	65	0.12	3.2	-	-	-	
ADMX 11T310SR-M:M8330	⊕ 1.0	255	0.15	4.0	150	0.14	4.0	240	0.15	4.0	-	-	-	60	0.12	3.2	-	-	-
ADMX 11T310SR-M:M8340	⊕ 1.0	230	0.15	4.0	135	0.14	4.0	215	0.15	4.0	-	-	-	55	0.12	3.2	-	-	-
ADMX 11T312SR-M:8215	⊕ 1.2	255	0.15	4.0	150	0.14	4.0	240	0.15	4.0	-	-	-	60	0.12	3.2	-	-	-
ADMX 11T312SR-M:M8330	⊕ 1.2	255	0.15	4.0	150	0.14	4.0	240	0.15	4.0	-	-	-	60	0.12	3.2	-	-	-
ADMX 11T312SR-M:M8340	⊕ 1.2	230	0.15	4.0	135	0.14	4.0	215	0.15	4.0	-	-	-	55	0.12	3.2	-	-	-
ADMX 11T316SR-M:8215	⊕ 1.6	270	0.15	4.0	160	0.14	4.0	255	0.15	4.0	-	-	-	65	0.12	3.2	-	-	-
ADMX 11T316SR-M:M6330	⊕ 1.6	230	0.15	4.0	165	0.14	4.0	-	-	-	-	-	65	0.12	3.2	-	-	-	
ADMX 11T316SR-M:M8310	⊕ 1.6	295	0.15	4.0	150	0.14	4.0	280	0.15	4.0	-	-	-	-	-	-	-	-	-
ADMX 11T316SR-M:M8330	⊕ 1.6	270	0.15	4.0	160	0.14	4.0	255	0.15	4.0	-	-	-	65	0.12	3.2	-	-	-
ADMX 11T316SR-M:M8340	⊕ 1.6	240	0.15	4.0	140	0.14	4.0	225	0.15	4.0	-	-	-	60	0.12	3.2	-	-	-
ADMX 11T320SR-M:M6330	⊕ 2.0	240	0.15	4.0	170	0.14	4.0	-	-	-	-	-	70	0.12	3.2	-	-	-	
ADMX 11T320SR-M:M8330	⊕ 2.0	280	0.15	4.0	165	0.14	4.0	265	0.15	4.0	-	-	-	70	0.12	3.2	-	-	-
ADMX 11T320SR-M:M8340	⊕ 2.0	255	0.15	4.0	150	0.14	4.0	240	0.15	4.0	-	-	-	60	0.12	3.2	-	-	-

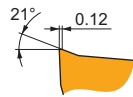
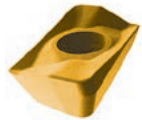
Lämplighet och startvärden för skärhastighet (vc), matning (f) och skärdjup (ap). Vi refererar till vår Dormer Pramet Calculator-app för vidare beräkningar.

Product	RE (mm)	P			M			K			N			S			H		
		vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)



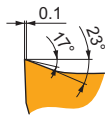
M geometri med positiv design för fin till medelfin fräsning.

ADMX 11T325SR-M:M6330	✱ 2.5	■ 240	■ 0.15	■ 4.0	■ 170	■ 0.14	■ 4.0	■ -	■ -	■ -	■ -	■ -	■ 70	■ 0.12	■ 3.2	■ -	■ -	■ -
ADMX 11T325SR-M:M8340	✱ 2.5	■ 255	■ 0.15	■ 4.0	■ 150	■ 0.14	■ 4.0	■ 240	■ 0.15	■ 4.0	■ -	■ -	■ 60	■ 0.12	■ 3.2	■ -	■ -	■ -
ADMX 11T330SR-M:M6330	✱ 3.0	■ 240	■ 0.15	■ 4.0	■ 170	■ 0.14	■ 4.0	■ -	■ -	■ -	■ -	■ -	■ 70	■ 0.12	■ 3.2	■ -	■ -	■ -
ADMX 11T330SR-M:M8330	✱ 3.0	■ 280	■ 0.15	■ 4.0	■ 165	■ 0.14	■ 4.0	■ 265	■ 0.15	■ 4.0	■ -	■ -	■ 70	■ 0.12	■ 3.2	■ -	■ -	■ -
ADMX 11T330SR-M:M8340	✱ 3.0	■ 255	■ 0.15	■ 4.0	■ 150	■ 0.14	■ 4.0	■ 240	■ 0.15	■ 4.0	■ -	■ -	■ 60	■ 0.12	■ 3.2	■ -	■ -	■ -



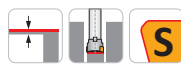
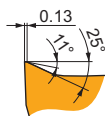
R geometri med positiv design för fräsning vid mindre stabila förhållanden.

ADMX 11T308PR-R:R215	✱ 0.8	■ 230	■ 0.18	■ 4.0	■ 135	■ 0.16	■ 4.0	■ 215	■ 0.18	■ 4.0	■ -	■ -	■ 55	■ 0.16	■ 3.2	■ 45	■ 0.12	■ 0.7
ADMX 11T308PR-R:M5315	✱ 0.8	■ 310	■ 0.18	■ 4.0	■ -	■ -	■ -	■ 290	■ 0.18	■ 4.0	■ -	■ -	■ -	■ -	■ -	■ 60	■ 0.13	■ 0.7
ADMX 11T308PR-R:M8310	✱ 0.8	■ 250	■ 0.18	■ 4.0	■ 125	■ 0.16	■ 4.0	■ 235	■ 0.18	■ 4.0	■ -	■ -	■ -	■ -	■ 50	■ 0.12	■ 0.7	■ -
ADMX 11T308PR-R:M8330	✱ 0.8	■ 230	■ 0.18	■ 4.0	■ 135	■ 0.16	■ 4.0	■ 215	■ 0.18	■ 4.0	■ -	■ -	■ 55	■ 0.16	■ 3.2	■ 45	■ 0.12	■ 0.7
ADMX 11T308PR-R:M8340	✱ 0.8	■ 210	■ 0.18	■ 4.0	■ 125	■ 0.16	■ 4.0	■ 195	■ 0.18	■ 4.0	■ -	■ -	■ 50	■ 0.16	■ 3.2	■ -	■ -	■ -
ADMX 11T308PR-R:M9315	✱ 0.8	■ 310	■ 0.18	■ 4.0	■ -	■ -	■ -	■ 290	■ 0.18	■ 4.0	■ -	■ -	■ -	■ -	■ -	■ 60	■ 0.13	■ 0.7
ADMX 11T308PR-R:M9325	✱ 0.8	■ 290	■ 0.18	■ 4.0	■ -	■ -	■ -	■ 275	■ 0.18	■ 4.0	■ -	■ -	■ -	■ -	■ -	■ 55	■ 0.13	■ 0.7
ADMX 11T316PR-R:R215	✱ 1.6	■ 255	■ 0.18	■ 4.0	■ 150	■ 0.16	■ 4.0	■ 240	■ 0.18	■ 4.0	■ -	■ -	■ 60	■ 0.16	■ 3.2	■ 50	■ 0.12	■ 0.7
ADMX 11T316PR-R:M8330	✱ 1.6	■ 255	■ 0.18	■ 4.0	■ 150	■ 0.16	■ 4.0	■ 240	■ 0.18	■ 4.0	■ -	■ -	■ 60	■ 0.16	■ 3.2	■ 50	■ 0.12	■ 0.7
ADMX 11T316PR-R:M9325	✱ 1.6	■ 320	■ 0.18	■ 4.0	■ -	■ -	■ -	■ 300	■ 0.18	■ 4.0	■ -	■ -	■ -	■ -	■ -	■ 60	■ 0.12	■ 0.7



MF geometri med mycket positiv design för finfräsning.

ADMX 11T304SR-MF:M6330	● 0.4	■ 215	■ 0.08	■ 2.5	■ 150	■ 0.07	■ 2.5	■ -	■ -	■ -	■ -	■ -	■ 60	■ 0.06	■ 2.0	■ -	■ -	■ -
ADMX 11T304SR-MF:M8340	● 0.4	■ 220	■ 0.08	■ 2.5	■ 130	■ 0.07	■ 2.5	■ -	■ -	■ -	■ -	■ -	■ 55	■ 0.06	■ 2.0	■ -	■ -	■ -
ADMX 11T308SR-MF:M6330	● 0.8	■ 255	■ 0.08	■ 2.5	■ 180	■ 0.07	■ 2.5	■ -	■ -	■ -	■ -	■ -	■ 75	■ 0.06	■ 2.0	■ -	■ -	■ -
ADMX 11T308SR-MF:M8340	● 0.8	■ 265	■ 0.08	■ 2.5	■ 155	■ 0.07	■ 2.5	■ -	■ -	■ -	■ -	■ -	■ 65	■ 0.06	■ 2.0	■ -	■ -	■ -



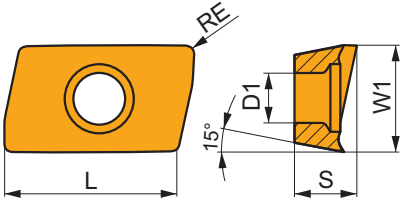
MM geometri med mycket positiv design för fin till medelfin fräsning.

ADMX 11T304SR-MM:M6330	● 0.4	■ 185	■ 0.14	■ 2.5	■ 130	■ 0.13	■ 2.5	■ -	■ -	■ -	■ -	■ -	■ 55	■ 0.11	■ 2.0	■ -	■ -	■ -
ADMX 11T304SR-MM:M8340	● 0.4	■ 195	■ 0.14	■ 2.5	■ 115	■ 0.13	■ 2.5	■ -	■ -	■ -	■ -	■ -	■ 45	■ 0.11	■ 2.0	■ -	■ -	■ -
ADMX 11T308SR-MM:M6330	● 0.8	■ 225	■ 0.14	■ 2.5	■ 155	■ 0.13	■ 2.5	■ -	■ -	■ -	■ -	■ -	■ 65	■ 0.11	■ 2.0	■ -	■ -	■ -
ADMX 11T308SR-MM:M8340	● 0.8	■ 235	■ 0.14	■ 2.5	■ 140	■ 0.13	■ 2.5	■ -	■ -	■ -	■ -	■ -	■ 55	■ 0.11	■ 2.0	■ -	■ -	■ -
ADMX 11T308SR-MM:M8345	● 0.8	■ 190	■ 0.14	■ 2.5	■ 110	■ 0.13	■ 2.5	■ -	■ -	■ -	■ -	■ -	■ 45	■ 0.11	■ 2.0	■ -	■ -	■ -
ADMX 11T308SR-MM:M9340	● 0.8	■ 300	■ 0.14	■ 2.5	■ 180	■ 0.13	■ 2.5	■ -	■ -	■ -	■ -	■ -	■ 75	■ 0.11	■ 2.0	■ -	■ -	■ -
ADMX 11T312SR-MM:M6330	● 1.2	■ 235	■ 0.14	■ 2.5	■ 165	■ 0.13	■ 2.5	■ -	■ -	■ -	■ -	■ -	■ 70	■ 0.11	■ 2.0	■ -	■ -	■ -
ADMX 11T312SR-MM:M8340	● 1.2	■ 245	■ 0.14	■ 2.5	■ 145	■ 0.13	■ 2.5	■ -	■ -	■ -	■ -	■ -	■ 60	■ 0.11	■ 2.0	■ -	■ -	■ -

ADEX 11-FA

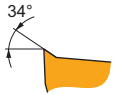


	W1 (mm)	D1 (mm)	L (mm)	S (mm)
11T3	6.450	2.90	9.70	3.91



Lämplighet och startvärden för skärhastighet (vc), matning (f) och skärdjup (ap). Vi refererar till vår Dormer Pramet Calculator-app för vidare beräkningar.

Product	RE (mm)	P			M			K			N			S			H		
		vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)



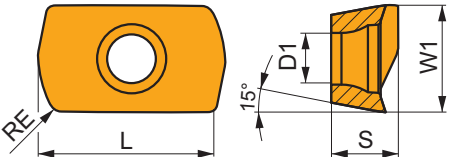
FA geometri med mycket positiv design för fin till medelfin fräsning.

ADEX 11T304FR-FA:HF7	● 0.4	-	-	-	-	-	-	-	-	-	■ 210	0.30	5.0	-	-	-	-	-	-
ADEX 11T304FR-FA:M0315	● 0.4	-	-	-	-	-	-	-	-	-	■ 480	0.30	5.0	-	-	-	-	-	-
ADEX 11T308FR-FA:HF7	● 0.8	-	-	-	-	-	-	-	-	-	■ 240	0.30	5.0	-	-	-	-	-	-
ADEX 11T308FR-FA:M0315	● 0.8	-	-	-	-	-	-	-	-	-	■ 570	0.30	5.0	-	-	-	-	-	-
ADEX 11T312FR-FA:HF7	● 1.2	-	-	-	-	-	-	-	-	-	■ 255	0.30	5.0	-	-	-	-	-	-
ADEX 11T316FR-FA:HF7	● 1.6	-	-	-	-	-	-	-	-	-	■ 270	0.18	5.0	-	-	-	-	-	-

ADEX 11-HF

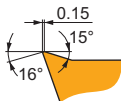
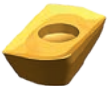


	W1 (mm)	D1 (mm)	L (mm)	S (mm)
11T3	6.450	2.90	10.67	3.82



Lämplighet och startvärden för skärhastighet (vc), matning (f) och skärdjup (ap). Vi refererar till vår Dormer Pramet Calculator-app för vidare beräkningar.

Product	RE (mm)	P			M			K			N			S			H		
		vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)

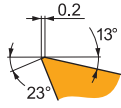


HF geometri med mycket positiv design för högmattningsfräsning.

ADEX 11T308SR-HF:8215	● 0.8	■ 215	0.68	0.4	■ 125	0.61	0.4	-	-	-	-	-	-	-	-	-	-	-	-
ADEX 11T308SR-HF:M6330	● 0.8	■ 185	0.68	0.4	■ 130	0.61	0.4	-	-	-	-	-	-	-	-	-	-	-	-
ADEX 11T308SR-HF:M8310	● 0.8	■ 220	0.68	0.4	■ 110	0.52	0.4	-	-	-	-	-	-	-	-	-	-	-	-
ADEX 11T308SR-HF:M8330	● 0.8	■ 215	0.68	0.4	■ 125	0.61	0.4	-	-	-	-	-	-	-	-	-	-	-	-
ADEX 11T308SR-HF:M8340	● 0.8	■ 200	0.68	0.4	■ 120	0.61	0.4	-	-	-	-	-	-	-	-	-	-	-	-
ADEX 11T308SR-HF:M9340	● 0.8	■ 220	0.68	0.4	■ 130	0.61	0.4	-	-	-	-	-	-	-	-	-	-	-	-

Lämplighet och startvärden för skärhastighet (vc), matning (f) och skärdjup (ap). Vi refererar till vår Dormer Pramet Calculator-app för vidare beräkningar.

Product	RE (mm)	P			M			K			N			S			H		
		vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)



HF2 geometri med positiv design för högmatningsfräsning.

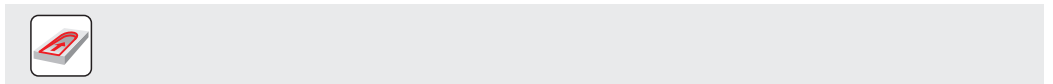
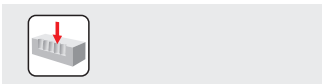
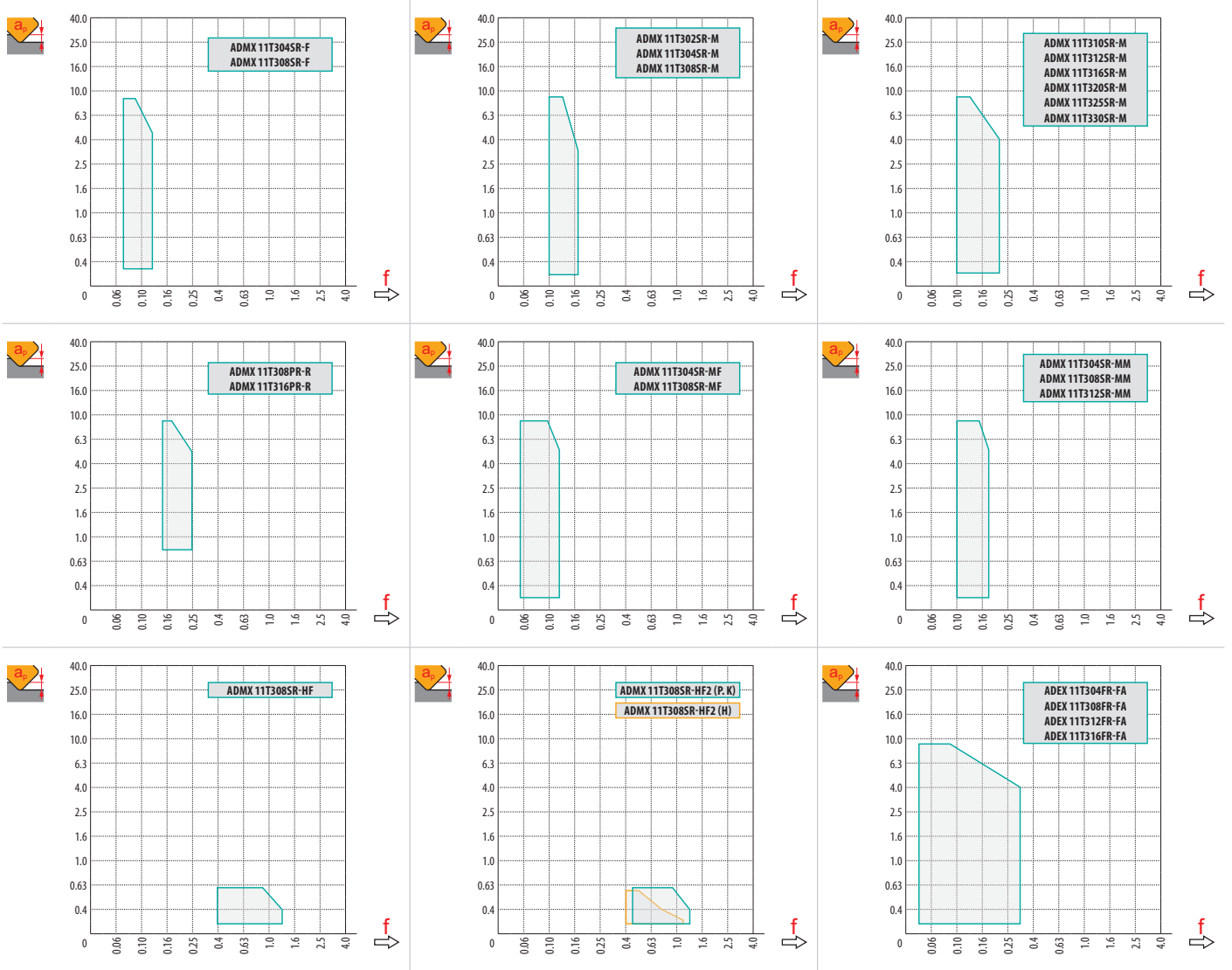
ADEX 11T308SR-HF2:M8310	0.8	220	0.68	0.4	110	0.61	0.4	205	0.68	0.4	–	–	–	–	–	–	40	0.48	0.3
ADEX 11T308SR-HF2:M8330	0.8	215	0.68	0.4	125	0.61	0.4	200	0.68	0.4	–	–	–	50	0.48	0.3	40	0.48	0.3
ADEX 11T308SR-HF2:M8340	0.8	200	0.68	0.4	120	0.61	0.4	190	0.68	0.4	–	–	–	50	0.48	0.3	–	–	–
ADEX 11T308SR-HF2:M9325	0.8	250	0.68	0.4	–	–	–	235	0.68	0.4	–	–	–	–	–	–	50	0.48	0.3



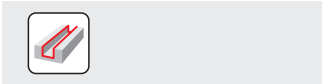
a_e / DC	5 %	10 %	15 %	20 %	25 %	30 %	40 %	50 %	60 %	70 %	75 %	80 %	90 %	100 %
	1.48	1.35	1.27	1.22	1.19	1.16	1.11	1.08	1.05	1.03	1.00	1.00	1.00	1.00
	2.20	1.60	1.35	1.20	1.10	0.95	0.85	0.75	0.85	0.95	1.00	1.00	1.00	1.00
	0.64	0.64	0.64	0.64	0.64	0.65	0.65	0.67	0.68	0.71	0.72	0.74	0.79	1.00

	ADMX 11-F		ADMX 11-M									ADMX 11-R		ADMX 11-MF	
	0.4	0.8	0.2	0.4	0.8	1.0	1.2	1.6	2.0	2.5	3.0	0.8	1.6	0.4	0.8
	1.89	1.48	2.09	1.89	1.48	1.27	1.08	0.68	1.61	1.13	0.66	1.48	0.68	1.89	1.48

	ADMX 11-MM			ADEX 11-HF	ADEX 11-HF2	ADEX 11-FA			
	0.4	0.8	1.2	0.8	0.8	0.4	0.8	1.2	1.6
	1.89	1.48	1.08	0.17	0.17	1.77	1.39	1.0	0.62



max
4.5



	1.0	5.0	9.0
--	-----	-----	-----

	0.20	0.13	0.10
--	------	------	------

DC	RPMX	APMX/I
16	13.5°	9.0/40
18	10.0°	9.0/53
20	9.0°	9.0/59
25	6.0°	9.0/87
32	5.3°	9.0/99
40	3.8°	6.5/100
50	2.8°	4.7/100
63	1.8°	3.0/100
80	1.6°	2.6/100

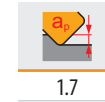
HFC			
DC	RPMX *	RPMX **	APMX/I
16	4.1°	5.7°	0.6/8
18	2.8°	4.5°	0.6/12
20	2.3°	4.3°	0.6/15
25	1.3°	6.7°	0.6/26
32	0.7°	4.3°	0.6/49
40	0.3°	2.9°	0.6/100
50	0.1°	2.1°	0.6/100
63	-	-	-
80	-	-	-

* HFC milling
** Conventional milling



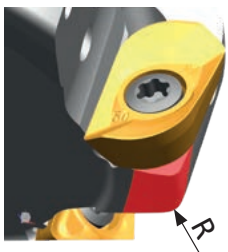
DC	DMIN	DMAX	SMAX DMIN	SMAX DMAX
16	27.0	32.0	8.3	9.0
18	32.0	36.0	7.5	9.0
20	35.0	40.0	7.5	9.0
25	45.0	50.0	6.5	7.5
32	59.0	64.0	4.0	4.5
40	75.0	80.0	1.5	2.0
50	-	-	-	-

HFC				
DC	DMIN	DMAX	SMAX DMIN	SMAX DMAX
16	21.0	32.0	0.6	0.6
18	29.0	36.0	0.6	0.6
20	29.0	40.0	0.6	0.6
25	39.0	50.0	0.6	0.6
32	53.0	64.0	0.6	0.6
40	68.5	80.0	0.6	0.6
50	88.5	100.0	0.6	0.6

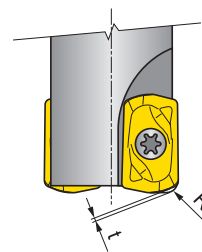


DC	μm	3	5	10	15	20	30	40	50	60	80	100
16		0.438	0.566	0.800	0.980	1.131	1.386	1.600	1.789	1.960	2.263	2.530
18		0.465	0.600	0.849	1.039	1.200	1.470	1.697	1.897	2.078	2.400	2.683
20		0.490	0.632	0.894	1.095	1.265	1.549	1.789	2.000	2.191	2.530	2.828
25		0.548	0.707	1.000	1.225	1.414	1.732	2.000	2.236	2.449	2.828	3.162
32		0.620	0.800	1.131	1.386	1.600	1.960	2.263	2.530	2.771	3.200	3.578
40		0.693	0.894	1.265	1.549	1.789	2.191	2.530	2.828	3.098	3.578	4.000
50		0.775	1.000	1.414	1.732	2.000	2.449	2.828	3.162	3.464	4.000	4.472
63		0.869	1.122	1.587	1.944	2.245	2.750	3.175	3.550	3.888	4.490	5.020
80		0.980	1.265	1.789	2.191	2.530	3.098	3.578	4.000	4.382	5.060	5.657

RE	μm	3	5	10	15	20	30	40	50	60	80	100
1.0		0.155	0.200	0.283	0.346	0.400	0.490	0.566	0.632	0.693	0.800	0.894
1.2		0.170	0.219	0.310	0.379	0.438	0.537	0.620	0.693	0.759	0.876	0.980
1.6		0.196	0.253	0.358	0.438	0.506	0.620	0.716	0.800	0.876	1.012	1.131
2.0		0.219	0.283	0.400	0.490	0.566	0.693	0.800	0.894	0.980	1.131	1.265
2.5		0.245	0.316	0.447	0.548	0.632	0.775	0.894	1.000	1.095	1.265	1.414
3.0		0.268	0.346	0.490	0.600	0.693	0.849	0.980	1.095	1.200	1.386	1.549



ADMX/ADEX 11	R
ADMX 11T320SR-M	1.0
ADMX 11T325SR-M	1.8
ADMX 11T330SR-M	1.8
ADEX 11T308SR-HF	1.4
ADEX 11T308SR-HF2	1.4



ADEX 11	R	t
ADEX 11T308SR-HF	1.42	0.35
ADEX 11T308SR-HF2	1.34	0.38

SAD16E



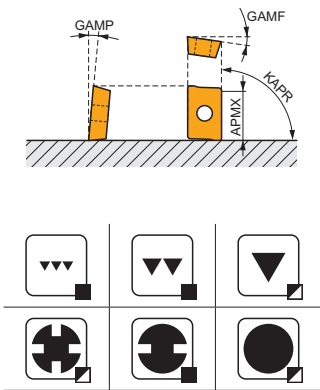
PRAMET



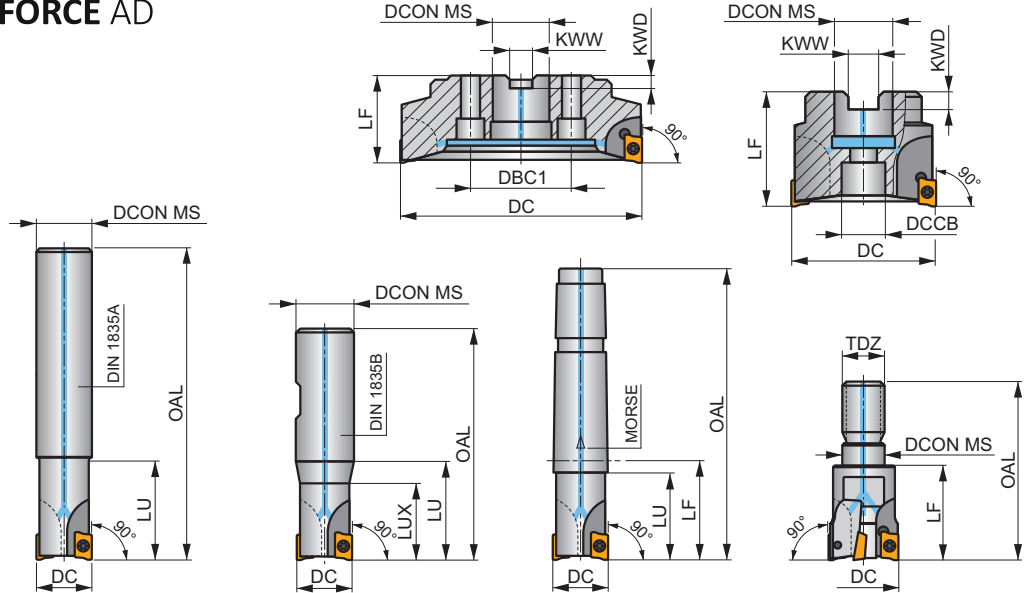
FORCE AD16 Rak hörnfräs med invändig kylning

90° hörn- och planfräs för positiva AD.. 16-skär med APMX 13 mm. Passar för en rad olika applikationer, bl a rampning, trochoidalfräsning och dykfräsning. Finns med cyl. skaft, Weldon-skaft, morse-kona, modulärt eller dornfäste (med differentiell tanddelning). Behandlad för lång livslängd.

KAPR	90°
APMX	13.0 mm



FORCE AD



Product	DC	OAL	DCON MS	DCCB	DBC1	LU	LUX	LF	TDZ	CZC MS	KWW	KWD	GAMF	GAMP	max.			kg	G		
	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(°)	(°)	rpm	m/min	kg	G165	SQ030		
25A2R033A25-SAD16E-C	25	165	25	-	-	33	-	-	-	-	-	-	-13	5	2	-	18700	✓	0.52	G165 SQ030	-
25A2R038A25-SAD16E-C	25	200	25	-	-	38	-	-	-	-	-	-	-13	5	2	-	18700	✓	0.66	G165 SQ030	-
32A3R033A32-SAD16E-C	32	195	32	-	-	33	-	-	-	-	-	-	-12	7	3	-	16500	✓	1.03	G165 SQ030	-
32A3R048A32-SAD16E-C	32	250	32	-	-	48	-	-	-	-	-	-	-12	7	3	-	16500	✓	1.35	G165 SQ030	-
25A2R042B25-SAD16E-C	25	98	25	-	-	-	42	-	-	-	-	-	-13	5	2	-	18700	✓	0.29	G165 SQ030	-
32A3R040B32-SAD16E-C	32	100	32	-	-	-	40	-	-	-	-	-	-12	7	3	-	16500	✓	0.51	G165 SQ030	-
40A3R050B32-SAD16E-C	40	110	32	-	-	-	50	-	-	-	-	-	-8.2	10.5	3	-	14800	✓	0.51	G165 SQ030	-
40A4R050B32-SAD16E-C	40	110	32	-	-	-	50	-	-	-	-	-	-8.2	10.5	4	-	14800	✓	0.64	G165 SQ030	-
25A2R043E03-SAD16E-C	25	98	-	-	-	38	-	43	-	3	-	-	-13	5	2	-	18600	✓	0.31	G165 SQ030	-
32A3R043E03-SAD16E-C	32	100	-	-	-	38	-	43	-	3	-	-	-12	7	3	-	16500	✓	0.33	G165 SQ030	-
40A3R054E04-SAD16E-C	40	110	-	-	-	48	-	54	-	4	-	-	-8.2	10.5	3	-	14700	✓	0.74	G165 SQ030	-
40A4R054E04-SAD16E-C	40	110	-	-	-	48	-	54	-	4	-	-	-8.2	10.5	4	-	14700	✓	0.70	G165 SQ030	-
32A3R043M16-SAD16E-C	32	66	17	-	-	-	43	M16	-	-	-	-	-12	7	3	-	-	✓	0.20	G165 SQ030	-
40A4R043M16-SAD16E-C	40	66	17	-	-	-	43	M16	-	-	-	-	-8.2	10.5	4	-	-	✓	0.26	G165 SQ030	-
40A04R-S90AD16E-C	40	-	16	14	-	-	-	40	-	-	8.4	5.6	-8.2	10.5	4	-	14700	✓	0.21	G165 SQ032	-
50A03R-S90AD16E-C	50	-	22	18	-	-	-	40	-	-	10.4	6.3	-7	11	3	-	13200	✓	0.43	G165 SQ033	-
50A05R-S90AD16E-C	50	-	22	18	-	-	-	40	-	-	10.4	6.3	-7	11	5	✓	13200	✓	0.40	G165 SQ033	-
63A04R-S90AD16E-C	63	-	22	18	-	-	-	40	-	-	10.4	6.3	-6	12	4	✓	11800	✓	0.60	G165 SQ033	-
63A06R-S90AD16E-C	63	-	22	18	-	-	-	40	-	-	10.4	6.3	-6	12	6	✓	11800	✓	0.59	G165 SQ033	-
80A05R-S90AD16E-C	80	-	27	38	-	-	-	50	-	-	12.4	7	-5	12	5	✓	10400	✓	1.09	G165 SQ031 AC001	-
80A07R-S90AD16E-C	80	-	27	38	-	-	-	50	-	-	12.4	7	-5	13	7	✓	10400	✓	0.97	G165 SQ031 AC001	-
100A06R-S90AD16E-C	100	-	32	45	-	-	-	50	-	-	14.4	8	-4	12	6	✓	9300	✓	1.85	G165 SQ031 AC002	-
100A08R-S90AD16E-C	100	-	32	45	-	-	-	50	-	-	14.4	8	-4	12	8	✓	9300	✓	1.89	G165 SQ031 AC002	-
125A09R-S90AD16E-C	125	-	40	56	-	-	-	63	-	-	16.4	9	-3.8	12	9	✓	8400	✓	3.65	G165 SQ031 AC003	-
140A08R-S90AD16E-C	140	-	40	56	-	-	-	63	-	-	16.4	9	-3.8	12	8	✓	7900	✓	4.06	G165 SQ031	-
160C10R-S90AD16E-C	160	-	40	-	66.7	-	-	63	-	-	16.4	9.2	-3.8	10	10	✓	7300	✓	6.04	G165 SQ036	-
175C10R-S90AD16E-C	175	-	40	-	66.7	-	-	63	-	-	16.4	9.2	-3.8	12	10	✓	7000	✓	6.86	G165 SQ036	-

GI165	ADMX 1606..	ADEX 1606..
-------	-------------	-------------

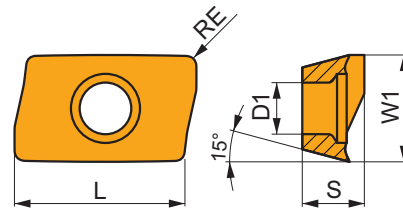
SQ030	US 4008-T15P	3.5	M 4	8	–	–	Flag T15P	–	–	–	–
SQ031	US 4011-T15P	3.5	M 4	10.6	D-T08P/T15P	FG-15	–	–	–	–	–
SQ032	US 4008-T15P	3.5	M 4	8	D-T08P/T15P	FG-15	–	HS 0830C	–	–	–
SQ033	US 4011-T15P	3.5	M 4	10.6	D-T08P/T15P	FG-15	–	HS 1030C	–	–	–
SQ036	US 4011-T15P	3.5	M 4	10.6	D-T08P/T15P	FG-15	–	HS 1240C	CAC 160C	HSD 0825C	HXK 5

AC001	KS 1230	K.FMH27
AC002	KS 1635	K.FMH32
AC003	KS 2040	K.FMH40

ADMX 16

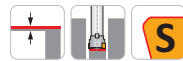
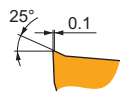
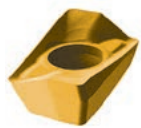


	W1	D1	L	S
	(mm)	(mm)	(mm)	(mm)
1606	9.950	4.50	16.00	6.25



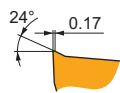
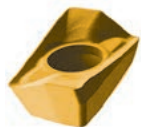
Lämplighet och startvärden för skärhastighet (vc), matning (f) och skärdjup (ap). Vi refererar till vår Dormer Pramet Calculator-app för vidare beräkningar.

Product	RE	P			M			K			N			S			H		
		vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)



F geometri med mycket positiv design för fin till medelfin fräsning.

ADMX 160608SR-F:8215	●	0.8	290	0.10	2.0	170	0.09	2.0	275	0.10	2.0	870	0.12	2.0	70	0.07	1.6	–	–	–
ADMX 160608SR-F:M8310	●	0.8	320	0.10	2.0	160	0.09	2.0	300	0.10	2.0	–	–	–	–	–	–	–	–	–
ADMX 160608SR-F:M8330	●	0.8	285	0.10	2.0	170	0.09	2.0	270	0.10	2.0	855	0.12	2.0	70	0.07	1.6	–	–	–
ADMX 160608SR-F:M8340	●	0.8	260	0.10	2.0	155	0.09	2.0	245	0.10	2.0	–	–	–	65	0.07	1.6	–	–	–
ADMX 160608SR-F:M9340	●	0.8	340	0.10	2.0	200	0.09	2.0	–	–	–	–	–	–	85	0.07	1.6	–	–	–

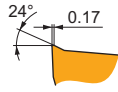
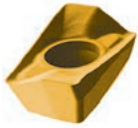


M geometri med positiv design för fin till medelfin fräsning.

ADMX 160604SR-M:8215	●	0.4	190	0.18	5.0	110	0.16	5.0	180	0.18	5.0	–	–	–	45	0.13	4.0	–	–	–
ADMX 160604SR-M:M8330	●	0.4	190	0.18	5.0	110	0.16	5.0	180	0.18	5.0	–	–	–	45	0.13	4.0	–	–	–
ADMX 160604SR-M:M8340	●	0.4	170	0.18	5.0	100	0.16	5.0	160	0.18	5.0	–	–	–	40	0.13	4.0	–	–	–
ADMX 160608SR-M:8215	●	0.8	225	0.18	5.0	135	0.16	5.0	210	0.18	5.0	–	–	–	55	0.13	4.0	–	–	–
ADMX 160608SR-M:M5315	●	0.8	305	0.18	5.0	–	–	–	285	0.18	5.0	–	–	–	–	–	–	–	–	–
ADMX 160608SR-M:M8310	●	0.8	250	0.18	5.0	125	0.16	5.0	235	0.18	5.0	–	–	–	–	–	–	–	–	–
ADMX 160608SR-M:M8330	●	0.8	225	0.18	5.0	135	0.16	5.0	210	0.18	5.0	–	–	–	55	0.13	4.0	–	–	–
ADMX 160608SR-M:M8340	●	0.8	205	0.18	5.0	120	0.16	5.0	190	0.18	5.0	–	–	–	50	0.13	4.0	–	–	–
ADMX 160608SR-M:M9315	●	0.8	305	0.18	5.0	–	–	–	285	0.18	5.0	–	–	–	–	–	–	–	–	–
ADMX 160608SR-M:M9325	●	0.8	280	0.18	5.0	–	–	–	265	0.18	5.0	–	–	–	–	–	–	–	–	–
ADMX 160608SR-M:M9340	●	0.8	255	0.18	5.0	150	0.16	5.0	–	–	–	–	–	–	60	0.13	4.0	–	–	–

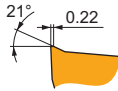
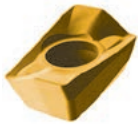
Lämplighet och startvärden för skärhastighet (vc), matning (f) och skärdjup (ap). Vi refererar till vår Dormer Pramet Calculator-app för vidare beräkningar.

Product	RE (mm)	P			M			K			N			S			H		
		vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)



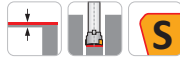
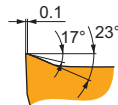
M geometri med positiv design för fin till medelfin fräsning.

ADMX 160616SR-M:8215	1.6	250	0.18	5.0	150	0.16	5.0	235	0.18	5.0	-	-	-	60	0.13	4.0	-	-	-
ADMX 160616SR-M:M8310	1.6	275	0.18	5.0	140	0.16	5.0	260	0.18	5.0	-	-	-	-	-	-	-	-	-
ADMX 160616SR-M:M8330	1.6	250	0.18	5.0	150	0.16	5.0	235	0.18	5.0	-	-	-	60	0.13	4.0	-	-	-
ADMX 160616SR-M:M8340	1.6	225	0.18	5.0	135	0.16	5.0	210	0.18	5.0	-	-	-	55	0.13	4.0	-	-	-
ADMX 160616SR-M:M9325	1.6	310	0.18	5.0	-	-	-	290	0.18	5.0	-	-	-	-	-	-	-	-	-
ADMX 160620SR-M:M8330	2.0	265	0.18	5.0	155	0.16	5.0	250	0.18	5.0	-	-	-	65	0.13	4.0	-	-	-
ADMX 160620SR-M:M8340	2.0	240	0.18	5.0	140	0.16	5.0	225	0.18	5.0	-	-	-	60	0.13	4.0	-	-	-
ADMX 160630SR-M:M8330	3.0	265	0.18	5.0	155	0.16	5.0	250	0.18	5.0	-	-	-	65	0.13	4.0	-	-	-
ADMX 160630SR-M:M8340	3.0	240	0.18	5.0	140	0.16	5.0	225	0.18	5.0	-	-	-	60	0.13	4.0	-	-	-
ADMX 160632SR-M:M6330	3.2	225	0.18	5.0	155	0.16	5.0	-	-	-	-	-	-	65	0.13	4.0	-	-	-
ADMX 160632SR-M:M8330	3.2	265	0.18	5.0	155	0.16	5.0	250	0.18	5.0	-	-	-	65	0.13	4.0	-	-	-
ADMX 160632SR-M:M8340	3.2	240	0.18	5.0	140	0.16	5.0	225	0.18	5.0	-	-	-	60	0.13	4.0	-	-	-
ADMX 160632SR-M:M9325	3.2	325	0.18	5.0	-	-	-	305	0.18	5.0	-	-	-	-	-	-	-	-	-
ADMX 160640SR-M:M8330	4.0	265	0.18	5.0	155	0.16	5.0	250	0.18	5.0	-	-	-	65	0.13	4.0	-	-	-
ADMX 160640SR-M:M8340	4.0	240	0.18	5.0	140	0.16	5.0	225	0.18	5.0	-	-	-	60	0.13	4.0	-	-	-
ADMX 160650SR-M:M8330	5.0	265	0.18	5.0	155	0.16	5.0	250	0.18	5.0	-	-	-	65	0.13	4.0	-	-	-
ADMX 160650SR-M:M8340	5.0	240	0.18	5.0	140	0.16	5.0	225	0.18	5.0	-	-	-	60	0.13	4.0	-	-	-



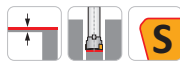
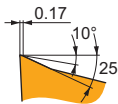
R geometri med positiv design för medelfin fräsning vid mindre stabila förhållanden.

ADMX 160608PR-R:8215	0.8	205	0.25	6.0	120	0.23	6.0	190	0.25	6.0	-	-	-	50	0.20	4.8	40	0.16	1.1
ADMX 160608PR-R:M5315	0.8	260	0.25	6.0	-	-	-	245	0.25	6.0	-	-	-	-	-	-	50	0.16	1.1
ADMX 160608PR-R:M8310	0.8	220	0.25	6.0	110	0.23	6.0	205	0.25	6.0	-	-	-	40	0.16	1.1	-	-	-
ADMX 160608PR-R:M8330	0.8	205	0.25	6.0	120	0.23	6.0	190	0.25	6.0	-	-	-	50	0.20	4.8	40	0.16	1.1
ADMX 160608PR-R:M8340	0.8	190	0.25	6.0	110	0.23	6.0	180	0.25	6.0	-	-	-	45	0.20	4.8	-	-	-
ADMX 160608PR-R:M9315	0.8	265	0.25	6.0	-	-	-	250	0.25	6.0	-	-	-	-	-	-	50	0.16	1.1
ADMX 160608PR-R:M9325	0.8	250	0.25	6.0	-	-	-	235	0.25	6.0	-	-	-	-	-	-	50	0.16	1.1
ADMX 160616PR-R:M8330	1.6	225	0.25	6.0	135	0.23	6.0	210	0.25	6.0	-	-	-	55	0.20	4.8	45	0.16	1.1
ADMX 160616PR-R:M8340	1.6	210	0.25	6.0	125	0.23	6.0	195	0.25	6.0	-	-	-	50	0.20	4.8	-	-	-
ADMX 160616PR-R:M9315	1.6	295	0.25	6.0	-	-	-	280	0.25	6.0	-	-	-	-	-	-	55	0.16	1.1



MF geometri med mycket positiv design för finfräsning.

ADMX 160608SR-MF:M6330	0.8	215	0.08	4.0	150	0.07	4.0	-	-	-	-	-	-	60	0.06	3.2	-	-	-
ADMX 160608SR-MF:M8340	0.8	225	0.08	4.0	135	0.07	4.0	-	-	-	-	-	-	55	0.06	3.2	-	-	-
ADMX 160608SR-MF:M9340	0.8	305	0.08	4.0	180	0.07	4.0	-	-	-	-	-	-	75	0.06	3.2	-	-	-



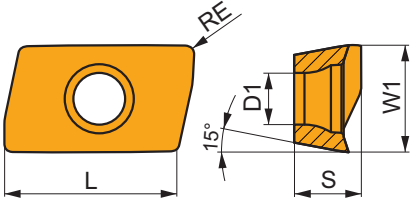
MM geometri med mycket positiv design för fin till medelfin fräsning.

ADMX 160604SR-MM:M6330	0.4	145	0.18	4.0	105	0.16	4.0	-	-	-	-	-	-	40	0.14	3.2	-	-	-
ADMX 160604SR-MM:M8340	0.4	160	0.18	4.0	95	0.16	4.0	-	-	-	-	-	-	40	0.14	3.2	-	-	-
ADMX 160608SR-MM:M6330	0.8	175	0.18	4.0	125	0.16	4.0	-	-	-	-	-	-	50	0.14	3.2	-	-	-
ADMX 160608SR-MM:M8340	0.8	190	0.18	4.0	110	0.16	4.0	-	-	-	-	-	-	45	0.14	3.2	-	-	-
ADMX 160608SR-MM:M8345	0.8	150	0.18	4.0	90	0.16	4.0	-	-	-	-	-	-	35	0.14	3.2	-	-	-
ADMX 160608SR-MM:M9340	0.8	235	0.18	4.0	140	0.16	4.0	-	-	-	-	-	-	55	0.14	3.2	-	-	-
ADMX 160616SR-MM:M6330	1.6	195	0.18	4.0	140	0.16	4.0	-	-	-	-	-	-	55	0.14	3.2	-	-	-
ADMX 160616SR-MM:M8340	1.6	210	0.18	4.0	125	0.16	4.0	-	-	-	-	-	-	50	0.14	3.2	-	-	-
ADMX 160616SR-MM:M8345	1.6	165	0.18	4.0	95	0.16	4.0	-	-	-	-	-	-	40	0.14	3.2	-	-	-
ADMX 160616SR-MM:M9340	1.6	260	0.18	4.0	155	0.16	4.0	-	-	-	-	-	-	65	0.14	3.2	-	-	-

ADEX 16

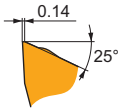


	W1 (mm)	D1 (mm)	L (mm)	S (mm)
1606	9.950	4.50	16.00	6.25



Lämplighet och startvärden för skärhastighet (vc), matning (f) och skärdjup (ap). Vi refererar till vår Dormer Pramet Calculator-app för vidare beräkningar.

Product	RE (mm)	P			M			K			N			S			H		
		vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)



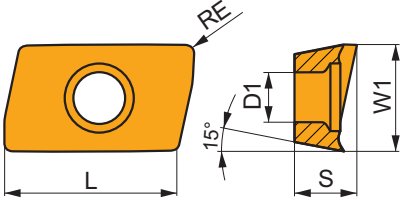
FM geometri med mycket positiv design för medelfin fräsning.

ADEX 160608SR-FM:8215	0.8	260	0.16	2.0	155	0.14	2.0	245	0.16	2.0	-	-	-	65	0.11	1.6	-	-	-
ADEX 160608SR-FM:M8330	0.8	255	0.16	2.0	150	0.14	2.0	240	0.16	2.0	-	-	-	60	0.11	1.6	-	-	-
ADEX 160608SR-FM:M8340	0.8	235	0.16	2.0	140	0.14	2.0	220	0.16	2.0	-	-	-	55	0.11	1.6	-	-	-

ADEX 16-FA

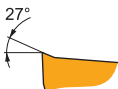


	W1 (mm)	D1 (mm)	L (mm)	S (mm)
1606	9.950	4.50	16.00	6.17



Lämplighet och startvärden för skärhastighet (vc), matning (f) och skärdjup (ap). Vi refererar till vår Dormer Pramet Calculator-app för vidare beräkningar.

Product	RE (mm)	P			M			K			N			S			H		
		vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)



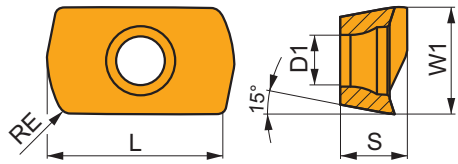
FA geometri med mycket positiv design för fin till medelfin fräsning.

ADEX 160604FR-FA:HF7	0.4	-	-	-	-	-	-	195	0.28	6.0	-	-	-	-	-	-	-	-	-
ADEX 160604FR-FA:M0315	0.4	-	-	-	-	-	-	480	0.28	6.0	-	-	-	-	-	-	-	-	-
ADEX 160608FR-FA:HF7	0.8	-	-	-	-	-	-	240	0.28	6.0	-	-	-	-	-	-	-	-	-
ADEX 160608FR-FA:M0315	0.8	-	-	-	-	-	-	570	0.28	6.0	-	-	-	-	-	-	-	-	-
ADEX 160616FR-FA:HF7	1.6	-	-	-	-	-	-	255	0.28	6.0	-	-	-	-	-	-	-	-	-
ADEX 160616FR-FA:M0315	1.6	-	-	-	-	-	-	630	0.28	6.0	-	-	-	-	-	-	-	-	-
ADEX 160630FR-FA:HF7	3.0	-	-	-	-	-	-	270	0.28	6.0	-	-	-	-	-	-	-	-	-

ADEX 16-HF

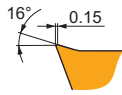


	W1	D1	L	S
	(mm)	(mm)	(mm)	(mm)
1606	9.950	4.50	16.00	5.88



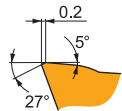
Lämplighet och startvärden för skärhastighet (vc), matning (f) och skärdjup (ap). Vi refererar till vår Dormer Pramet Calculator-app för vidare beräkningar.

Product	RE (mm)	P			M			K			N			S			H		
		vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)			



HF geometri med mycket positiv design för högmatningsfräsning.

ADEX 160612SR-HF:8215	1.2	195	1.00	0.6	115	0.90	0.6	-	-	-	-	-	-	-	-	-	-	-
ADEX 160612SR-HF:M8310	1.2	205	1.00	0.6	100	0.77	0.6	-	-	-	-	-	-	-	-	-	-	-
ADEX 160612SR-HF:M8330	1.2	200	1.00	0.6	120	0.90	0.6	-	-	-	-	-	-	-	-	-	-	-
ADEX 160612SR-HF:M8340	1.2	185	1.00	0.6	110	0.90	0.6	-	-	-	-	-	-	-	-	-	-	-
ADEX 160612SR-HF:M9340	1.2	195	1.00	0.6	115	0.90	0.6	-	-	-	-	-	-	-	-	-	-	-



HF2 geometri med positiv design för högmatningsfräsning.

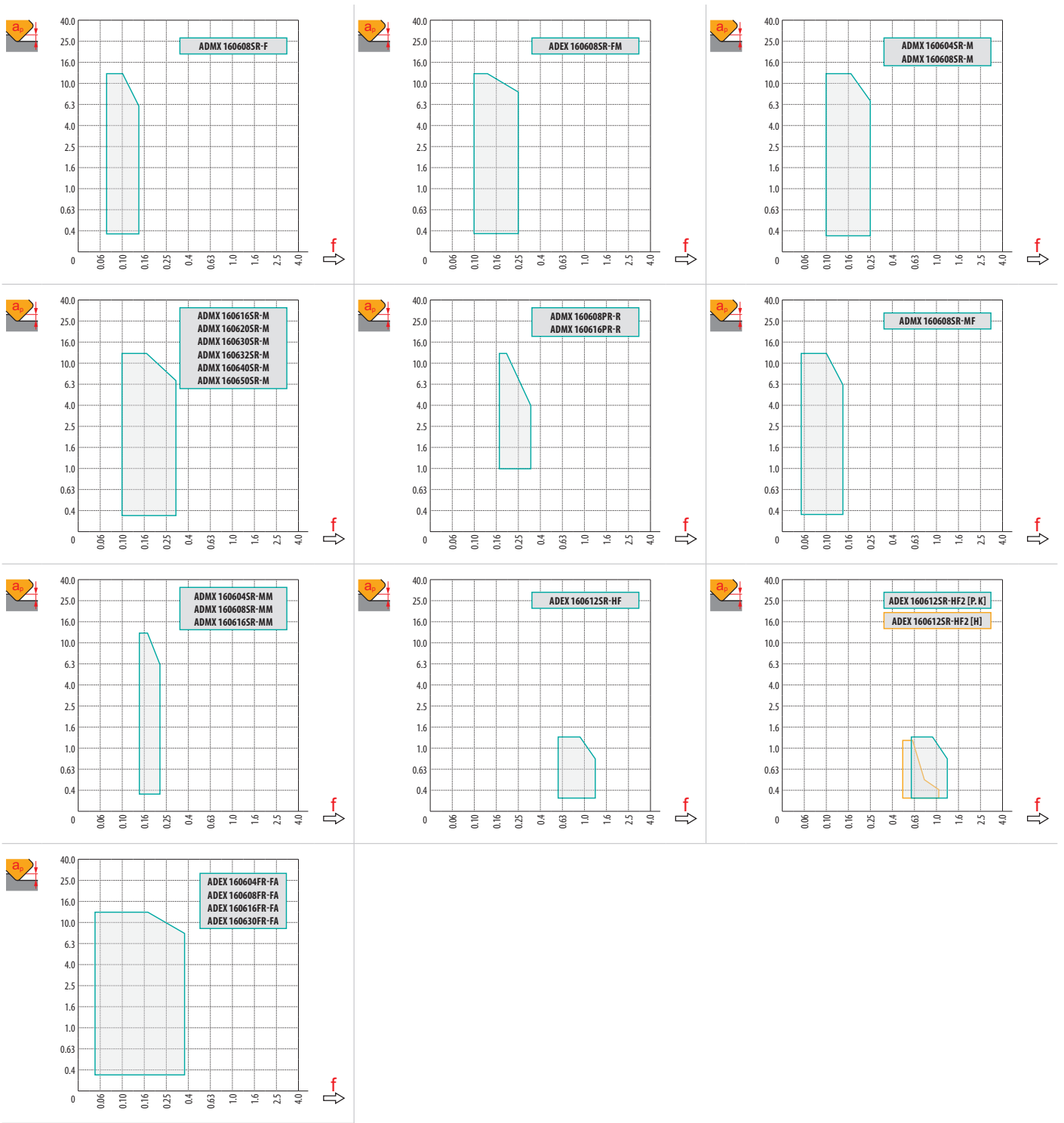
ADEX 160612SR-HF2:M8310	1.2	205	0.90	0.6	100	0.81	0.6	190	0.90	0.6	-	-	-	-	-	-	40	0.63	0.5
ADEX 160612SR-HF2:M8330	1.2	205	0.90	0.6	120	0.81	0.6	190	0.90	0.6	50	0.81	0.5	40	0.63	0.5	-	-	-
ADEX 160612SR-HF2:M8340	1.2	190	0.90	0.6	110	0.81	0.6	180	0.90	0.6	45	0.81	0.5	-	-	-	-	-	-
ADEX 160612SR-HF2:M9325	1.2	230	0.90	0.6	-	-	-	215	0.90	0.6	-	-	-	45	0.63	0.5	-	-	-



a_e / DC	5 %	10 %	15 %	20 %	25 %	30 %	40 %	50 %	60 %	70 %	75 %	80 %	90 %	100 %
	1.48	1.35	1.27	1.22	1.19	1.16	1.11	1.08	1.05	1.03	1.00	1.00	1.00	1.00
	2.20	1.60	1.35	1.20	1.10	0.95	0.85	0.75	0.85	0.95	1.00	1.00	1.00	1.00
	0.64	0.64	0.64	0.64	0.64	0.65	0.65	0.67	0.68	0.71	0.72	0.74	0.79	1.00

	ADMX 16-F	ADEX 16-FM	ADMX 16-M									ADMX 16-R	
	0.8	0.8	0.4	0.8	1.6	2.0	3.0	3.2	4.0	5.0	0.8	1.6	
	2.99	2.18	3.39	2.99	1.62	1.23	0.28	0.09	2.69	1.52	2.99	1.62	

	ADMX 16-MF	ADMX 16-MM			ADEX 16-HF	ADEX 16-HF2	ADEX 16-FA			
	0.8	0.4	0.8	1.6	1.2	1.2	0.4	0.8	1.6	3.0
	2.99	3.39	2.99	1.62	0.52	0.52	2.84	2.44	1.65	0.69



max	7.5		
	1.0	6.0	13.0
	0.28	0.19	0.10

DC	RPMX	APMX/I
25	12.5°	13.0/60
32	7.5°	13.0/100
40	5.0°	8.6/100
50	3.5°	6.0/100
63	2.5°	4.2/100
80	2.0°	3.3/100

HFC			
DC	RPMX *	RPMX **	APMX/I
25	4.0°	8.0°	1.3/19
32	2.0°	7.5°	1.3/38
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

* HFC milling
 ** Conventional milling



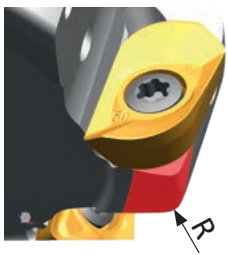
	D _{MIN}	D _{MAX}	D _{MIN}	D _{MAX}
25	42.0	50.0	10.0	12.5
32	55.0	64.0	6.5	9.0
40	72.0	80.0	5.0	8.0
50	92.0	100.0	4.5	6.0
63	118.0	126.0	4.0	5.0
80	136.0	160.0	1.5	2.0

HFC				
	D _{MIN}	D _{MAX}	D _{MIN}	D _{MAX}
25	42.0	50.0	1.3	1.3
32	55.0	64.0	1.3	1.3
40	72.0	80.0	1.3	1.3
50	92.0	100.0	1.3	1.3
63	118.0	126.0	1.3	1.3
80	136.0	160.0	1.3	1.3

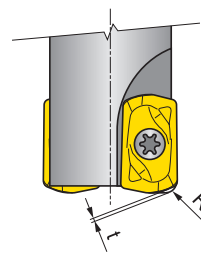


		3	5	10	15	20	30	40	50	60	80	100
25		0.548	0.707	1.000	1.225	1.414	1.732	2.000	2.236	2.449	2.828	3.162
32		0.620	0.800	1.131	1.386	1.600	1.960	2.263	2.530	2.771	3.200	3.578
40		0.693	0.894	1.265	1.549	1.789	2.191	2.530	2.828	3.098	3.578	4.000
50		0.775	1.000	1.414	1.732	2.000	2.449	2.828	3.162	3.464	4.000	4.472
63		0.869	1.122	1.587	1.944	2.245	2.750	3.175	3.550	3.888	4.490	5.020
80		0.980	1.265	1.789	2.191	2.530	3.098	3.578	4.000	4.382	5.060	5.657

		3	5	10	15	20	30	40	50	60	80	100
1.6		0.196	0.253	0.358	0.438	0.506	0.620	0.716	0.800	0.876	1.012	1.131
2.0		0.219	0.283	0.400	0.490	0.566	0.693	0.800	0.894	0.980	1.131	1.265
3.0		0.268	0.346	0.490	0.600	0.693	0.849	0.980	1.095	1.200	1.386	1.549
3.2		0.277	0.358	0.506	0.620	0.716	0.876	1.012	1.131	1.239	1.431	1.600
4.0		0.310	0.400	0.566	0.693	0.800	0.980	1.131	1.265	1.386	1.600	1.789
5.0		0.346	0.447	0.632	0.775	0.894	1.095	1.265	1.414	1.549	1.789	2.000



ADMX/ADEX 16	R
ADMX 160630SR-M	2.5
ADMX 160632SR-M	2.5
ADMX 160640SR-M	4.0
ADMX 160650SR-M	4.5
ADEX 160612SR-HF	3.0
ADEX 160612SR-HF2	3.0



ADEX 16	R	t
ADEX 160612SR-HF	2.59	0.56
ADEX 160612SR-HF2	2.48	0.57

SAP10D

P M K N S

PRAMET

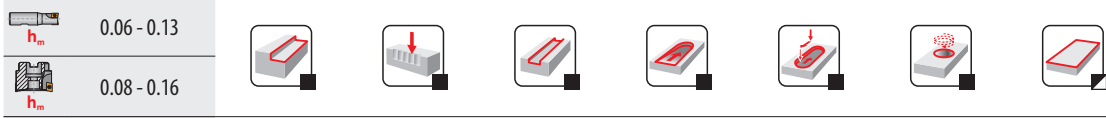
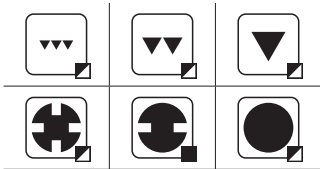
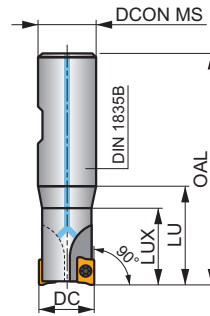
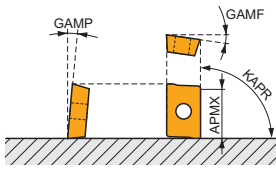
S



Rak hörnfräs för APKT 10-skär, med invändig kylning

90° hörn- och planfräs för positiva APKT 10-skär med APMX 9 mm. Passar för en rad olika applikationer, bl a rampning, trochoidalfräsning och dykfräsning. Finns med Weldon-skaft och för dornmontering (med differentiell tanddelning). Behandlad för lång livslängd.

KAPR	90°
APMX	9.0 mm



Product	DC	OAL	DCON MS	DCCB	LU	LUX	LF	KWW	KWD	GAMF	GAMP							
	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(°)	(°)			max.				
10A1R020B16-SAP10D-C	10	78	16	-	30	20	-	-	-	12	2	1	-	39000	✓	0.09	G1081	SQ215
12A1R027B16-SAP10D-C	12	75	16	-	27	-	-	-	-	12	2	1	-	35600	✓	0.10	G1081	SQ210
16A2R032B16-SAP10D-C	16	80	16	-	32	-	-	-	-	12	4	2	-	30800	✓	0.12	G1081	SQ210
20A3R032B20-SAP10D-C	20	82	20	-	32	-	-	-	-	12	4	3	-	27600	✓	0.13	G1081	SQ210
25A3R042B25-SAP10D-C	25	98	25	-	42	-	-	-	-	12	4	3	-	24700	✓	0.36	G1081	SQ210

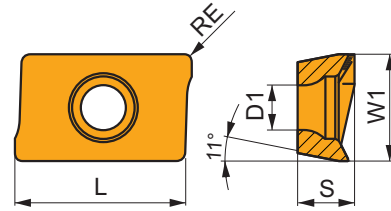
G1081	APKT 1003..

SQ210	US 2506-T07P	1.2	M 2.5	6.3	Flag T07P
SQ215	US 2505-T07P	1.2	M 2.5	5.2	Flag T07P

APKT 10

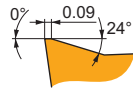
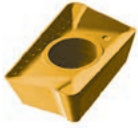


	W1 (mm)	D1 (mm)	L (mm)	S (mm)
1003	6.700	2.88	11.00	3.50



Lämplighet och startvärden för skärhastighet (vc), matning (f) och skärdjup (ap). Vi refererar till vår Dormer Pramet Calculator-app för vidare beräkningar.

Product	RE (mm)	P			M			K			N			S			H		
		vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)



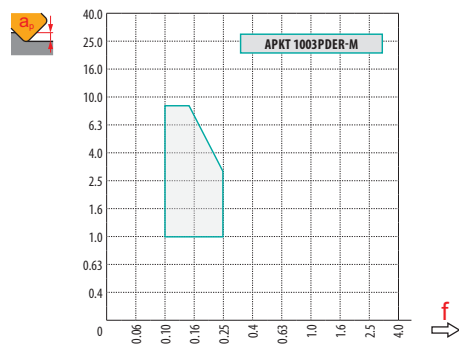
M geometri med mycket positiv design för fin till medelfin fräsning.

APKT 1003PDER-M:8215	0.5	285	0.12	4.0	170	0.11	4.0	270	0.12	4.0	-	-	-	70	0.11	3.2	-	-	-
APKT 1003PDER-M:M8330	0.5	285	0.12	4.0	170	0.11	4.0	270	0.12	4.0	-	-	-	70	0.11	3.2	-	-	-
APKT 1003PDER-M:M8340	0.5	255	0.12	4.0	150	0.11	4.0	240	0.12	4.0	-	-	-	60	0.11	3.2	-	-	-
APKT 1003PDER-M:M9325	0.5	360	0.12	4.0	-	-	-	340	0.12	4.0	-	-	-	-	-	-	-	-	-
APKT 1003PDER-M:M9340	0.5	335	0.12	4.0	200	0.11	4.0	-	-	-	-	-	-	80	0.11	3.2	-	-	-



a_e / DC	5 %	10 %	15 %	20 %	25 %	30 %	40 %	50 %	60 %	70 %	75 %	80 %	90 %	100 %
	1.48	1.35	1.27	1.22	1.19	1.16	1.11	1.08	1.05	1.03	1.00	1.00	1.00	1.00
	2.20	1.60	1.35	1.20	1.10	0.95	0.85	0.75	0.85	0.95	1.00	1.00	1.00	1.00
	0.64	0.64	0.64	0.64	0.64	0.65	0.65	0.67	0.68	0.71	0.72	0.74	0.79	1.00

	APKT 10-M
	0.5
	0.84



4.5

	1.0	3.0	5.0
	0.20	0.13	0.10

	RPMX	APMX/I
10	7.3°	9.0/72
12	6.2°	9.0/84
16	2.4°	4.0/100
20	2.2°	3.7/100
25	2.2°	3.7/100

	DMIN	DMAX		
10	11.0	20.0	0.4	3.8
12	13.0	24.0	0.3	3.9
16	20.5	32.0	0.6	2.0
20	27.2	40.0	0.9	2.4
25	37.9	50.0	1.6	3.0

0.3

SAP16D



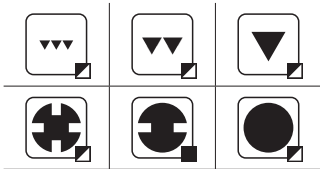
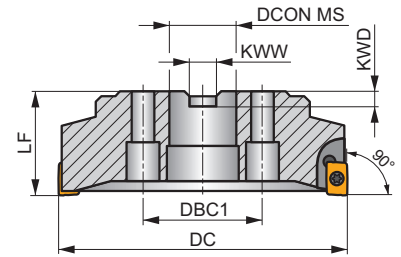
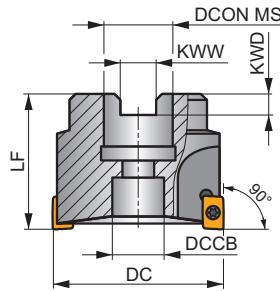
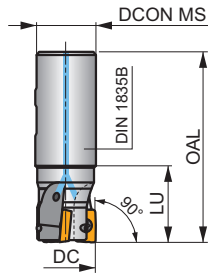
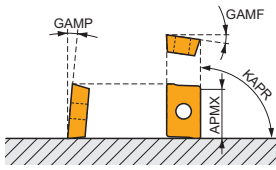
PRAMET



Rak hörnfräs för APKT 16-skär, med invändig kylning

90° hörn- och planfräs för positiva APKT 16-skär med APMX 13 mm. Passar för en rad olika applikationer, bl a rampning, trochoidalfräsning och dykfräsning. Finns med Weldon-skaft och för dornmontering (med differentiell tanddelning). Behandlad för lång livslängd.

KAPR	90°
APMX	13.0 mm



	0.06 - 0.18
	0.10 - 0.22



Product	DC	OAL	DCON MS	DCCB	DBC1	LU	LF	KWW	KWD	GAMF	GAMP								
	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(°)	(°)		kg						
25A2R042B25-SAP16D-C	25	98	25	-	-	42	-	-	-	0	6	2	-	16800	✓	0.31	GI080	SQ030	-
32A3R040B32-SAP16D-C	32	100	32	-	-	50	-	-	-	0	8	3	-	14800	✓	0.51	GI080	SQ220	-
40A4R050B32-SAP16D-C	40	110	32	-	-	50	-	-	-	0	8	4	-	13200	✓	0.67	GI080	SQ220	-
40A4R-S90AP16D	40	40	16	11	-	-	40	8.4	5.6	0	6	4	✓	13200	-	0.23	GI080	SQ031	-
50A5R-S90AP16D	50	40	22	18	-	-	40	10.4	6.3	0	6	5	✓	11800	-	0.35	GI080	SQ031	-
63A6R-S90AP16D	63	40	22	18	-	-	40	10.4	6.3	0	6	6	✓	10600	-	0.50	GI080	SQ031	-
80B5R-S90AP16D	80	50	27	38	-	-	50	12.4	7	0	6	5	✓	9400	-	0.97	GI080	SQ031	AC001
80B7R-S90AP16D	80	50	27	38	-	-	50	12.4	7	0	6	7	✓	9400	-	0.99	GI080	SQ031	AC001
100B8R-S90AP16D	100	50	32	45	-	-	50	14.4	8	0	6	8	✓	8400	-	1.50	GI080	SQ031	AC002
125B9R-S90AP16D	125	63	40	56	-	-	63	16.4	9	0	6	9	✓	7500	-	2.80	GI080	SQ031	AC003

GI080	APKT 1604..	APET 1604..

SQ030	US 4008-T15P	3.5	M 4	8	-	-	Flag T15P
SQ031	US 4011-T15P	3.5	M 4	10.6	D-T08P/T15P	FG-15	-
SQ220	US 4011-T15P	3.5	M 4	10.6	-	-	Flag T15P

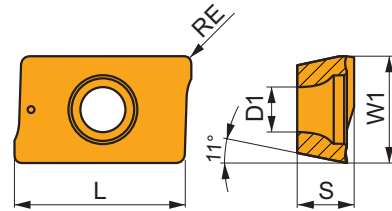
AC001	KS 1230	K.FMH27

AC002	KS 1635	K.FMH32
AC003	KS 2040	K.FMH40

APKT 16

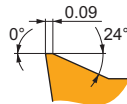
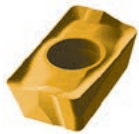


	W1	D1	L	S
	(mm)	(mm)	(mm)	(mm)
1604	9.440	4.60	17.00	5.67



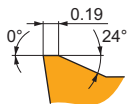
Lämplighet och startvärden för skärhastighet (vc), matning (f) och skärdjup (ap). Vi refererar till vår Dormer Pramet Calculator-app för vidare beräkningar.

Product	RE (mm)	P			M			K			N			S			H		
		vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap			
	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)



GM geometri med mycket positiv design för fin till medelfin fräsning.

APKT 1604PDR-GM:M8330	0.8	235	0.20	8.0	140	0.18	8.0	220	0.20	8.0	—	—	—	55	0.16	6.4	—	—	—
APKT 1604PDR-GM:M8340	0.8	210	0.20	8.0	125	0.18	8.0	195	0.20	8.0	—	—	—	50	0.16	6.4	—	—	—
APKT 1604PDR-GM:M9315	0.8	310	0.20	8.0	—	—	—	290	0.20	8.0	—	—	—	—	—	—	—	—	—
APKT 1604PDR-GM:M9325	0.8	285	0.20	8.0	—	—	—	270	0.20	8.0	—	—	—	—	—	—	—	—	—
APKT 1604PDR-GM:M9340	0.8	260	0.20	8.0	155	0.18	8.0	—	—	—	—	—	—	65	0.16	6.4	—	—	—



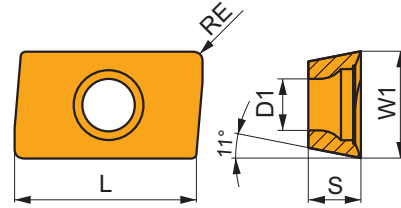
HM geometri med mycket positiv design för medelfin fräsning vid mindre stabila förhållanden.

APKT 160404-HM:M8340	0.4	160	0.30	6.0	95	0.27	6.0	150	0.30	6.0	—	—	—	40	0.24	4.8	—	—	—
APKT 160416-HM:M8340	1.6	210	0.30	6.0	125	0.27	6.0	195	0.30	6.0	—	—	—	50	0.24	4.8	—	—	—
APKT 160431-HM:M8340	3.1	220	0.30	6.0	130	0.27	6.0	205	0.30	6.0	—	—	—	55	0.24	4.8	—	—	—
APKT 1604PDR-HM:8215	0.8	220	0.30	6.0	130	0.27	6.0	205	0.30	6.0	—	—	—	55	0.24	4.8	—	—	—
APKT 1604PDR-HM:M5315	0.8	270	0.30	6.0	—	—	—	255	0.30	6.0	—	—	—	—	—	—	—	—	—
APKT 1604PDR-HM:M8330	0.8	220	0.30	6.0	130	0.27	6.0	205	0.30	6.0	—	—	—	55	0.24	4.8	—	—	—
APKT 1604PDR-HM:M8340	0.8	200	0.30	6.0	120	0.27	6.0	190	0.30	6.0	—	—	—	50	0.24	4.8	—	—	—
APKT 1604PDR-HM:M9325	0.8	260	0.30	6.0	—	—	—	245	0.30	6.0	—	—	—	—	—	—	—	—	—

APET 16-FA

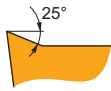


	W1 (mm)	D1 (mm)	L (mm)	S (mm)
1604	9.600	4.50	17.00	4.76



Lämplighet och startvärden för skärhastighet (vc), matning (f) och skärdjup (ap). Vi refererar till vår Dormer Pramet Calculator-app för vidare beräkningar.

Product	RE (mm)	P			M			K			N			S			H		
		vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)



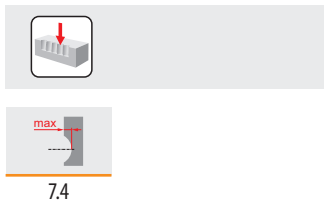
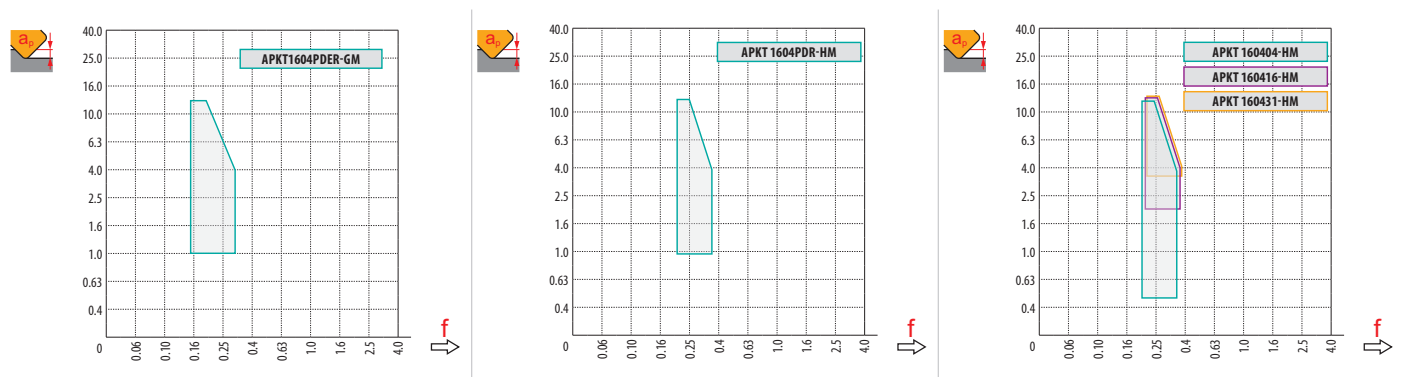
FA geometri med mycket positiv design för fin till medelfin fräsning.

APET 160408FR-FA:HF7	● 0.8										■ 255	0.24	8.0						
-----------------------------	-------	--	--	--	--	--	--	--	--	--	-------	------	-----	--	--	--	--	--	--



a_e / DC	5 %	10 %	15 %	20 %	25 %	30 %	40 %	50 %	60 %	70 %	75 %	80 %	90 %	100 %
	1.48	1.35	1.27	1.22	1.19	1.16	1.11	1.08	1.05	1.03	1.00	1.00	1.00	1.00
	2.20	1.60	1.35	1.20	1.10	0.95	0.85	0.75	0.85	0.95	1.00	1.00	1.00	1.00
	0.64	0.64	0.64	0.64	0.64	0.65	0.65	0.67	0.68	0.71	0.72	0.74	0.79	1.00

	APKT 16-GM	APKT 16-HM			
	0.8	0.4	0.8	1.6	3.1
	1.39	1.87	1.48	0.64	1.30



a_e	1.0	6.0	13.0
	0.28	0.19	0.13












	DMIN	DMAX		
			DMIN	DMAX
25	34.7	50.0	1.2	3.1
32	48.5	64.0	0.9	1.7
40	63.5	80.0	1.3	2.2
50	83.5	100.0	0.9	1.4
63	110.0	126.0	1.0	1.4
80	144.0	160.0	1.1	1.3

	RPMX	APMX/I
25	2.3	3.9/100
32	1.0	1.6/100
40	1.0	1.6/100
50	0.5	0.7/100
63	0.4	0.5/100
80	0.3	0.4/100

a_e
0.2

INDEXABLE FACE MILLS – NAVIGATOR

FACE MILLING

	SSO09	SSD12	FTB27X			
	90°		90°		90°	
	APMX (mm) 8.0	APMX (mm) 10.0	APMX (mm) 18.0			
	DC (mm) 20 – 80	DC (mm) 50 – 160	DC (mm) 175, 260			
Cylindrical shank						
Weldon		DC = 20 – 32 (mm)				
Modular						
Shell mill						
	DC = 40 – 80 (mm)					
Page	122	125	128			
ISO	P M K S	P M K N S	P M K			
Insert shape						
Inserts	SOMT 09T3	SDMT 1205	TBMR 2707			
No. of cutting edges	4	4	3			
Shallow shoulder milling 	■	■	■			
Shallow slot milling 	■	■	▣			
Plunge milling 	■	■				
Face milling 	▣	▣	▣			

SS009

P M K S

PRAMET

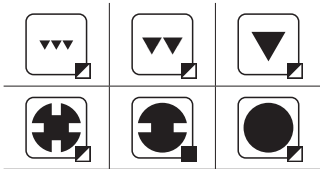
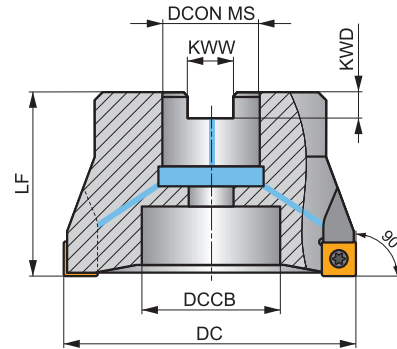
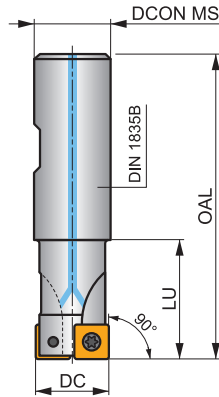
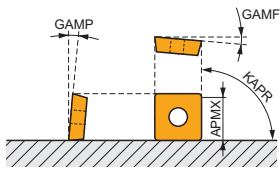
S



90° hörnfräs för SOMT 09-skär, med invändig kylning

90° hörn- och planfräs för positiva SOMT 09-skär med APMX 8 mm. Passar för en rad olika applikationer, bl a rampning, trochoidalfräsning och dykfräsning, med differentiell tanddelning. Behandlad för lång livslängd.

KAPR	90°
APMX	8.0 mm



h_m	0.07 - 0.18				
h_m	0.07 - 0.22				

Product	DC	OAL	DCON MS	DCCB	LU	LF	KWW	KWD	GAMP	GAMP									
	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(°)	(°)									
20A2R032B20-SS009-C	20	82	20	-	32	-	-	-	-12	6	2	-	23800	✓	0.21	GI146	SQ400	-	-
25A3R042B25-SS009-C	25	98	25	-	42	-	-	-	-12	6	3	-	21300	✓	0.31	GI146	SQ400	-	-
32A4R042B32-SS009-C	32	102	32	-	42	-	-	-	-10	10	4	✓	18800	✓	0.55	GI146	SQ400	-	-
40A05R-S90S009-C	40	-	16	14	-	40	8.4	5.6	-9.1	10	5	-	16800	✓	0.29	GI146	SQ402	-	-
50A06R-S90S009-C	50	-	22	18	-	40	10.4	6.4	-8.8	10	6	-	15100	✓	0.33	GI146	SQ403	-	-
63A07R-S90S009-C	63	-	22	18	-	40	10.4	6.4	-8.6	10	7	-	13400	✓	0.62	GI146	SQ403	-	-
80A09R-S90S009-C	80	-	27	38	-	50	12.4	7	-8.1	10	9	-	11900	✓	1.03	GI146	SQ401	AC001	-

GI146	SOMT 09T3..																		

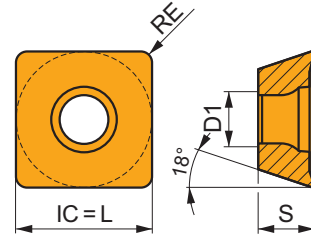
SQ400	US 3006-T09P	2.0	M 3	6	-	-	Flag T09P	-
SQ401	US 3006-T09P	2.0	M 3	6	D-T07P/T09P	FG-15	-	-
SQ402	US 3006-T09P	2.0	M 3	6	D-T07P/T09P	FG-15	-	HS 0830C
SQ403	US 3006-T09P	2.0	M 3	6	D-T07P/T09P	FG-15	-	HS 1030C

AC001	KS 1230			K.FMH27

SOMT 09

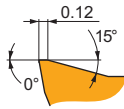
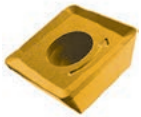


	IC	D1	L	S
	(mm)	(mm)	(mm)	(mm)
09T3	9.550	3.50	9.55	3.97



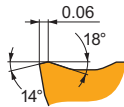
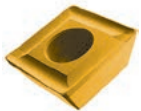
Lämplighet och startvärden för skärhastighet (vc), matning (f) och skärdjup (ap). Värden gäller för angreppsvinkel 90°. Refererar till vår Dormer Pramet Calculator-app för vidare beräkningar.

Product	RE (mm)	P			M			K			N			S			H		
		vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)



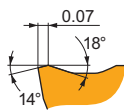
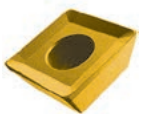
M geometri med positiv design för medelgrov fräsning.

SOMT 09T308-M:8215	● 0.8	■ 275	■ 0.14	■ 2.5	■ 165	■ 0.13	■ 2.5	■ 260	■ 0.14	■ 2.5	■ -	■ -	■ -	■ 65	■ 0.13	■ 2.0	■ -	■ -	■ -
SOMT 09T308-M:M5315	● 0.8	■ 390	■ 0.14	■ 2.5	■ -	■ -	■ -	■ 370	■ 0.14	■ 2.5	■ -	■ -	■ -	■ -	■ -	■ -	■ -	■ -	■ -
SOMT 09T308-M:M8330	● 0.8	■ 270	■ 0.14	■ 2.5	■ 160	■ 0.13	■ 2.5	■ 255	■ 0.14	■ 2.5	■ -	■ -	■ -	■ 65	■ 0.13	■ 2.0	■ -	■ -	■ -
SOMT 09T308-M:M8340	● 0.8	■ 250	■ 0.14	■ 2.5	■ 150	■ 0.13	■ 2.5	■ 235	■ 0.14	■ 2.5	■ -	■ -	■ -	■ 60	■ 0.13	■ 2.0	■ -	■ -	■ -
SOMT 09T308-M:M9315	● 0.8	■ 380	■ 0.14	■ 2.5	■ -	■ -	■ -	■ 360	■ 0.14	■ 2.5	■ -	■ -	■ -	■ -	■ -	■ -	■ -	■ -	■ -



MI geometri med stabilt positiv design för medelfin fräsning.

SOMT 09T304-MI:8215	● 0.4	■ 230	■ 0.14	■ 2.5	■ 135	■ 0.13	■ 2.5	■ 215	■ 0.14	■ 2.5	■ -	■ -	■ -	■ 55	■ 0.10	■ 2.0	■ -	■ -	■ -
SOMT 09T304-MI:M8310	● 0.4	■ 255	■ 0.14	■ 2.5	■ 130	■ 0.13	■ 2.5	■ 240	■ 0.14	■ 2.5	■ -	■ -	■ -	■ -	■ -	■ -	■ -	■ -	■ -
SOMT 09T304-MI:M8330	● 0.4	■ 230	■ 0.14	■ 2.5	■ 135	■ 0.13	■ 2.5	■ 215	■ 0.14	■ 2.5	■ -	■ -	■ -	■ 55	■ 0.10	■ 2.0	■ -	■ -	■ -
SOMT 09T304-MI:M8340	● 0.4	■ 210	■ 0.14	■ 2.5	■ 125	■ 0.13	■ 2.5	■ 195	■ 0.14	■ 2.5	■ -	■ -	■ -	■ 50	■ 0.10	■ 2.0	■ -	■ -	■ -
SOMT 09T304-MI:M9315	● 0.4	■ 320	■ 0.14	■ 2.5	■ -	■ -	■ -	■ 300	■ 0.14	■ 2.5	■ -	■ -	■ -	■ -	■ -	■ -	■ -	■ -	■ -
SOMT 09T304-MI:M9340	● 0.4	■ 265	■ 0.14	■ 2.5	■ 155	■ 0.13	■ 2.5	■ -	■ -	■ -	■ -	■ -	■ -	■ 65	■ 0.10	■ 2.0	■ -	■ -	■ -



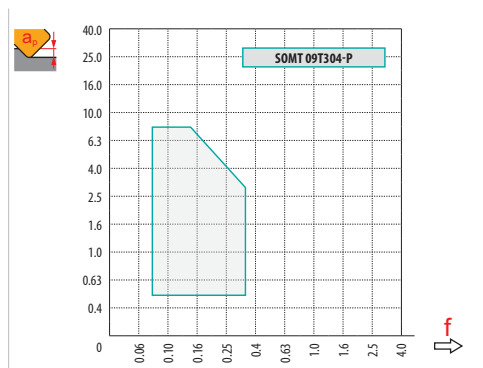
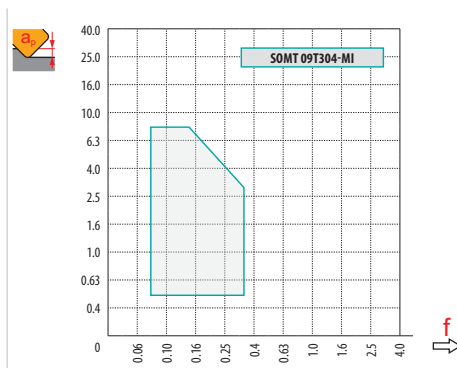
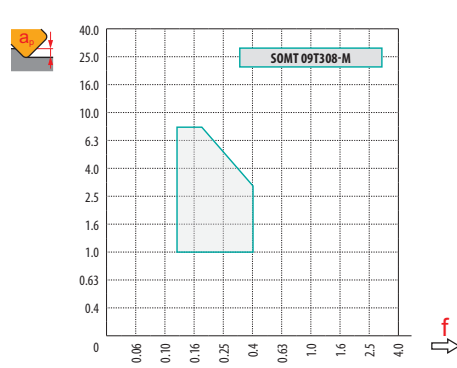
P geometri med mycket positiv design för medelfin fräsning.

SOMT 09T304-P:M8330	● 0.4	■ 250	■ 0.14	■ 2.5	■ 150	■ 0.13	■ 2.5	■ 235	■ 0.14	■ 2.5	■ -	■ -	■ -	■ 60	■ 0.10	■ 2.0	■ -	■ -	■ -
SOMT 09T304-P:M8340	● 0.4	■ 230	■ 0.14	■ 2.5	■ 135	■ 0.13	■ 2.5	■ 215	■ 0.14	■ 2.5	■ -	■ -	■ -	■ 55	■ 0.10	■ 2.0	■ -	■ -	■ -
SOMT 09T304-P:M9325	● 0.4	■ 320	■ 0.14	■ 2.5	■ -	■ -	■ -	■ 300	■ 0.14	■ 2.5	■ -	■ -	■ -	■ -	■ -	■ -	■ -	■ -	■ -



a_e / DC	5 %	10 %	15 %	20 %	25 %	30 %	40 %	50 %	60 %	70 %	75 %	80 %	90 %	100 %
	1.48	1.35	1.27	1.22	1.19	1.16	1.11	1.08	1.05	1.03	1.00	1.00	1.00	1.00
	2.20	1.60	1.35	1.20	1.10	0.95	0.85	0.75	0.85	0.95	1.00	1.00	1.00	1.00
	0.64	0.64	0.64	0.64	0.64	0.65	0.65	0.67	0.68	0.71	0.72	0.74	0.79	1.00

	SOMT 09-M	SOMT 09-MI	SOMT 09-P
	0.8	0.4	0.4
	0.90	1.30	1.30



6.0

	1.0	4.0	8.0
	0.28	0.19	0.09

SSD12

P M K N S

PRAMET

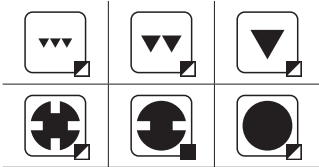
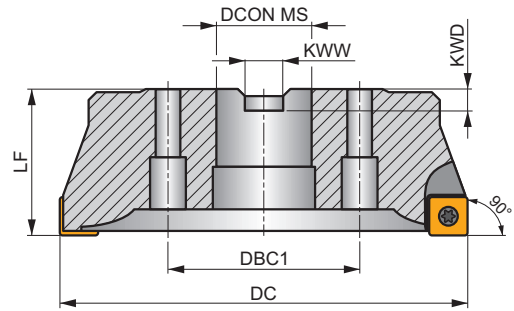
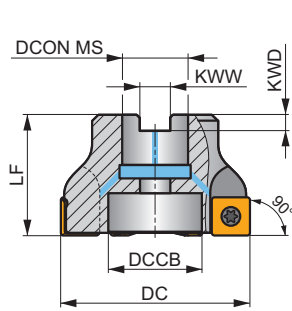
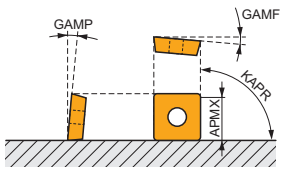
S



90° hörnfräs för SDMT 12-skär, med invändig kylning

90° hörnfräs för positiva SDMT 12-skär med APMX 10 mm. Passar för en rad olika applikationer, t ex plan-hörn- och spårfräsning. Finns med dornfäste. Behandlad för lång livslängd.

KAPR	90°
APMX	10.0 mm



0.09 - 0.25



Product	DC (mm)	LF (mm)	DCON MS (mm)	DCCB (mm)	DBC1 (mm)	KWW (mm)	KWD (mm)	GAMP (°)	GAMP (°)								
50A05R-S90SD12-C	50	40	22	18	-	10.4	6.3	-5	8	5	-	13000	✓	0.34	GI057	SQ413	-
63A06R-S90SD12-C	63	40	22	18	-	10.4	6.3	-5	8	6	-	11600	✓	0.53	GI057	SQ413	-
80A06R-S90SD12-C	80	50	27	38	-	12.4	7	-5	8	6	-	10300	✓	1.16	GI057	SQ411	AC001
100A08R-S90SD12-C	100	50	32	45	-	14.4	8	-5	8	8	-	9200	✓	1.69	GI057	SQ411	AC002
125A09R-S90SD12-C	125	63	40	56	-	16.4	9	-5	8	9	-	8300	✓	3.19	GI057	SQ411	AC003
160C12R-S90SD12	160	63	40	-	66.7	16.4	9	-5	8	12	-	7300	-	5.70	GI057	SQ411	-

	GI057		SDMT 1205..
--	-------	--	-------------

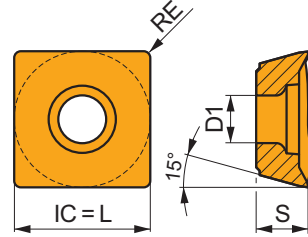
SQ411	SSN 100312	MS 3510	HXK 3.5	US 3511-T15	3.0	M 3.5	11	D-T07/T15	FG-15	-
SQ413	-	-	-	US 3511-T15	3.0	M 3.5	11	D-T07/T15	FG-15	HS 1030C

AC001	KS 1230	K.FMH27
AC002	KS 1635	K.FMH32
AC003	KS 2040	K.FMH40

SDMT 12

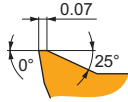


	IC	D1	L	S
	(mm)	(mm)	(mm)	(mm)
1205	12.700	4.40	12.70	5.00



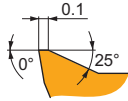
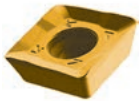
Lämplighet och startvärden för skärhastighet (vc), matning (f) och skärdjup (ap). Vi refererar till vår Dormer Pramet Calculator-app för vidare beräkningar.

Product	RE (mm)	P			M			K			N			S			H		
		vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)



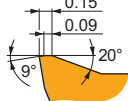
F geometri med positiv design för fin till medelfin fräsning.

SDMT 120508SR-F-M8330	0.8	275	0.10	3.0	165	0.09	3.0	260	0.10	3.0	825	0.12	3.0	65	0.08	2.4	-	-	-
SDMT 120508SR-F-M8340	0.8	250	0.10	3.0	150	0.09	3.0	235	0.10	3.0	-	-	-	60	0.08	2.4	-	-	-



M geometri med positiv design för fin till medelfin fräsning.

SDMT 120508SR-M-M8215	0.8	245	0.16	3.5	145	0.14	3.5	230	0.16	3.5	-	-	-	60	0.11	2.8	-	-	-
SDMT 120508SR-M-M8330	0.8	240	0.16	3.5	140	0.14	3.5	225	0.16	3.5	-	-	-	60	0.11	2.8	-	-	-
SDMT 120508SR-M-M8340	0.8	220	0.16	3.5	130	0.14	3.5	205	0.16	3.5	-	-	-	55	0.11	2.8	-	-	-
SDMT 120508SR-M-M9325	0.8	305	0.16	3.5	-	-	-	285	0.16	3.5	-	-	-	-	-	-	-	-	-



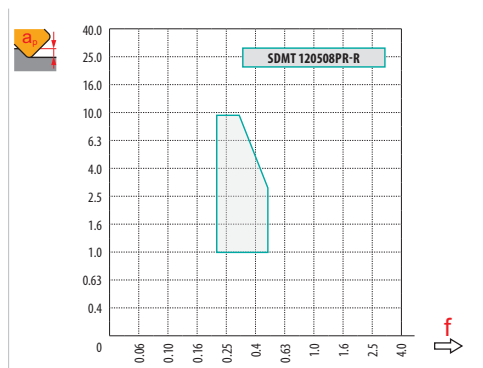
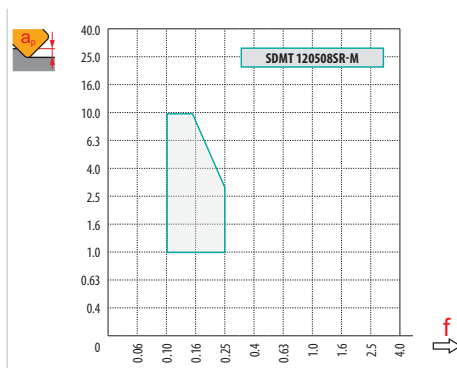
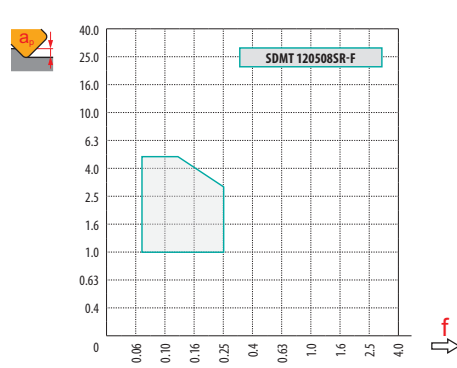
R geometri med positiv, stabil design för medelgrov fräsning.

SDMT 120508PR-R-M8330	0.8	220	0.25	3.5	130	0.23	3.5	205	0.25	3.5	-	-	-	55	0.23	2.8	-	-	-
SDMT 120508PR-R-M8340	0.8	195	0.25	3.5	115	0.23	3.5	185	0.25	3.5	-	-	-	45	0.23	2.8	-	-	-
SDMT 120508PR-R-M9315	0.8	280	0.25	3.5	-	-	-	265	0.25	3.5	-	-	-	-	-	-	-	-	-
SDMT 120508PR-R-M9325	0.8	265	0.25	3.5	-	-	-	250	0.25	3.5	-	-	-	-	-	-	-	-	-



a_e / DC	5 %	10 %	15 %	20 %	25 %	30 %	40 %	50 %	60 %	70 %	75 %	80 %	90 %	100 %
	1.48	1.35	1.27	1.22	1.19	1.16	1.11	1.08	1.05	1.03	1.00	1.00	1.00	1.00
	2.20	1.60	1.35	1.20	1.10	0.95	0.85	0.75	0.85	0.95	1.00	1.00	1.00	1.00
	0.64	0.64	0.64	0.64	0.64	0.65	0.65	0.67	0.68	0.71	0.72	0.74	0.79	1.00

	SDMT 12-F	SDMT 12-M	SDMT 12-R
	0.8	0.8	0.8
	—	—	—



8.0

	1.0	5.0	10.0
	0.39	0.25	0.14

FTB27X



PRAMET

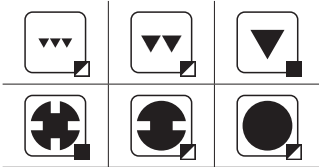
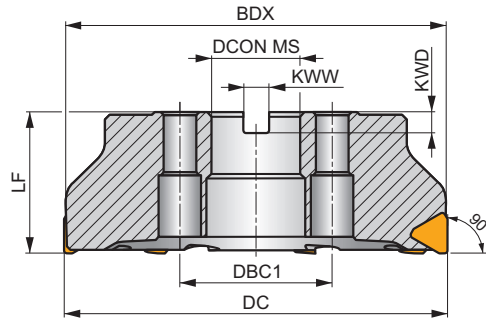
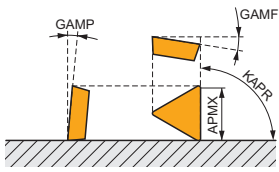


ROUGH TB planfräs för TBMR 27-skär för grovfräsning

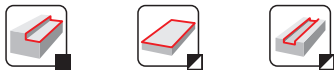
90° hörnfräs för positiva TBMR 27-skär med APMX 18 mm. Passar för grov plan-, hörn- och spårfräsning, med differentiell tanddelning. Behandlad för lång livslängd.

ROUGH TB

KAPR	90°
APMX	18.0 mm



0.15 - 0.38



Product	DC	BDX	LF	D CON MS	DCCB	DBC1	KWW	KWD	GAMF	GAMP									
	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(°)	(°)									
175C08R-F90TB27X	175	169.6	63	40	-	66.7	16.4	16.4	-9	9	8	✓	-	-	7.59	G163	SQ424	-	-
260C12R-F90TB27X	260	253.4	63	60	-	101.6	25.7	25.7	-9	9	12	✓	-	-	18.21	G163	SQ425	-	-

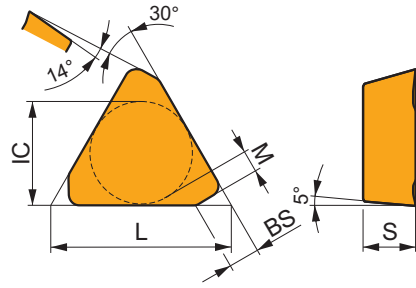
G163	TBMR 2707PZ..																		

SQ424	LNK 220616	US 6013-T20P	SDR T20P-T	KU TBMR 2707	DS 01Z	KL 04	HS 1240
SQ425	LNK 220616	US 6013-T20P	SDR T20P-T	KU TBMR 2707	DS 01Z	KL 04	HS 1655

TBMR 27

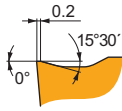


	BS	IC	L	M	S
	(mm)	(mm)	(mm)	(mm)	(mm)
2707	4.61	15.875	27.50	3.2	7.94



Lämplighet och startvärden för skärhastighet (vc), matning (f) och skärdjup (ap). Vi refererar till vår Dormer Pramet Calculator-app för vidare beräkningar.

Product	RE (mm)	P			M			K			N			S			H		
		vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)



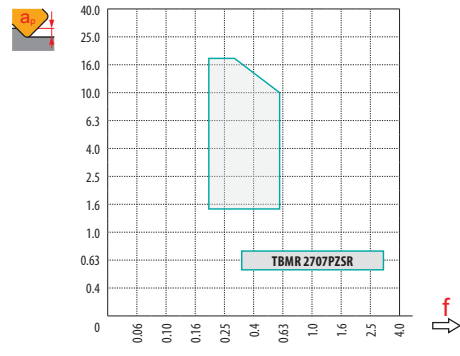
PZSR stark design för grovfräsning.

TBMR 2707PZSR:M8326	☺	–	☑	130	0.20	11.0	–	–	–	☑	120	0.20	11.0	–	–	–	–	–	–
TBMR 2707PZSR:M8346	☺	–	☑	110	0.20	11.0	☑	65	0.20	11.0	–	–	–	–	–	–	–	–	–



a_e / DC	5 %	10 %	15 %	20 %	25 %	30 %	40 %	50 %	60 %	70 %	75 %	80 %	90 %	100 %
	1.48	1.35	1.27	1.22	1.19	1.16	1.11	1.08	1.05	1.03	1.00	1.00	1.00	1.00
	2.20	1.60	1.35	1.20	1.10	0.95	0.85	0.75	0.85	0.95	1.00	1.00	1.00	1.00
	0.64	0.64	0.64	0.64	0.64	0.65	0.65	0.67	0.68	0.71	0.72	0.74	0.79	1.00

	TBMR 27
	-
	2.70






















	1.5	8.0	18.0
	0.60	0.39	0.24



FRÄSNING AV HÖGA KANTER

INDEXABLE FACE MILLS – NAVIGATOR

FACE MILLING

	J(T)-SAD11E	J(T)-SAD16E	J(T)-SSAP	J(T)-CSD12X	J(T)-SLSN	
	90°		90°		90°	
	APMX (mm) 37.0 – 56.0	APMX (mm) 40.0 – 108.0	APMX (mm) 58.0 – 95.0	APMX (mm) 44.1 – 87.3	APMX (mm) 104.0 – 134.0	
	DC (mm) 25 – 50	DC (mm) 50 – 100	DC (mm) 50 – 80	DC (mm) 40 – 80	DC (mm) 63, 80	
Cylindrical shank	 DC = 25 – 40 (mm)					
Weldon	 DC = 25 – 40 (mm)			 DC = 50 (mm)		
Modular		 DC = 50 – 80 (mm)		 DC = 40 – 63 (mm)		
Shell mill	 DC = 50 (mm)	 DC = 50 – 100 (mm)		 DC = 50 – 80 (mm)		
Page	134	139	145	150	153	
ISO	P M K N S H	P M K N S H	P M K N S H	P M S	P K	
Insert shape						
Inserts	AD 11T3	AD.. 1606	APE. 150412 SPE. 1204	SD.X 1205	LNET 1606 SN.. 1305	
No. of cutting edges	2	2	2 / 4	4	2 / 8	
Hörnfräsning, hög kant 	■	■	■	■	■	
Djup spårfräsning 	■	■	■	■	■	
Planfräsning 	▣	▣	▣	▣	▣	
Dykfräsning 	▣	▣	▣		▣	

J(T)-SAD11E



PRAMET

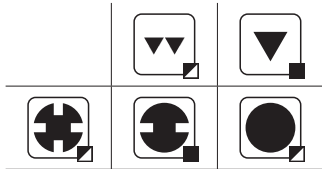
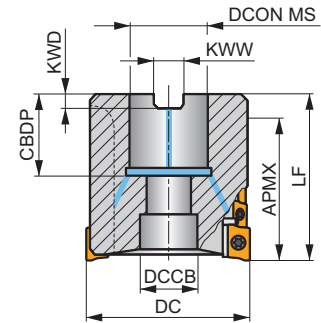
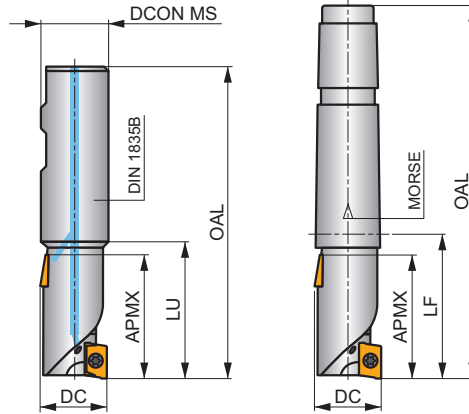
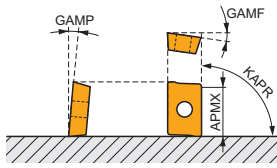


HELICAL AD11 lång fräs med invändig kylning

90° lång hörnfräs för ADMX 11-skär med APMX 36 till 56 mm. Invändig kylning. Passar för en rad olika applikationer, bl a hörn-, plan-, spår- och dykfräsning. Finns med Weldon-skaft, morse-kona och för dornmontering. Behandlad för lång livslängd.

FORCE AD

KAPR	90°
APMX	37.0 - 56.0 mm



	0.05 - 0.08				
	0.05 - 0.08				

Product	DC	OAL	DCON MS	DCCB	LU	LF	APMX	CBDBP	CZC MS	GAMF	GAMP	NOF							
	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)		(°)	(°)								
25J2R50B25-SAD11E38-C	25	106	25	-	50	-	38.00	-	-	-10.5	5	2	8	-	24100	✓	0.32	G1184	SQ210
32J2R60B32-SAD11E47-C	32	120	32	-	60	-	47.00	-	-	-9	8	2	10	-	21300	✓	0.60	G1184	SQ210
40J2R60B40-SAD11E47-C	40	130	40	-	60	-	47.00	-	-	-8.1	11	2	10	-	19100	✓	1.07	G1184	SQ210
40J3R70B32-SAD11E56-C	40	130	32	-	70	-	56.00	-	-	-8.1	11	3	18	-	19100	✓	0.76	G1184	SQ210
40J3R70B40-SAD11E56-C	40	140	40	-	70	-	56.00	-	-	-8.1	11	3	18	-	19100	✓	1.07	G1184	SQ210
25J2R55E03-SAD11E38-C	25	136	-	-	-	55	38.00	-	3	-10.5	5	2	8	-	24100	✓	0.32	G1184	SQ210
32J2R65E04-SAD11E47-C	32	167.5	-	-	-	65	47.00	-	4	-9	8	2	10	-	21300	✓	0.71	G1184	SQ210
40J3R75E04-SAD11E56-C	40	177.5	-	-	-	75	56.00	-	4	-8.1	11	3	18	-	19100	✓	0.85	G1184	SQ210
50T03R-S90AD11E37-C	50	-	22	18	-	58	37.00	21	-	-7.2	12	3	12	-	17000	✓	0.66	G1184	SQ903

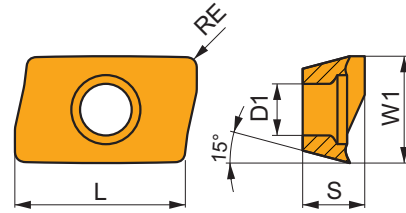
G1184	ADMX 11T3..	ADEX 11T3..-FA

SQ210	US 2506-T07P	1.2	M 2.5	6.3	-	-	Flag T07P	-
SQ903	US 2506-T07P	1.2	M 2.5	6.3	D-T07P/T09P	FG-15	-	HS 1030C

ADMX 11

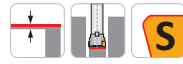
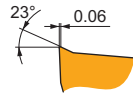
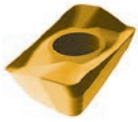


	W1 (mm)	D1 (mm)	L (mm)	S (mm)
11T3	6.530	2.90	11.00	3.97



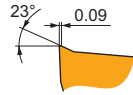
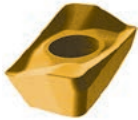
Lämplighet och startvärden för skärhastighet (vc), matning (f) och skärdjup (ap). Vi refererar till vår Dormer Pramet Calculator-app för vidare beräkningar.

Product	RE (mm)	P			M			K			N			S			H		
		vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)



F geometri med mycket vass positiv design för finfräsning.

ADMX 11T304SR-F:8215	● 0.4	245	0.10	2.0	145	0.09	2.0	230	0.10	2.0	735	0.12	2.0	60	0.08	1.6	-	-	-
ADMX 11T304SR-F:M8330	● 0.4	240	0.10	2.0	140	0.09	2.0	225	0.10	2.0	720	0.12	2.0	60	0.08	1.6	-	-	-
ADMX 11T304SR-F:M8340	● 0.4	220	0.10	2.0	130	0.09	2.0	205	0.10	2.0	-	-	-	55	0.08	1.6	-	-	-
ADMX 11T304SR-F:M9340	● 0.4	285	0.10	2.0	170	0.09	2.0	-	-	-	-	-	70	0.08	1.6	-	-	-	
ADMX 11T308SR-F:8215	⊕ 0.8	290	0.10	2.0	170	0.09	2.0	275	0.10	2.0	870	0.12	2.0	70	0.08	1.6	-	-	-
ADMX 11T308SR-F:M8330	⊕ 0.8	285	0.10	2.0	170	0.09	2.0	270	0.10	2.0	855	0.12	2.0	70	0.08	1.6	-	-	-
ADMX 11T308SR-F:M8340	⊕ 0.8	260	0.10	2.0	155	0.09	2.0	245	0.10	2.0	-	-	-	65	0.08	1.6	-	-	-
ADMX 11T308SR-F:M9340	⊕ 0.8	340	0.10	2.0	200	0.09	2.0	-	-	-	-	-	85	0.08	1.6	-	-	-	

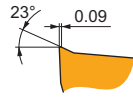
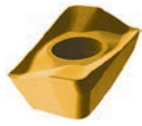


M geometri med positiv design för fin till medelfin fräsning.

ADMX 11T302SR-M:M8330	● 0.2	190	0.15	4.0	110	0.14	4.0	180	0.15	4.0	-	-	-	45	0.12	3.2	-	-	-
ADMX 11T302SR-M:M8340	⊕ 0.2	170	0.15	4.0	100	0.14	4.0	160	0.15	4.0	-	-	-	40	0.12	3.2	-	-	-
ADMX 11T304SR-M:8215	● 0.4	205	0.15	4.0	120	0.14	4.0	190	0.15	4.0	-	-	-	50	0.12	3.2	-	-	-
ADMX 11T304SR-M:M8310	● 0.4	220	0.15	4.0	110	0.14	4.0	205	0.15	4.0	-	-	-	-	-	-	-	-	-
ADMX 11T304SR-M:M8330	⊕ 0.4	205	0.15	4.0	120	0.14	4.0	190	0.15	4.0	-	-	-	50	0.12	3.2	-	-	-
ADMX 11T304SR-M:M8340	⊕ 0.4	185	0.15	4.0	110	0.14	4.0	175	0.15	4.0	-	-	-	45	0.12	3.2	-	-	-
ADMX 11T304SR-M:M9325	● 0.4	255	0.15	4.0	-	-	-	240	0.15	4.0	-	-	-	-	-	-	-	-	-
ADMX 11T304SR-M:M9340	● 0.4	235	0.15	4.0	140	0.14	4.0	-	-	-	-	-	55	0.12	3.2	-	-	-	
ADMX 11T308SR-M:8215	⊕ 0.8	245	0.15	4.0	145	0.14	4.0	230	0.15	4.0	-	-	-	60	0.12	3.2	-	-	-
ADMX 11T308SR-M:M5315	⊕ 0.8	335	0.15	4.0	-	-	-	315	0.15	4.0	-	-	-	-	-	-	-	-	-
ADMX 11T308SR-M:M8310	⊕ 0.8	265	0.15	4.0	135	0.14	4.0	250	0.15	4.0	-	-	-	-	-	-	-	-	-
ADMX 11T308SR-M:M8330	⊕ 0.8	245	0.15	4.0	145	0.14	4.0	230	0.15	4.0	-	-	-	60	0.12	3.2	-	-	-
ADMX 11T308SR-M:M8340	⊕ 0.8	220	0.15	4.0	130	0.14	4.0	205	0.15	4.0	-	-	-	55	0.12	3.2	-	-	-
ADMX 11T308SR-M:M9315	⊕ 0.8	330	0.15	4.0	-	-	-	310	0.15	4.0	-	-	-	-	-	-	-	-	-
ADMX 11T308SR-M:M9325	⊕ 0.8	305	0.15	4.0	-	-	-	285	0.15	4.0	-	-	-	-	-	-	-	-	-
ADMX 11T308SR-M:M9340	⊕ 0.8	275	0.15	4.0	165	0.14	4.0	-	-	-	-	-	65	0.12	3.2	-	-	-	
ADMX 11T310SR-M:M8330	⊕ 1.0	255	0.15	4.0	150	0.14	4.0	240	0.15	4.0	-	-	-	60	0.12	3.2	-	-	-
ADMX 11T310SR-M:M8340	⊕ 1.0	230	0.15	4.0	135	0.14	4.0	215	0.15	4.0	-	-	-	55	0.12	3.2	-	-	-
ADMX 11T312SR-M:8215	⊕ 1.2	255	0.15	4.0	150	0.14	4.0	240	0.15	4.0	-	-	-	60	0.12	3.2	-	-	-
ADMX 11T312SR-M:M8330	⊕ 1.2	255	0.15	4.0	150	0.14	4.0	240	0.15	4.0	-	-	-	60	0.12	3.2	-	-	-
ADMX 11T312SR-M:M8340	⊕ 1.2	230	0.15	4.0	135	0.14	4.0	215	0.15	4.0	-	-	-	55	0.12	3.2	-	-	-
ADMX 11T316SR-M:8215	⊕ 1.6	270	0.15	4.0	160	0.14	4.0	255	0.15	4.0	-	-	-	65	0.12	3.2	-	-	-
ADMX 11T316SR-M:M6330	⊕ 1.6	230	0.15	4.0	165	0.14	4.0	-	-	-	-	-	65	0.12	3.2	-	-	-	
ADMX 11T316SR-M:M8310	⊕ 1.6	295	0.15	4.0	150	0.14	4.0	280	0.15	4.0	-	-	-	-	-	-	-	-	-
ADMX 11T316SR-M:M8330	⊕ 1.6	270	0.15	4.0	160	0.14	4.0	255	0.15	4.0	-	-	-	65	0.12	3.2	-	-	-
ADMX 11T316SR-M:M8340	⊕ 1.6	240	0.15	4.0	140	0.14	4.0	225	0.15	4.0	-	-	-	60	0.12	3.2	-	-	-
ADMX 11T320SR-M:M6330	⊕ 2.0	240	0.15	4.0	170	0.14	4.0	-	-	-	-	-	70	0.12	3.2	-	-	-	
ADMX 11T320SR-M:M8330	⊕ 2.0	280	0.15	4.0	165	0.14	4.0	265	0.15	4.0	-	-	-	70	0.12	3.2	-	-	-
ADMX 11T320SR-M:M8340	⊕ 2.0	255	0.15	4.0	150	0.14	4.0	240	0.15	4.0	-	-	-	60	0.12	3.2	-	-	-

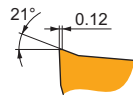
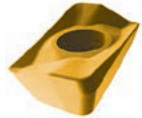
Lämplighet och startvärden för skärhastighet (vc), matning (f) och skärdjup (ap). Vi refererar till vår Dormer Pramet Calculator-app för vidare beräkningar.

Product	RE (mm)	P			M			K			N			S			H		
		vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)



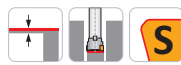
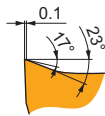
M geometri med positiv design för fin till medelfin fräsning.

ADMX 11T325SR-M:M6330	2.5	240	0.15	4.0	170	0.14	4.0	–	–	–	–	–	–	70	0.12	3.2	–	–	–
ADMX 11T325SR-M:M8340	2.5	255	0.15	4.0	150	0.14	4.0	240	0.15	4.0	–	–	–	60	0.12	3.2	–	–	–
ADMX 11T330SR-M:M6330	3.0	240	0.15	4.0	170	0.14	4.0	–	–	–	–	–	–	70	0.12	3.2	–	–	–
ADMX 11T330SR-M:M8330	3.0	280	0.15	4.0	165	0.14	4.0	265	0.15	4.0	–	–	–	70	0.12	3.2	–	–	–
ADMX 11T330SR-M:M8340	3.0	255	0.15	4.0	150	0.14	4.0	240	0.15	4.0	–	–	–	60	0.12	3.2	–	–	–



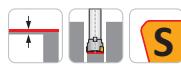
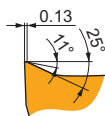
R geometri med positiv design för fräsning vid mindre stabila förhållanden.

ADMX 11T308PR-R:R215	0.8	230	0.18	4.0	135	0.16	4.0	215	0.18	4.0	–	–	–	55	0.16	3.2	45	0.12	0.7
ADMX 11T308PR-R:M5315	0.8	310	0.18	4.0	–	–	–	290	0.18	4.0	–	–	–	–	–	–	60	0.13	0.7
ADMX 11T308PR-R:M8310	0.8	250	0.18	4.0	125	0.16	4.0	235	0.18	4.0	–	–	–	–	–	–	50	0.12	0.7
ADMX 11T308PR-R:M8330	0.8	230	0.18	4.0	135	0.16	4.0	215	0.18	4.0	–	–	–	55	0.16	3.2	45	0.12	0.7
ADMX 11T308PR-R:M8340	0.8	210	0.18	4.0	125	0.16	4.0	195	0.18	4.0	–	–	–	50	0.16	3.2	–	–	–
ADMX 11T308PR-R:M9315	0.8	310	0.18	4.0	–	–	–	290	0.18	4.0	–	–	–	–	–	–	60	0.13	0.7
ADMX 11T308PR-R:M9325	0.8	290	0.18	4.0	–	–	–	275	0.18	4.0	–	–	–	–	–	–	55	0.13	0.7
ADMX 11T316PR-R:R215	1.6	255	0.18	4.0	150	0.16	4.0	240	0.18	4.0	–	–	–	60	0.16	3.2	50	0.12	0.7
ADMX 11T316PR-R:M8330	1.6	255	0.18	4.0	150	0.16	4.0	240	0.18	4.0	–	–	–	60	0.16	3.2	50	0.12	0.7
ADMX 11T316PR-R:M9325	1.6	320	0.18	4.0	–	–	–	300	0.18	4.0	–	–	–	–	–	–	60	0.12	0.7



MF geometri med mycket positiv design för finfräsning.

ADMX 11T304SR-MF:M6330	0.4	215	0.08	2.5	150	0.07	2.5	–	–	–	–	–	–	60	0.06	2.0	–	–	–
ADMX 11T304SR-MF:M8340	0.4	220	0.08	2.5	130	0.07	2.5	–	–	–	–	–	–	55	0.06	2.0	–	–	–
ADMX 11T308SR-MF:M6330	0.8	255	0.08	2.5	180	0.07	2.5	–	–	–	–	–	–	75	0.06	2.0	–	–	–
ADMX 11T308SR-MF:M8340	0.8	265	0.08	2.5	155	0.07	2.5	–	–	–	–	–	–	65	0.06	2.0	–	–	–



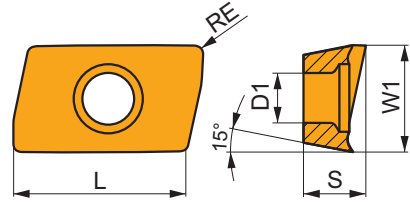
MM geometri med mycket positiv design för fin till medelfin fräsning.

ADMX 11T304SR-MM:M6330	0.4	185	0.14	2.5	130	0.13	2.5	–	–	–	–	–	–	55	0.11	2.0	–	–	–
ADMX 11T304SR-MM:M8340	0.4	195	0.14	2.5	115	0.13	2.5	–	–	–	–	–	–	45	0.11	2.0	–	–	–
ADMX 11T308SR-MM:M6330	0.8	225	0.14	2.5	155	0.13	2.5	–	–	–	–	–	–	65	0.11	2.0	–	–	–
ADMX 11T308SR-MM:M8340	0.8	235	0.14	2.5	140	0.13	2.5	–	–	–	–	–	–	55	0.11	2.0	–	–	–
ADMX 11T308SR-MM:M8345	0.8	190	0.14	2.5	110	0.13	2.5	–	–	–	–	–	–	45	0.11	2.0	–	–	–
ADMX 11T308SR-MM:M9340	0.8	300	0.14	2.5	180	0.13	2.5	–	–	–	–	–	–	75	0.11	2.0	–	–	–
ADMX 11T312SR-MM:M6330	1.2	235	0.14	2.5	165	0.13	2.5	–	–	–	–	–	–	70	0.11	2.0	–	–	–
ADMX 11T312SR-MM:M8340	1.2	245	0.14	2.5	145	0.13	2.5	–	–	–	–	–	–	60	0.11	2.0	–	–	–

ADEX 11-FA

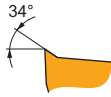


	W1 (mm)	D1 (mm)	L (mm)	S (mm)
11T3	6.450	2.90	9.70	3.91



Lämplighet och startvärden för skärhastighet (vc), matning (f) och skärdjup (ap). Vi refererar till vår Dormer Pramet Calculator-app för vidare beräkningar.

Product	RE (mm)	P			M			K			N			S			H		
		vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)



FA geometri med mycket positiv design för fin till medelfin fräsning.

ADEX 11T304FR-FA:HF7	● 0.4	—	—	—	—	—	—	—	—	—	■ 210	0.30	5.0	—	—	—	—	—	—
ADEX 11T304FR-FA:M0315	● 0.4	—	—	—	—	—	—	—	—	—	■ 480	0.30	5.0	—	—	—	—	—	—
ADEX 11T308FR-FA:HF7	● 0.8	—	—	—	—	—	—	—	—	—	■ 240	0.30	5.0	—	—	—	—	—	—
ADEX 11T308FR-FA:M0315	● 0.8	—	—	—	—	—	—	—	—	—	■ 570	0.30	5.0	—	—	—	—	—	—
ADEX 11T312FR-FA:HF7	● 1.2	—	—	—	—	—	—	—	—	—	■ 255	0.30	5.0	—	—	—	—	—	—
ADEX 11T316FR-FA:HF7	● 1.6	—	—	—	—	—	—	—	—	—	■ 270	0.18	5.0	—	—	—	—	—	—



a_e / DC	5 %	10 %	15 %	20 %	25 %	30 %	40 %	50 %	60 %	70 %	75 %	80 %	90 %	100 %
	0.89	0.81	0.76	0.73	0.71	0.70	0.67	0.65	0.63	0.62	0.60	0.60	0.60	0.45



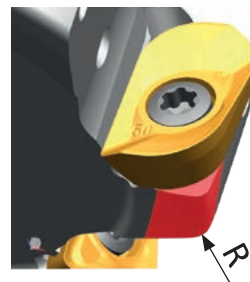
	1		2.5		5		7.5		10		15		20	
	f_{min}	f_{max}	f_{min}	f_{max}	f_{min}	f_{max}	f_{min}	f_{max}	f_{min}	f_{max}	f_{min}	f_{max}	f_{min}	f_{max}
25	0.25	0.40	0.16	0.26	0.12	0.19	0.10	0.15	0.09	0.14	0.07	0.12	0.07	0.11
32	0.28	0.45	0.18	0.29	0.13	0.21	0.11	0.17	0.09	0.15	0.08	0.13	0.07	0.12
40	0.32	0.51	0.20	0.32	0.14	0.23	0.12	0.19	0.10	0.17	0.09	0.14	0.08	0.13
50	0.35	0.57	0.23	0.36	0.16	0.26	0.13	0.21	0.12	0.19	0.10	0.15	0.09	0.14

	25		32		40		50	
	f_{min}	f_{max}	f_{min}	f_{max}	f_{min}	f_{max}	f_{min}	f_{max}
25	0.08	0.13	-	-	-	-	-	-
32	0.07	0.11	0.08	0.13	-	-	-	-
40	0.07	0.12	0.07	0.11	0.08	0.13	-	-
50	0.08	0.13	0.07	0.12	0.07	0.11	0.08	0.13

	ADMX 11-F		ADMX 11-M						ADMX 11-R		ADMX 11-MF		ADMX 11-MM			ADEX 11-FA						
	0.4	0.8	0.2	0.4	0.8	1.0	1.2	1.6	2.0	2.5	3.0	0.8	1.6	0.4	0.8	0.4	0.8	1.2	0.4	0.8	1.2	1.6
	1.89	1.48	2.09	1.89	1.48	1.27	1.08	0.68	1.61	1.13	0.66	1.48	0.68	1.89	1.48	1.89	1.48	1.08	1.77	1.39	1.0	0.62



ISO				
25J2R50B25-SAD11E38-C	25	2	38	34.5
32J2R60B32-SAD11E47-C	32	2	47	43.5
40J2R60B40-SAD11E47-C	40	2	47	43.5
40J3R70B32-SAD11E56-C	40	3	56	52.5
40J3R70B40-SAD11E56-C	40	3	56	52.5
25J2R55E03-SAD11E38-C	25	2	38	34.5
32J2R65E04-SAD11E47-C	32	2	47	43.5
40J3R75E04-SAD11E56-C	40	3	56	52.5
50T03R-S90AD11E37-C	50	3	37	33.5



ADMX/ADEX 11	R
ADMX 11T320SR-M	1.0
ADMX 11T325SR-M	1.8
ADMX 11T330SR-M	1.8



	4.5
--	-----

J(T)-SAD16E



PRAMET

S

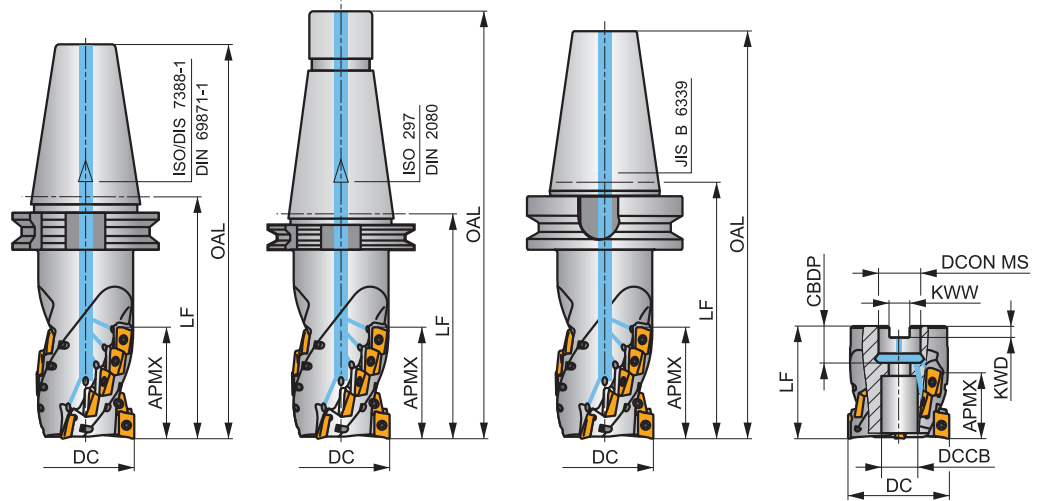
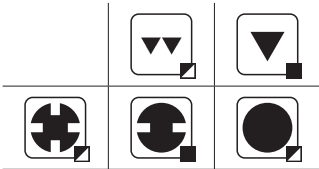
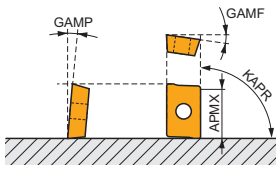


HELICAL AD16 lång fräs med invändig kylning

90° lång hörnfräs för AD.. 16-skär med APMX 40 till 108 mm. Invändig kylning. Passar för en rad olika applikationer, bl a hörn-, plan-, spår- och dykfräsning. Finns med DIN 69871-, BT- och DIN 2080-fäste. Behandlad för lång livslängd.

FORCE AD

KAPR	90°
APMX	40.0 - 108.0 mm



	0.08 - 0.1
	0.08 - 0.1



Product	DC	OAL	DCON MS	DCCB	LF	APMX	CBDP	CZC MS	GAMP	GAMP	NOF	1	2	3	4	5	max.	kg	GI282	SQ031
	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(°)	(°)										
50J3R100H50-SAD16E54-C	50	202	-	-	100	54.00	-	50	-6	12	3	12	-	13200	✓	4.08	GI282	SQ031		
50J3R140H50-SAD16E80-C	50	242	-	-	140	80.00	-	50	-6	12	3	18	-	13200	✓	4.38	GI282	SQ031		
63J3R140H50-SAD16E68-C	63	242	-	-	140	68.00	-	50	-6	12	3	15	-	11700	✓	5.34	GI282	SQ031		
63J3R155H50-SAD16E95-C	63	257	-	-	155	95.00	-	50	-6	12	3	21	-	11700	✓	5.43	GI282	SQ031		
80J4R165H50-SAD16E108-C	80	257	-	-	165	108.00	-	50	-6	12	4	32	✓	10400	✓	7.37	GI282	SQ031		
50J3R140G50-SAD16E80-C	50	267	-	-	140	80.00	-	50	-6	12	3	18	-	13200	✓	4.48	GI282	SQ031		
63J3R155G50-SAD16E95-C	63	282	-	-	155	95.00	-	50	-6	12	3	21	-	11700	✓	5.52	GI282	SQ031		
80J4R165G50-SAD16E108-C	80	292	-	-	165	108.00	-	50	-6	12	4	32	✓	10400	✓	7.51	GI282	SQ031		
50J3R140X50-SAD16E68-C	50	242	-	-	140	68.00	-	50	-6	12	3	15	-	13200	✓	5.28	GI282	SQ031		
63J3R155X50-SAD16E80-C	63	257	-	-	155	80.00	-	50	-6	12	3	18	-	11700	✓	6.19	GI282	SQ031		
80J4R165X50-SAD16E95-C	80	267	-	-	165	95.00	-	50	-6	12	4	28	✓	10400	✓	7.84	GI282	SQ031		
50T03R-S90AD16E40-C	50	-	22	18	70	40.00	21	-	-6	12	3	9	-	13200	✓	0.63	GI282	SQ913		
63T04R-S90AD16E40-C	63	-	27	22	70	40.00	22	-	-6	12	4	12	✓	11700	✓	1.14	GI282	SQ914		
63T04R-S90AD16E68-C	63	-	27	22	100	68.00	22	-	-6	12	4	20	✓	11700	✓	1.86	GI282	SQ914		
80T04R-S90AD16E55-C	80	-	32	30	85	55.00	25	-	-6	12	4	16	✓	10400	✓	2.56	GI282	SQ915		
80T04R-S90AD16E80-C	80	-	32	30	115	80.00	25	-	-6	12	4	24	✓	10400	✓	3.17	GI282	SQ915		
100T05R-S90AD16E80-C	100	-	40	36	120	80.00	30	-	-6	12	5	30	✓	9300	✓	5.31	GI282	SQ916		

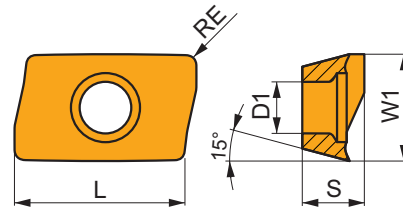
GI282	ADMX 1606..	ADEX 1606..-FA	ADEX 1606..-FM
-------	-------------	----------------	----------------

SQ031	US 4011-T15P	3.5	M 4	10.6	D-T08P/T15P	FG-15	-
SQ913	US 4011-T15P	3.5	M 4	10.6	D-T08P/T15P	FG-15	HS 1030C
SQ914	US 4011-T15P	3.5	M 4	10.6	D-T08P/T15P	FG-15	HS 1230C
SQ915	US 4011-T15P	3.5	M 4	10.6	D-T08P/T15P	FG-15	HS 1630C
SQ916	US 4011-T15P	3.5	M 4	10.6	D-T08P/T15P	FG-15	HS 2040C

ADMX 16

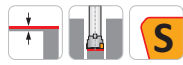
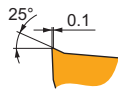
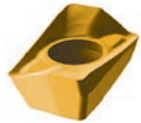


	W1	D1	L	S
	(mm)	(mm)	(mm)	(mm)
1606	9.950	4.50	16.00	6.25



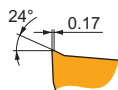
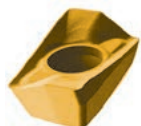
Lämplighet och startvärden för skärhastighet (vc), matning (f) och skärdjup (ap). Vi refererar till vår Dormer Pramet Calculator-app för vidare beräkningar.

Product	RE (mm)	P			M			K			N			S			H					
		vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap			
		(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)



F geometri med mycket positiv design för fin till medelfin fräsning.

ADMX 160608SR-F:8215	0.8	290	0.10	2.0	170	0.09	2.0	275	0.10	2.0	870	0.12	2.0	70	0.07	1.6	-	-	-
ADMX 160608SR-F:M8310	0.8	320	0.10	2.0	160	0.09	2.0	300	0.10	2.0	-	-	-	-	-	-	-	-	-
ADMX 160608SR-F:M8330	0.8	285	0.10	2.0	170	0.09	2.0	270	0.10	2.0	855	0.12	2.0	70	0.07	1.6	-	-	-
ADMX 160608SR-F:M8340	0.8	260	0.10	2.0	155	0.09	2.0	245	0.10	2.0	-	-	-	65	0.07	1.6	-	-	-
ADMX 160608SR-F:M9340	0.8	340	0.10	2.0	200	0.09	2.0	-	-	-	-	-	-	85	0.07	1.6	-	-	-

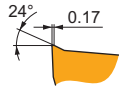
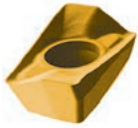


M geometri med positiv design för fin till medelfin fräsning.

ADMX 160604SR-M:8215	0.4	190	0.18	5.0	110	0.16	5.0	180	0.18	5.0	-	-	-	45	0.13	4.0	-	-	-
ADMX 160604SR-M:M8330	0.4	190	0.18	5.0	110	0.16	5.0	180	0.18	5.0	-	-	-	45	0.13	4.0	-	-	-
ADMX 160604SR-M:M8340	0.4	170	0.18	5.0	100	0.16	5.0	160	0.18	5.0	-	-	-	40	0.13	4.0	-	-	-
ADMX 160608SR-M:8215	0.8	225	0.18	5.0	135	0.16	5.0	210	0.18	5.0	-	-	-	55	0.13	4.0	-	-	-
ADMX 160608SR-M:M5315	0.8	305	0.18	5.0	-	-	-	285	0.18	5.0	-	-	-	-	-	-	-	-	-
ADMX 160608SR-M:M8310	0.8	250	0.18	5.0	125	0.16	5.0	235	0.18	5.0	-	-	-	-	-	-	-	-	-
ADMX 160608SR-M:M8330	0.8	225	0.18	5.0	135	0.16	5.0	210	0.18	5.0	-	-	-	55	0.13	4.0	-	-	-
ADMX 160608SR-M:M8340	0.8	205	0.18	5.0	120	0.16	5.0	190	0.18	5.0	-	-	-	50	0.13	4.0	-	-	-
ADMX 160608SR-M:M9315	0.8	305	0.18	5.0	-	-	-	285	0.18	5.0	-	-	-	-	-	-	-	-	-
ADMX 160608SR-M:M9325	0.8	280	0.18	5.0	-	-	-	265	0.18	5.0	-	-	-	-	-	-	-	-	-
ADMX 160608SR-M:M9340	0.8	255	0.18	5.0	150	0.16	5.0	-	-	-	-	-	-	60	0.13	4.0	-	-	-
ADMX 160616SR-M:8215	1.6	250	0.18	5.0	150	0.16	5.0	235	0.18	5.0	-	-	-	60	0.13	4.0	-	-	-
ADMX 160616SR-M:M8310	1.6	275	0.18	5.0	140	0.16	5.0	260	0.18	5.0	-	-	-	-	-	-	-	-	-
ADMX 160616SR-M:M8330	1.6	250	0.18	5.0	150	0.16	5.0	235	0.18	5.0	-	-	-	60	0.13	4.0	-	-	-
ADMX 160616SR-M:M8340	1.6	225	0.18	5.0	135	0.16	5.0	210	0.18	5.0	-	-	-	55	0.13	4.0	-	-	-
ADMX 160616SR-M:M9325	1.6	310	0.18	5.0	-	-	-	290	0.18	5.0	-	-	-	-	-	-	-	-	-
ADMX 160620SR-M:M8330	2.0	265	0.18	5.0	155	0.16	5.0	250	0.18	5.0	-	-	-	65	0.13	4.0	-	-	-
ADMX 160620SR-M:M8340	2.0	240	0.18	5.0	140	0.16	5.0	225	0.18	5.0	-	-	-	60	0.13	4.0	-	-	-
ADMX 160630SR-M:M8330	3.0	265	0.18	5.0	155	0.16	5.0	250	0.18	5.0	-	-	-	65	0.13	4.0	-	-	-
ADMX 160630SR-M:M8340	3.0	240	0.18	5.0	140	0.16	5.0	225	0.18	5.0	-	-	-	60	0.13	4.0	-	-	-
ADMX 160632SR-M:M6330	3.2	225	0.18	5.0	155	0.16	5.0	-	-	-	-	-	-	65	0.13	4.0	-	-	-
ADMX 160632SR-M:M8330	3.2	265	0.18	5.0	155	0.16	5.0	250	0.18	5.0	-	-	-	65	0.13	4.0	-	-	-

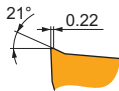
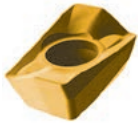
Lämplighet och startvärden för skärhastighet (vc), matning (f) och skärdjup (ap). Vi refererar till vår Dormer Pramet Calculator-app för vidare beräkningar.

Product	RE (mm)	P			M			K			N			S			H		
		vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)



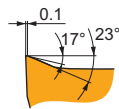
M geometri med positiv design för fin till medelfin fräsning.

ADMX 160632SR-M:M8340	3.2	240	0.18	5.0	140	0.16	5.0	225	0.18	5.0	-	-	-	60	0.13	4.0	-	-	-
ADMX 160632SR-M:M9325	3.2	325	0.18	5.0	-	-	-	305	0.18	5.0	-	-	-	-	-	-	-	-	-
ADMX 160640SR-M:M8330	4.0	265	0.18	5.0	155	0.16	5.0	250	0.18	5.0	-	-	-	65	0.13	4.0	-	-	-
ADMX 160640SR-M:M8340	4.0	240	0.18	5.0	140	0.16	5.0	225	0.18	5.0	-	-	-	60	0.13	4.0	-	-	-
ADMX 160650SR-M:M8330	5.0	265	0.18	5.0	155	0.16	5.0	250	0.18	5.0	-	-	-	65	0.13	4.0	-	-	-
ADMX 160650SR-M:M8340	5.0	240	0.18	5.0	140	0.16	5.0	225	0.18	5.0	-	-	-	60	0.13	4.0	-	-	-



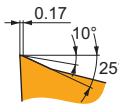
R geometri med positiv design för medelfin fräsning vid mindre stabila förhållanden.

ADMX 160608PR-R:R215	0.8	205	0.25	6.0	120	0.23	6.0	190	0.25	6.0	-	-	-	50	0.20	4.8	40	0.16	1.1
ADMX 160608PR-R:M5315	0.8	260	0.25	6.0	-	-	-	245	0.25	6.0	-	-	-	-	-	-	50	0.16	1.1
ADMX 160608PR-R:M8310	0.8	220	0.25	6.0	110	0.23	6.0	205	0.25	6.0	-	-	-	-	-	40	0.16	1.1	
ADMX 160608PR-R:M8330	0.8	205	0.25	6.0	120	0.23	6.0	190	0.25	6.0	-	-	-	50	0.20	4.8	40	0.16	1.1
ADMX 160608PR-R:M8340	0.8	190	0.25	6.0	110	0.23	6.0	180	0.25	6.0	-	-	-	45	0.20	4.8	-	-	-
ADMX 160608PR-R:M9315	0.8	265	0.25	6.0	-	-	-	250	0.25	6.0	-	-	-	-	-	-	50	0.16	1.1
ADMX 160608PR-R:M9325	0.8	250	0.25	6.0	-	-	-	235	0.25	6.0	-	-	-	-	-	-	50	0.16	1.1
ADMX 160616PR-R:M8330	1.6	225	0.25	6.0	135	0.23	6.0	210	0.25	6.0	-	-	-	55	0.20	4.8	45	0.16	1.1
ADMX 160616PR-R:M8340	1.6	210	0.25	6.0	125	0.23	6.0	195	0.25	6.0	-	-	-	50	0.20	4.8	-	-	-
ADMX 160616PR-R:M9315	1.6	295	0.25	6.0	-	-	-	280	0.25	6.0	-	-	-	-	-	-	55	0.16	1.1



MF geometri med mycket positiv design för finfräsning.

ADMX 160608SR-MF:M6330	0.8	215	0.08	4.0	150	0.07	4.0	-	-	-	-	-	-	60	0.06	3.2	-	-	-
ADMX 160608SR-MF:M8340	0.8	225	0.08	4.0	135	0.07	4.0	-	-	-	-	-	-	55	0.06	3.2	-	-	-
ADMX 160608SR-MF:M9340	0.8	305	0.08	4.0	180	0.07	4.0	-	-	-	-	-	-	75	0.06	3.2	-	-	-



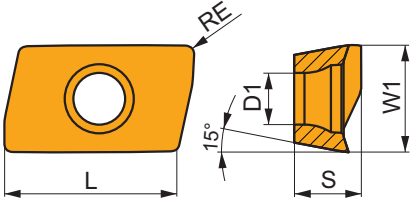
MM geometri med mycket positiv design för fin till medelfin fräsning.

ADMX 160604SR-MM:M6330	0.4	145	0.18	4.0	105	0.16	4.0	-	-	-	-	-	-	40	0.14	3.2	-	-	-
ADMX 160604SR-MM:M8340	0.4	160	0.18	4.0	95	0.16	4.0	-	-	-	-	-	-	40	0.14	3.2	-	-	-
ADMX 160608SR-MM:M6330	0.8	175	0.18	4.0	125	0.16	4.0	-	-	-	-	-	-	50	0.14	3.2	-	-	-
ADMX 160608SR-MM:M8340	0.8	190	0.18	4.0	110	0.16	4.0	-	-	-	-	-	-	45	0.14	3.2	-	-	-
ADMX 160608SR-MM:M8345	0.8	150	0.18	4.0	90	0.16	4.0	-	-	-	-	-	-	35	0.14	3.2	-	-	-
ADMX 160608SR-MM:M9340	0.8	235	0.18	4.0	140	0.16	4.0	-	-	-	-	-	-	55	0.14	3.2	-	-	-
ADMX 160616SR-MM:M6330	1.6	195	0.18	4.0	140	0.16	4.0	-	-	-	-	-	-	55	0.14	3.2	-	-	-
ADMX 160616SR-MM:M8340	1.6	210	0.18	4.0	125	0.16	4.0	-	-	-	-	-	-	50	0.14	3.2	-	-	-
ADMX 160616SR-MM:M8345	1.6	165	0.18	4.0	95	0.16	4.0	-	-	-	-	-	-	40	0.14	3.2	-	-	-
ADMX 160616SR-MM:M9340	1.6	260	0.18	4.0	155	0.16	4.0	-	-	-	-	-	-	65	0.14	3.2	-	-	-

ADEX 16

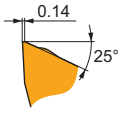


	W1 (mm)	D1 (mm)	L (mm)	S (mm)
1606	9.950	4.50	16.00	6.25



Lämplighet och startvärden för skärhastighet (vc), matning (f) och skärdjup (ap). Vi refererar till vår Dormer Pramet Calculator-app för vidare beräkningar.

Product	RE (mm)	P			M			K			N			S			H		
		vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)



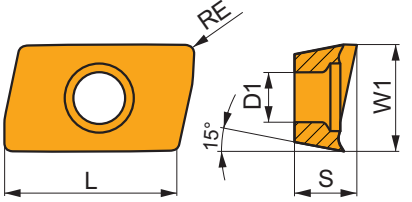
FM geometri med mycket positiv design för medelfin fräsning.

ADEX 160608SR-FM:8215	● 0.8	■ 260	■ 0.16	■ 2.0	■ 155	■ 0.14	■ 2.0	■ 245	■ 0.16	■ 2.0	■ -	■ -	■ -	■ 65	■ 0.11	■ 1.6	■ -	■ -	■ -
ADEX 160608SR-FM:M8330	● 0.8	■ 255	■ 0.16	■ 2.0	■ 150	■ 0.14	■ 2.0	■ 240	■ 0.16	■ 2.0	■ -	■ -	■ -	■ 60	■ 0.11	■ 1.6	■ -	■ -	■ -
ADEX 160608SR-FM:M8340	● 0.8	■ 235	■ 0.16	■ 2.0	■ 140	■ 0.14	■ 2.0	■ 220	■ 0.16	■ 2.0	■ -	■ -	■ -	■ 55	■ 0.11	■ 1.6	■ -	■ -	■ -

ADEX 16-FA

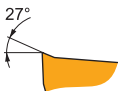


	W1 (mm)	D1 (mm)	L (mm)	S (mm)
1606	9.950	4.50	16.00	6.17



Lämplighet och startvärden för skärhastighet (vc), matning (f) och skärdjup (ap). Vi refererar till vår Dormer Pramet Calculator-app för vidare beräkningar.

Product	RE (mm)	P			M			K			N			S			H		
		vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)



FA geometri med mycket positiv design för fin till medelfin fräsning.

ADEX 160604FR-FA:HF7	● 0.4	■ -	■ -	■ -	■ -	■ -	■ -	■ -	■ -	■ -	■ 195	■ 0.28	■ 6.0	■ -	■ -	■ -	■ -	■ -	■ -
ADEX 160604FR-FA:M0315	● 0.4	■ -	■ -	■ -	■ -	■ -	■ -	■ -	■ -	■ -	■ 480	■ 0.28	■ 6.0	■ -	■ -	■ -	■ -	■ -	■ -
ADEX 160608FR-FA:HF7	● 0.8	■ -	■ -	■ -	■ -	■ -	■ -	■ -	■ -	■ -	■ 240	■ 0.28	■ 6.0	■ -	■ -	■ -	■ -	■ -	■ -
ADEX 160608FR-FA:M0315	● 0.8	■ -	■ -	■ -	■ -	■ -	■ -	■ -	■ -	■ -	■ 570	■ 0.28	■ 6.0	■ -	■ -	■ -	■ -	■ -	■ -
ADEX 160616FR-FA:HF7	● 1.6	■ -	■ -	■ -	■ -	■ -	■ -	■ -	■ -	■ -	■ 255	■ 0.28	■ 6.0	■ -	■ -	■ -	■ -	■ -	■ -
ADEX 160616FR-FA:M0315	● 1.6	■ -	■ -	■ -	■ -	■ -	■ -	■ -	■ -	■ -	■ 630	■ 0.28	■ 6.0	■ -	■ -	■ -	■ -	■ -	■ -
ADEX 160630FR-FA:HF7	● 3.0	■ -	■ -	■ -	■ -	■ -	■ -	■ -	■ -	■ -	■ 270	■ 0.28	■ 6.0	■ -	■ -	■ -	■ -	■ -	■ -



a_e / DC	5 %	10 %	15 %	20 %	25 %	30 %	40 %	50 %	60 %	70 %	75 %	80 %	90 %	100 %
	0.89	0.81	0.76	0.73	0.71	0.70	0.66	0.65	0.63	0.62	0.60	0.60	0.60	0.45



	1		2.5		5		7.5		10		15		20	
	f_{min}	f_{max}	f_{min}	f_{max}	f_{min}	f_{max}	f_{min}	f_{max}	f_{min}	f_{max}	f_{min}	f_{max}	f_{min}	f_{max}
50	0.57	0.71	0.36	0.45	0.26	0.32	0.21	0.27	0.19	0.23	0.15	0.19	0.14	0.17
63	0.64	0.80	0.40	0.51	0.29	0.36	0.24	0.30	0.21	0.26	0.17	0.21	0.15	0.19
80	0.72	0.90	0.45	0.57	0.32	0.40	0.27	0.33	0.23	0.29	0.19	0.24	0.17	0.21
100	0.80	1.00	0.51	0.64	0.36	0.45	0.30	0.37	0.26	0.32	0.21	0.27	0.19	0.23

	25		32		40		50		63		80		100	
	f_{min}	f_{max}	f_{min}	f_{max}	f_{min}	f_{max}	f_{min}	f_{max}	f_{min}	f_{max}	f_{min}	f_{max}	f_{min}	f_{max}
50	0.13	0.16	0.12	0.14	0.11	0.14	0.13	0.16	-	-	-	-	-	-
63	0.14	0.17	0.12	0.16	0.12	0.15	0.11	0.14	0.13	0.16	-	-	-	-
80	0.15	0.19	0.14	0.17	0.13	0.16	0.12	0.15	0.11	0.14	0.13	0.16	-	-
100	0.17	0.21	0.15	0.19	0.14	0.17	0.13	0.16	0.12	0.15	0.11	0.14	0.13	0.16

	ADMX 16-F	ADEX 16-FM	ADMX 16-M								ADMX 16-R	
	0.8	0.8	0.4	0.8	1.6	2.0	3.0	3.2	4.0	5.0	0.8	1.6
	2.99	2.18	3.39	2.99	1.62	1.23	0.28	0.09	2.69	1.52	2.99	1.62

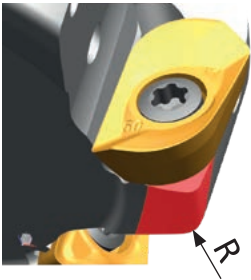
	ADMX 16-MF	ADMX 16-MM			ADEX 16-FA			
	0.8	0.4	0.8	1.6	0.4	0.8	1.6	3.0
	2.99	3.39	2.99	1.62	2.84	2.44	1.65	0.69



ISO				
50J3R100H50-SAD16E54-C	50	3	54	50.5
50J3R140H50-SAD16E80-C	50	3	80	76.5
63J3R140H50-SAD16E68-C	63	3	68	64.5
63J3R155H50-SAD16E95-C	63	3	95	91.5
80J4R165H50-SAD16E108-C	80	4	108	104.5
50J3R140G50-SAD16E80-C	50	3	80	76.5
63J3R155G50-SAD16E95-C	63	3	95	91.5
80J4R165G50-SAD16E108-C	80	4	108	104.5
50J3R140X50-SAD16E68-C	50	3	68	64.5
63J3R155X50-SAD16E80-C	63	3	80	76.5
80J4R165X50-SAD16E95-C	80	4	95	91.5
50T03R-S90AD16E40-C	50	3	40	36.5
63T04R-S90AD16E40-C	63	4	40	36.5
63T04R-S90AD16E68-C	63	4	68	64.5
80T04R-S90AD16E55-C	80	4	55	51.5
80T04R-S90AD16E80-C	80	4	80	76.5
100T05R-S90AD16E80-C	100	5	80	76.5



7.5



ADMX/ADEX 16	R
ADMX 160630SR-M	2.5
ADMX 160632SR-M	2.5
ADMX 160640SR-M	4.0
ADMX 160650SR-M	4.5

J(T)-SSAP



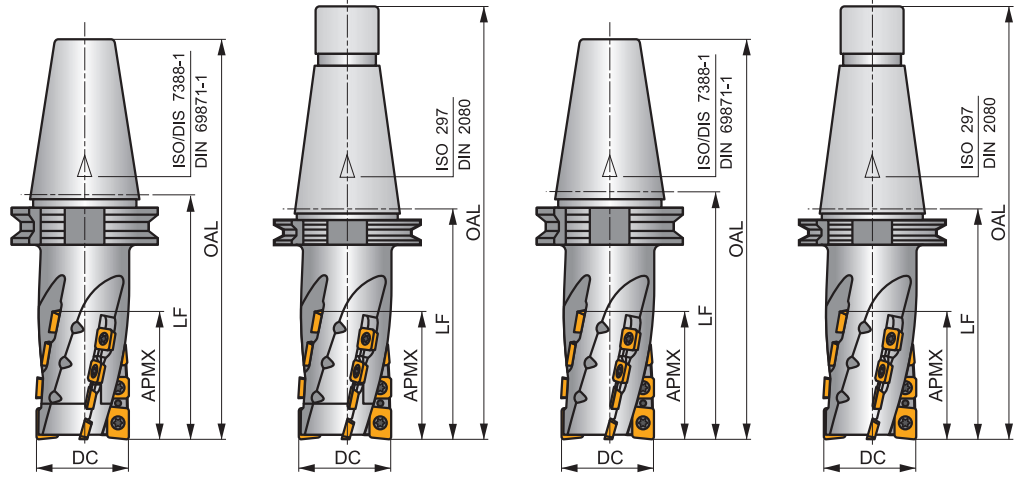
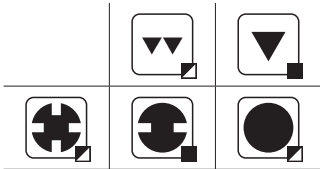
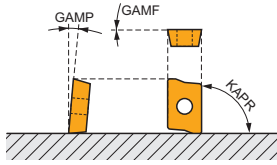
PRAMET



Fräs med lång skärkropp för AP..15- och SP..12-skär

90° lång hörnfräs för AP.. 15 och SP.. 12-skär med APMX 58 till 95 mm. Utbytbar skärkropp. Passar för en rad olika applikationer, bl a hörn-, plan-, spår- och dykfräsning. Finns med DIN 69871- och DIN 2080-fäste, kona 50. Behandlad för lång livslängd.

KAPR	90°
APMX	58.0 - 95.0 mm



h_m 0.07 - 0.1



Product	DC (mm)	OAL (mm)	APMX (mm)	LF (mm)	GAMP (°)	GAMF (°)	CZCMS	NOF	AP	SP	max.	kg	SQ941	SQ942	SQ943
50J4R128H50-SSAP55+21	50	230	76.00	128	0	7	50	4	2	16	9500	3.80	GI128	SQ942	
63J4R150H50-SSAP74+21	63	252	95.00	150	0	7	50	4	2	20	8500	4.50	GI128	SQ943	
50J4R124X50-SSAP55+21	50	251	76.00	124	0	7	50	4	2	16	9500	4.43	GI128	SQ942	
63J4R146X50-SSAP74+21	63	273	95.00	146	0	7	50	4	2	20	8500	4.75	GI128	SQ943	
63J4R150H50-SSAP95-A	63	252	95.00	150	0	7	50	4	2	20	8500	5.32	GI128	SQ941	
80J6R155H50-SSAP95-A	80	257	95.00	155	0	7	50	6	3	30	7500	6.30	GI128	SQ941	
50J4R124X50-SSAP76-A	50	251	76.00	124	0	7	50	4	2	16	9500	3.80	GI128	SQ941	
63J4R146X50-SSAP95-A	63	273	95.00	146	0	7	50	4	2	20	8500	4.50	GI128	SQ941	
80J6R151X50-SSAP95-A	80	275	95.00	151	0	7	50	6	3	30	7500	6.20	GI128	SQ941	

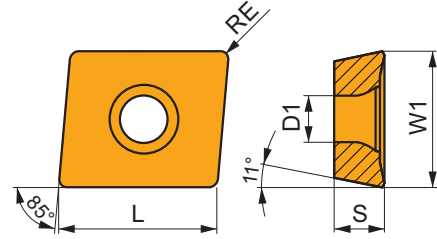
GI128	APE. 1504..	SPE. 1204..
-------	-------------	-------------

SQ941	SQ942	SQ943
-	P50X21	P63X21
-	SR 25	SR 26
-	HXK 6	HXK 8
US 4511-T20	US 4511-T20	US 4511-T20
5.0	5.0	5.0
M 4.5	M 4.5	M 4.5
11	11	11
SDRT20-T	SDRT20-T	SDRT20-T

APET 15

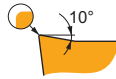
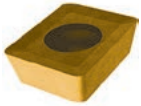


	W1	D1	L	S
	(mm)	(mm)	(mm)	(mm)
1504	12.700	5.50	15.90	4.76



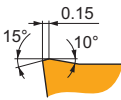
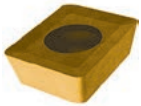
Lämplighet och startvärden för skärhastighet (vc), matning (f) och skärdjup (ap). Vi refererar till vår Dormer Pramet Calculator-app för vidare beräkningar.

Product	RE (mm)	P			M			K			N			S			H		
		vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)



EN eggpreparering, positiv geometri för fin till medelfin fräsning.

APET 150412EN:M8330	1.2	225	0.20	12.0	135	0.18	12.0	210	0.20	12.0	-	-	-	55	0.14	9.6	-	-	-
----------------------------	-----	-----	------	------	-----	------	------	-----	------	------	---	---	---	----	------	-----	---	---	---



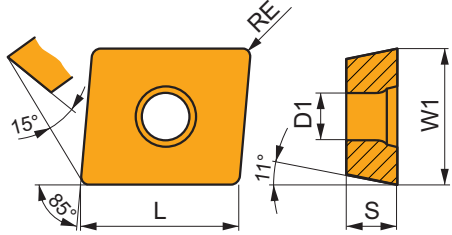
SN eggpreparering, positiv geometri för medel till grov fräsning.

APET 150412SN:M8330	1.2	215	0.25	12.0	125	0.23	12.0	200	0.25	12.0	-	-	-	50	0.25	9.6	-	-	-
APET 150412SN:M8340	1.2	190	0.25	12.0	110	0.23	12.0	180	0.25	12.0	-	-	-	45	0.25	9.6	-	-	-

APEW 15

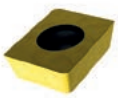


	W1	D1	L	M	S
	(mm)	(mm)	(mm)	(mm)	(mm)
1504	12.700	5.50	15.90	3.7	4.76



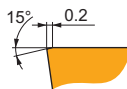
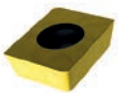
Lämplighet och startvärden för skärhastighet (vc), matning (f) och skärdjup (ap). Vi refererar till vår Dormer Pramet Calculator-app för vidare beräkningar.

Product	RE (mm)	P			M			K			N			S			H		
		vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)



ER eggpreparering, neutral spånvinkel för fin till medelfin fräsning.

APEW 150412ER:M8330	1.2	200	0.20	12.0	-	-	-	190	0.20	12.0	-	-	-	-	-	-	40	0.13	1.0
----------------------------	-----	-----	------	------	---	---	---	-----	------	------	---	---	---	---	---	---	----	------	-----



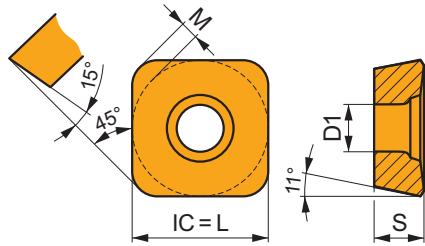
SR eggpreparering, neutral spånvinkel för medel till grov fräsning.

APEW 150412SR:M8330	1.2	200	0.20	12.0	-	-	-	190	0.20	12.0	-	-	-	-	-	-	40	0.13	1.0
----------------------------	-----	-----	------	------	---	---	---	-----	------	------	---	---	---	---	---	---	----	------	-----

SPET 12

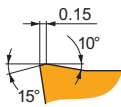


	IC	D1	L	M	S
	(mm)	(mm)	(mm)	(mm)	(mm)
1204	12.700	5.50	12.70	1.9	4.76



Lämplighet och startvärden för skärhastighet (vc), matning (f) och skärdjup (ap). Vi refererar till vår Dormer Pramet Calculator-app för vidare beräkningar.

Product	RE (mm)	P			M			K			N			S			H		
		vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)



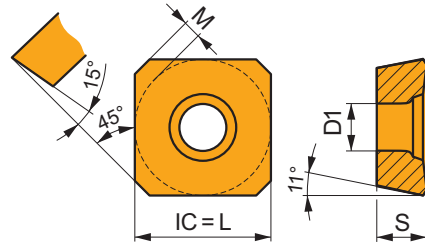
S eggpreparering, positiv geometri för allmän fräsning.

SPET 120408S:M8330	0.8	215	0.20	12.0	125	0.18	12.0	200	0.20	12.0	-	-	-	50	0.18	9.6	-	-	-
SPET 120408S:M8340	0.8	190	0.20	12.0	110	0.18	12.0	180	0.20	12.0	-	-	-	45	0.18	9.6	-	-	-

SPET 12 AD

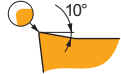
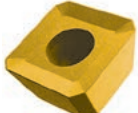


	IC	D1	L	M	S
	(mm)	(mm)	(mm)	(mm)	(mm)
1204	12.700	5.50	12.70	1.9	4.76



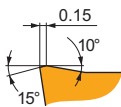
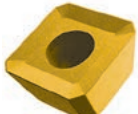
Lämplighet och startvärden för skärhastighet (vc), matning (f) och skärdjup (ap). Vi refererar till vår Dormer Pramet Calculator-app för vidare beräkningar.

Product	RE (mm)	P			M			K			N			S			H		
		vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)



ADEN eggpreparering, positiv geometri för fin till medelfin fräsning.

SPET 1204ADEN:M8330	-	245	0.20	12.0	145	0.18	12.0	230	0.20	12.0	-	-	-	60	0.14	9.6	-	-	-
SPET 1204ADEN:M8340	-	220	0.20	12.0	130	0.18	12.0	205	0.20	12.0	-	-	-	55	0.14	9.6	-	-	-



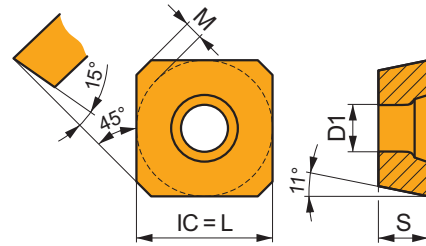
ADSN eggpreparering, positiv geometri för medelfin fräsning.

SPET 1204ADSN:M8330	-	245	0.20	12.0	145	0.18	12.0	230	0.20	12.0	-	-	-	60	0.14	9.6	-	-	-
SPET 1204ADSN:M8340	-	220	0.20	12.0	130	0.18	12.0	205	0.20	12.0	-	-	-	55	0.14	9.6	-	-	-

SPEW 12 AD

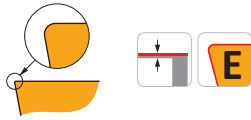
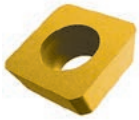


	IC	D1	L	M	S
	(mm)	(mm)	(mm)	(mm)	(mm)
1204	12.700	5.50	12.70	1.9	4.76



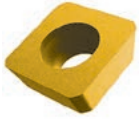
Lämplighet och startvärden för skärhastighet (vc), matning (f) och skärdjup (ap). Vi refererar till vår Dormer Pramet Calculator-app för vidare beräkningar.

Product	RE (mm)	P			M			K			N			S			H		
		vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)



ADEN eggpreparering, neutral geometri för fin till medelfin fräsning.

SPEW 1204ADEN:M8330	☐	–	☑	220	0.20	12.0	–	–	–	☑	205	0.20	12.0	–	–	–	–	–	–	☑	40	0.10	1.0
----------------------------	---	---	---	-----	------	------	---	---	---	---	-----	------	------	---	---	---	---	---	---	---	----	------	-----



ADSN eggpreparering, neutral geometri för medelfin fräsning.

SPEW 1204ADSN:M8330	☐	–	☑	220	0.20	12.0	–	–	–	☑	205	0.20	12.0	–	–	–	–	–	–	☑	40	0.13	1.0
----------------------------	---	---	---	-----	------	------	---	---	---	---	-----	------	------	---	---	---	---	---	---	---	----	------	-----



a_e / DC	5 %	10 %	15 %	20 %	25 %	30 %	40 %	50 %	60 %	70 %	75 %	80 %	90 %	100 %
	0.89	0.81	0.76	0.73	0.71	0.70	0.67	0.65	0.63	0.62	0.60	0.60	0.60	0.45



	1	2.5	5	7.5	10	15	20	
	f_{min}	f_{max}	f_{min}	f_{max}	f_{min}	f_{max}	f_{min}	f_{max}
50	0.50	0.71	0.32	0.45	0.23	0.32	0.19	0.27
63	0.56	0.80	0.35	0.51	0.25	0.36	0.21	0.30
80	0.63	0.90	0.40	0.57	0.28	0.40	0.23	0.33

	25	32	40	50	63	80
	f_{min}	f_{max}	f_{min}	f_{max}	f_{min}	f_{max}
50	0.11	0.16	0.10	0.14	0.10	0.14
63	0.12	0.17	0.11	0.16	0.10	0.15
80	0.13	0.19	0.12	0.17	0.10	0.16

	APET 15	APEW 15	SPET 12	SPET 12AD	SPEW 12AD
	1.2	1.2	0.8	-	-
	-	-	-	-	-



ISO				
50J4R128H50-SSAP55+21	50	2+2	76	73.6
63J4R150H50-SSAP74+21	63	2+2	95	92.6
50J4R124X50-SSAP55+21	50	2+2	76	73.6
63J4R146X50-SSAP74+21	63	2+2	95	92.6
63J4R150H50-SSAP95-A	63	2+2	95	92.6
80J6R155H50-SSAP95-A	80	3+3	95	92.6
50J4R124X50-SSAP76-A	50	2+2	76	73.6
63J4R146X50-SSAP95-A	63	2+2	95	92.6
80J6R151X50-SSAP95-A	80	3+3	95	92.6

J(T)-CSD12X

P **M** **S**

PRAMET

C

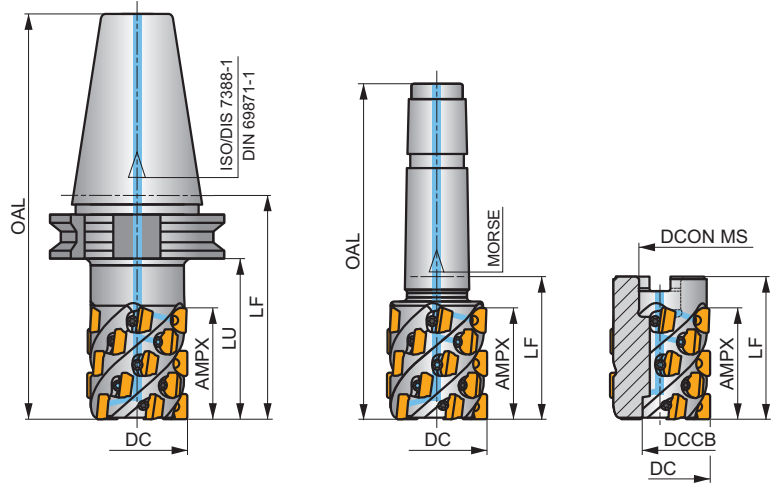
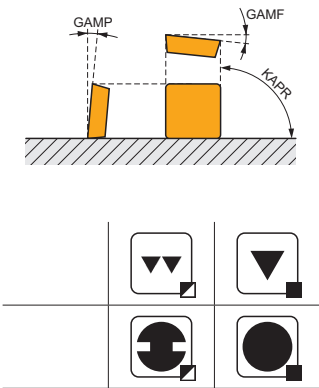


MULTISIDE SD lång fräs

90° lång hörnfräs för SD.. 12-skär med APMX 44.1 till 87.3 mm. Passar för en rad olika applikationer, bl a hörn-, plan- och spårfräsning. Finns med dornfäste, PSC-, morse-kona och DIN 69871-fäste. Behandlad för lång livslängd.

MULTISIDE SD

KAPR	90°
APMX	44.1 - 87.3 mm



	0.025 - 0.05			
	0.025 - 0.05			

Product	DC	OAL	DCON MS	DCCB	LU	LF	APMX	GAMF	GAMP	CZC MS	NOF						
	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(°)	(°)								
40J4R090H40-CSD12X44	40	158.4	-	-	70	90	44.10	-5	8	40	4	16	-	4000	✓	1.16	GI271 SQ091
50J5R100H50-CSD12X55	50	201.7	-	-	80	100	54.90	-5	8	50	5	25	-	3200	✓	4.20	GI271 SQ091
63J6R110H50-CSD12X66	63	211.7	-	-	90	110	65.70	-5	8	50	6	36	-	2500	✓	4.90	GI271 SQ091
50J5R065E04-CSD12X55	50	167.5	-	-	-	65	54.90	-5	8	4	5	25	-	3200	✓	1.34	GI271 SQ091
50T05R-C90SD12X55	50	-	22	18	-	78	54.90	-5	8	-	5	25	-	3200	✓	1.21	GI271 SQ923
63T06R-C90SD12X66	63	-	27	22	-	90	65.70	-5	8	-	6	36	-	2500	✓	1.72	GI271 SQ924
80T08R-C90SD12X88	80	-	40	36	-	115	87.30	-5	8	-	8	64	-	2000	✓	3.20	GI271 SQ925

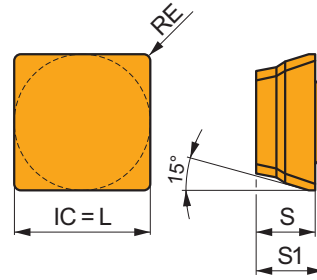
GI271	SDGX 1205..	SDMX 1205..

SQ091	US 63511D-T15P	3.0	M 3.5	11	D-T08P/T15P	FG-15	-
SQ923	US 63511D-T15P	3.0	M 3.5	11	D-T08P/T15P	FG-15	HSD 1070
SQ924	US 63511D-T15P	3.0	M 3.5	11	D-T08P/T15P	FG-15	HS 1280
SQ925	US 63511D-T15P	3.0	M 3.5	11	D-T08P/T15P	FG-15	HS 20100

SDGX 12

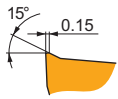
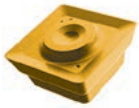


	IC (mm)	L (mm)	S (mm)	S1 (mm)
1205	12.700	12.70	5.56	6.35



Lämplighet och startvärden för skärhastighet (vc), matning (f) och skärdjup (ap). Vi refererar till vår Dormer Pramet Calculator-app för vidare beräkningar.

Product	RE (mm)	P			M			K			N			S			H		
		vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)



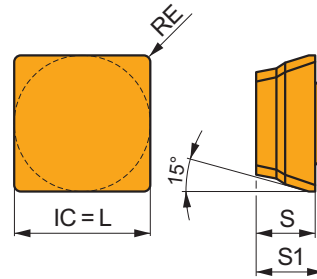
FM geometri med positiv design för medelfin till medelgrov fräsning.

SDGX 120508EN-FM:M8330	0.8	220	0.15	12.0	130	0.14	12.0	-	-	-	-	-	55	0.11	9.6	-	-	-
SDGX 120508EN-FM:M8345	0.8	155	0.15	12.0	90	0.14	12.0	-	-	-	-	-	35	0.11	9.6	-	-	-

SDMX 12

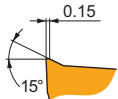
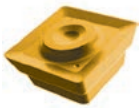


	IC (mm)	L (mm)	S (mm)	S1 (mm)
1205	12.700	12.70	5.56	6.35



Lämplighet och startvärden för skärhastighet (vc), matning (f) och skärdjup (ap). Vi refererar till vår Dormer Pramet Calculator-app för vidare beräkningar.

Product	RE (mm)	P			M			K			N			S			H		
		vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)



M geometri med positiv design för fin till grovfräsning.

SDMX 120508EN-M:M8330	0.8	220	0.15	12.0	130	0.14	12.0	-	-	-	-	-	55	0.11	9.6	-	-	-
SDMX 120508EN-M:M8345	0.8	155	0.15	12.0	90	0.14	12.0	-	-	-	-	-	35	0.11	9.6	-	-	-



a_e / DC	5 %	10 %	15 %	20 %	25 %	30 %	40 %	50 %	60 %	70 %	75 %	80 %	90 %	100 %
	0.89	0.81	0.76	0.73	0.71	0.70	0.66	0.65	0.63	0.62	0.60	0.60	0.60	0.45



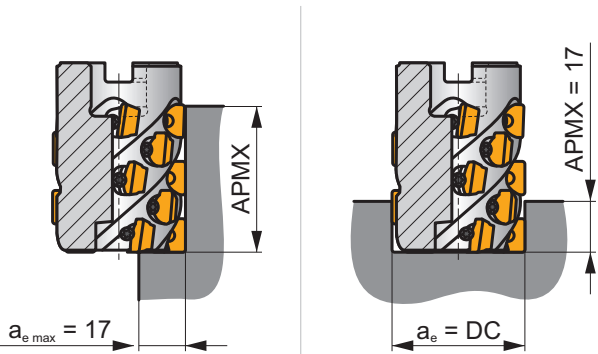
	1		2.5		5		7.5		10		15		20	
	f_{min}	f_{max}	f_{min}	f_{max}	f_{min}	f_{max}	f_{min}	f_{max}	f_{min}	f_{max}	f_{min}	f_{max}	f_{min}	f_{max}
40	0.16	0.32	0.10	0.20	0.07	0.14	0.06	0.12	0.05	0.10	0.04	0.09	0.04	0.08
50	0.18	0.35	0.11	0.23	0.08	0.16	0.07	0.13	0.06	0.12	0.05	0.10	0.04	0.09
63	0.20	0.40	0.13	0.25	0.09	0.18	0.07	0.15	0.06	0.13	0.05	0.11	0.05	0.09
80	0.22	0.45	0.14	0.28	0.10	0.20	0.08	0.17	0.07	0.14	0.06	0.12	0.05	0.10

	25		32		40		50		63		80	
	f_{min}	f_{max}	f_{min}	f_{max}	f_{min}	f_{max}	f_{min}	f_{max}	f_{min}	f_{max}	f_{min}	f_{max}
40	0.04	0.07	0.03	0.07	0.04	0.08	-	-	-	-	-	-
50	0.04	0.08	0.04	0.07	0.03	0.07	0.04	0.08	-	-	-	-
63	0.04	0.09	0.04	0.08	0.04	0.07	0.03	0.07	0.04	0.08	-	-
80	0.05	0.09	0.04	0.09	0.04	0.08	0.04	0.07	0.03	0.07	0.04	0.08

	SDGX 12-FM	SDMX 12-M
	0.8	0.8
	2.99	2.99



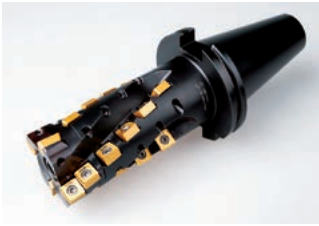
ISO				
40J4R090H40-CSD12X44	40	4	44.1	42.5
50J5R100H50-CSD12X55	50	5	54.9	53.3
63J6R110H50-CSD12X66	63	6	65.7	64.1
80J8R130H50-CSD12X88	80	8	87.3	85.7
40J4R080XC5-CSD12X44	40	4	44.1	42.5
50J5R080XC5-CSD12X55	50	5	54.9	53.3
63J6R095XC6-CSD12X66	63	6	65.7	64.1
50J5R065E04-CSD12X55	50	5	54.9	53.3
50T05R-C90SD12X55	50	5	54.9	53.3
63T06R-C90SD12X66	63	6	65.7	64.1
80T08R-C90SD12X88	80	8	87.3	85.7



J(T)-SLSN



PRAMET

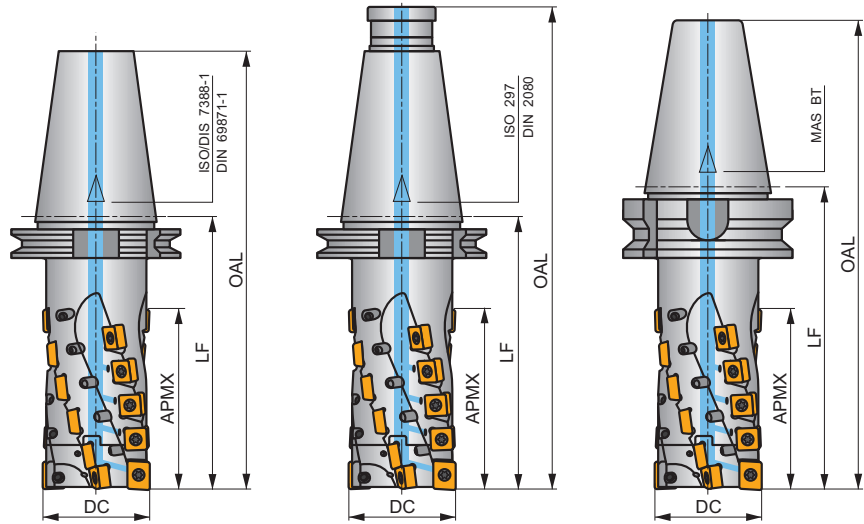
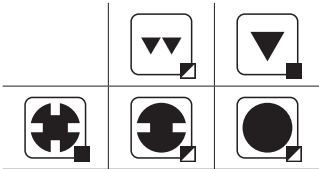
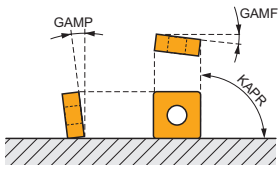


ROUGH SN-fräs med lång skärkropp för grovfräsning, med invändig kylning

90° lång hörnfräs för LNET 16 och SN.. 13-skär med APMX 104 till 134 mm. Utbytbar skärkropp. Passar för en rad olika applikationer, bl a hörn-, plan-, spår- och dykfräsning. Finns med DIN 69871-, BT- och DIN 2080-fäste, kona 50, från Ø63 till Ø80 mm. Behandlad för lång livslängd.

ROUGH SN

KAPR	90°
APMX	104.0 - 134.0 mm



h_m 0.08 - 0.22



Product	DC (mm)	OAL (mm)	APMX (mm)	LF (mm)	GAMP (°)	GAMP (°)	CZCMS	NOF	LN	SN	max.	kg	GI209	SQ934	SQ935	
63J2R155H50-SLSN104-C	63	257	104.00	155	-9	-10	50	4	2	20	-	8500	✓	5.03	GI209	SQ934
80J2R190H50-SLSN134-C	80	292	134.00	190	-9	-10	50	4	2	26	-	7500	✓	7.45	GI209	SQ935
63J2R155G50-SLSN104-C	63	282	104.00	155	-9	-10	50	4	2	20	-	8500	✓	5.20	GI209	SQ934
80J2R190G50-SLSN134-C	80	317	134.00	190	-9	-10	50	4	2	26	-	7500	✓	7.40	GI209	SQ935
63J2R175X50-SLSN104-C	63	277	104.00	175	-9	-10	50	4	2	20	-	8500	✓	6.10	GI209	SQ934
80J2R210X50-SLSN134-C	80	312	134.00	210	-9	-10	50	4	2	26	-	7500	✓	8.50	GI209	SQ935

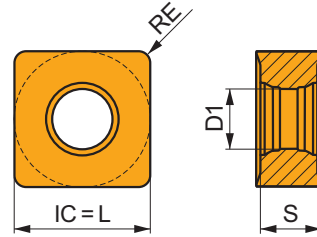
GI209	LNET 1606..	SN.. 1305..

SQ934	EH6326-SL-C	HS 1230	HXK 10	US 45012-T20P	5.0	M 5	12	SDR T20P-T
SQ935	EH8036-SL-C	HS 1640	HXK 14	US 45012-T20P	5.0	M 5	12	SDR T20P-T

SNGX 13

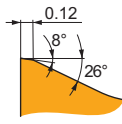


	IC (mm)	D1 (mm)	S (mm)
1305	13.200	5.90	5.96



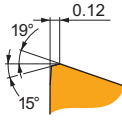
Lämplighet och startvärden för skärhastighet (vc), matning (f) och skärdjup (ap). Vi refererar till vår Dormer Pramet Calculator-app för vidare beräkningar.

Product	RE (mm)	P			M			K			N			S			H		
		vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)



M geometri med positiv design för finfräsning.

SNGX 130512SN-M:M8330	1.2	105	0.15	12.0	–	–	–	95	0.15	12.0	–	–	–	–	–	–	–	–	–
SNGX 130512SN-M:M8340	1.2	105	0.15	12.0	–	–	–	95	0.15	12.0	–	–	–	–	–	–	–	–	–



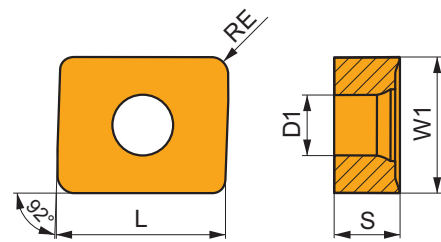
R geometri med positiv design för grovfräsning vid mindre stabila förhållanden.

SNGX 130512PN-R:M8330	1.2	95	0.15	12.0	–	–	–	90	0.15	12.0	–	–	–	–	–	–	–	–	–
SNGX 130512PN-R:M8340	1.2	95	0.15	12.0	–	–	–	90	0.15	12.0	–	–	–	–	–	–	–	–	–

LNET 16

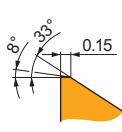


	W1 (mm)	D1 (mm)	L (mm)	S (mm)
1606	13.200	5.90	16.40	6.38



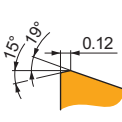
Lämplighet och startvärden för skärhastighet (vc), matning (f) och skärdjup (ap). Vi refererar till vår Dormer Pramet Calculator-app för vidare beräkningar.

Product	RE (mm)	P			M			K			N			S			H		
		vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)



M geometri med mycket positiv design för medelfin fräsning.

LNET 160616SR-M:M8340	1.6	105	0.15	15.0	–	–	–	95	0.15	15.0	–	–	–	–	–	–	–	–	–
------------------------------	-----	-----	------	------	---	---	---	----	------	------	---	---	---	---	---	---	---	---	---

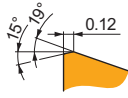


R geometri med mycket positiv design för medelfin fräsning.

LNET 160616SR-R:M8330	1.6	100	0.15	15.0	–	–	–	95	0.15	15.0	–	–	–	–	–	–	–	–	–
------------------------------	-----	-----	------	------	---	---	---	----	------	------	---	---	---	---	---	---	---	---	---

Lämplighet och startvärden för skärhastighet (vc), matning (f) och skärdjup (ap). Vi refererar till vår Dormer Pramet Calculator-app för vidare beräkningar.

Product	RE (mm)	P			M			K			N			S			H		
		vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)



R geometri med mycket positiv design för medelfin fräsning.

LNET 160616SR-R:M8340	1.6	95	0.15	15.0	-	-	-	90	0.15	15.0	-	-	-	-	-	-	-	-
------------------------------	-----	----	------	------	---	---	---	----	------	------	---	---	---	---	---	---	---	---



a_e / DC	5 %	10 %	15 %	20 %	25 %	30 %	40 %	50 %	60 %	70 %	75 %	80 %	90 %	100 %
	1.48	1.35	1.27	1.22	1.19	1.16	1.11	1.08	1.05	1.03	1.00	1.00	1.00	1.00



	1	2.5	5	7.5	10	15	20							
	f_{min}	f_{max}	f_{min}	f_{max}	f_{min}	f_{max}	f_{min}	f_{max}	f_{min}	f_{max}	f_{min}	f_{max}	f_{min}	f_{max}
63	0.64	1.75	0.40	1.11	0.29	0.79	0.24	0.65	0.21	0.57	0.17	0.47	0.15	0.41
80	0.72	1.97	0.45	1.25	0.32	0.89	0.27	0.73	0.23	0.64	0.19	0.53	0.17	0.46

	25	32	40	50	63	80						
	f_{min}	f_{max}	f_{min}	f_{max}	f_{min}	f_{max}	f_{min}	f_{max}	f_{min}	f_{max}	f_{min}	f_{max}
63	0.14	0.38	0.12	0.34	0.12	0.32	0.11	0.30	0.13	0.35	-	-
80	0.15	0.42	0.14	0.38	0.13	0.35	0.12	0.32	0.11	0.30	0.13	0.35

	LNET 16-M	LNET 16-R	SNGX 13-M	SNGX 13-R
RE	1.6	1.6	1.2	1.2
BS	-	-	-	-























ISO				a_e
63J2R155H50-SLSN104-C	63	2+2	104	101.2
80J2R190H50-SLSN134-C	80	2+2	134	131.2
63J2R155G50-SLSN104-C	63	2+2	104	101.2
80J2R190G50-SLSN134-C	80	2+2	134	131.2
63J2R175X50-SLSN104-C	63	2+2	104	101.2
80J2R210X50-SLSN134-C	80	2+2	134	131.2



KOPIERFRÄSNING

INDEXABLE FACE MILLS – NAVIGATOR

COPY MILLING – ROUND INSERT SEAT

	SRD05		SRD07		SRD10		SRD12		SRD16		
	-		-		-		-		-		
	APMX (mm)	1.5	APMX (mm)	2.0	APMX (mm)	2.5	APMX (mm)	3.0	APMX (mm)	4.0	
	DCX (mm)	10 – 15	DCX (mm)	15 – 25	DCX (mm)	20 – 52	DCX (mm)	24 – 80	DCX (mm)	32 – 100	
Cylindrical shank											
Weldon				DCX = 15 (mm)		DCX = 20 (mm)					
Modular				DCX = 15 – 25 (mm)		DCX = 20 – 42 (mm)		DCX = 24 – 42 (mm)		DCX = 32 (mm)	
Shell mill						DCX = 42, 52 (mm)		DCX = 50 – 80 (mm)		DCX = 52 – 100 (mm)	
Page	160		163		168		174		180		
ISO	P	K	H	P M K N S H	P M K N S H	P M K N S H	P M K N S H	P M K N S H	P M K N S H		
Insert shape											
Inserts	RD 0501		RD 0702		RD 1003		RD 12T3		RD 1604		
No. of cutting edges	-		-		-		-		-		
Kopierfräsning 	■		■		■		■		■		
Planfräsning 	■		■		■		■		■		
Spiralinterpolering 	■		■		■		■		■		
Progressiv dykfräsning 	■		■		■		■		■		
Rampning 	■		■		■		■		■		

SRD05



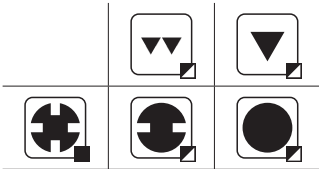
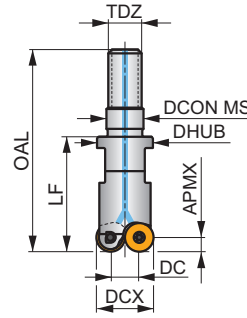
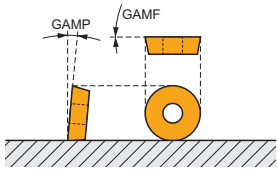
PRAMET



Kopierfräs för runda RDHX 05-skär, invändig kylning

Kopierfräs för positiva RDHX 05-skär med APMX 1,5 mm. Invändig kylning. För plan-, hörn- och dykfräsning, rampning, mm. Finns med modulärt fäste. Diametrar från 10 till 15 mm. Behandlad för lång livslängd.

APMX	1.5 mm
------	--------



h_m 0.03 - 0.1



Product	DCX	DC	DHUB	OAL	LF	DCON MS	TDZ	GAMF	GAMP							
	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)		(°)	(°)			max.		kg		
10E2R020M06-SRD05-CF	10	5	9.8	35	20	6.5	M6	5	3	2	-	89300	✓	0.01	GI117	C0352
12E3R020M06-SRD05-CF	12	7	10	35	20	6.5	M6	0	3	3	-	81500	✓	0.01	GI117	C0352
15E4R020M08-SRD05-CF	15	10	13.5	38	20	8.5	M8	0	3	4	-	72900	✓	0.02	GI117	C0352

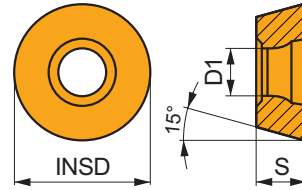
	GI117		RD.. 0501M0..
--	-------	--	---------------

	C0352		US 62003B-T06P		0.9		M 2		3		Flag T06P
--	-------	--	----------------	--	-----	--	-----	--	---	--	-----------

RDHX 05



	INSD	D1	S
	(mm)	(mm)	(mm)
0501	5.000	2.20	1.51



Lämplighet och startvärden för skärhastighet (vc), matning (f) och skärdjup (ap). Vi refererar till vår Dormer Pramet Calculator-app för vidare beräkningar.

Product	RE (mm)	P			M			K			N			S			H		
		vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)



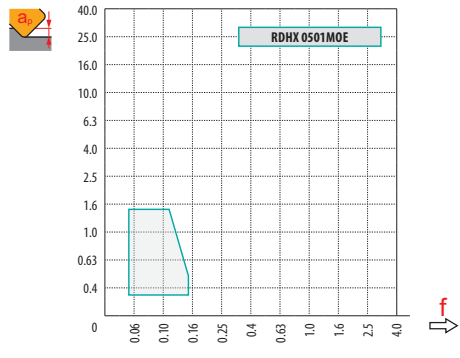
MOE neutral spänvinkel för finfräsning.

RDHX 0501M0E:M8310	✳	-	<input checked="" type="checkbox"/>	400	0.10	0.5	-	-	-	380	0.10	0.5	-	-	-	-	-	-	80	0.10	0.3
---------------------------	---	---	-------------------------------------	-----	------	-----	---	---	---	-----	------	-----	---	---	---	---	---	---	----	------	-----



a_e DCX	5 %	10 %	15 %	20 %	25 %	30 %	40 %	50 %	60 %	70 %	75 %	80 %	90 %	100 %
	1.48	1.35	1.27	1.22	1.19	1.16	1.11	1.08	1.05	1.03	1.00	1.00	1.00	1.00
	2.20	1.60	1.35	1.20	1.10	0.95	0.85	0.75	0.85	0.95	1.00	1.00	1.00	1.00
	0.64	0.64	0.64	0.64	0.64	0.65	0.65	0.67	0.68	0.71	0.72	0.74	0.79	1.00

	RDHX 05
	2.5
	-



		0.00	0.30	0.50	0.75	1.00	1.25	1.50	2.00	2.50
10		5.0	7.4	8.0	8.6	9.0	9.3	9.6	9.9	10.0
12		7.0	9.4	10.0	10.6	11.0	11.3	11.6	11.9	12.0
15		10.0	12.4	13.0	13.6	14.0	14.3	14.6	14.9	15.0
		-	0.30	0.50	0.75	1.00	1.25	1.50	2.00	2.50
		-	0.25	0.19	0.16	0.14	0.13	0.12	0.10	0.09

	RPMX	APMX/I
10	15.0	1.3/11
12	11.0	1.3/14
15	7.0	1.3/22

	DMIN	DMAX		
10	12.0	20.0	1.2	1.2
12	16.0	24.0	1.2	1.2
15	22.0	30.0	1.2	1.2

1.0

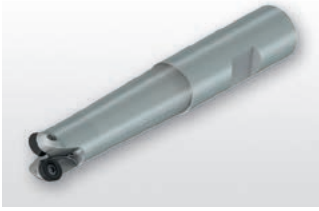
	μm	3	5	10	15	20	30	40	50	60	80	100
10		0.346	0.447	0.632	0.775	0.894	1.095	1.265	1.414	1.549	1.789	2.000
12		0.379	0.490	0.693	0.849	0.980	1.200	1.386	1.549	1.697	1.960	2.191
15		0.424	0.548	0.775	0.949	1.095	1.342	1.549	1.732	1.897	2.191	2.449
		3	5	10	15	20	30	40	50	60	80	100
2.5		0.245	0.316	0.447	0.548	0.632	0.775	0.894	1.000	1.095	1.265	1.414

SRD07

P M K N S H

PRAMET

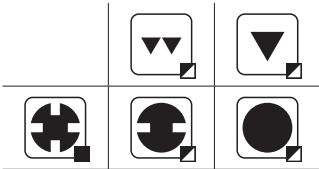
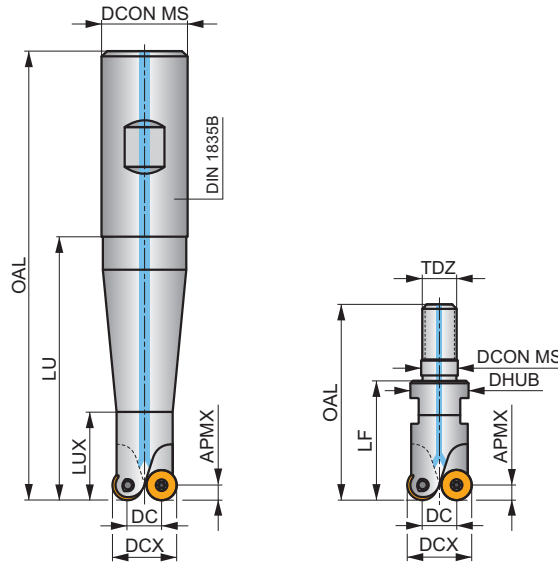
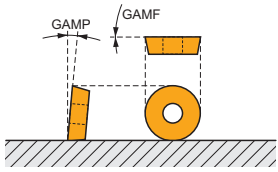
S



Kopierfräs för runda RD.. 07-skär, invändig kylning

Kopierfräs för positiva RD.. 07-skär med APMX 2 mm. Invändig kylning. För plan-, hörn- och dykfräsning, rampning, mm. Finns med Weldonskaft, modulärt fäste. Diametrar från 15 till 25 mm. Behandlad för lång livslängd.

APMX	2.0 mm
------	--------



h_m 0.065 - 0.13



Product	DCX	DC	OAL	D CON MS	DHUB	LU	LUX	LF	TDZ	GAMF	GAMP							
	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)		(°)	(°)							
15E2R040B16-SRD07-CF	15	8	88	16	-	40	20	-	-	1	0	2	-	44200	✓	0.12	G118	C0354
15E2R060B16-SRD07-CF	15	8	108	16	-	60	20	-	-	1	0	2	-	44200	✓	0.15	G118	C0354
15E2R080B20-SRD07-CF	15	8	130	20	-	80	22	-	-	1	0	2	-	44200	✓	0.22	G118	C0354
15E2R100B20-SRD07-CF	15	8	150	20	-	100	22	-	-	1	0	2	-	44200	✓	0.25	G118	C0354
15E2R120B25-SRD07-CF	15	8	176	25	-	120	22	-	-	1	0	2	-	44200	✓	0.45	G118	C0354
15E2R028M08-SRD07-CF	15	8	46	8.5	13.5	-	-	28	M8	1	0	2	-	44200	✓	0.03	G118	C0354
15E3R028M08-SRD07-CF	15	8	46	10.5	13.5	-	-	28	M8	2	0	3	-	44200	✓	0.05	G118	C0354
20E4R028M10-SRD07-CF	20	13	47	12.5	18	-	-	28	M10	-8	0	4	-	38200	✓	0.07	G118	C0354
25E5R028M12-SRD07-CF	25	18	50	12.5	21	-	-	28	M12	-2	0	5	-	34200	✓	0.09	G118	C0354

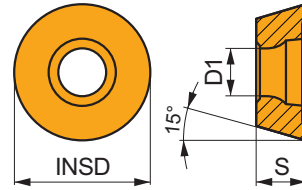
G118	RD..07..MO..

C0354	US 42505-T07P	1.2	M 2.5	5	Flag T07P

RDGT 07

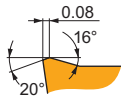


	INSD (mm)	D1 (mm)	S (mm)
0702	7.000	2.80	2.38



Lämplighet och startvärden för skärhastighet (vc), matning (f) och skärdjup (ap). Vi refererar till vår Dormer Pramet Calculator-app för vidare beräkningar.

Product	RE (mm)	P			M			K			N			S			H		
		vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)
	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—



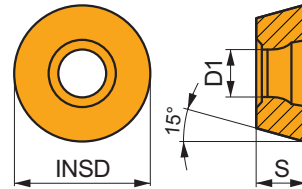
MOT positiv design för finfräsning.

RDGT 0702MOT:M8325		—	305	0.15	0.5	145	0.14	0.5	—	—	—	—	—	—	—	—	—	—	—
RDGT 0702MOT:M8345		—	270	0.15	0.5	160	0.14	0.5	—	—	—	—	65	0.12	0.4	—	—	—	—

RDHX 07

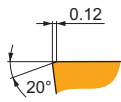


	INSD (mm)	D1 (mm)	S (mm)
0702	7.000	2.80	2.38
07T1	7.000	2.80	1.98



Lämplighet och startvärden för skärhastighet (vc), matning (f) och skärdjup (ap). Vi refererar till vår Dormer Pramet Calculator-app för vidare beräkningar.

Product	RE (mm)	P			M			K			N			S			H		
		vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)
	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—



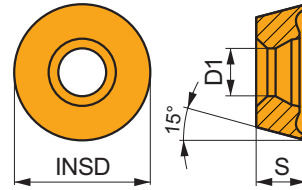
MOT neutral spånvinkel för finfräsning.

RDHX 0702MOT:M4303		—	370	0.15	0.5	—	—	—	350	0.15	0.5	—	—	—	—	—	—	70	0.11	0.5
RDHX 0702MOT:M8310		—	360	0.15	0.5	—	—	—	340	0.15	0.5	—	—	—	—	—	—	70	0.11	0.5
RDHX 0702MOT:M8325		—	275	0.15	0.5	—	—	—	—	—	—	—	—	—	—	—	—	—	—	
RDHX 07T1MOT:M8310		—	360	0.15	0.5	—	—	—	340	0.15	0.5	—	—	—	—	—	—	70	0.11	0.5

RDHT 07-FA

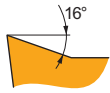
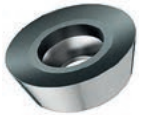


	INSD	D1	S
	(mm)	(mm)	(mm)
0702	7.000	2.80	2.38



Lämplighet och startvärden för skärhastighet (vc), matning (f) och skärdjup (ap). Vi refererar till vår Dormer Pramet Calculator-app för vidare beräkningar.

Product	RE (mm)	P			M			K			N			S			H		
		vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)



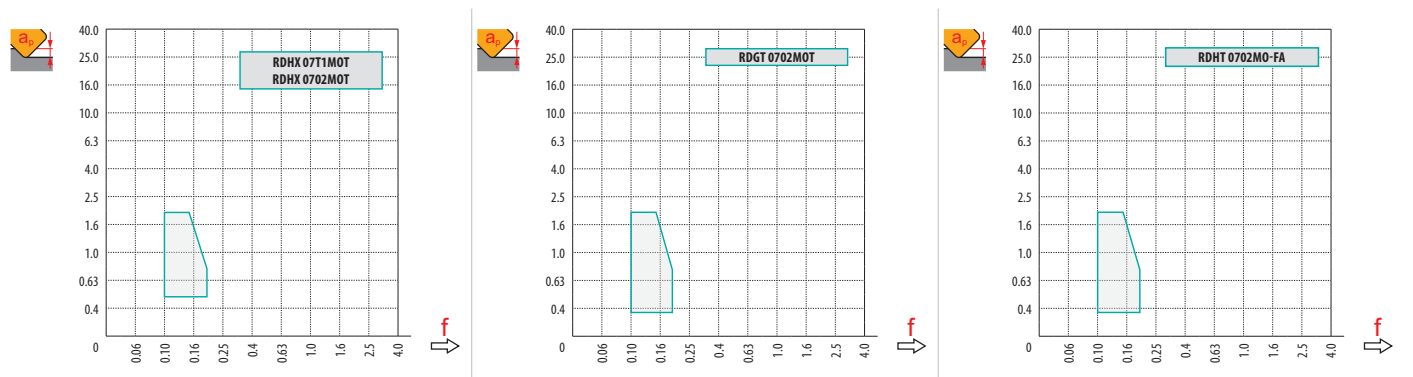
FA geometri med mycket positiv design för fin till medelfin fräsning.

RDHT 0702M0-FA:HF7	●	-	-	-	-	-	-	-	-	-	■	420	0.18	0.5	-	-	-	-	-
---------------------------	---	---	---	---	---	---	---	---	---	---	---	-----	------	-----	---	---	---	---	---

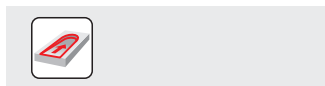


a_e / DCX	5 %	10 %	15 %	20 %	25 %	30 %	40 %	50 %	60 %	70 %	75 %	80 %	90 %	100 %
	1.48	1.35	1.27	1.22	1.19	1.16	1.11	1.08	1.05	1.03	1.00	1.00	1.00	1.00
	2.20	1.60	1.35	1.20	1.10	0.95	0.85	0.75	0.85	0.95	1.00	1.00	1.00	1.00
	0.64	0.64	0.64	0.64	0.64	0.65	0.65	0.67	0.68	0.71	0.72	0.74	0.79	1.00

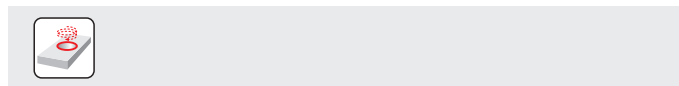
	RDHX 07	RDGT 07	RDHT 07-FA
	3.5	3.5	3.5
	—	—	—



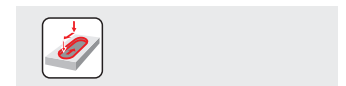
		0.00	0.30	0.50	0.75	1.00	1.25	1.50	2.00	2.50	3.00	3.50
15		8.0	10.8	11.6	12.3	12.9	13.4	13.7	14.3	14.7	14.9	15.0
20		13.0	15.8	16.6	17.3	17.9	18.4	18.7	19.3	19.7	19.9	20.0
25		18.0	20.8	21.6	22.3	22.9	23.4	23.7	24.3	24.7	24.9	25.0
		0.00	0.30	0.50	0.75	1.00	1.25	1.50	2.00	2.50	3.00	3.50
		—	0.29	0.23	0.19	0.16	0.15	0.13	0.12	0.11	0.10	0.09



	RPMX	APMX/I
15	11.0	1.7/20
20	7.0	1.7/30
25	6.0	1.7/35











	DMIN	DMAX		
15	17.0	30.0	0.4	1.7
20	28.0	40.0	1.7	1.7
25	38.0	50.0	1.7	1.7



1.2



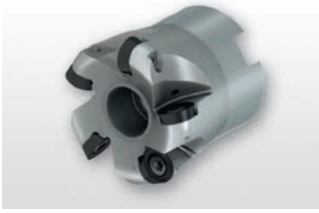
		3	5	10	15	20	30	40	50	60	80	100
15		0.424	0.548	0.775	0.949	1.095	1.342	1.549	1.732	1.897	2.191	2.449
20		0.490	0.632	0.894	1.095	1.265	1.549	1.789	2.000	2.191	2.530	2.828
25		0.548	0.707	1.000	1.225	1.414	1.732	2.000	2.236	2.449	2.828	3.162
		3	5	10	15	20	30	40	50	60	80	100
3.5		0.290	0.374	0.529	0.648	0.748	0.917	1.058	1.183	1.296	1.497	1.673

SRD10

P M K N S H

PRAMET

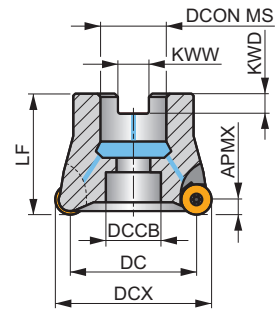
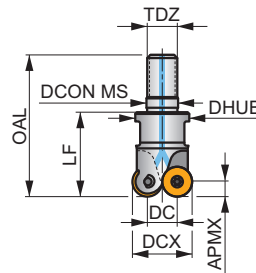
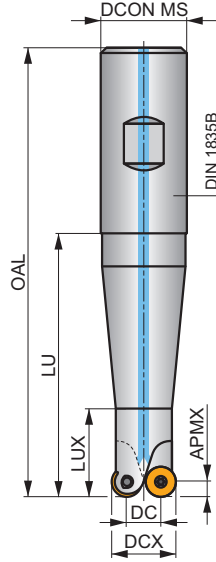
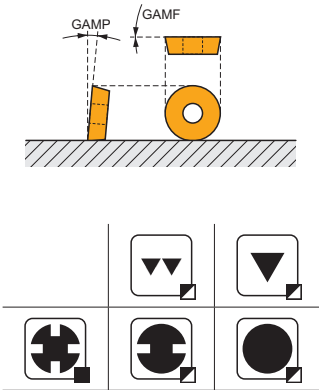
S



Kopierfräs för runda RD.. 10-skär, invändig kylning

Kopierfräs för positiva RD.. 10-skär med APMX 2,5 mm. Invändig kylning. För plan-, hörn- och dykfräsning, rampning, mm. Finns med Weldonskaft, modulärt och dornfäste. Diametrar från 20 till 52 mm. Behandlad för lång livslängd.

APMX	2.5 mm
------	--------



h_m 0.065 - 0.19



Product	DCX	DC	OAL	DCON MS	DHUB	DCCB	LU	LUX	LF	TDZ	KWW	KWD	GAMF	GAMP							
	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(°)	(°)							
20E2R040B20-SRD10-CF	20	10	90	20	-	-	40	20	-	-	-	-	-2	0	2	-	30800	✓	0.20	G1119	C0356
20E2R060B20-SRD10-CF	20	10	110	20	-	-	60	22	-	-	-	-	-2	0	2	-	30800	✓	0.20	G1119	C0356
20E2R080B25-SRD10-CF	20	10	136	25	-	-	80	25	-	-	-	-	-2	0	2	-	30800	✓	0.40	G1119	C0356
20E2R100B25-SRD10-CF	20	10	156	25	-	-	100	25	-	-	-	-	-2	0	2	-	30800	✓	0.45	G1119	C0356
20E2R120B25-SRD10-CF	20	10	176	25	-	-	120	25	-	-	-	-	-2	0	2	-	30800	✓	0.46	G1119	C0356
20E2R028M10-SRD10-CF	20	10	47	10.5	18	-	-	-	28	M10	-	-	-2	0	2	-	30800	✓	0.07	G1119	C0356
25E2R032M12-SRD10-CF	25	15	54	12.5	21	-	-	-	32	M12	-	-	0.5	0.5	2	-	27500	✓	0.08	G1119	C0356
25E3R032M12-SRD10-CF	25	15	54	12.5	21	-	-	-	32	M12	-	-	0.5	0.5	3	-	27500	✓	0.10	G1119	C0356
30E4R042M16-SRD10-CF	30	20	65	17	29	-	-	-	42	M16	-	-	0	0	4	-	25100	✓	0.20	G1119	C0356
32E4R042M16-SRD10-CF	32	22	65	17	29	-	-	-	42	M16	-	-	0	0	4	-	24300	✓	0.19	G1119	C0356
35E5R042M16-SRD10-CF	35	25	65	17	29	-	-	-	42	M16	-	-	0	0	5	-	23200	✓	0.22	G1119	C0356
42E4R042M16-SRD10-CF	42	32	65	17	29	-	-	-	42	M16	-	-	0	0	4	-	21200	✓	0.24	G1119	C0356
42E5R042M16-SRD10-CF	42	32	65	17	29	-	-	-	42	M16	-	-	0	0	5	-	21200	✓	0.24	G1119	C0356
42A05R-SMORD10-CF	42	32	-	16	-	14	-	-	40	-	8.4	8.4	0	0	5	-	21200	✓	0.20	G1119	C0358
52A07R-SMORD10-CF	52	42	-	22	-	18	-	-	40	-	10.4	10.4	0	0	7	-	19100	✓	0.41	G1119	C0360

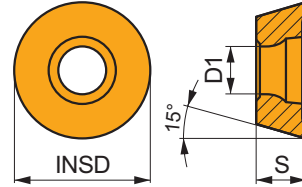
G1119	RD.. 1003MOT	RDHT 1003MO-FA

C0356	US 63507-T15P	3.0	M 3.5	7	Flag T15P	-	-
C0358	US 63507-T15P	3.0	M 3.5	7	D-T08P/T15P	FG-15	HS 0830C
C0360	US 63507-T15P	3.0	M 3.5	7	D-T08P/T15P	FG-15	HS 1030C

RDGT 10

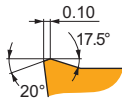


	INSD	D1	S
	(mm)	(mm)	(mm)
1003	10.000	3.90	3.18



Lämplighet och startvärden för skärhastighet (vc), matning (f) och skärdjup (ap). Vi refererar till vår Dormer Pramet Calculator-app för vidare beräkningar.

Product	RE (mm)	P			M			K			N			S			H		
		vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)



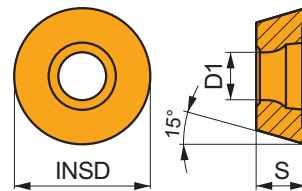
MOT positiv design för finfräsning.

RDGT 1003MOT:M6330	☼	–	■	290	0.15	1.0	■	205	0.14	1.0	■	–	–	–	■	85	0.12	0.8	■	–	–	–
RDGT 1003MOT:M8310	☼	–	■	375	0.15	1.0	■	190	0.14	1.0	■	■	355	0.15	1.0	–	–	–	–	–	–	–
RDGT 1003MOT:M8325	☼	–	■	280	0.15	1.0	■	130	0.14	1.0	■	–	–	–	–	–	–	–	–	–	–	
RDGT 1003MOT:M8345	☼	–	■	250	0.15	1.0	■	150	0.14	1.0	■	–	–	–	■	60	0.12	0.8	–	–	–	
RDGT 1003MOT:M9340	☼	–	■	395	0.15	1.0	■	235	0.14	1.0	■	–	–	–	■	95	0.12	0.8	–	–	–	

RDMT 10

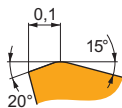


	INSD	D1	S
	(mm)	(mm)	(mm)
1003	10.000	3.90	3.18



Lämplighet och startvärden för skärhastighet (vc), matning (f) och skärdjup (ap). Vi refererar till vår Dormer Pramet Calculator-app för vidare beräkningar.

Product	RE (mm)	P			M			K			N			S			H		
		vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)



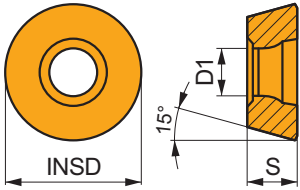
MOT positiv design för finfräsning.

RDMT 1003MOT:M8325	☼	–	■	280	0.15	1.0	■	130	0.14	1.0	■	–	–	–	–	–	–	–	–	–	–
RDMT 1003MOT:M8345	☼	–	■	250	0.15	1.0	■	150	0.14	1.0	■	–	–	–	–	–	–	–	–	–	–

RDMX 10

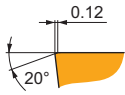
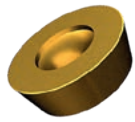


	INSD (mm)	D1 (mm)	S (mm)
1003	10.000	3.90	3.18



Lämplighet och startvärden för skärhastighet (vc), matning (f) och skärdjup (ap). Vi refererar till vår Dormer Pramet Calculator-app för vidare beräkningar.

Product	RE (mm)	P			M			K			N			S			H		
		vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)



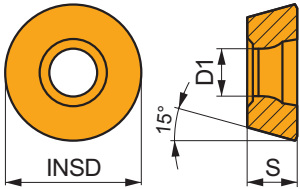
MOT neutral spånvinkel för finfräsning.

RDMX 1003MOT:M8310	✳	–	✔	335	0.15	1.0	–	–	–	✔	315	0.15	1.0	–	–	–	–	–	–	✔	65	0.11	0.7
RDMX 1003MOT:M8325	✳	–	✔	250	0.15	1.0	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
RDMX 1003MOT:M8345	✳	–	✔	225	0.15	1.0	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–

RDHX 10

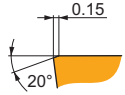


	INSD (mm)	D1 (mm)	S (mm)
1003	10.000	3.90	3.18



Lämplighet och startvärden för skärhastighet (vc), matning (f) och skärdjup (ap). Vi refererar till vår Dormer Pramet Calculator-app för vidare beräkningar.

Product	RE (mm)	P			M			K			N			S			H		
		vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)



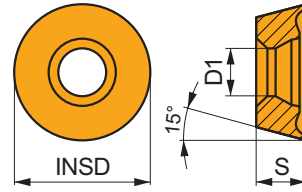
MOT neutral spånvinkel för finfräsning.

RDHX 1003MOT:M4303	✳	–	✔	340	0.15	1.0	–	–	–	✔	320	0.15	1.0	–	–	–	–	–	–	✔	65	0.12	0.7
RDHX 1003MOT:M8310	✳	–	✔	335	0.15	1.0	–	–	–	✔	315	0.15	1.0	–	–	–	–	–	–	✔	65	0.12	0.7
RDHX 1003MOT:M8325	✳	–	✔	250	0.15	1.0	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
RDHX 1003MOT:M8345	✳	–	✔	225	0.15	1.0	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–

RDHT 10-FA

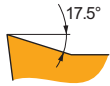
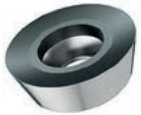


	INSD	D1	S
	(mm)	(mm)	(mm)
1003	10.000	3.90	3.18



Lämplighet och startvärden för skärhastighet (vc), matning (f) och skärdjup (ap). Vi refererar till vår Dormer Pramet Calculator-app för vidare beräkningar.

Product	RE (mm)	P			M			K			N			S			H		
		vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)



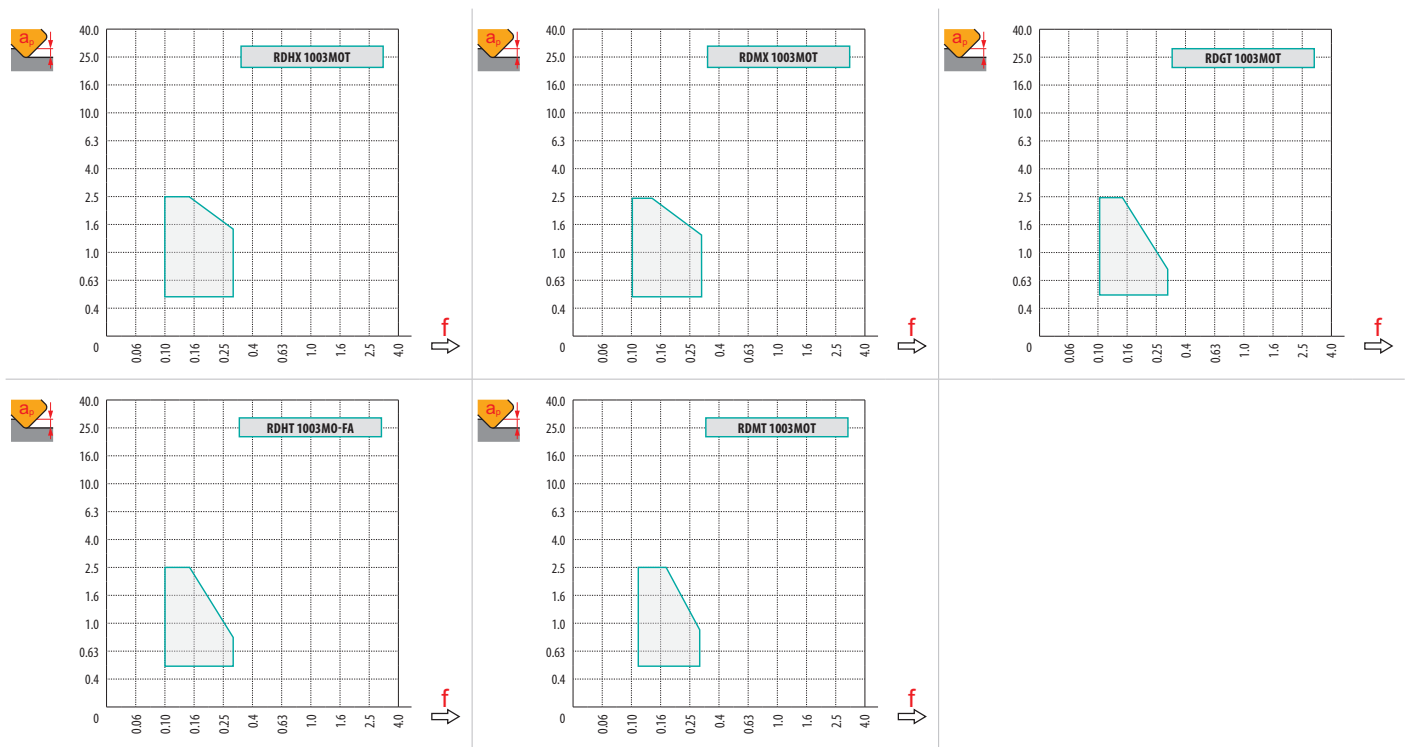
FA geometri med mycket positiv design för fin till medelfin fräsning.

RDHT 1003MO-FA:HF7	●	-	-	-	-	-	-	-	-	-	■	390	0.18	1.0	-	-	-	-	-
---------------------------	---	---	---	---	---	---	---	---	---	---	---	-----	------	-----	---	---	---	---	---

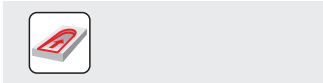


a_e / DCX	5 %	10 %	15 %	20 %	25 %	30 %	40 %	50 %	60 %	70 %	75 %	80 %	90 %	100 %
	1.48	1.35	1.27	1.22	1.19	1.16	1.11	1.08	1.05	1.03	1.00	1.00	1.00	1.00
	2.20	1.60	1.35	1.20	1.10	0.95	0.85	0.75	0.85	0.95	1.00	1.00	1.00	1.00
	0.64	0.64	0.64	0.64	0.64	0.65	0.65	0.67	0.68	0.71	0.72	0.74	0.79	1.00

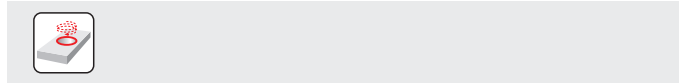
	RDHX 10	RDMX 10	RDGT 10	RDHT 10-FA	RDMT 10
	5.0	5.0	5.0	5.0	5.0
	-	-	-	-	-



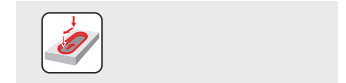
		0.00	0.50	0.75	1.00	1.25	1.50	2.00	2.50	3.00	3.50	4.00	5.00
20		10.0	14.4	15.3	16.0	16.6	17.1	18.0	18.7	19.2	19.5	19.8	20.0
25		15.0	19.4	20.3	21.0	21.6	22.1	23.0	23.7	24.2	24.5	24.8	25.0
30		20.0	24.4	25.3	26.0	26.6	27.1	28.0	28.7	29.2	29.5	29.8	30.0
32		22.0	26.4	27.3	28.0	28.6	29.1	30.0	30.7	31.2	31.5	31.8	32.0
35		25.0	29.4	30.3	31.0	31.6	32.1	33.0	33.7	34.2	34.5	34.8	35.0
42		32.0	36.4	37.3	38.0	38.6	39.1	40.0	40.7	41.2	41.5	41.8	42.0
52		42.0	46.4	47.3	48.0	48.6	49.1	50.0	50.7	51.2	51.5	51.8	52.0
			0.00	0.50	0.75	1.00	1.25	1.50	2.00	2.50	3.00	3.50	4.00
		-	0.54	0.44	0.39	0.35	0.32	0.28	0.25	0.23	0.22	0.21	0.19



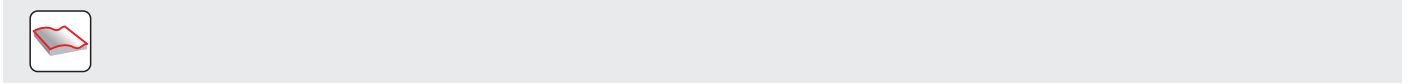
	RPMX	APMX/I
20	20	2.5/15
25	12	2.5/25
30	8	2.5/37
32	7.5	2.5/20
35	7	2.5/42
42	4	2.5/37
52	3	2.5/49



	DMIN	DMAX		
			DMIN	DMAX
20	22.0	40.0	2.5	2.5
25	32.0	50.0	2.5	2.5
30	42.0	60.0	2.5	2.5
32	46.0	64.0	2.5	2.5
35	52.0	70.0	2.5	2.5
42	66.0	84.0	2.5	2.5
52	86.0	104.0	2.5	2.5



	2.5
--	-----



		3	5	10	15	20	30	40	50	60	80	100
20		0.490	0.632	0.894	1.095	1.265	1.549	1.789	2.000	2.191	2.530	2.828
25		0.548	0.707	1.000	1.225	1.414	1.732	2.000	2.236	2.449	2.828	3.162
30		0.600	0.775	1.095	1.342	1.549	1.897	2.191	2.449	2.683	3.098	3.464
32		0.620	0.800	1.131	1.386	1.600	1.960	2.263	2.530	2.771	3.200	3.578
35		0.648	0.837	1.183	1.449	1.673	2.049	2.366	2.646	2.898	3.347	3.742
42		0.710	0.917	1.296	1.587	1.833	2.245	2.592	2.898	3.175	3.666	4.099
52		0.790	1.020	1.442	1.766	2.040	2.498	2.884	3.225	3.533	4.079	4.561
		3	5	10	15	20	30	40	50	60	80	100
5.0		0.346	0.447	0.632	0.775	0.894	1.095	1.265	1.414	1.549	1.789	2.000

SRD12

P M K N S H

PRAMET

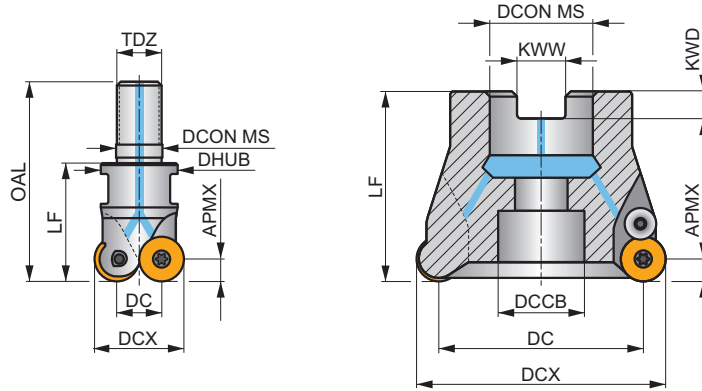
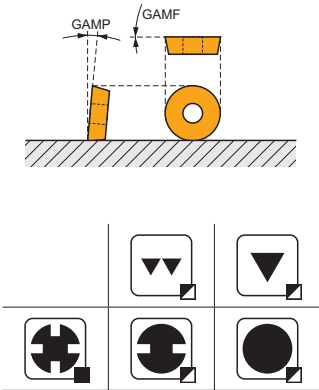
(S(C))



Kopierfräs för runda RD.. 12-skär, invändig kylning

Kopierfräs för positiva RD.. 12-skär med APMX 3 mm. Invändig kylning. För plan-, hörn- och dykfräsning, rampning, mm. Finns med modulärt och dornfäste. Diametrar från 24 till 80 mm. Behandlad för lång livslängd.

APMX	3.0 mm
------	--------



	0.065 - 0.25					
	0.065 - 0.22					

Product	DCX	DC	OAL	DCON MS	DHUB	DCCB	LF	TDZ	KWW	KWD	GAMF	GAMP					kg			
	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)		(mm)	(mm)	(°)	(°)								
24E2R032M12-SRD12-CF	24	12	54	12.5	21	-	32	M12	-	-	-3	0	2	-	21900	✓	0.10	GI120	C0362	
35E3R042M16-SCRD12-CF	35	23	65	17	29	-	42	M16	-	-	0	0	3	-	18100	✓	0.22	GI120	C0364	
35E4R042M16-SRD12-CF	35	23	65	17	29	-	42	M16	-	-	0	0	4	-	18100	✓	0.20	GI120	C0362	
42E4R042M16-SCRD12-CF	42	30	65	17	29	-	42	M16	-	-	0	0	4	-	16600	✓	0.21	GI120	C0364	
42E5R042M16-SRD12-CF	42	30	65	17	29	-	42	M16	-	-	0	0	5	-	16600	✓	0.22	GI120	C0366	
50A05R-SCMORD12-CF	50	38	-	22	-	18	50	-	10.4	10.4	2	7	5	-	15200	✓	0.29	GI120	C0366	
52A05R-SCMORD12-CF	52	40	-	22	-	18	50	-	10.4	10.4	2	7	5	-	14900	✓	0.44	GI120	C0366	
66A06R-SCMORD12-CF	66	54	-	27	-	22	50	-	12.4	12.4	2	7	6	-	13200	✓	0.54	GI120	C0370	
80A07R-SCMORD12-CF	80	68	-	27	-	38	52	-	12.4	12.4	2	7	7	-	12000	✓	0.89	GI120	C0372	

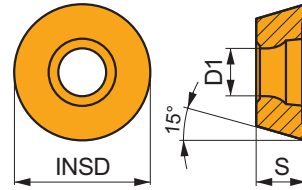
GI120	RD.. 12T3MOT	RDHT 12T3MO-FA

C0362	US 3508-T15P	3.5	M 3.5	8	-	-	Flag T15P	-	-
C0364	US 3006-T09P	2.0	M 3	6	D-T07P/T09P	FG-15	-	CS12P	-
C0366	US 3508-T15P	3.5	M 3.5	8	D-T08P/T15P	FG-15	-	CS12P	HS 1030C
C0370	US 3508-T15P	3.5	M 3.5	8	D-T08P/T15P	FG-15	-	CS12P	HS 1230C
C0372	US 3508-T15P	3.5	M 3.5	8	D-T08P/T15P	FG-15	-	CS12P	-

RDGT 12

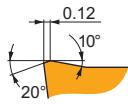


	INSD	D1	S
	(mm)	(mm)	(mm)
12T3	12.000	3.90	3.97



Lämplighet och startvärden för skärhastighet (vc), matning (f) och skärdjup (ap). Vi refererar till vår Dormer Pramet Calculator-app för vidare beräkningar.

Product	RE (mm)	P			M			K			N			S			H		
		vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
		(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)



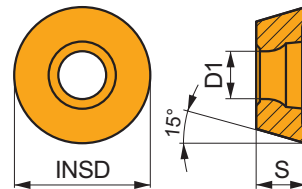
MOT positiv design för finfräsning.

RDGT 12T3MOT:M6330	✳	–	■	260	0.20	1.5	■	185	0.18	1.5	■	–	–	–	■	75	0.14	1.2	■	–	–	–	
RDGT 12T3MOT:M8310	✳	–	■	330	0.20	1.5	■	165	0.18	1.5	■	■	310	0.20	1.5	■	–	–	–	■	–	–	–
RDGT 12T3MOT:M8325	✳	–	■	250	0.20	1.5	■	120	0.18	1.5	■	■	–	–	–	■	–	–	–	■	–	–	–
RDGT 12T3MOT:M8345	✳	–	■	225	0.20	1.5	■	135	0.18	1.5	■	■	–	–	–	■	55	0.14	1.2	■	–	–	–
RDGT 12T3MOT:M9340	✳	–	■	340	0.20	1.5	■	200	0.18	1.5	■	■	–	–	–	■	85	0.14	1.2	■	–	–	–

RDMT 12

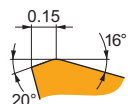


	INSD	D1	S
	(mm)	(mm)	(mm)
12T3	12.000	3.90	3.97



Lämplighet och startvärden för skärhastighet (vc), matning (f) och skärdjup (ap). Vi refererar till vår Dormer Pramet Calculator-app för vidare beräkningar.

Product	RE (mm)	P			M			K			N			S			H		
		vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
		(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)



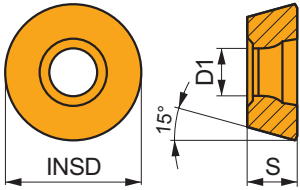
MOT positiv design för finfräsning.

RDMT 12T3MOT:M8345	✳	–	■	225	0.20	1.5	■	135	0.18	1.5	■	■	–	–	–	■	–	–	–	■	–	–	–
---------------------------	---	---	---	-----	------	-----	---	-----	------	-----	---	---	---	---	---	---	---	---	---	---	---	---	---

RDMX 12

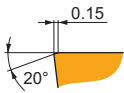
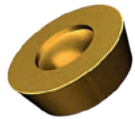


	INSD (mm)	D1 (mm)	S (mm)
12T3	12.000	3.90	3.97



Lämplighet och startvärden för skärhastighet (vc), matning (f) och skärdjup (ap). Vi refererar till vår Dormer Pramet Calculator-app för vidare beräkningar.

Product	RE (mm)	P			M			K			N			S			H		
		vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)



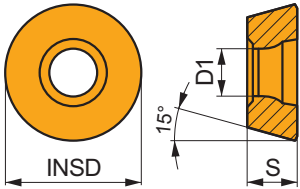
MOT neutral spånvinkel för finfräsning.

RDMX 12T3MOT:M8310	✳	–	✔	300	0.20	1.5	–	–	–	■	285	0.20	1.5	–	–	–	–	–	–	■	60	0.10	0.8
RDMX 12T3MOT:M8325	✳	–	✔	225	0.20	1.5	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
RDMX 12T3MOT:M8345	✳	–	✔	200	0.20	1.5	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–

RDHX 12

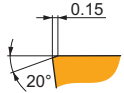


	INSD (mm)	D1 (mm)	S (mm)
12T3	12.000	3.90	3.97



Lämplighet och startvärden för skärhastighet (vc), matning (f) och skärdjup (ap). Vi refererar till vår Dormer Pramet Calculator-app för vidare beräkningar.

Product	RE (mm)	P			M			K			N			S			H		
		vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)



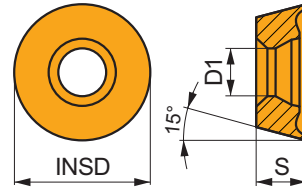
MOT neutral spånvinkel för finfräsning.

RDHX 12T3MOT:M4303	✳	–	✔	300	0.20	1.5	–	–	–	■	285	0.20	1.5	–	–	–	–	–	–	■	60	0.14	0.8
RDHX 12T3MOT:M8310	✳	–	✔	300	0.20	1.5	–	–	–	■	285	0.20	1.5	–	–	–	–	–	–	■	60	0.14	0.8
RDHX 12T3MOT:M8325	✳	–	✔	225	0.20	1.5	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
RDHX 12T3MOT:M8345	✳	–	✔	200	0.20	1.5	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–

RDHT 12-FA

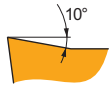


	INSD	D1	S
	(mm)	(mm)	(mm)
12T3	12.000	3.90	3.97



Lämplighet och startvärden för skärhastighet (vc), matning (f) och skärdjup (ap). Vi refererar till vår Dormer Pramet Calculator-app för vidare beräkningar.

Product	RE (mm)	P			M			K			N			S			H		
		vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)



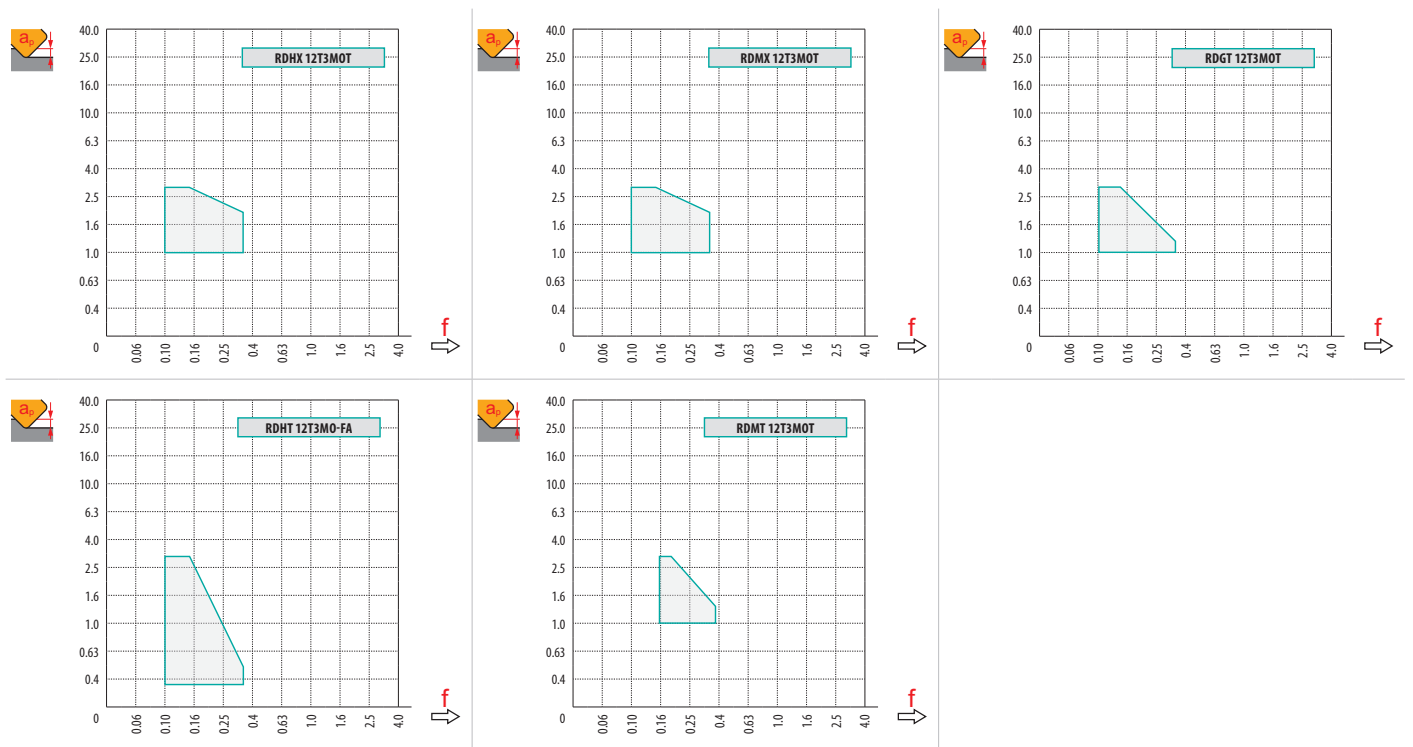
FA geometri med mycket positiv design för fin till medelfin fräsning.

RDHT 12T3M0-FA:HF7	●	-	-	-	-	-	-	-	-	-	■	360	0.24	1.5	-	-	-	-	-
---------------------------	---	---	---	---	---	---	---	---	---	---	---	-----	------	-----	---	---	---	---	---



a_e / DCX	5 %	10 %	15 %	20 %	25 %	30 %	40 %	50 %	60 %	70 %	75 %	80 %	90 %	100 %
	1.48	1.35	1.27	1.22	1.19	1.16	1.11	1.08	1.05	1.03	1.00	1.00	1.00	1.00
	2.20	1.60	1.35	1.20	1.10	0.95	0.85	0.75	0.85	0.95	1.00	1.00	1.00	1.00
	0.64	0.64	0.64	0.64	0.64	0.65	0.65	0.67	0.68	0.71	0.72	0.74	0.79	1.00

	RDHX 12	RDMX 12	RDGT 12	RDHT 12-FA	RDMT 12
	6.0	6.0	6.0	6.0	6.0
	-	-	-	-	-



		0.00	0.50	0.75	1.00	1.25	1.50	2.00	2.50	3.00	3.50	4.00	5.00	6.00
24		12.0	16.8	17.8	18.6	19.3	19.9	20.9	21.7	22.4	22.9	23.3	23.8	24.0
35		23.0	27.8	28.8	29.6	30.3	30.9	31.9	32.7	33.4	33.9	34.3	34.8	35.0
42		30.0	34.8	35.8	36.6	37.3	37.9	38.9	39.7	40.4	40.9	41.3	41.8	42.0
50		38.0	42.8	43.8	44.6	45.3	45.9	46.9	47.7	48.4	48.9	49.3	49.8	50.0
52		40.0	44.8	45.8	46.6	47.3	47.9	48.9	49.7	50.4	50.9	51.3	51.8	52.0
66		54.0	58.8	59.8	60.6	61.3	61.9	62.9	63.7	64.4	64.9	65.3	65.8	66.0
80	68.0	72.8	73.8	74.6	75.3	75.9	76.9	77.7	78.4	78.9	79.3	79.8	80.0	
		0.00	0.50	0.75	1.00	1.25	1.50	2.00	2.50	3.00	3.50	4.00	5.00	6.00
		-	0.49	0.40	0.35	0.32	0.29	0.25	0.23	0.21	0.20	0.18	0.17	0.16

	RPMX	APMX/I
24	25.0	3.0/14
35	9.0	3.0/39
42	8.0	3.0/44
50	4.0	3.0/87
52	4.0	3.0/87
66	3.0	3.0/100
80	2.2	3.0/100

	DMIN	DMAX		
			DMIN	DMAX
24	26.0	48.0	3.0	3.0
35	46.0	70.0	3.0	3.0
42	62.0	84.0	3.0	3.0
50	78.0	100.0	2.8	2.8
52	82.0	104.0	2.8	2.8
66	110.0	132.0	2.8	2.8
80	136.0	160.0	2.8	2.8

2.8

		3	5	10	15	20	30	40	50	60	80	100
24		0.537	0.693	0.980	1.200	1.386	1.697	1.960	2.191	2.400	2.771	3.098
35		0.648	0.837	1.183	1.449	1.673	2.049	2.366	2.646	2.898	3.347	3.742
42		0.710	0.917	1.296	1.587	1.833	2.245	2.592	2.898	3.175	3.666	4.099
50		0.775	1.000	1.414	1.732	2.000	2.449	2.828	3.162	3.464	4.000	4.472
52		0.790	1.020	1.442	1.766	2.040	2.498	2.884	3.225	3.533	4.079	4.561
66		0.890	1.149	1.625	1.990	2.298	2.814	3.250	3.633	3.980	4.596	5.138
80		0.980	1.265	1.789	2.191	2.530	3.098	3.578	4.000	4.382	5.060	5.657
		3	5	10	15	20	30	40	50	60	80	100
6.0		0.379	0.490	0.693	0.849	0.980	1.200	1.386	1.549	1.697	1.960	2.191

SRD16

P M K N S H

PRAMET

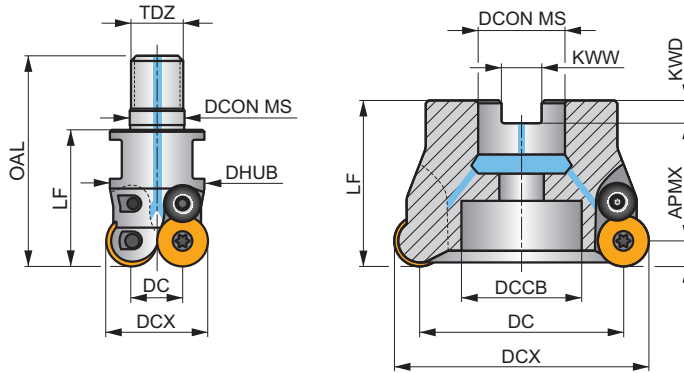
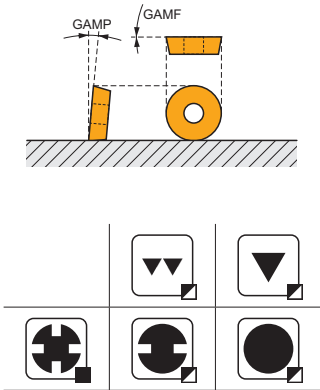
(S)(C)



Kopierfräs för runda RD.. 16-skär, invändig kylning

Kopierfräs för positiva RD.. 16-skär med APMX 4 mm. Invändig kylning. För plan-, hörn- och dykfräsning, rampning, mm. Finns med modulärt och dornfäste. Diametrar från 32 till 100 mm. Behandlad för lång livslängd.

APMX	4.0 mm
------	--------



	0.11 - 0.25					
	0.1 - 0.2					

Product	DCX	DC	OAL	DCON MS	DHUB	DCCB	LF	TDZ	KWW	KWD	GAMF	GAMP							
	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(°)	(°)							
32E2R042M16-SCRD16-CF	32	16	65	17	29	-	42	M16	-	-	-2	0	2	-	12600	✓	0.18	G1121	C0374
52A04R-SCMORD16-CF	52	36	-	22	-	16.5	50	-	10.4	10.4	0	7	4	-	9900	✓	0.41	G1121	C0376
66A05R-SCMORD16-CF	66	50	-	27	-	22	50	-	12.4	12.4	0	7	5	-	8800	✓	0.60	G1121	C0378
80A06R-SCMORD16-CF	80	64	-	27	-	38	52	-	12.4	12.4	0	7	6	-	8000	✓	0.87	G1121	C0380
100A07R-SCMORD16-CF	100	84	-	32	-	45	52	-	14.4	14.4	0	7	7	-	7100	✓	1.41	G1121	C0380

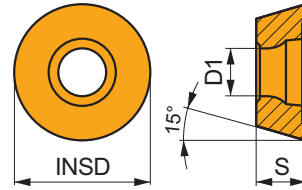
G1121	RD.. 1604MOT	RDHT 1604MO-FA

C0374	US 64510-T20P	4.5	M 4.5	10	-	Flag T20P	CS16P	-
C0376	US 64510-T20P	4.5	M 4.5	10	SDR T20P-T	-	CS16P	HS 1030C
C0378	US 64510-T20P	4.5	M 4.5	10	SDR T20P-T	-	CS16P	HS 1230C
C0380	US 64510-T20P	4.5	M 4.5	10	SDR T20P-T	-	CS16P	-

RDGT 16

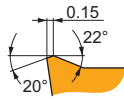


	INSD	D1	S
	(mm)	(mm)	(mm)
1604	16.000	5.20	4.76



Lämplighet och startvärden för skärhastighet (vc), matning (f) och skärdjup (ap). Vi refererar till vår Dormer Pramet Calculator-app för vidare beräkningar.

Product	RE (mm)	P			M			K			N			S			H		
		vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)



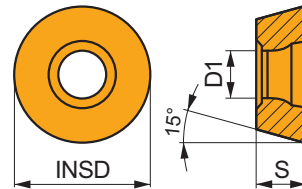
MOT positiv design för finfräsning.

RDGT 1604MOT:M8310	☉	–	■	285	0.30	2.0	▣	145	0.27	2.0	■	270	0.30	2.0	–	–	–	–	–	–	–
RDGT 1604MOT:M8325	☉	–	■	220	0.30	2.0	▣	105	0.27	2.0	–	–	–	–	–	–	–	–	–	–	
RDGT 1604MOT:M8345	☉	–	■	200	0.30	2.0	▣	120	0.27	2.0	–	–	–	–	–	–	▣	50	0.21	1.6	–

RDMX 16

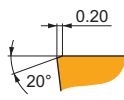


	INSD	D1	S
	(mm)	(mm)	(mm)
1604	16.000	5.20	4.76



Lämplighet och startvärden för skärhastighet (vc), matning (f) och skärdjup (ap). Vi refererar till vår Dormer Pramet Calculator-app för vidare beräkningar.

Product	RE (mm)	P			M			K			N			S			H		
		vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)



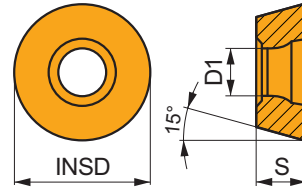
MOT neutral spåninkel för finfräsning.

RDMX 1604MOT:M8310	☉	–	▣	255	0.30	2.0	–	–	–	–	■	240	0.30	2.0	–	–	–	–	–	–	■	50	0.15	1.1
---------------------------	---	---	---	-----	------	-----	---	---	---	---	---	-----	------	-----	---	---	---	---	---	---	---	----	------	-----

RDHX 16

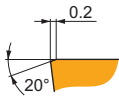


	INSD	D1	S
	(mm)	(mm)	(mm)
1604	16.000	5.20	4.76



Lämplighet och startvärden för skärhastighet (vc), matning (f) och skärdjup (ap). Vi refererar till vår Dormer Pramet Calculator-app för vidare beräkningar.

Product	RE (mm)	P			M			K			N			S			H		
		vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)



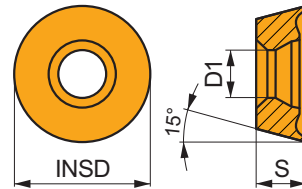
MOT neutral spånvinkel för finfräsning.

RDHX 1604MOT:M8310	☼	–	✓	255	0.30	2.0	–	–	–	■	240	0.30	2.0	–	–	–	–	–	–	■	50	0.15	1.1
RDHX 1604MOT:M8325	☼	–	✓	195	0.30	2.0	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
RDHX 1604MOT:M8345	☼	–	✓	180	0.30	2.0	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
RDHX 1604MOT:M9325	☼	–	✓	290	0.30	2.0	–	–	–	■	275	0.30	2.0	–	–	–	–	–	–	■	55	0.15	1.1

RDHT 16-FA

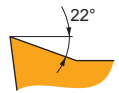


	INSD	D1	S
	(mm)	(mm)	(mm)
1604	16.000	5.20	4.76



Lämplighet och startvärden för skärhastighet (vc), matning (f) och skärdjup (ap). Vi refererar till vår Dormer Pramet Calculator-app för vidare beräkningar.

Product	RE (mm)	P			M			K			N			S			H		
		vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)



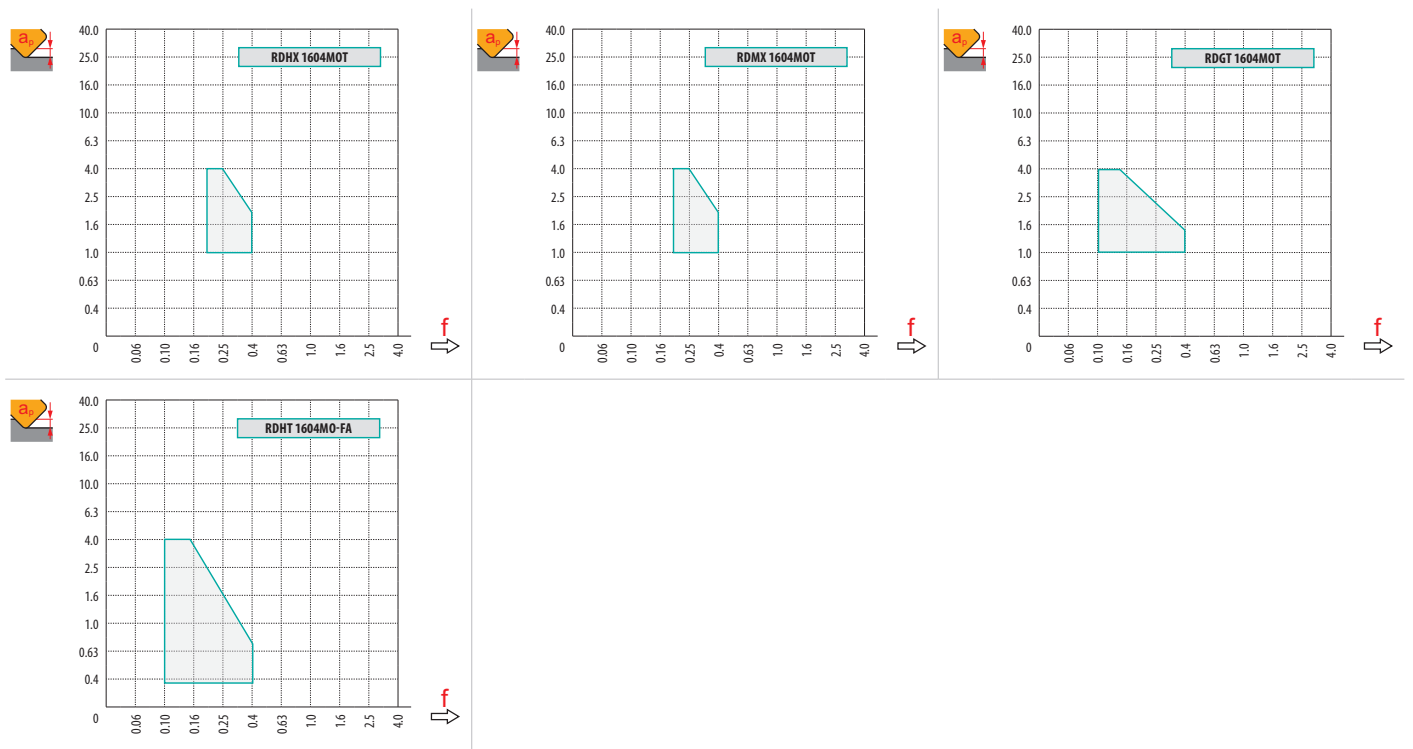
FA geometri med mycket positiv design för fin till medelfin fräsning.

RDHT 1604MO-FA:HF7	●	–	–	–	–	–	–	–	–	–	–	–	■	315	0.36	2.0	–	–	–	–	–	–	–
--------------------	---	---	---	---	---	---	---	---	---	---	---	---	---	-----	------	-----	---	---	---	---	---	---	---



a_e / DCX	5 %	10 %	15 %	20 %	25 %	30 %	40 %	50 %	60 %	70 %	75 %	80 %	90 %	100 %
	1.48	1.35	1.27	1.22	1.19	1.16	1.11	1.08	1.05	1.03	1.00	1.00	1.00	1.00
	2.20	1.60	1.35	1.20	1.10	0.95	0.85	0.75	0.85	0.95	1.00	1.00	1.00	1.00
	0.64	0.64	0.64	0.64	0.64	0.65	0.65	0.67	0.68	0.71	0.72	0.74	0.79	1.00

	RDHX 16	RDMX 16	RDGT 16	RDHT 16-FA
	8.0	8.0	8.0	8.0
	-	-	-	-



		0.00	0.50	0.75	1.00	1.25	1.50	2.00	2.50	3.00	3.50	4.00	5.00	6.00	7.00	8.00
32		16.0	21.6	22.8	23.7	24.6	25.3	26.6	27.6	28.5	29.2	29.9	30.8	31.5	31.9	32.0
52		36.0	41.6	42.8	43.7	44.6	45.3	46.6	47.6	48.5	49.2	49.9	50.8	51.5	51.9	52.0
66		50.0	55.6	56.8	57.7	58.6	59.3	60.6	61.6	62.5	63.2	63.9	64.8	65.5	65.9	66.0
80		64.0	69.6	70.8	71.7	72.6	73.3	74.6	75.6	76.5	77.2	77.9	78.8	79.5	79.9	80.0
100		84.0	89.6	90.8	91.7	92.6	93.3	94.6	95.6	96.5	97.2	97.9	98.8	99.5	99.9	100.0
		0.00	0.50	0.75	1.00	1.25	1.50	2.00	2.50	3.00	3.50	4.00	5.00	6.00	7.00	8.00
		-	0.91	0.74	0.65	0.58	0.53	0.46	0.42	0.38	0.36	0.34	0.30	0.28	0.26	0.25

	RPMX	APMX/I
32	25.0	4.0/19
52	8.0	4.0/58
66	6.0	4.0/78
80	4.0	4.0/100
100	3.0	4.0/100
















	DMIN	DMAX		
32	34.0	64.0	4.0	4.0
52	74.0	104.0	4.0	4.0
66	102.0	132.0	4.0	4.0
80	130.0	160.0	4.0	4.0
100	170.0	200.0	4.0	4.0

4.0

		3	5	10	15	20	30	40	50	60	80	100
32		0.620	0.800	1.131	1.386	1.600	1.960	2.263	2.530	2.771	3.200	3.578
52		0.790	1.020	1.442	1.766	2.040	2.498	2.884	3.225	3.533	4.079	4.561
66		0.890	1.149	1.625	1.990	2.298	2.814	3.250	3.633	3.980	4.596	5.138
80		0.980	1.265	1.789	2.191	2.530	3.098	3.578	4.000	4.382	5.060	5.657
100		1.095	1.414	2.000	2.449	2.828	3.464	4.000	4.472	4.899	5.657	6.325
		3	5	10	15	20	30	40	50	60	80	100
8.0		0.438	0.566	0.800	0.980	1.131	1.386	1.600	1.789	1.960	2.263	2.530

INDEXABLE FACE MILLS – NAVIGATOR

COPY MILLING – SEAT WITH LOCATING FLATS

	SRC10		SRC12		SRC16		SRC20													
	-		-		-		-													
	APMX (mm)	5.0	APMX (mm)	6.0	APMX (mm)	8.0	APMX (mm)	10.0												
	DCX (mm)	25 – 66	DCX (mm)	40 – 100	DCX (mm)	63 – 160	DCX (mm)	80 – 160												
Cylindrical shank																				
	DCX = 25, 32 (mm)																			
Weldon																				
Modular																				
	DCX = 25– 35 (mm)																			
Shell mill																				
	DCX = 40 – 66 (mm)																			
Page	186		190		194		198													
ISO	P	M	K	S	H	P	M	K	S	H	P	M	K	S	H	P	M	K	S	H
Insert shape																				
Inserts	RC 10T3		RC 1204		RC 1606		RC 2006													
No. of cutting edges	8		12		8		8													
Kopierfräsning 	■		■		■		■													
Planfräsning 	■		■		■		■													
Spiralinterpolering 	■		■		■		■													
Progressiv dykfräsning 	■		■		■		■													
Rampning 	■		■		■		■													

SRC10

P M K S H

PRAMET

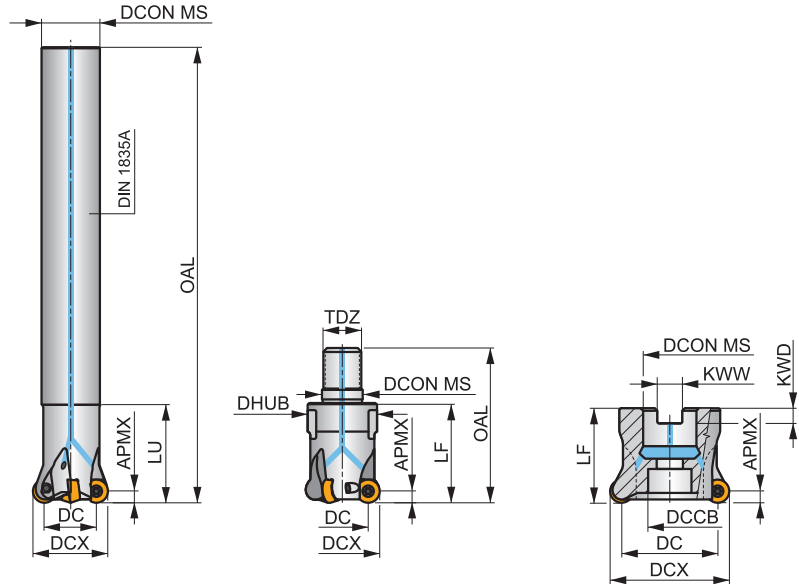
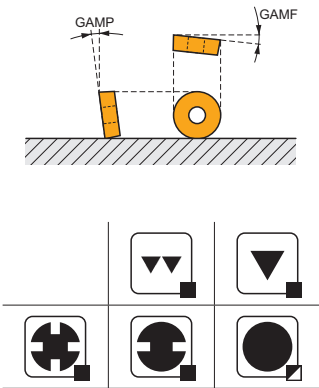
S



Kopierfräs för runda RCMT 10-skär, invändig kylning

Kopierfräs för positiva RCMT 10-skär med APMX 5 mm. Invändig kylning. För plan-, hörn- och högmättningsfräsning, mm. Finns med cyl. skaft, modulärt och för dormmontering. Diametrar från 25 till 66 mm. Behandlad för lång livslängd.

APMX	5.0 mm
------	--------



	0.05 - 0.12					
	0.08 - 0.15					

Product	DCX	DC	OAL	DCON MS	DHUB	DCCB	LU	LF	TDZ	KWW	KWD	GAMF	GAMP				max.	kg	
	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(°)	(°)							
25E2R034A20-SRC10-C	25	15	170	20	-	-	34	-	-	-	-	-3	-7	2	-	20900	✓	0.40	GI328 C0010
25E3R034A20-SRC10-C	25	15	170	20	-	-	34	-	-	-	-	-3	-7	3	-	20900	✓	0.36	GI328 C0010
32E3R042A25-SRC10-C	32	22	200	25	-	-	42	-	-	-	-	-2.6	-7	4	-	18500	✓	0.67	GI328 C0010
32E4R042A25-SRC10-C	32	22	200	25	-	-	42	-	-	-	-	-2.6	-7	3	-	18500	✓	0.70	GI328 C0010
25E2R032M12-SRC10-C	25	15	54	12.5	21	-	-	32	M12	-	-	-3	-7	2	-	20900	✓	0.11	GI328 C0010
25E3R032M12-SRC10-C	25	15	54	12.5	21	-	-	32	M12	-	-	-3	-7	3	-	20900	✓	0.08	GI328 C0010
32E4R042M16-SRC10-C	32	22	65	17	29	-	-	42	M16	-	-	-2.6	-7	4	-	18500	✓	0.20	GI328 C0010
35E4R042M16-SRC10-C	35	25	65	17	29	-	-	42	M16	-	-	-2.4	-7	4	-	17700	✓	0.20	GI328 C0010
40A05R-SMORC10-C	40	30	-	16	-	14	-	40	-	8.4	5.6	-2.2	-7	5	-	16500	✓	0.21	GI328 C0012
50A05R-SMORC10-C	50	40	-	22	-	18	-	40	-	10.4	6.3	-2	-7	5	-	14800	✓	0.34	GI328 C0013
50A06R-SMORC10-C	50	40	-	22	-	18	-	40	-	10.4	6.3	-2	-7	6	-	14800	✓	0.33	GI328 C0013
52A05R-SMORC10-C	52	42	-	22	-	18	-	40	-	10.4	6.3	-2	-7	5	-	14500	✓	0.35	GI328 C0013
52A06R-SMORC10-C	52	42	-	22	-	18	-	40	-	10.4	6.3	-2	-7	6	-	14500	✓	0.28	GI328 C0013
63A06R-SMORC10-C	63	53	-	22	-	18	-	40	-	10.4	6.3	-1.8	-7	6	-	13200	✓	0.52	GI328 C0013
63A07R-SMORC10-C	63	53	-	22	-	18	-	40	-	10.4	6.3	-1.8	-7	7	-	13200	✓	0.52	GI328 C0013
66A06R-SMORC10-C	66	56	-	27	-	22	-	50	-	12.4	7	-1.4	-7	6	-	12800	✓	0.58	GI328 C0014
66A07R-SMORC10-C	66	56	-	27	-	22	-	50	-	12.4	7	-1.4	-7	7	-	12800	✓	0.60	GI328 C0014

	RCMT 10T3MO..
--	---------------

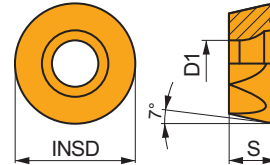
C0010	US 63509-T10P	3.0	M 3.5	9	Flag T10P	-
C0012	US 63509-T10P	3.0	M 3.5	9	Flag T10P	HS 0830C

C0013	US 63509-T10P	3.0	M 3.5	9	Flag T10P	HS 1030C
C0014	US 63509-T10P	3.0	M 3.5	9	Flag T10P	HS 1230C

RCMT 10

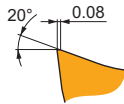


	INSD	D1	S
	(mm)	(mm)	(mm)
10T3	10.000	3.90	3.97



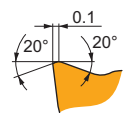
Lämplighet och startvärden för skärhastighet (vc), matning (f) och skärdjup (ap). Vi refererar till vår Dormer Pramet Calculator-app för vidare beräkningar.

Product	RE (mm)	P			M			K			N			S			H		
		vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)



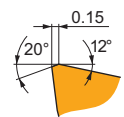
F geometri med mycket positiv design för finfräsning.

RCMT 10T3MOSN-F:M6330	✱	-	■	340	0.10	1.0	■	240	0.09	1.0	-	-	-	-	-	-	■	100	0.08	0.8	-	-	-
RCMT 10T3MOSN-F:M8330	✱	-	■	395	0.10	1.0	■	235	0.09	1.0	-	-	-	-	-	-	■	95	0.08	0.8	-	-	-



M geometri med mycket positiv design för medelfin fräsning.

RCMT 10T3MOSN-M:M6330	✱	-	■	310	0.12	1.0	■	220	0.11	1.0	-	-	-	-	-	-	■	90	0.11	0.8	-	-	-	
RCMT 10T3MOSN-M:M8310	✱	-	■	400	0.12	1.0	■	200	0.11	1.0	■	380	0.12	1.0	-	-	-	-	-	-	-	-	-	
RCMT 10T3MOSN-M:M8330	✱	-	■	360	0.12	1.0	■	215	0.11	1.0	■	340	0.12	1.0	-	-	-	■	90	0.11	0.8	-	-	-
RCMT 10T3MOSN-M:M8340	✱	-	■	330	0.12	1.0	■	195	0.11	1.0	■	310	0.12	1.0	-	-	-	■	80	0.11	0.8	-	-	-



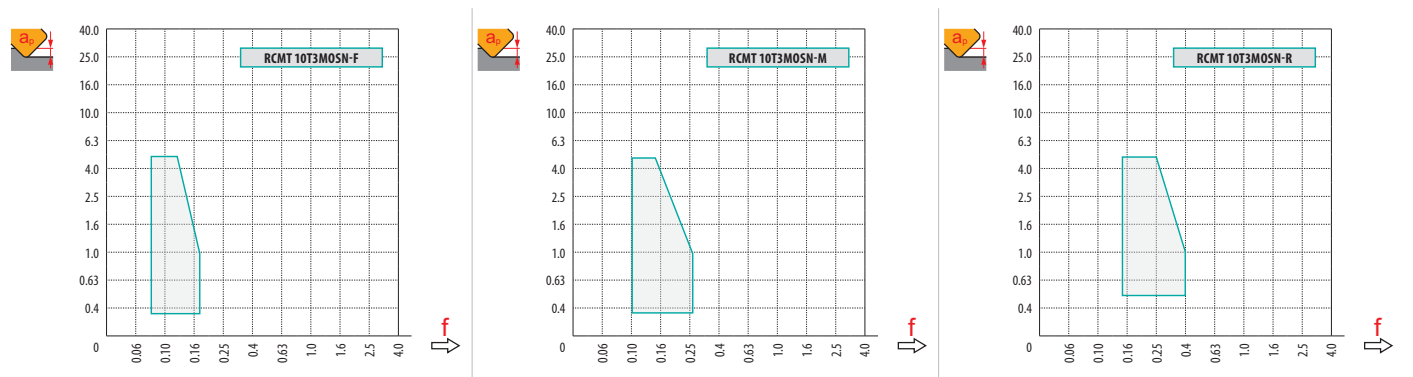
R geometri med positiv design för grov kopierfräsning.

RCMT 10T3MOSN-R:M8310	✱	-	■	345	0.17	1.0	-	-	-	-	■	325	0.17	1.0	-	-	-	-	-	-	■	65	0.12	0.7	
RCMT 10T3MOSN-R:M8330	✱	-	■	310	0.17	1.0	-	-	-	-	■	290	0.17	1.0	-	-	-	■	75	0.17	0.8	■	60	0.12	0.7

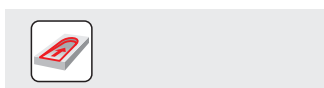


a_e / DCX	5 %	10 %	15 %	20 %	25 %	30 %	40 %	50 %	60 %	70 %	75 %	80 %	90 %	100 %
	1.48	1.35	1.27	1.22	1.19	1.16	1.11	1.08	1.05	1.03	1.00	1.00	1.00	1.00
	2.20	1.60	1.35	1.20	1.10	0.95	0.85	0.75	0.85	0.95	1.00	1.00	1.00	1.00
	0.64	0.64	0.64	0.64	0.64	0.65	0.65	0.67	0.68	0.71	0.72	0.74	0.79	1.00

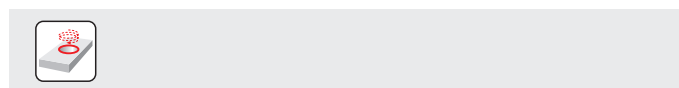
	RCMT 10-F	RCMT 10-M	RCMT 10-R
	5.0	5.0	5.0
	—	—	—



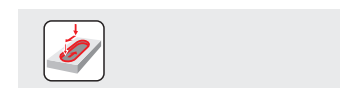
DCX	a_e	0.00	0.15	0.30	0.50	0.75	1.00	1.25	1.50	2.00	2.50	3.00	4.00	5.00
25		15.00	17.43	18.41	19.36	20.27	21.00	21.61	22.14	23.00	23.66	24.17	24.80	25.00
32		22.00	24.43	25.41	26.36	27.27	28.00	28.61	29.14	30.00	30.66	31.17	31.80	32.00
35		25.00	27.43	28.41	29.36	30.27	31.00	31.61	32.14	33.00	33.66	34.17	34.80	35.00
40		30.00	32.43	33.41	34.36	35.27	36.00	36.61	37.14	38.00	38.66	39.17	39.80	40.00
50		40.00	42.43	43.41	44.36	45.27	46.00	46.61	47.14	48.00	48.66	49.17	49.80	50.00
52		42.00	44.43	45.41	46.36	47.27	48.00	48.61	49.14	50.00	50.66	51.17	51.80	52.00
63		53.00	55.43	56.41	57.36	58.27	59.00	59.61	60.14	61.00	61.66	62.17	62.80	63.00
66	56.00	58.43	59.41	60.36	61.27	62.00	62.61	63.14	64.00	64.66	65.17	65.80	66.00	
	a_e	—	0.15	0.30	0.50	0.75	1.00	1.25	1.50	2.00	2.50	3.00	4.00	5.00
	f	—	0.90	0.64	0.50	0.41	0.35	0.32	0.29	0.25	0.23	0.21	0.19	0.17



DCX	RPMX	APMX/I
25	13.2	5/23
32	12.6	5/24
35	12.3	5/24
40	9.5	5/31
50	6.4	5/46
52	6.1	5/48
63	4.7	5/62
66	4.4	5/66



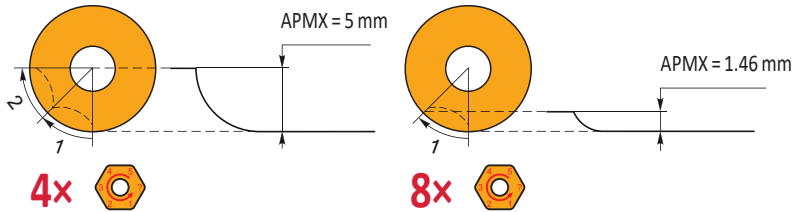
DCX	DMIN	DMAX	SMAX DMIN	SMAX DMAX
25	32.0	50.0	3.0	3.0
32	45.0	64.0	3.0	3.0
35	51.0	70.0	3.0	3.0
40	61.0	80.0	3.0	3.0
50	81.0	100.0	3.0	3.0
52	85.0	104.0	3.0	3.0
63	107.0	126.0	3.0	3.0
66	113.0	132.0	3.0	3.0



a_e
2.24



	μm	3	5	10	15	20	30	40	50	60	80	100
25		0.548	0.707	1.000	1.225	1.414	1.732	2.000	2.236	2.449	2.828	3.162
32		0.620	0.800	1.131	1.386	1.600	1.960	2.263	2.530	2.771	3.200	3.578
35		0.648	0.837	1.183	1.449	1.673	2.049	2.366	2.646	2.898	3.347	3.742
40		0.693	0.894	1.265	1.549	1.789	2.191	2.530	2.828	3.098	3.578	4.000
50		0.775	1.000	1.414	1.732	2.000	2.449	2.828	3.162	3.464	4.000	4.472
52		0.790	1.020	1.442	1.766	2.040	2.498	2.884	3.225	3.533	4.079	4.561
63		0.869	1.122	1.587	1.944	2.245	2.750	3.175	3.550	3.888	4.490	5.020
66	0.890	1.149	1.625	1.990	2.298	2.814	3.250	3.633	3.980	4.596	5.138	
	μm	3	5	10	15	20	30	40	50	60	80	100
5.0		0.346	0.447	0.632	0.775	0.894	1.095	1.265	1.414	1.549	1.789	2.000



SRC12

P M K S H

PRAMET

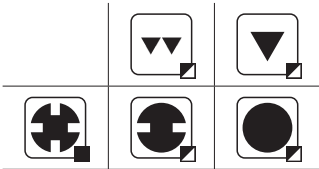
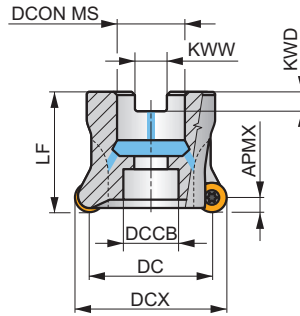
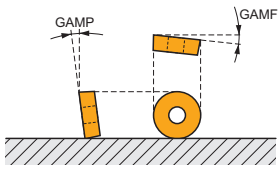
S



Kopierfräs för runda RCMT 12-skär, invändig kylning

Kopierfräs för positiva RCMT 12-skär med APMX 6 mm. Invändig kylning. För plan-, hörn- och dykfräsning, rampning, mm. Finns endast med dornfäste. Diametrar från 40 till 100 mm. Behandlad för lång livslängd.

APMX	6.0 mm
------	--------



0.1 - 0.2



Product	DCX (mm)	DC (mm)	DCON MS (mm)	DCCB (mm)	LF (mm)	KWW (mm)	KWD (mm)	GAMF (°)	GAMP (°)								
40A03R-SMORC12-C	40	28	16	12	40	8.4	5.6	-2.1	-7	3	-	14800	✓	0.27	GI279	C0022	-
50A04R-SMORC12-C	50	38	22	18	40	10.4	6.3	-2	-7	4	-	13200	✓	0.36	GI279	C0023	-
52A05R-SMORC12-C	52	40	22	18	40	10.4	6.3	-2	-7	5	-	12900	✓	0.15	GI279	C0023	-
63A05R-SMORC12-C	63	51	22	30	40	10.4	6.3	-2	-7	5	-	11800	✓	0.45	GI279	C0023	-
66A06R-SMORC12-C	66	54	27	22	50	12.4	7	-1.5	-7	6	-	11400	✓	0.65	GI279	C0024	-
80A05R-SMORC12-C	80	68	27	37	50	12.4	7	-1.7	-7	5	-	10400	✓	1.08	GI279	C0024	-
100A06R-SMORC12-C	100	88	32	45	50	14.4	8	-1.8	-7	6	-	9300	✓	1.78	GI279	C0021	AC002

GI279	RCMT 1204M0..

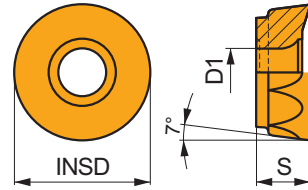
C0021	US 63509-T15P	3.0	M 3.5	10	D-T08P/T15P	FG-15	-
C0022	US 63509-T15P	3.0	M 3.5	10	D-T08P/T15P	FG-15	HS 90835
C0023	US 63509-T15P	3.0	M 3.5	10	D-T08P/T15P	FG-15	HS 1030C
C0024	US 63509-T15P	3.0	M 3.5	10	D-T08P/T15P	FG-15	HS 1230C

AC002	KS 1635	K.FMH32

RCMT 12

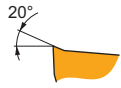


	INSD (mm)	D1 (mm)	S (mm)
1204	12.000	4.40	4.76



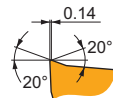
Lämplighet och startvärden för skärhastighet (vc), matning (f) och skärdjup (ap). Vi refererar till vår Dormer Pramet Calculator-app för vidare beräkningar.

Product	RE (mm)	P			M			K			N			S			H		
		vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)



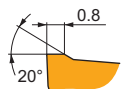
F geometri med mycket positiv design för finfräsning.

RCMT 1204MOEN-F:M8310	☹	–	■	420	0.10	1.5	▣	210	0.09	1.5	■	–	–	–	–	–	–	–	–	–	–
RCMT 1204MOEN-F:M8330	☹	–	■	380	0.10	1.5	▣	225	0.09	1.5	■	–	–	–	▣	95	0.07	1.2	–	–	–



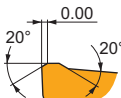
M geometri med mycket positiv design för medelfin fräsning.

RCMT 1204MOSN-M:M6330	☹	–	■	265	0.20	1.5	▣	185	0.18	1.5	■	–	–	–	–	■	75	0.16	1.2	–	–	–	
RCMT 1204MOSN-M:M8310	☹	–	■	335	0.20	1.5	▣	170	0.18	1.5	■	315	0.20	1.5	–	–	–	–	–	–	–	–	
RCMT 1204MOSN-M:M8330	☹	–	■	305	0.20	1.5	▣	180	0.18	1.5	■	285	0.20	1.5	–	–	–	▣	75	0.16	1.2	–	–
RCMT 1204MOSN-M:M8345	☹	–	■	225	0.20	1.5	▣	135	0.18	1.5	■	–	–	–	–	–	–	■	55	0.16	1.2	–	–
RCMT 1204MOSN-M:M9325	☹	–	■	380	0.20	1.5	▣	–	–	–	■	360	0.20	1.5	–	–	–	–	–	–	–	–	–
RCMT 1204MOSN-M:M9340	☹	–	■	345	0.20	1.5	▣	205	0.18	1.5	■	–	–	–	–	–	–	■	85	0.16	1.2	–	–



EN-R geometri med positiv spånvinkel för grov kopierfräsning.

RCMT 1204MOEN-R:M8310	☹	–	■	280	0.30	1.5	▣	140	0.27	1.5	■	265	0.30	1.5	–	–	–	–	–	–	■	55	0.15	0.8	
RCMT 1204MOEN-R:M8330	☹	–	■	260	0.30	1.5	▣	155	0.27	1.5	■	245	0.30	1.5	–	–	–	▣	65	0.24	1.2	▣	50	0.15	0.8



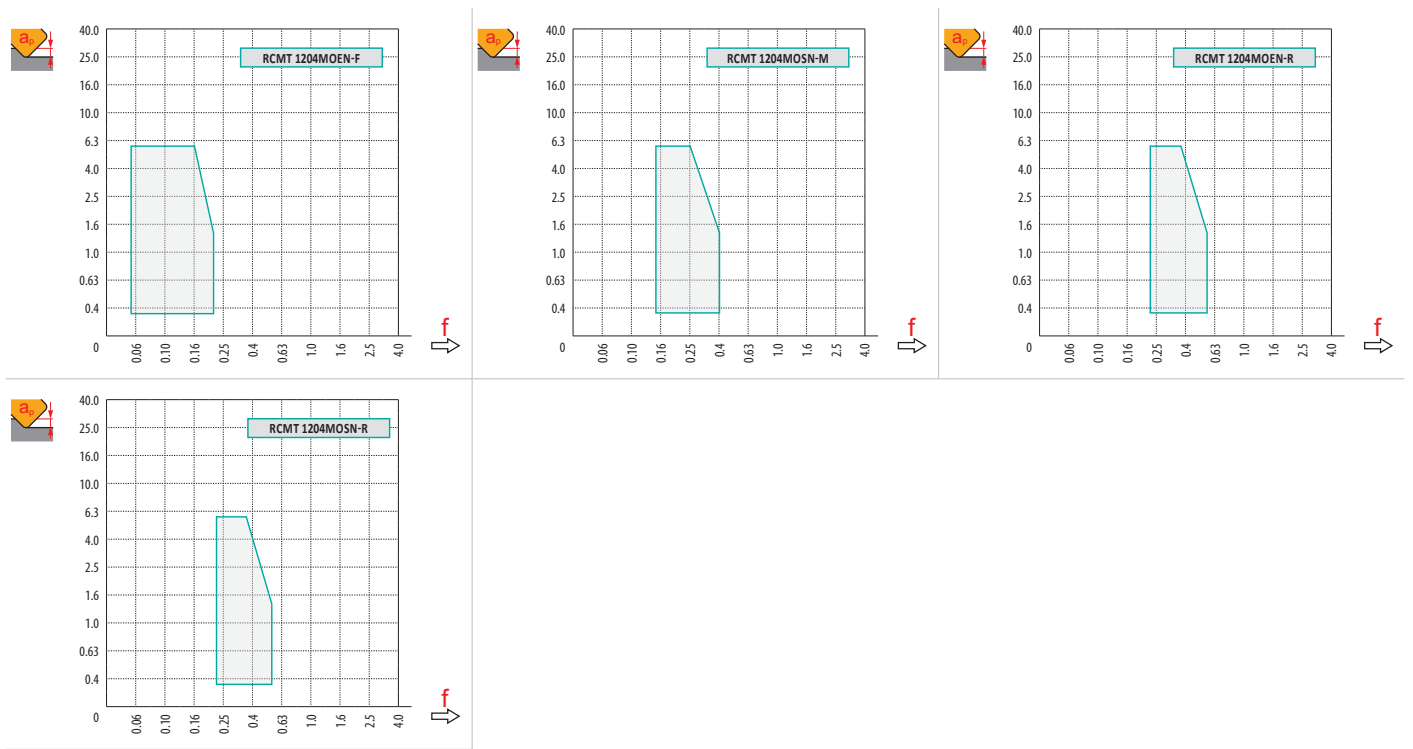
SN-R geometri med positiv design för grov kopierfräsning.

RCMT 1204MOSN-R:M8345	☹	–	■	190	0.35	1.5	▣	–	–	–	■	–	–	–	–	–	–	▣	45	0.25	1.2	–	–	–	
RCMT 1204MOSN-R:M9315	☹	–	■	315	0.35	1.5	▣	–	–	–	■	295	0.35	1.5	–	–	–	–	–	–	–	▣	60	0.18	0.8



a_e / DCX	5 %	10 %	15 %	20 %	25 %	30 %	40 %	50 %	60 %	70 %	75 %	80 %	90 %	100 %
	1.48	1.35	1.27	1.22	1.19	1.16	1.11	1.08	1.05	1.03	1.00	1.00	1.00	1.00
	2.20	1.60	1.35	1.20	1.10	0.95	0.85	0.75	0.85	0.95	1.00	1.00	1.00	1.00
	0.64	0.64	0.64	0.64	0.64	0.65	0.65	0.67	0.68	0.71	0.72	0.74	0.79	1.00

	RCMT 12-F	RCMT 12-M	RCMT 12 EN-R	RCMT 12 SN-R
	6.0	6.0	6.0	6.0
	-	-	-	-



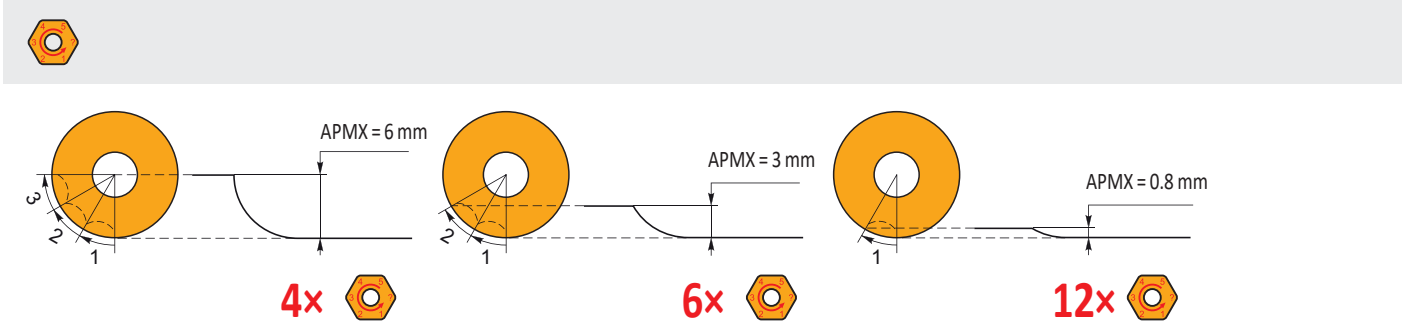
		0.00	0.30	0.50	0.75	1.00	1.25	1.50	2.00	2.50	3.00	4.00	5.00	6.00
40		28.0	31.7	32.8	33.8	34.6	35.3	35.9	36.9	37.7	38.4	39.3	39.8	40.0
50		38.0	41.7	42.8	43.8	44.6	45.3	45.9	46.9	47.7	48.4	49.3	49.8	50.0
52		40.0	43.7	44.8	45.8	46.6	47.3	47.9	48.9	49.7	50.4	51.3	51.8	52.0
63		51.0	54.7	55.8	56.8	57.6	58.3	58.9	59.9	60.7	61.4	62.3	62.8	63.0
66		54.0	57.7	58.8	59.8	60.6	61.3	61.9	62.9	63.7	64.4	65.3	65.8	66.0
80		68.0	71.7	72.8	73.8	74.6	75.3	75.9	76.9	77.7	78.4	79.3	79.8	80.0
100	88.0	91.7	92.8	93.8	94.6	95.3	95.9	96.9	97.7	98.4	99.3	99.8	100.0	
		-	0.30	0.50	0.75	1.00	1.25	1.50	2.00	2.50	3.00	4.00	5.00	6.00
		-	0.95	0.74	0.61	0.53	0.47	0.43	0.38	0.34	0.31	0.28	0.25	0.24

DC	RPMX	APMX/I
40	9.0	6.0/39
50	7.0	6.0/50
52	6.5	6.0/53
63	5.0	6.0/70
66	4.5	6.0/76
80	3.0	5.1/100
100	2.0	3.3/100

DC	DMIN	DMAX	SMAX DMIN	SMAX DMAX
40	56.0	80.0	6.0	6.0
50	76.0	100.0	6.0	6.0
52	80.0	104.0	6.0	6.0
63	102.0	126.0	6.0	6.0
66	108.0	132.0	6.0	6.0
80	136.0	160.0	6.0	6.0
100	176.0	200.0	6.0	6.0

a
3.5

DC	μm	3	5	10	15	20	30	40	50	60	80	100
40		0.693	0.894	1.265	1.549	1.789	2.191	2.530	2.828	3.098	3.578	4.000
50		0.775	1.000	1.414	1.732	2.000	2.449	2.828	3.162	3.464	4.000	4.472
52		0.790	1.020	1.442	1.766	2.040	2.498	2.884	3.225	3.533	4.079	4.561
63		0.869	1.122	1.587	1.944	2.245	2.750	3.175	3.550	3.888	4.490	5.020
66		0.890	1.149	1.625	1.990	2.298	2.814	3.250	3.633	3.980	4.596	5.138
80		0.980	1.265	1.789	2.191	2.530	3.098	3.578	4.000	4.382	5.060	5.657
100		1.095	1.414	2.000	2.449	2.828	3.464	4.000	4.472	4.899	5.657	6.325
RE	μm	3	5	10	15	20	30	40	50	60	80	100
6.0		0.379	0.490	0.693	0.849	0.980	1.200	1.386	1.549	1.697	1.960	2.191



SRC16



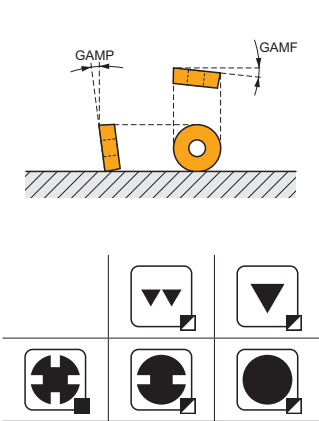
PRAMET



Kopierfräs för runda RCMT 12-skär, inväddig kylning

Kopierfräs för positiva RCMT 16-skär med APMX 8 mm. Inväddig kylning. För plan-, hörn- och dykfräsning, rampning, mm. Finns endast med dornfäste. Diametrar från 63 till 160 mm. Behandlad för lång livslängd.

APMX	8.0 mm
------	--------



0.1 - 0.25



Product	DCX	DC	DCON MS	DCCB	DBC1	LF	KWW	KWD	GAMP	GAMP			kg			
	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(°)	(°)						
63A04R-SMORC16-C	63	47	22	18	-	50	10.4	6.3	-2.6	-7	4	-	9700	✓	0.60	G1280 C0033 -
66A05R-SMORC16-C	66	50	27	22	-	50	12.4	7	-2.5	-7	5	-	9200	✓	0.59	G1280 C0030 -
80A05R-SMORC16-C	80	64	27	37	-	50	12.4	7	-1.7	-7	5	-	8600	✓	0.87	G1280 C0030 -
100A06R-SMORC16-C	100	84	32	45	-	50	14.4	8	-1.7	-7	6	-	7700	✓	1.27	G1280 C0031 AC002
125A07R-SMORC16-C	125	109	40	36	-	63	16.4	9	-1.2	-7	7	-	6500	✓	3.03	G1280 C0032 -
160C08R-SMORC16-C	160	144	40	-	66.7	63	16.4	9	-0.9	-7	8	-	5400	✓	5.63	G1280 C0034 -

	G1280		RCMT 1606M0..
--	-------	--	---------------

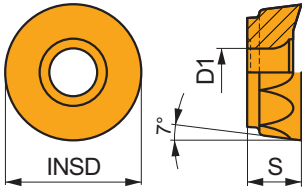
C0030	US 65014-T20P	5.0	M 5	14	SDR T20P-T	HS 1230C	-	-	-
C0031	US 65014-T20P	5.0	M 5	14	SDR T20P-T	-	-	-	-
C0032	US 65014-T20P	5.0	M 5	14	SDR T20P-T	HSD 2040	-	-	-
C0033	US 65014-T20P	5.0	M 5	14	SDR T20P-T	HS 1030C	-	-	-
C0034	US 65014-T20P	5.0	M 5	14	SDR T20P-T	HS 1240C	CAC 160C	HSD 0825C	HXK 5

	AC002		KS 1635		K.FMH32
--	-------	--	---------	--	---------

RCMT 16

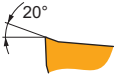


	INSD	D1	S
	(mm)	(mm)	(mm)
1606	16.000	5.50	6.35



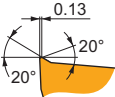
Lämplighet och startvärden för skärhastighet (vc), matning (f) och skärdjup (ap). Vi refererar till vår Dormer Pramet Calculator-app för vidare beräkningar.

Product	RE (mm)	P			M			K			N			S			H		
		vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)



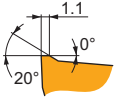
F geometri med mycket positiv design för finfräsning.

RCMT 1606MOEN-F:M8310	☹	–	■	410	0.10	2.0	▣	205	0.09	2.0	■	–	–	–	–	–	–	–	–
RCMT 1606MOEN-F:M8330	☹	–	■	370	0.10	2.0	▣	220	0.09	2.0	■	–	–	–	▣	90	0.07	1.6	–



M geometri med mycket positiv design för medelfin fräsning.

RCMT 1606MOSN-M:M6330	☹	–	■	255	0.20	2.0	▣	180	0.18	2.0	■	–	–	–	■	75	0.16	1.6	–
RCMT 1606MOSN-M:M8330	☹	–	■	300	0.20	2.0	▣	180	0.18	2.0	■	285	0.20	2.0	▣	75	0.16	1.6	–
RCMT 1606MOSN-M:M8345	☹	–	■	215	0.20	2.0	▣	125	0.18	2.0	■	–	–	–	■	50	0.16	1.6	–
RCMT 1606MOSN-M:M9325	☹	–	■	370	0.20	2.0	▣	–	–	–	■	350	0.20	2.0	–	–	–	–	–
RCMT 1606MOSN-M:M9340	☹	–	■	335	0.20	2.0	▣	200	0.18	2.0	■	–	–	–	■	80	0.16	1.6	–



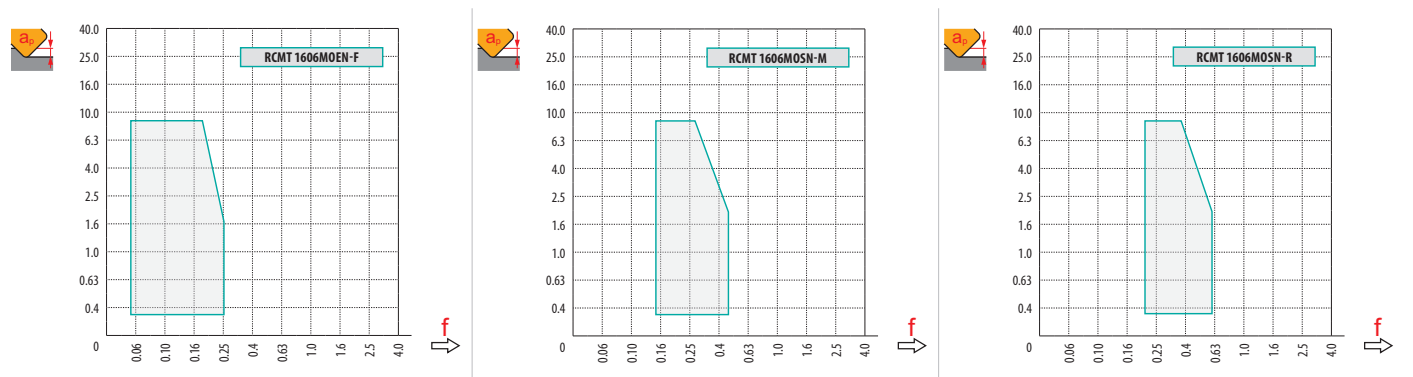
R geometri med positiv design för grov kopierfräsning.

RCMT 1606MOSN-R:M8310	☹	–	■	250	0.40	2.0	▣	–	–	–	■	235	0.40	2.0	–	–	–	■	50
RCMT 1606MOSN-R:M8330	☹	–	■	240	0.40	2.0	▣	–	–	–	■	225	0.40	2.0	▣	60	0.28	1.6	▣
RCMT 1606MOSN-R:M8345	☹	–	■	175	0.40	2.0	▣	–	–	–	■	–	–	–	▣	40	0.28	1.6	–

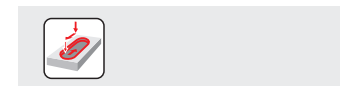
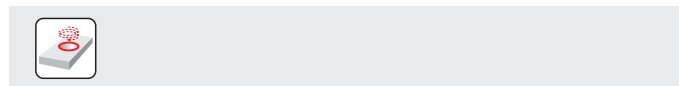
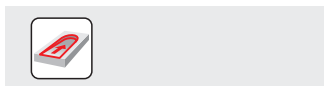


a_e / DCX	5 %	10 %	15 %	20 %	25 %	30 %	40 %	50 %	60 %	70 %	75 %	80 %	90 %	100 %
	1.48	1.35	1.27	1.22	1.19	1.16	1.11	1.08	1.05	1.03	1.00	1.00	1.00	1.00
	2.20	1.60	1.35	1.20	1.10	0.95	0.85	0.75	0.85	0.95	1.00	1.00	1.00	1.00
	0.64	0.64	0.64	0.64	0.64	0.65	0.65	0.67	0.68	0.71	0.72	0.74	0.79	1.00

	RCMT 16-F	RCMT 16-M	RCMT 16-R
	8.0	8.0	8.0
	—	—	—



DCX	a_e	0.00	0.30	0.50	0.75	1.00	1.25	1.50	2.00	2.50	3.00	4.00	5.00	6.00	7.00	8.00
63		47.0	51.3	52.6	53.8	54.7	55.6	56.3	57.6	58.6	59.5	60.9	61.8	62.5	62.9	63.0
66		50.0	54.3	55.6	56.8	57.8	58.6	59.3	60.6	61.6	62.5	63.9	64.8	65.5	65.9	66.0
80		64.0	68.3	69.6	70.8	71.7	72.6	73.3	74.6	75.6	76.5	77.9	78.8	79.5	79.9	80.0
100		84.0	88.3	89.6	90.8	91.7	92.6	93.3	94.6	95.6	96.5	97.9	98.8	99.5	99.9	100.0
125		109.0	113.3	114.6	115.8	116.7	117.6	118.3	119.6	120.6	121.5	122.9	123.8	124.5	124.9	125.0
160		144.0	148.3	149.6	150.8	151.7	152.6	153.3	154.6	155.6	156.5	157.9	158.8	159.5	159.9	160.0
	a_e	—	0.30	0.50	0.75	1.00	1.25	1.50	2.00	2.50	3.00	4.00	5.00	6.00	7.00	8.00
		—	1.10	0.85	0.70	0.61	0.54	0.50	0.43	0.39	0.36	0.31	0.28	0.26	0.25	0.24



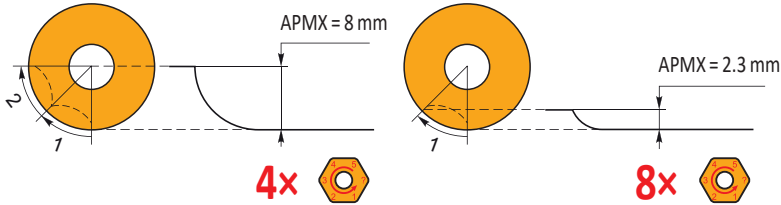
DC	RPMX	APMX/I
63	7.0	8.0/67
66	6.5	8.0/71
80	5.0	8.0/93
100	4.0	6.8/100

DC	DMIN	DMAX	SMAX DMIN	SMAX DMAX
63	94.0	126.0	8.0	8.0
66	100.0	132.0	8.0	8.0
80	128.0	160.0	8.0	8.0
100	168.0	200.0	8.0	8.0

a_e
5.0



	μm	3	5	10	15	20	30	40	50	60	80	100
63		0.869	1.122	1.587	1.944	2.245	2.750	3.175	3.550	3.888	4.490	5.020
66		0.890	1.149	1.625	1.990	2.298	2.814	3.250	3.633	3.980	4.596	5.138
80		0.980	1.265	1.789	2.191	2.530	3.098	3.578	4.000	4.382	5.060	5.657
100		1.095	1.414	2.000	2.449	2.828	3.464	4.000	4.472	4.899	5.657	6.325
125		1.225	1.581	2.236	2.739	3.162	3.873	4.472	5.000	5.477	6.325	7.071
160		1.386	1.789	2.530	3.098	3.578	4.382	5.060	5.657	6.197	7.155	8.000
	μm	3	5	10	15	20	30	40	50	60	80	100
8.0		0.438	0.566	0.800	0.980	1.131	1.386	1.600	1.789	1.960	2.263	2.530



SRC20

P M K S H

PRAMET

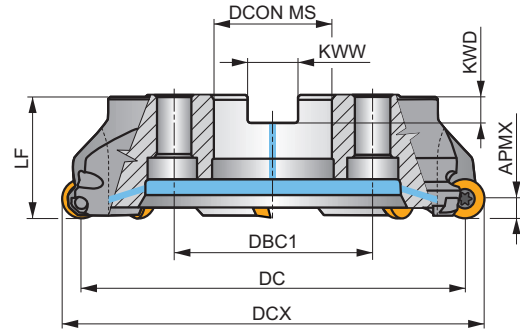
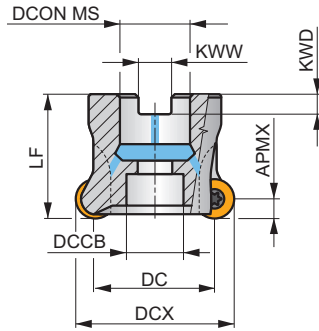
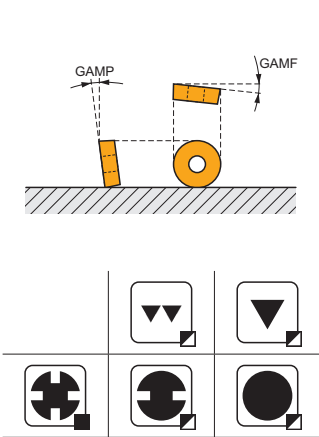
S



Kopierfräs för runda RCMT 20-skär, invändig kylning

Kopierfräs för positiva RCMT 16-skär med APMX 10 mm. Invändig kylning. För plan-, hörn- och dykfräsning, rampning, mm. Finns endast med dornfäste. Diametrar från 80 till 160 mm. Behandlad för lång livslängd.

APMX	10.0 mm
------	---------



0.11 - 0.32



Product	DCX	DC	DCON MS	DCCB	DBC1	LF	KWW	KWD	GAMP	GAMP							
	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(°)	(°)			kg				
80A04R-SMORC20-C	80	60	27	28	-	50	12.4	7	-2.7	-7	4	-	8500	✓	0.91	GI281 C0040	-
100A05R-SMORC20-C	100	80	32	45	-	50	14.4	8	-1.7	-7	5	-	7600	✓	1.20	GI281 C0041	AC002
125A06R-SMORC20-C	125	105	40	36	-	63	16.4	9	-1	-7	6	-	6500	✓	2.92	GI281 C0042	-
160C07R-SMORC20-C	160	140	40	-	66.7	63	16.4	9	-0.9	-7	7	-	5400	✓	5.37	GI281 C0046	-

	GI281		RCMT 2006MO..
--	-------	--	---------------

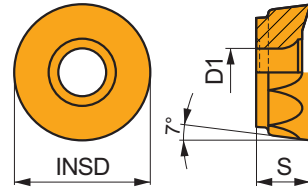
C0040	US 66015-T25P	7.5	M 6	15	SDR T25P-T	HS 1230C	-	-	-
C0041	US 66015-T25P	7.5	M 6	15	SDR T25P-T	-	-	-	-
C0042	US 66015-T25P	7.5	M 6	15	SDR T25P-T	HSD 2040	-	-	-
C0046	US 66015-T25P	7.5	M 6	15	SDR T25P-T	HS 1240C	CAC 160C	HSD 0825C	HXK 5

	AC002		KS 1635		K.FMH32
--	-------	--	---------	--	---------

RCMT 20

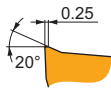


	INSD (mm)	D1 (mm)	S (mm)
2006	20.000	6.50	6.35



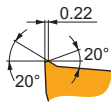
Lämplighet och startvärden för skärhastighet (vc), matning (f) och skärdjup (ap). Vi refererar till vår Dormer Pramet Calculator-app för vidare beräkningar.

Product	RE (mm)	P			M			K			N			S			H		
		vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)



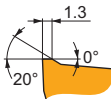
F geometri med mycket positiv design för finfräsning.

RCMT 2006MOSN-F:M8330	☼	-	■	320	0.15	3.0	▣	190	0.14	3.0	■	-	-	-	▣	80	0.11	2.4	■	-	-	-
------------------------------	---	---	---	-----	------	-----	---	-----	------	-----	---	---	---	---	---	----	------	-----	---	---	---	---



M geometri med mycket positiv design för medelfin fräsning.

RCMT 2006MOSN-M:M6330	☼	-	■	225	0.30	3.0	▣	155	0.27	3.0	■	-	-	-	▣	65	0.21	2.4	■	-	-	-
RCMT 2006MOSN-M:M8330	☼	-	■	255	0.30	3.0	▣	150	0.27	3.0	■	240	0.30	3.0	▣	60	0.21	2.4	■	-	-	-
RCMT 2006MOSN-M:M8345	☼	-	■	190	0.30	3.0	▣	110	0.27	3.0	■	-	-	-	▣	45	0.21	2.4	■	-	-	-
RCMT 2006MOSN-M:M9315	☼	-	■	330	0.30	3.0	▣	-	-	-	■	310	0.30	3.0	▣	-	-	-	■	-	-	-
RCMT 2006MOSN-M:M9325	☼	-	■	315	0.30	3.0	▣	-	-	-	■	295	0.30	3.0	▣	-	-	-	■	-	-	-
RCMT 2006MOSN-M:M9340	☼	-	■	275	0.30	3.0	▣	165	0.27	3.0	■	-	-	-	▣	65	0.21	2.4	■	-	-	-



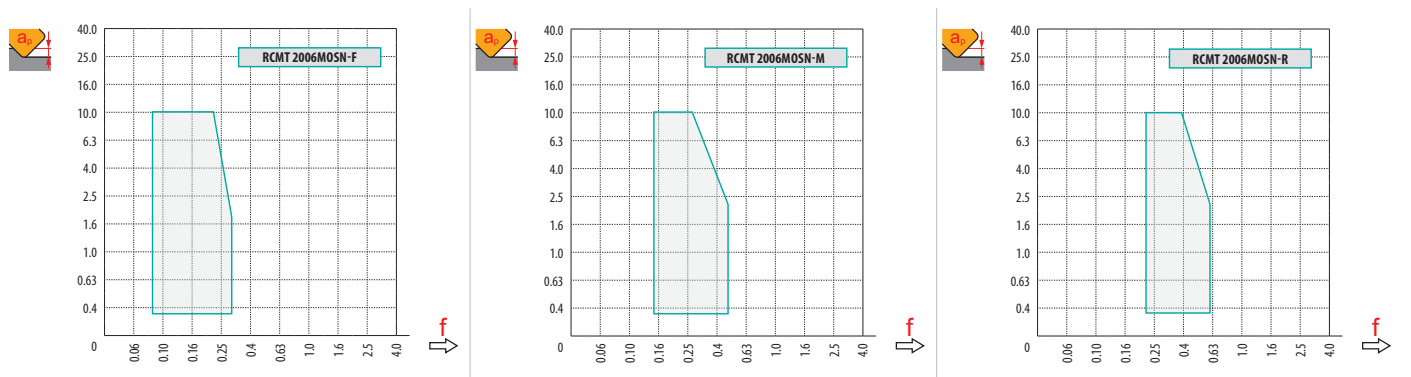
R geometri med positiv design för grov kopierfräsning.

RCMT 2006MOSN-R:M8330	☼	-	■	225	0.45	3.0	▣	-	-	-	■	210	0.45	3.0	▣	55	0.32	2.4	▣	45	0.23	1.3
RCMT 2006MOSN-R:M8345	☼	-	■	165	0.45	3.0	▣	-	-	-	■	-	-	-	▣	40	0.32	2.4	▣	-	-	-
RCMT 2006MOSN-R:M9325	☼	-	■	260	0.45	3.0	▣	-	-	-	■	245	0.45	3.0	▣	-	-	-	▣	50	0.23	1.3

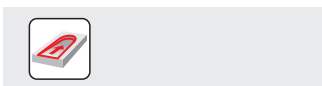


a_e / DCX	5 %	10 %	15 %	20 %	25 %	30 %	40 %	50 %	60 %	70 %	75 %	80 %	90 %	100 %
	1.48	1.35	1.27	1.22	1.19	1.16	1.11	1.08	1.05	1.03	1.00	1.00	1.00	1.00
	2.20	1.60	1.35	1.20	1.10	0.95	0.85	0.75	0.85	0.95	1.00	1.00	1.00	1.00
	0.64	0.64	0.64	0.64	0.64	0.65	0.65	0.67	0.68	0.71	0.72	0.74	0.79	1.00

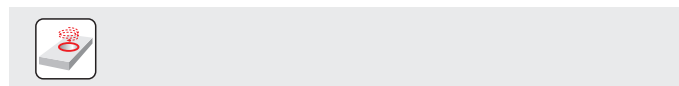
	RCMT 20-F	RCMT 20-M	RCMT 20-R
	10.0	10.0	10.0
	-	-	-



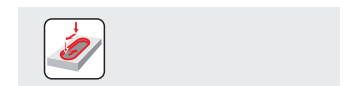
		0.00	0.30	0.50	0.75	1.00	1.25	1.50	2.00	2.50	3.00	4.00	5.00	6.00	7.00	8.00	9.00	10.00
80		60.0	64.9	66.2	67.6	68.7	69.7	70.5	72.0	73.2	74.3	76.0	77.3	78.3	79.1	79.6	79.9	80.0
100		80.0	84.9	86.2	87.6	88.7	89.7	90.5	92.0	93.2	94.3	96.0	97.3	98.3	99.1	99.6	99.9	100.0
125		105.0	109.9	111.2	112.6	113.7	114.7	115.5	117.0	118.2	119.3	121.0	122.3	123.3	124.1	124.6	124.9	125.0
160		140.0	144.9	146.2	147.6	148.7	149.7	150.5	152.0	153.2	154.3	156.0	157.3	158.3	159.1	159.6	159.9	160.0
		-	0.30	0.50	0.75	1.00	1.25	1.50	2.00	2.50	3.00	4.00	5.00	6.00	7.00	8.00	9.00	10.00
		-	1.23	0.95	0.78	0.68	0.61	0.55	0.48	0.43	0.40	0.35	0.31	0.29	0.27	0.26	0.25	0.24



	RPMX	APMX/I
80	7.0	10.0/83
100	5.0	8.6/100



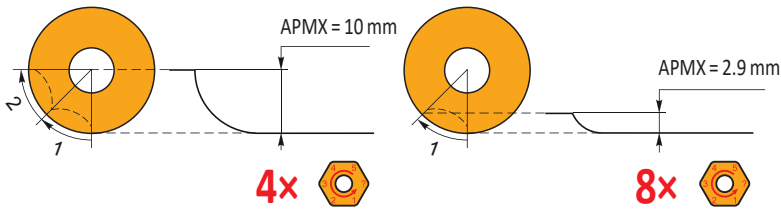
	DMIN	DMAX		
80	120.0	160.0	10.0	10.0
100	160.0	200.0	10.0	10.0



6.0



	μm	3	5	10	15	20	30	40	50	60	80	100
80		0.980	1.265	1.789	2.191	2.530	3.098	3.578	4.000	4.382	5.060	5.657
100		1.095	1.414	2.000	2.449	2.828	3.464	4.000	4.472	4.899	5.657	6.325
125		1.225	1.581	2.236	2.739	3.162	3.873	4.472	5.000	5.477	6.325	7.071
160		1.386	1.789	2.530	3.098	3.578	4.382	5.060	5.657	6.197	7.155	8.000
	μm	3	5	10	15	20	30	40	50	60	80	100
10.0		0.490	0.632	0.894	1.095	1.265	1.549	1.789	2.000	2.191	2.530	2.828





PROFILFRÄSNING

INDEXABLE FACE MILLS – NAVIGATOR

PROFILE MILLING – BALL NOSE

	L2-SZP	K2-SRC	K2-SLC	K2-PPH	K3-CXP	
	-	-	90°	-	-	
	APMX (mm) 8.9 – 44.7	APMX (mm) 0.6 – 3.2	APMX (mm) 1.0 – 3.0	APMX (mm) 0.3 – 4.0	APMX (mm) 8.0 – 16.0	
	DCX (mm) 10 – 50	DCX (mm) 8 – 32	DCX (mm) 12 – 20	DCX (mm) 8 – 32	DCX (mm) 16 – 32	
Cylindrical shank	DCX = 10 – 32 (mm)	DCX = 8 – 32 (mm)		DCX = 8 – 32 (mm)	DCX = 16 – 32 (mm)	
Weldon	DCX = 12 – 50 (mm)				DCX = 16 – 25 (mm)	
Modular	DCX = 10 – 32 (mm)	DCX = 8 – 20 (mm)		DCX = 16, 20 (mm)	DCX = 16 – 25 (mm)	
Morse	DCX = 12 – 32 (mm)					
Page	206	211	218	222	234	
ISO	P M K S H	P M K S H	H P M K S H	H P M K S H	P M K S H	
Insert shape						
Inserts	ZP	RC LC	LC	PPH PPHF PPHT	XP	
No. of cutting edges	2	2	2	2	1	
Kopierfräsning	■	■	■	■	■	
Spiralinterpolering			▣	▣		
Progressiv dykfräsning			▣	▣		
Rampning			▣	▣		
Fasfräsning			▣	▣		

L2-SZP



PRAMET

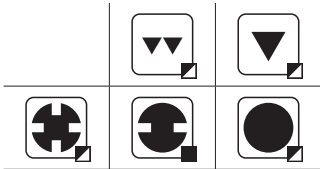
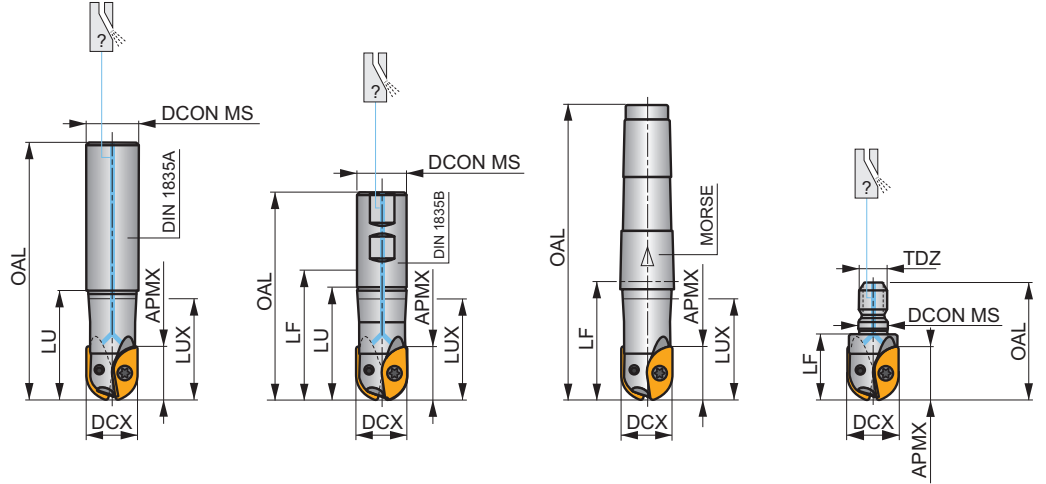
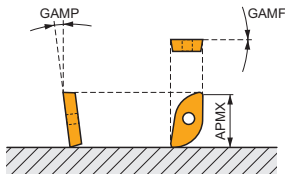
S



Radiefräs för ZP.-skär

Radiefräs för ZP.-skär med APMX från 8.9 till 44.7 mm. Användbar till profilfräsning. Behandlad för lång livslängd.

APMX	8.9 - 44.7 mm
------	---------------



h_m	0.05 - 0.19
-------	-------------



Product	DCX	OAL	DCON MS	LU	LUX	LF	TDZ	CZC MS	APMX	GAMF	GAMP							
	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)			(mm)	(°)	(°)							
10L2R030A10-SZP10	10	130	10	30	30	-	-	-	8.90	0	-10	2	-	35800	-	0.11	G1255	C0510
10L2R050A16-SZP10	10	160	16	50	22.3	-	-	-	8.90	0	-10	2	-	35800	-	0.24	G1255	C0510
12L2R035A12-SZP12	12	140	12	35	35	-	-	-	10.70	0	-10	2	-	21000	-	0.15	G1253	C0510
12L2R045A20-SZP12	12	200	20	-	22	-	-	-	10.70	0	-10	2	-	21000	-	0.48	G1253	C0511
16L2R040A16-SZP16-C	16	160	16	40	40	-	-	-	14.40	0	-10	2	-	20000	✓	0.24	G1256	C0510
16L2R045A20-SZP16-C	16	200	20	-	29.4	-	-	-	14.40	0	-10	2	-	20000	✓	0.43	G1256	C0512
20L2R050A20-SZP20-C	20	250	20	50	-	-	-	-	17.90	0	-10	2	-	24000	✓	0.54	G1254	C0513
20L2R055A25-SZP20-C	20	200	25	-	36.1	-	-	-	17.90	0	-10	2	-	24000	✓	0.68	G1254	C0513
25L2R060A25-SZP25-C	25	250	25	60	-	-	-	-	22.30	0	-10	2	-	24000	✓	0.85	G1257	C0514
25L2R065A32-SZP25-C	25	250	32	-	43	-	-	-	22.30	0	-10	2	-	24000	✓	1.34	G1257	C0514
32L2R070A32-SZP32-C	32	250	32	-	-	-	-	-	28.60	0	-10	2	-	18500	✓	1.43	G1258	C0515
12L2R040B20-SZP12	12	91	20	40	21.5	66.5	-	-	10.70	0	-10	2	-	21000	-	0.19	G1253	C0511
12L2R060B20-SZP12	12	111	20	60	23.8	86.5	-	-	10.70	0	-10	2	-	21000	-	0.22	G1253	C0511
16L2R040B20-SZP16-C	16	91	20	40	28.3	66.5	-	-	14.40	0	-10	2	-	20000	✓	0.15	G1256	C0512
16L2R060B20-SZP16-C	16	111	20	60	32.9	86.5	-	-	14.40	0	-10	2	-	20000	✓	0.21	G1256	C0512
20L2R050B25-SZP20-C	20	107	25	50	35.1	75.5	-	-	17.90	0	-10	2	-	24000	✓	0.30	G1254	C0513
20L2R070B25-SZP20-C	20	127	25	70	39.5	95.5	-	-	17.90	0	-10	2	-	24000	✓	0.36	G1254	C0513
25L2R060B25-SZP25-C	25	117	25	60	-	85.5	-	-	22.30	0	-10	2	-	24000	✓	0.36	G1257	C0514
25L2R080B25-SZP25-C	25	137	25	80	-	105	-	-	22.30	0	-10	2	-	24000	✓	0.42	G1257	C0514
32L2R070B32-SZP32-C	32	131	32	70	-	95.5	-	-	28.60	0	-10	2	-	18500	✓	0.72	G1258	C0515
32L2R100B32-SZP32-C	32	161	32	100	-	125.5	-	-	28.60	0	-10	2	-	18500	✓	0.81	G1258	C0515
40L2R070B32-SZP40-C	40	131	32	70	-	95.5	-	-	35.70	0	-10	2	-	8000	✓	0.81	G1259	C0516
40L2R100B40-SZP40-C	40	171	40	100	-	131	-	-	35.70	0	-10	2	-	8000	✓	1.40	G1259	C0516
50L2R100B50-SZP50-C	50	181	50	100	-	136.5	-	-	44.70	0	-10	2	-	7000	✓	2.25	G1260	C0517
12L2R060E02-SZP12	12	124	-	-	25.8	60	-	2	10.70	0	-10	2	-	21000	-	0.17	G1253	C0511
12L2R090E02-SZP12	12	154	-	-	25.8	90	-	2	10.70	0	-10	2	-	21000	-	0.23	G1253	C0511
16L2R060E02-SZP16	16	124	-	-	42.2	60	-	2	14.40	0	-10	2	-	20000	-	0.19	G1256	C0512

Product	DCX	OAL	DCOM MS		LU	LUX	LF	TDZ	CZC MS	APMX	GAMIF	GAMP							
	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)		(mm)	(mm)	(°)	(°)							
16L2R090E02-SZP16	16	154	-	-	75.9	90	-	2	14.40	0	-10	2	-	20000	-	0.23	G1256	C0512	
20L2R070E03-SZP20	20	151	-	-	-	70	-	3	17.90	0	-10	2	-	24000	-	0.37	G1254	C0513	
20L2R100E03-SZP20	20	181	-	-	77.4	100	-	3	17.90	0	-10	2	-	24000	-	0.42	G1254	C0513	
25L2R080E03-SZP25	25	161	-	-	-	80	-	3	22.30	0	-10	2	-	24000	-	0.44	G1257	C0514	
25L2R110E04-SZP25	25	213	-	-	92.7	110	-	4	22.30	0	-10	2	-	24000	-	0.83	G1257	C0514	
32L2R100E04-SZP32	32	203	-	-	-	100	-	4	28.60	0	-10	2	-	18500	-	0.90	G1258	C0515	
32L2R150E04-SZP32	32	253	-	-	-	150	-	4	28.60	0	-10	2	-	18500	-	1.10	G1258	C0515	
10L2R025M08-SZP10	10	-	8.5	-	-	25	M8	-	8.90	0	-10	2	-	-	-	0.03	G1255	C0510	
12L2R025M06-SZP12	12	-	6.5	-	-	25	M6	-	10.70	0	-10	2	-	-	-	0.05	G1253	C0510	
12L2R025M08-SZP12	12	-	8.5	-	-	25	M8	-	10.70	0	-10	2	-	-	-	0.04	G1253	C0511	
16L2R025M08-SZP16	16	-	8.5	-	-	25	M8	-	14.40	0	-10	2	-	-	-	0.05	G1256	C0512	
20L2R030M10-SZP20-C	20	-	10.5	-	-	30	M10	-	17.90	0	-10	2	-	-	✓	0.07	G1254	C0513	
25L2R035M12-SZP25-C	25	-	12.5	-	-	35	M12	-	22.30	0	-10	2	-	-	✓	0.09	G1257	C0514	
32L2R045M16-SZP32-C	32	-	17	-	-	45	M16	-	27.90	0	-10	2	-	-	✓	0.15	G1258	C0515	

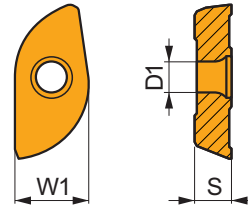
G1253	ZP 12..
G1254	ZP 20..
G1255	ZP 10..
G1256	ZP 16..
G1257	ZP 25..
G1258	ZP 32..
G1259	ZP 40..
G1260	ZP 50..

C0510	-	-	Flag T06P	US 62004-T06P	0.6	M 2	4	-
C0511	-	-	Flag T08P	US 62506-T08P	1.2	M 2.5	6	-
C0512	-	-	Flag T08P	US 62508-T08P	1.2	M 2.5	7	-
C0513	-	-	Flag T10P	US 63510-T10P	2.0	M 3.5	9	-
C0514	-	-	Flag T15P	US 4011A-T15P	3.5	M 4	11	-
C0515	-	-	-	US 65013-T20	5.0	M 5	13	SDR T20
C0516	-	-	-	US 66015-T25P	7.5	M 6	15	SDR T25P
C0517	SZN 400322	US 3508-T15P	Flag T15P	US 68020-T30P	15.0	M 8	20	SDR T30P

ZP



	W1 (mm)	D1 (mm)	S (mm)
10	10.000	2.20	1.70
12	12.000	2.90	2.38
16	16.000	2.90	3.18
20	20.000	4.00	3.97
25	25.000	4.70	4.76
32	32.000	5.90	6.35
40	40.000	7.00	7.94
50	50.000	9.60	7.94



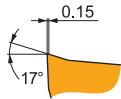
Lämplighet och startvärden för skärhastighet (vc), matning (f) och skärdjup (ap). Vi refererar till vår Dormer Pramet Calculator-app för vidare beräkningar.

Product	RE (mm)	P			M			K			N			S			H		
		vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)



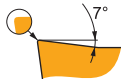
FM geometri med vass neutral design för fin till medelfin fräsning.

ZP 10ER-FM:M8310	●	–	■	305	0.36	0.5	–	–	–	■	285	0.36	0.5	–	–	–	–	–	–	■	60	0.25	0.5
ZP 10ER-FM:M8345	●	–	■	210	0.36	0.5	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
ZP 12ER-FM:M8310	●	–	■	300	0.36	0.6	–	–	–	■	285	0.36	0.6	–	–	–	–	–	–	■	60	0.25	0.6
ZP 12ER-FM:M8345	●	–	■	205	0.36	0.6	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
ZP 16ER-FM:M8310	●	–	■	290	0.36	0.8	–	–	–	■	275	0.36	0.8	–	–	–	–	–	–	■	55	0.25	0.8
ZP 20ER-FM:M8310	●	–	■	285	0.36	1.0	–	–	–	■	270	0.36	1.0	–	–	–	–	–	–	■	55	0.25	1.0
ZP 25ER-FM:M8310	●	–	■	275	0.36	1.3	–	–	–	■	260	0.36	1.3	–	–	–	–	–	–	■	55	0.25	1.3
ZP 32ER-FM:M8310	●	–	■	270	0.36	1.6	–	–	–	■	255	0.36	1.6	–	–	–	–	–	–	■	50	0.25	1.6



M geometri med mycket positiv design för medelfin fräsning.

ZP 12ER-M:M8330	●	–	■	280	0.36	0.6	■	165	0.32	0.6	■	265	0.36	0.6	–	–	–	■	70	0.25	0.5	–	–	–	
ZP 12ER-M:M8345	●	–	■	205	0.36	0.6	■	120	0.32	0.6	–	–	–	–	–	–	–	–	■	50	0.25	0.5	–	–	–
ZP 16ER-M:M8330	●	–	■	270	0.36	0.8	■	160	0.32	0.8	■	255	0.36	0.8	–	–	–	■	65	0.25	0.6	–	–	–	
ZP 16ER-M:M8340	●	–	■	250	0.36	0.8	■	150	0.32	0.8	■	235	0.36	0.8	–	–	–	■	60	0.25	0.6	–	–	–	
ZP 16ER-M:M8345	●	–	■	200	0.36	0.8	■	120	0.32	0.8	–	–	–	–	–	–	–	■	50	0.25	0.6	–	–	–	
ZP 20ER-M:M8330	●	–	■	265	0.36	1.0	■	155	0.32	1.0	■	250	0.36	1.0	–	–	–	■	65	0.25	0.8	–	–	–	
ZP 20ER-M:M8345	●	–	■	195	0.36	1.0	■	115	0.32	1.0	–	–	–	–	–	–	–	■	45	0.25	0.8	–	–	–	
ZP 25ER-M:M8330	●	–	■	260	0.36	1.3	■	155	0.32	1.3	■	245	0.36	1.3	–	–	–	■	65	0.25	1.0	–	–	–	
ZP 25ER-M:M8345	●	–	■	190	0.36	1.3	■	110	0.32	1.3	–	–	–	–	–	–	–	■	45	0.25	1.0	–	–	–	
ZP 32ER-M:M8330	●	–	■	255	0.36	1.6	■	150	0.32	1.6	■	240	0.36	1.6	–	–	–	■	60	0.25	1.3	–	–	–	



R geometri med vass, något positiv design för fin till medelfin fräsning.

ZP 16ER-R:M8345	●	–	■	190	0.45	0.8	■	110	0.41	0.8	–	–	–	–	–	–	–	■	45	0.32	0.8	–	–	–	
ZP 20ER-R:M8345	●	–	■	185	0.45	1.0	■	110	0.41	1.0	–	–	–	–	–	–	–	■	45	0.32	1.0	–	–	–	
ZP 25ER-R:M8345	●	–	■	180	0.45	1.3	■	105	0.41	1.3	–	–	–	–	–	–	–	■	45	0.32	1.3	–	–	–	
ZP 32ER-R:M8330	●	–	■	240	0.45	1.6	■	140	0.41	1.6	■	225	0.45	1.6	–	–	–	■	60	0.32	1.6	■	45	0.32	1.6
ZP 32ER-R:M8345	●	–	■	175	0.45	1.6	■	105	0.41	1.6	–	–	–	–	–	–	–	■	40	0.32	1.6	–	–	–	
ZP 40ER-R:M8345	●	–	■	170	0.45	2.0	■	100	0.41	2.0	–	–	–	–	–	–	–	■	40	0.32	2.0	–	–	–	
ZP 50ER-R:M8345	●	–	■	165	0.45	2.5	■	95	0.41	2.5	–	–	–	–	–	–	–	■	40	0.32	2.5	–	–	–	

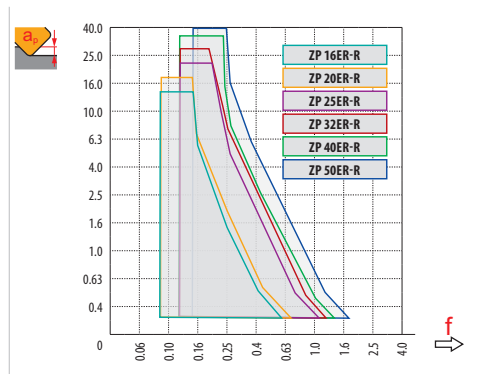
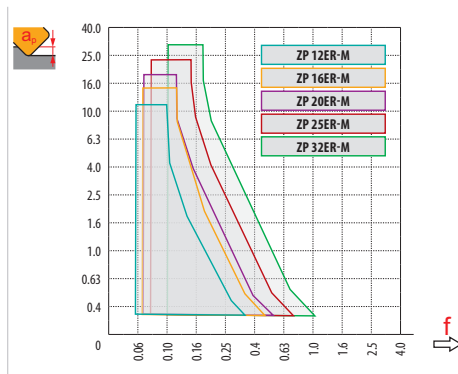
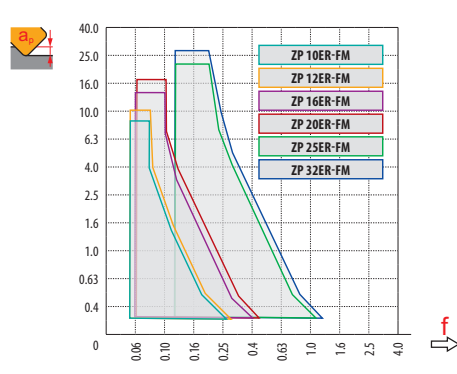


a_e / DCX	5 %	10 %	15 %	20 %	25 %	30 %	40 %	50 %	60 %	70 %	75 %	80 %	90 %	100 %
	1.48	1.35	1.27	1.22	1.19	1.16	1.11	1.08	1.05	1.03	1.00	1.00	1.00	1.00
	2.20	1.60	1.35	1.20	1.10	0.95	0.85	0.75	0.85	0.95	1.00	1.00	1.00	1.00
	0.64	0.64	0.64	0.64	0.64	0.65	0.65	0.67	0.68	0.71	0.72	0.74	0.79	1.00

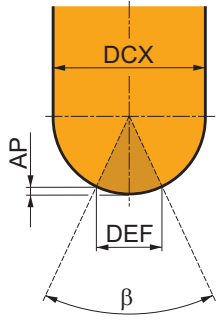
	ZP 10-FM	ZP 12-FM	ZP 16-FM	ZP 20-FM	ZP 25-FM	ZP 32-FM
	5.0	6.0	8.0	10.0	12.5	16.0
	-	-	-	-	-	-

	ZP 12-M	ZP 16-M	ZP 20-M	ZP 25-M	ZP 32-M
	6.0	8.0	10.0	12.5	16.0
	-	-	-	-	-

	ZP 16-R	ZP 20-R	ZP 25-R	ZP 32-R	ZP 40-R	ZP 50-R
	8.0	10.0	12.5	16.0	20.0	25.0
	-	-	-	-	-	-



		0.30	0.40	0.50	0.70	1.00	1.25	1.50	2.00	2.50	3.00	4.00	5.00	6.00	8.00	10.00	12.00	15.00	16.00	20.00	22.50	25.00			
10		3.4	3.9	4.4	5.1	6.0	6.6	7.1	8.0	8.7	9.2	9.8	10.0	-	-	-	-	-	-	-	-	-	-		
12		3.7	4.3	4.8	5.6	6.6	7.3	7.9	8.9	9.7	10.4	11.3	11.8	12.0	-	-	-	-	-	-	-	-	-	-	
16		4.3	5.0	5.6	6.5	7.7	8.6	9.3	10.6	11.6	12.5	13.9	14.8	15.5	16.0	-	-	-	-	-	-	-	-	-	-
20		4.9	5.6	6.2	7.4	8.7	9.7	10.5	12.0	13.2	14.3	16.0	17.3	18.3	19.6	20.0	-	-	-	-	-	-	-	-	-
25		5.4	6.3	7.0	8.2	9.8	10.9	11.9	13.6	15.0	16.2	18.3	20.0	21.4	23.3	24.5	25.0	-	-	-	-	-	-	-	-
32		6.2	7.1	7.9	9.4	11.1	12.4	13.5	15.5	17.2	18.7	21.2	23.2	25.0	27.7	29.7	31.2	31.9	32.0	-	-	-	-	-	-
40		6.9	8.0	8.9	10.5	12.5	13.9	15.2	17.4	19.4	21.1	24.0	26.5	28.6	32.0	34.6	37.1	38.7	39.2	40.0	-	-	-	-	-
50	7.7	8.9	9.9	11.7	14.0	15.6	17.1	19.6	21.8	23.7	27.1	30.0	32.5	36.7	40.0	43.3	45.8	46.6	49.0	49.7	50.0	-	-	-	

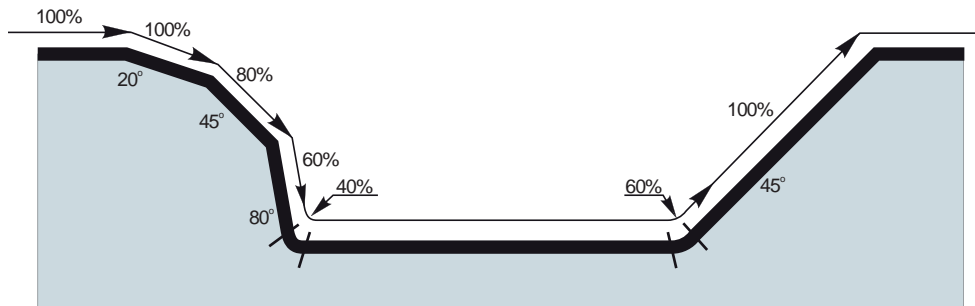


		β		AP
10	FM	41°	3.496	0.322
12	FM	41°	4.194	0.381
16	FM	42°	5.660	0.520
20	FM	42°	7.100	0.650
25	FM	41°	8.756	0.794
35	FM	41°	11.113	0.998
40	R	41°	14.108	1.298
50	R	45°	19.176	1.915



	μm	3	5	10	15	20	30	40	50	60	80	100
10		0.346	0.447	0.632	0.775	0.894	1.095	1.265	1.414	1.549	1.789	2.000
12		0.379	0.490	0.693	0.849	0.980	1.200	1.386	1.549	1.697	1.960	2.191
16		0.438	0.566	0.800	0.980	1.131	1.386	1.600	1.789	1.960	2.263	2.530
20		0.490	0.632	0.894	1.095	1.265	1.549	1.789	2.000	2.191	2.530	2.828
25		0.548	0.707	1.000	1.225	1.414	1.732	2.000	2.236	2.449	2.828	3.162
32		0.620	0.800	1.131	1.386	1.600	1.960	2.263	2.530	2.771	3.200	3.578
40		0.693	0.894	1.265	1.549	1.789	2.191	2.530	2.828	3.098	3.578	4.000
50		0.775	1.000	1.414	1.732	2.000	2.449	2.828	3.162	3.464	4.000	4.472

	a_e	1%	2.5%	5%	7.5%	10%	15%	20%	25%	30%	35%	40%	45%	50%	60%	70%	75%	80%	90%	100%
19.9%	1.0%	2.86	1.84	1.33	1.12	1.00	0.89	-	-	-	-	-	-	-	-	-	-	-	-	-
31.2%	2.5%	3.58	2.28	1.64	1.36	1.20	1.01	0.92	0.88	0.91	-	-	-	-	-	-	-	-	-	-
43.6%	5.0%	4.22	2.68	1.92	1.58	1.39	1.16	1.03	0.95	0.90	0.88	0.89	-	-	-	-	-	-	-	-
52.7%	7.5%	4.63	2.95	2.10	1.73	1.51	1.26	1.11	1.02	0.96	0.91	0.89	0.88	0.90	-	-	-	-	-	-
60.0%	10.0%	4.94	3.14	2.24	1.84	1.61	1.33	1.18	1.07	1.00	0.95	0.91	0.89	0.88	1.00	-	-	-	-	-
71.4%	15.0%	5.39	3.42	2.43	2.00	1.74	1.44	1.27	1.15	1.07	1.01	0.96	0.93	0.90	0.88	0.93	-	-	-	-
80.0%	20.0%	5.70	3.62	2.57	2.11	1.84	1.52	1.33	1.21	1.12	1.05	1.00	0.96	0.93	0.89	0.88	0.89	1.00	-	-
86.6%	25.0%	5.93	3.76	2.67	2.20	1.91	1.58	1.38	1.25	1.16	1.08	1.03	0.99	0.95	0.90	0.88	0.88	0.89	-	-
91.7%	30.0%	6.10	3.87	2.75	2.26	1.96	1.62	1.42	1.28	1.18	1.11	1.05	1.01	0.97	0.92	0.89	0.88	0.88	0.93	-
95.4%	35.0%	6.23	3.95	2.80	2.30	2.00	1.65	1.44	1.31	1.20	1.13	1.07	1.02	0.98	0.93	0.89	0.88	0.88	0.90	-
98.0%	40.0%	6.31	4.00	2.84	2.33	2.03	1.67	1.46	1.32	1.22	1.14	1.08	1.03	0.99	0.93	0.90	0.89	0.88	0.89	-
99.5%	45.0%	6.36	4.03	2.86	2.35	2.04	1.68	1.47	1.33	1.23	1.15	1.09	1.04	1.00	0.94	0.90	0.89	0.88	0.88	-
100.0%	50.0%	6.38	4.04	2.87	2.35	2.05	1.69	1.48	1.33	1.23	1.15	1.09	1.04	1.00	0.94	0.90	0.89	0.88	0.88	1.00



Överhäng (multiplar av diametern DCX)	< 3.0	3.0 – 3.5	3.6 – 4.0	4.1 – 4.5	> 4.6
Multiplikationsfaktor för hastighet	1.0	0.9	0.8	0.7	0.5

K2-SRC



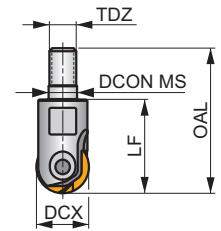
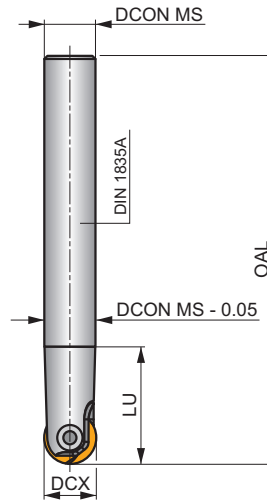
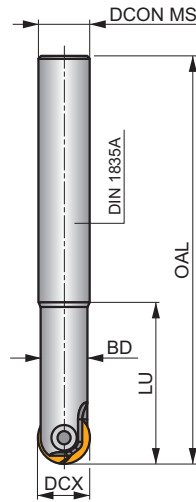
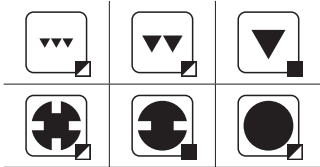
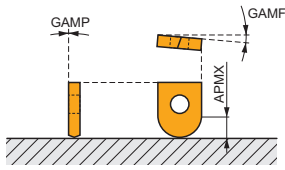
PRAMET



Kopierpinnfräs

Mångsidig fräs för formtillverkning. Kan bestyckas med radieskär eller torodial-skär. Finns med cylindriskt skaft eller modulärt fäste och i diametrar 8 till 32 mm. Behandlad för lång livslängd.

APMX	0.6 - 3.2 mm
------	--------------



h_m	0.07 - 0.14
-------	-------------



Product	DCX (mm)	OAL (mm)	DCON MS (mm)	BD (mm)	LU (mm)	LF (mm)	TDZ						
08K2R025A10-SRC08-A	8	110	10	7.5	25	-	-	2	-	56000	-	0.08	G1030 C0530
08K2R050A12-SRC08-A	8	140	12	-	13.5	-	-	2	-	56000	-	0.14	G1030 C0530
10K2R030A12-SRC10-A	10	130	12	9	30	-	-	2	-	42000	-	0.16	G1031 C0531
10K2R060A16-SRC10-A	10	150	16	-	19.5	-	-	2	-	42000	-	0.18	G1031 C0531
12K2R030A12-SRC12-A	12	130	12	10.5	30	-	-	2	-	35000	-	0.11	G1032 C0532
12K2R060A16-SRC12-A	12	160	16	-	24.5	-	-	2	-	35000	-	0.14	G1032 C0532
16K2R035A16-SRC16-A	16	140	16	14	35	-	-	2	-	22000	-	0.23	G1033 C0533
16K2R065A20-SRC16-A	16	175	20	-	31.5	-	-	2	-	22000	-	0.30	G1033 C0533
20K2R045A20-SRC20-A	20	160	20	18	45	-	-	2	-	16000	-	0.40	G1034 C0534
20K2R080A25-SRC20-A	20	190	25	-	33.5	-	-	2	-	16000	-	0.66	G1034 C0534
25K2R045A25-SRC25-A	25	160	25	22.4	45	-	-	2	-	10000	-	0.59	G1035 C0535
32K2R060A32-SRC32-A	32	180	32	28.6	60	-	-	2	-	6000	-	1.10	G1036 C0536
08K2R30M06-SRC08-A	8	45	6.5	-	-	30	M6	2	-	-	-	0.02	G1123 C0530
10K2R30M06-SRC10-A	10	45	6.5	-	-	30	M6	2	-	-	-	0.03	G1124 C0531
12K2R30M06-SRC12-A	12	45	6.5	-	-	30	M6	2	-	-	-	0.15	G1125 C0530
12K2R30M08-SRC12-A	12	48	8.5	-	-	30	M8	2	-	-	-	0.04	G1125 C0532
16K2R35M08-SRC16-A	16	53	8.5	-	-	35	M8	2	-	-	-	0.16	G1033 C0533
20K2R35M10-SRC20-A	20	54	10.5	-	-	35	M10	2	-	-	-	0.08	G1034 C0534

G1030	RC 08	-	-	-	LC 08-KP	LC 08-KPF
G1031	RC 10	-	RC 10-F	-	LC 10-KP	LC 10-KPF
G1032	RC 12	-	RC 12-F	-	-	-
G1033	RC 16	-	RC 16-F	-	-	-
G1034	RC 20	-	-	-	-	-
G1035	RC 25	-	-	-	-	-

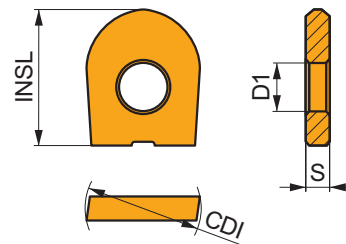
GI036	RC 32	-	-	-	-
GI123	RC 08	-	-	-	-
GI124	RC 10	RC 10-F	-	-	-
GI125	RC 12	RC 12-F	-	-	-

C0530	CS 3007-T08P	1.2	M 3	7	-	-	-	Flag T08P
C0531	CS 4008-T15P	3.0	M 4	8	-	D-T08P/T15P	FG-15	-
C0532	CS 5009-T20P	5.0	M 5	9	SDR T20P	-	-	-
C0533	CS 5013-T20P	5.0	M 5	13	SDR T20P	-	-	-
C0534	CS 5015-T20P	5.0	M 5	15	SDR T20P	-	-	-
C0535	CS 6020-T20P	7.5	M 6	20	SDR T20P	-	-	-
C0536	CS 8025-T30P	15.0	M 8	25	SDR T30P	-	-	-

RC



	CDI	D1	INSL	S
	(mm)	(mm)	(mm)	(mm)
08	8.0	3.00	9.5	2.00
10	10.0	4.00	11.5	2.50
12	12.0	5.00	12.0	2.50
16	16.0	5.00	14.0	3.00
20	20.0	5.00	16.0	3.00
25	25.0	6.00	21.5	4.00
32	32.0	8.00	25.8	5.00



Lämplighet och startvärden för skärhastighet (vc), matning (f) och skärdjup (ap). Vi refererar till vår Dormer Pramet Calculator-app för vidare beräkningar.

Product	RE (mm)	P			M			K			N			S			H		
		vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)



N neutral spånvinkel och positiv släppning.

RC 08:M4310	☹	-	☑	255	0.36	0.4	-	-	-	☹	240	0.36	0.4	-	-	-	-	-	-	☹	50	0.18	0.8
RC 08:M8310	☹	-	☑	295	0.36	0.4	-	-	-	☹	280	0.36	0.4	-	-	-	-	-	-	☹	55	0.18	0.8
RC 10:M4310	☹	-	☑	250	0.36	0.5	-	-	-	☹	235	0.36	0.5	-	-	-	-	-	-	☹	50	0.18	1.0
RC 10:M8310	☹	-	☑	290	0.36	0.5	-	-	-	☹	275	0.36	0.5	-	-	-	-	-	-	☹	55	0.18	1.0
RC 10:M8330	☹	-	☑	270	0.36	0.5	-	-	-	☹	255	0.36	0.5	-	-	-	-	-	-	☑	50	0.18	1.0
RC 12:M4310	☹	-	☑	245	0.36	0.6	-	-	-	☹	230	0.36	0.6	-	-	-	-	-	-	☹	45	0.18	1.2
RC 12:M8310	☹	-	☑	285	0.36	0.6	-	-	-	☹	270	0.36	0.6	-	-	-	-	-	-	☹	55	0.18	1.2
RC 12:M8330	☹	-	☑	265	0.36	0.6	-	-	-	☹	250	0.36	0.6	-	-	-	-	-	-	☑	50	0.18	1.2
RC 16:M4310	☹	-	☑	235	0.36	0.8	-	-	-	☹	220	0.36	0.8	-	-	-	-	-	-	☹	45	0.18	1.1
RC 16:M8310	☹	-	☑	275	0.36	0.8	-	-	-	☹	260	0.36	0.8	-	-	-	-	-	-	☹	55	0.18	1.1
RC 16:M8330	☹	-	☑	255	0.36	0.8	-	-	-	☹	240	0.36	0.8	-	-	-	-	-	-	☑	50	0.18	1.1
RC 20:M4310	☹	-	☑	235	0.36	1.0	-	-	-	☹	220	0.36	1.0	-	-	-	-	-	-	☹	45	0.18	1.3
RC 20:M8310	☹	-	☑	270	0.36	1.0	-	-	-	☹	255	0.36	1.0	-	-	-	-	-	-	☹	50	0.18	1.3
RC 20:M8330	☹	-	☑	250	0.36	1.0	-	-	-	☹	235	0.36	1.0	-	-	-	-	-	-	☑	50	0.18	1.3
RC 25:M8310	☹	-	☑	260	0.36	1.3	-	-	-	☹	245	0.36	1.3	-	-	-	-	-	-	☹	50	0.18	1.7
RC 25:M8330	☹	-	☑	245	0.36	1.3	-	-	-	☹	230	0.36	1.3	-	-	-	-	-	-	☑	45	0.18	1.7
RC 32:M4310	☹	-	☑	220	0.36	1.6	-	-	-	☹	205	0.36	1.6	-	-	-	-	-	-	☹	40	0.18	2.1
RC 32:M8330	☹	-	☑	240	0.36	1.6	-	-	-	☹	225	0.36	1.6	-	-	-	-	-	-	☑	45	0.18	2.1

Lämplighet och startvärden för skärhastighet (vc), matning (f) och skärdjup (ap). Vi refererar till vår Dormer Pramet Calculator-app för vidare beräkningar.

Product	RE (mm)	P			M			K			N			S			H		
		vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)



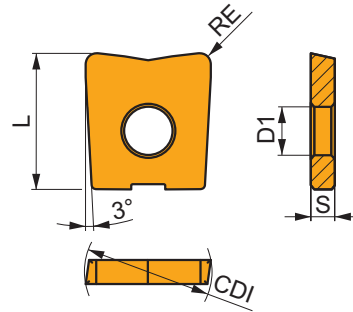
F geometri med vass design för finfräsning.

RC 10-F:M4310	●	–	250	0.36	0.5	125	0.32	0.5	235	0.36	0.5	–	–	–	–	–	–	–	50	0.18	1.0
RC 12-F:M4310	●	–	245	0.36	0.6	120	0.32	0.6	230	0.36	0.6	–	–	–	–	–	–	–	45	0.18	1.2
RC 16-F:M4310	●	–	235	0.36	0.8	115	0.32	0.8	220	0.36	0.8	–	–	–	–	–	–	–	45	0.18	1.1
RC 16-F:M8330	●	–	255	0.36	0.8	150	0.32	0.8	240	0.36	0.8	–	–	–	–	–	–	–	50	0.18	1.1

LC



	CDI (mm)	D1 (mm)	L (mm)	S (mm)
08	8.0	3.00	9.50	2.00
10	10.0	4.00	11.50	2.50

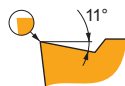


Product	RE (mm)	P			M			K			N			S			H		
		vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)



KP geometri med neutral spånvinkel för fin till medelfin fräsning.

LC 0806-KP:M4310	●	0.6	280	0.16	0.3	–	–	–	265	0.16	0.3	–	–	–	–	–	–	–	55	0.11	0.6
LC 0806-KP:M8310	●	0.6	325	0.16	0.3	–	–	–	305	0.16	0.3	–	–	–	–	–	–	–	65	0.11	0.6
LC 0810-KP:M4310	●	1.0	280	0.16	0.5	–	–	–	265	0.16	0.5	–	–	–	–	–	–	–	55	0.11	1.0
LC 1008-KP:M4310	●	0.8	270	0.16	0.4	–	–	–	255	0.16	0.4	–	–	–	–	–	–	–	50	0.08	0.8
LC 1008-KP:M8310	●	0.8	315	0.16	0.4	–	–	–	295	0.16	0.4	–	–	–	–	–	–	–	60	0.08	0.8
LC 1010-KP:M4310	●	1.0	280	0.16	0.5	–	–	–	265	0.16	0.5	–	–	–	–	–	–	–	55	0.08	1.0
LC 1010-KP:M8310	●	1.0	325	0.16	0.5	–	–	–	305	0.16	0.5	–	–	–	–	–	–	–	65	0.08	1.0



KPF geometri med positiv design för fin till medelfin fräsning.

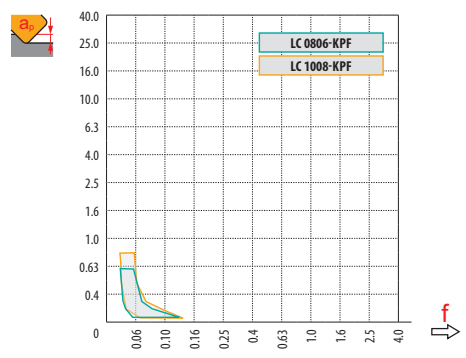
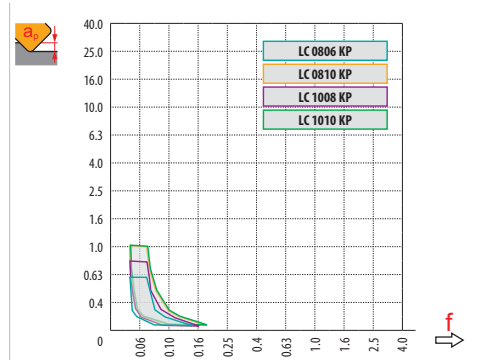
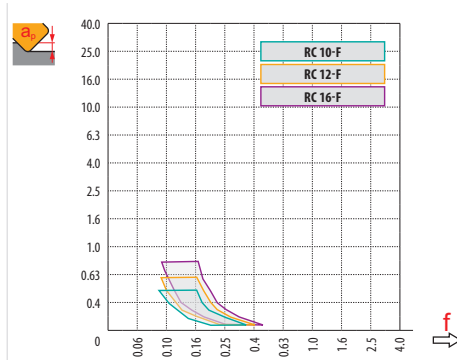
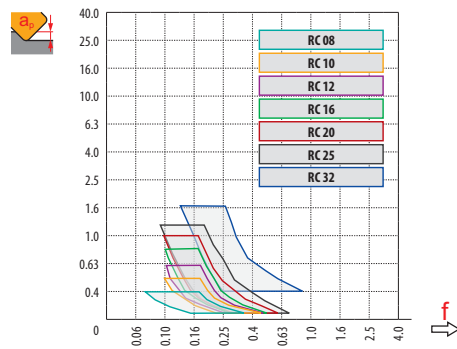
LC 0806-KPF:M4310	●	0.6	280	0.16	0.3	140	0.14	0.3	265	0.16	0.3	–	–	–	–	–	–	–	55	0.08	0.6
LC 1008-KPF:M4310	●	0.8	270	0.16	0.4	135	0.14	0.4	255	0.16	0.4	–	–	–	–	–	–	–	50	0.08	0.8



	RC 08	RC 10	RC 12	RC 16	RC 20	RC 25	RC 32
	4.0	5.0	6.0	8.0	10.0	12.5	16.0
	-	-	-	-	-	-	-

	RC 10-F	RC 12-F	RC 16-F
	5.0	6.0	8.0
	-	-	-

	LC 08-KP	LC 08-KP	LC 10-KP	LC 10-KP	LC 08-KPF	LC 10-KPF
	0.6	1.0	0.8	1.0	0.6	0.8
	-	-	-	-	-	-



RC 08	8
RC 10 / RC 10-F	10
RC 12 / RC 12-F	12
RC 16 / RC 16-F	16
RC 20	20
RC 25	25
RC 32	32

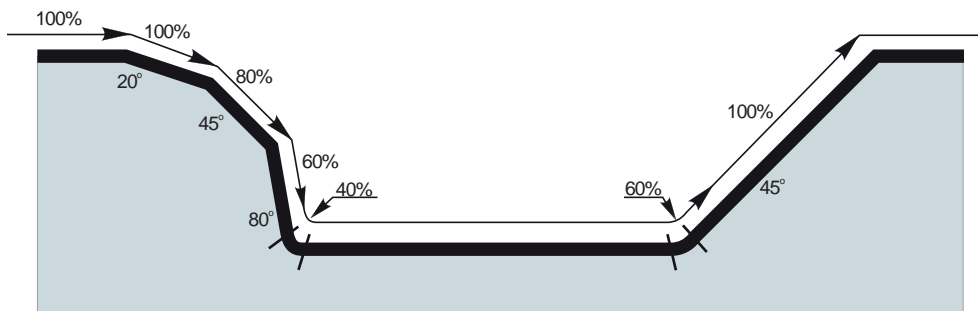
	0.3	0.4	0.5	0.7	1.0	1.25	1.5	2.0	2.5	3.0	4.0	5.0	6.0	8.0	10.0	12.0	15.0	16.0
	3.0	3.5	3.9	4.5	5.3	5.8	6.2	6.9	7.4	7.7	8.0	-	-	-	-	-	-	-
	3.4	3.9	4.4	5.1	6.0	6.6	7.1	8.0	8.7	9.2	9.8	10.0	-	-	-	-	-	-
	3.7	4.3	4.8	5.6	6.6	7.3	7.9	8.9	9.7	10.4	11.3	11.8	12.0	-	-	-	-	-
	4.3	5.0	5.6	6.5	7.7	8.6	9.3	10.6	11.6	12.5	13.9	14.8	15.5	16.0	-	-	-	-
	4.9	5.6	6.2	7.4	8.7	9.7	10.5	12.0	13.2	14.3	16.0	17.3	18.3	19.6	20.0	-	-	-
	5.4	6.3	7.0	8.2	9.8	10.9	11.9	13.6	15.0	16.2	18.3	20.0	21.4	23.3	24.5	25.0	-	-
	6.17	7.11	7.94	9.36	11.14	12.40	13.53	15.49	17.18	18.65	21.17	23.24	24.98	27.71	29.66	30.98	31.94	32.00



RC 08	8
RC 10 / RC 10-F	10
RC 12 / RC 12-F	12
RC 16 / RC 16-F	16
RC 20	20
RC 25	25
RC 32	32

	3	5	10	15	20	30	40	50	60	80	100
	0.310	0.400	0.566	0.693	0.800	0.980	1.131	1.265	1.386	1.600	1.789
	0.346	0.447	0.632	0.775	0.894	1.095	1.265	1.414	1.549	1.789	2.000
	0.379	0.490	0.693	0.849	0.980	1.200	1.386	1.549	1.697	1.960	2.191
	0.438	0.566	0.800	0.980	1.131	1.386	1.600	1.789	1.960	2.263	2.530
	0.490	0.632	0.894	1.095	1.265	1.549	1.789	2.000	2.191	2.530	2.828
	0.548	0.707	1.000	1.225	1.414	1.732	2.000	2.236	2.449	2.828	3.162
	0.620	0.800	1.131	1.386	1.600	1.960	2.263	2.530	2.771	3.200	3.578

	a_e	1.0%	2.5%	5.0%	7.5%	10%	15%	20%	25%	30%	35%	40%	45%	50%	60%	70%	75%	80%	90%	100%
19.9%	1.0%	2.86	1.84	1.33	1.12	1.00	0.89	-	-	-	-	-	-	-	-	-	-	-	-	-
31.2%	2.5%	3.58	2.28	1.64	1.36	1.20	1.01	0.92	0.88	0.91	-	-	-	-	-	-	-	-	-	-
43.6%	5.0%	4.22	2.68	1.92	1.58	1.39	1.16	1.03	0.95	0.90	0.88	0.89	-	-	-	-	-	-	-	-
52.7%	7.5%	4.63	2.95	2.10	1.73	1.51	1.26	1.11	1.02	0.96	0.91	0.89	0.88	0.90	-	-	-	-	-	-
60.0%	10.0%	4.94	3.14	2.24	1.84	1.61	1.33	1.18	1.07	1.00	0.95	0.91	0.89	0.88	1.00	-	-	-	-	-
71.4%	15.0%	5.39	3.42	2.43	2.00	1.74	1.44	1.27	1.15	1.07	1.01	0.96	0.93	0.90	0.88	0.93	-	-	-	-
80.0%	20.0%	5.70	3.62	2.57	2.11	1.84	1.52	1.33	1.21	1.12	1.05	1.00	0.96	0.93	0.89	0.88	0.89	1.00	-	-
86.6%	25.0%	5.93	3.76	2.67	2.20	1.91	1.58	1.38	1.25	1.16	1.08	1.03	0.99	0.95	0.90	0.88	0.88	0.89	-	-
91.7%	30.0%	6.10	3.87	2.75	2.26	1.96	1.62	1.42	1.28	1.18	1.11	1.05	1.01	0.97	0.92	0.89	0.88	0.88	0.93	-
95.4%	35.0%	6.23	3.95	2.80	2.30	2.00	1.65	1.44	1.31	1.20	1.13	1.07	1.02	0.98	0.93	0.89	0.88	0.88	0.90	-
98.0%	40.0%	6.31	4.00	2.84	2.33	2.03	1.67	1.46	1.32	1.22	1.14	1.08	1.03	0.99	0.93	0.90	0.89	0.88	0.89	-
99.5%	45.0%	6.36	4.03	2.86	2.35	2.04	1.68	1.47	1.33	1.23	1.15	1.09	1.04	1.00	0.94	0.90	0.89	0.88	0.88	-
100.0%	50.0%	6.38	4.04	2.87	2.35	2.05	1.69	1.48	1.33	1.23	1.15	1.09	1.04	1.00	0.94	0.90	0.89	0.88	0.88	1.00





	DCX	RE	a _r														
			0.00	0.30	0.40	0.50	0.60	0.70	0.80	0.90	1.00	1.25	1.50	2.00	2.50	3.00	4.00
LC 0806-KP	8	0.6	6.8	7.8	7.9	8.0	8.0	-	-	-	-	-	-	-	-	-	-
LC 0806-KPF		0.6	6.8	7.8	7.9	8.0	8.0	-	-	-	-	-	-	-	-	-	-
LC 0810-KP		1.0	6.0	7.4	7.6	7.7	7.8	7.9	8.0	8.0	8.0	-	-	-	-	-	-
LC 1008-KP	10	0.8	8.4	9.6	9.8	9.9	9.9	10.0	10.0	-	-	-	-	-	-	-	-
LC 1008-KPF		0.8	8.4	9.6	9.8	9.9	9.9	10.0	10.0	-	-	-	-	-	-	-	-
LC 1010-KP		1.0	8.0	9.4	9.6	9.7	9.8	9.9	10.0	10.0	10.0	-	-	-	-	-	-



DCX	μm	3	5	10	15	20	30	40	50	60	80	100
8	FE	0.310	0.400	0.566	0.693	0.800	0.980	1.131	1.265	1.386	1.600	1.789
	RE	0.346	0.447	0.632	0.775	0.894	1.095	1.265	1.414	1.549	1.789	2.000
DCX	μm	3	5	10	15	20	30	40	50	60	80	100
0.6	FE	0.120	0.155	0.219	0.268	0.310	0.379	0.438	0.490	0.537	0.620	0.693
	RE	0.139	0.179	0.253	0.310	0.358	0.438	0.506	0.566	0.620	0.716	0.800
	RE	0.155	0.200	0.283	0.346	0.400	0.490	0.566	0.632	0.693	0.800	0.89



	DCX	RE	max
LC 0806-KP	8	0.6	3.0
LC 0806-KPF		0.6	2.8
LC 0810-KP		1.0	3.0
LC 1008-KP	10	0.8	3.8
LC 1008-KPF		0.8	3.6
LC 1010-KP		1.0	3.8



	DCX	RE	RPMX	APMX/I
LC 0806-KP	8	0.6	2.5	1.5/35
LC 0806-KPF		0.6	2.2	1.5/39
LC 0810-KP		1.0	2.4	1.5/36
LC 1008-KP	10	0.8	2.6	1.5/33
LC 1008-KPF		0.8	2.3	1.5/38
LC 1010-KP		1.0	2.6	1.5/33



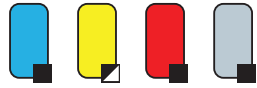
	DCX	RE	DMIN	DMAX	SMAX DMIN	SMAX DMAX
LC 0806-KP	8	0.6	9.8	15.9	0.8	1.0
LC 0806-KPF		0.6	10.2	15.9	0.1	0.1
LC 0810-KP		1.0	9.9	15.9	0.1	0.1
LC 1008-KP	10	0.8	12.2	19.9	0.9	1.1
LC 1008-KPF		0.8	12.6	19.9	0.2	0.2
LC 1010-KP		1.0	12.2	19.9	0.2	0.2



	DCX	RE	a _r
LC 0806-KP	8	0.6	0.15
LC 0806-KPF		0.6	0.13
LC 0810-KP		1.0	0.13
LC 1008-KP	10	0.8	0.2
LC 1008-KPF		0.8	0.18
LC 1010-KP		1.0	0.19

Överhäng (multiplar av diametern DCX)	< 3.0	3.0 – 3.5	3.6 – 4.0	4.1 – 4.5	> 4.6
Multiplikationsfaktor för hastighet	1.0	0.9	0.8	0.7	0.5

K2-SLC



PRAMET

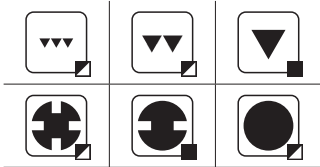
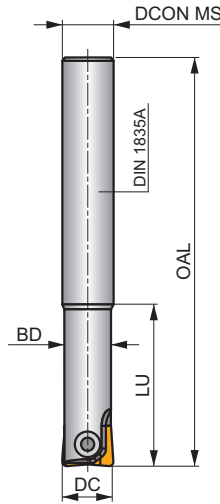
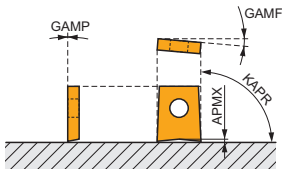
S



Kopierfräs för finfräsning

Fräs för en rad olika applikationer, t ex finfräsning. Bestyckad med precisionslipade LC-skär. Används till profilfräsning, rampning, spiralinterpolering, mm. Finns med cyl. skaft och i diametrar 12 till 20 mm. Behandlad för lång livslängd.

APMX	1.0 - 3.0 mm
------	--------------



h_m	0.03 - 0.10
-------	-------------



Product	DC (mm)	OAL (mm)	DCON MS (mm)	LU (mm)	BD (mm)							
12K2R030A12-SLC12-A	12	130	12	30	10.5	2	-	35000	-	0.11	GI037	C0532
16K2R035A16-SLC16-A	16	140	16	35	14	2	-	22000	-	0.20	GI038	C0533
20K2R045A20-SLC20-A	20	160	20	45	18	2	-	16000	-	0.38	GI039	C0534

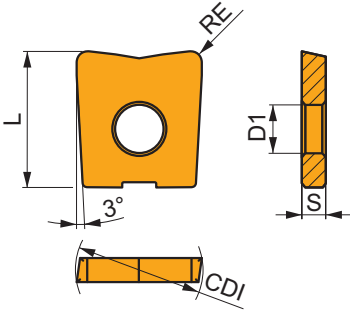
GI037	LC 12-KP	LC 12-KPF
GI038	LC 16-KP	-
GI039	LC 20-KP	-

C0532	CS 5009-T20P	5.0	M 5	9	SDR T20P
C0533	CS 5013-T20P	5.0	M 5	13	SDR T20P
C0534	CS 5015-T20P	5.0	M 5	15	SDRT20P

LC



	CDI (mm)	D1 (mm)	L (mm)	S (mm)
12	12.0	5.00	14.00	2.50
16	16.0	5.00	16.00	3.00
20	20.0	5.00	18.00	3.00



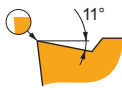
Lämplighet och startvärden för skärhastighet (vc), matning (f) och skärdjup (ap). Vi refererar till vår Dormer Pramet Calculator-app för vidare beräkningar.

Product	RE (mm)	P			M			K			N			S			H		
		vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)



KP geometri med neutral spånvinkel för fin till medelfin fräsning.

LC 1210-KP:M4310	1.0	280	0.16	0.5	-	-	-	265	0.16	0.5	-	-	-	-	-	-	55	0.08	1.0
LC 1210-KP:M8310	1.0	325	0.16	0.5	-	-	-	305	0.16	0.5	-	-	-	-	-	-	65	0.08	1.0
LC 1210-KP:M8330	1.0	295	0.16	0.5	-	-	-	280	0.16	0.5	-	-	-	-	-	-	55	0.08	1.0
LC 1610-KP:M4310	1.0	280	0.16	0.5	-	-	-	265	0.16	0.5	-	-	-	-	-	-	55	0.08	1.0
LC 1610-KP:M8310	1.0	325	0.16	0.5	-	-	-	305	0.16	0.5	-	-	-	-	-	-	65	0.08	1.0
LC 1610-KP:M8330	1.0	295	0.16	0.5	-	-	-	280	0.16	0.5	-	-	-	-	-	-	55	0.08	1.0
LC 1613-KP:M4310	1.3	270	0.16	0.7	-	-	-	255	0.16	0.7	-	-	-	-	-	-	50	0.08	1.3
LC 1613-KP:M8310	1.3	315	0.16	0.7	-	-	-	295	0.16	0.7	-	-	-	-	-	-	60	0.08	1.3
LC 2010-KP:M4310	1.0	280	0.16	0.5	-	-	-	265	0.16	0.5	-	-	-	-	-	-	55	0.08	1.0
LC 2010-KP:M8310	1.0	325	0.16	0.5	-	-	-	305	0.16	0.5	-	-	-	-	-	-	65	0.08	1.0
LC 2016-KP:M4310	1.6	280	0.16	0.8	-	-	-	265	0.16	0.8	-	-	-	-	-	-	55	0.08	1.1
LC 2016-KP:M8310	1.6	325	0.16	0.8	-	-	-	305	0.16	0.8	-	-	-	-	-	-	65	0.08	1.1
LC 2040-KP:M8330	4.0	285	0.16	2.0	-	-	-	270	0.16	2.0	-	-	-	-	-	-	55	0.08	2.7



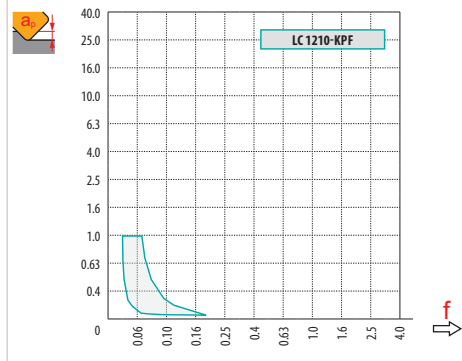
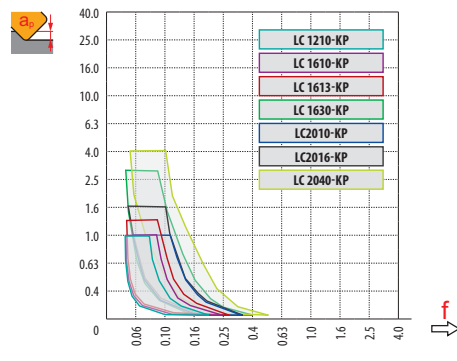
KPF geometri med positiv design för fin till medelfin fräsning.

LC 1210-KPF:M4310	1.0	280	0.16	0.5	140	0.14	0.5	265	0.16	0.5	-	-	-	-	-	-	55	0.08	1.0
LC 1210-KPF:M8330	1.0	295	0.16	0.5	175	0.14	0.5	280	0.16	0.5	-	-	-	-	-	-	55	0.08	1.0



a_e / DC	5%	10%	15%	20%	25%	30%	40%	50%	60%	70%	75%	80%	90%	100%
	1.48	1.35	1.27	1.22	1.19	1.16	1.11	1.08	1.05	1.03	1.00	1.00	1.00	1.00
	2.20	1.60	1.35	1.20	1.10	0.95	0.85	0.75	0.85	0.95	1.00	1.00	1.00	1.00
	0.64	0.64	0.64	0.64	0.64	0.65	0.65	0.67	0.68	0.71	0.72	0.74	0.79	1.00

	LC 1210-KP	LC 1610-KP	LC 1613-KP	LC 2010-KP	LC 2016-KP	LC 2040-KP	LC 1210-KPF
	1.0	1.3	3.0	1.0	1.6	4.0	1.0
	-	-	-	-	-	-	-



	DC		0.0	0.3	0.4	0.5	0.6	0.7	0.8	0.9	1.0	1.25	1.5	2.0	2.5	3.0	4.0
LC 1210-KP	12	1.0	10.0	11.4	11.6	11.7	11.8	11.9	12.0	12.0	12.0	-	-	-	-	-	-
LC 1210-KPF		1.0	10.0	11.4	11.6	11.7	11.8	11.9	12.0	12.0	12.0	-	-	-	-	-	-
LC 1610-KP	16	1.0	14.0	15.4	15.6	15.7	15.8	15.9	16.0	16.0	16.0	-	-	-	-	-	-
LC 1613-KP		1.3	13.4	15.1	15.3	15.4	15.6	15.7	15.8	15.9	15.9	16.0	-	-	-	-	-
LC 2010-KP	20	1.0	18.0	19.4	19.6	19.7	19.8	19.9	20.0	20.0	20.0	-	-	-	-	-	-
LC 2016-KP		1.6	16.8	18.7	18.9	19.1	19.3	19.4	19.6	19.7	19.8	19.9	20.0	-	-	-	-
LC 2040-KP		4.0	12.0	15.0	15.5	15.9	16.2	16.5	16.8	17.1	17.3	17.8	18.2	18.9	19.4	-	-



		3	5	10	15	20	30	40	50	60	80	100
12		0.379	0.490	0.693	0.849	0.980	1.200	1.386	1.549	1.697	1.960	2.191
16		0.438	0.566	0.800	0.980	1.131	1.386	1.600	1.789	1.960	2.263	2.530
20		0.490	0.632	0.894	1.095	1.265	1.549	1.789	2.000	2.191	2.530	2.828
		3	5	10	15	20	30	40	50	60	80	100
1.3		0.177	0.228	0.322	0.395	0.456	0.559	0.645	0.721	0.790	0.912	1.020
1.6		0.196	0.253	0.358	0.438	0.506	0.620	0.716	0.800	0.876	1.012	1.131
2.0		0.219	0.283	0.400	0.490	0.566	0.693	0.800	0.894	0.980	1.131	1.265
4.0		0.310	0.400	0.566	0.693	0.800	0.980	1.131	1.265	1.386	1.600	1.789



LC 1210-KP	12	4.8
LC 1210-KPF	12	4.4
LC 1610-KP	16	6.6
LC 1613-KP	16	6.6
LC 2010-KP	20	8.5
LC 2016-KP	20	8.5
LC 2040-KP	4.0	8.5



LC 1210-KP	12	4.7	1.5/19
LC 1210-KPF	12	3.8	1.5/23
LC 1610-KP	16	4.8	1.5/18
LC 1613-KP	16	4.8	1.5/18
LC 2010-KP	20	5.0	1.5/18
LC 2016-KP	20	4.9	1.6/19
LC 2040-KP	4.0	4.5	4.0/51



		D _{MIN}	D _{MAX}		
LC 1210-KP	12	14.1	23.9	1.0	1.2
LC 1210-KPF	12	15.0	23.9	0.4	0.4
LC 1610-KP	16	18.6	31.9	1.1	1.4
LC 1613-KP	16	18.6	31.9	0.6	0.6
LC 2010-KP	20	22.8	39.9	1.3	1.5
LC 2016-KP	20	22.8	39.9	0.8	0.8
LC 2040-KP	4.0	22.8	39.9	0.5	0.5



LC 1210-KP	12	0.44
LC 1210-KPF	12	0.9
LC 1610-KP	16	0.65
LC 1613-KP	16	0.62
LC 2010-KP	20	0.85
LC 2016-KP	20	0.79
LC 2040-KP	4.0	0.54

Överhäng (multiplar av diametern DCX)	< 3.0	3 – 3.5	3.6 – 4.0	4.1 – 4.5	> 4.6
Multiplikationsfaktor för hastighet	1.0	0.9	0.8	0.7	0.5

K2-PPH



PRAMET

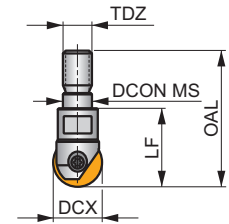
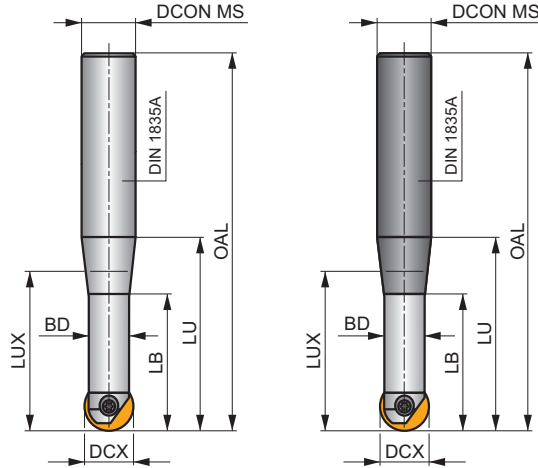
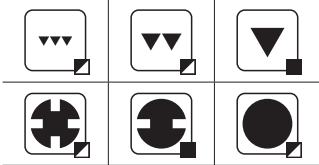
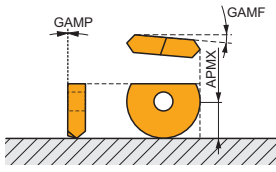
S



Kopierpinnfräs

Mångsidig fräs för formtillverkning. Kan bestyckas med radieskär, högmatningskär eller torodial-skär. Finns med cylindriskt skaft eller modulärt fäste och i diametrar 8 till 32 mm. Behandlad för lång livslängd.

APMX	0.3 - 4.0 mm
------	--------------



	0.07 - 0.14
--	-------------



Product	DCX (mm)	OAL (mm)	DCON MS (mm)	BD (mm)	LB (mm)	LU (mm)	LUX (mm)	LF (mm)	TDZ	Carbide			kg		
PPH-08/02-QC12-092	8	92	12	6.5	19	35	23.1	-	-	-	40000	-	0.14	GI284	C0540
PPH-08/02-QC12-110	8	110	12	6.5	33.5	53	41.5	-	-	-	33600	-	0.14	GI284	C0540
PPH-08/02-QC12-132	8	132	12	6.5	19	75	41.8	-	-	-	16800	-	0.15	GI284	C0540
PPH-10/02-QC12-092	10	92	12	8	22.4	38	30	-	-	-	40000	-	0.12	GI285	C0541
PPH-10/02-QC12-110	10	110	12	8	38.7	53	51.9	-	-	-	40000	-	0.15	GI285	C0541
PPH-10/02-QC12-132	10	132	12	8	21.8	75	73.6	-	-	-	20300	-	0.16	GI285	C0541
PPH-12/02-QC16-145	12	145	16	10	22.5	85	63.3	-	-	-	19800	-	0.23	GI286	C0542
PPH-16/02-QC20-166	16	166	20	14	29.5	100	75.5	-	-	-	20000	-	0.37	GI287	C0543
PPH-20/02-QC25-191	20	191	25	17	35	115	82.2	-	-	-	18400	-	0.64	GI288	C0544
PPH-25/02-QC32-215	25	215	32	21	42.5	135	97	-	-	-	16500	-	1.07	GI289	C0545
PPH-12/02-QC12-083	12	83	12	10	-	26	-	-	-	-	40000	-	0.15	GI286	C0542
PPH-12/02-QC12-110	12	110	12	10	-	53	-	-	-	-	40000	-	0.15	GI286	C0542
PPH-16/02-QC16-092	16	92	16	14	-	92	-	-	-	-	36000	-	0.20	GI287	C0543
PPH-16/02-QC16-123	16	123	16	14	-	63	-	-	-	-	36000	-	0.24	GI287	C0543
PPH-20/02-QC20-104	20	104	20	17	-	38	-	-	-	-	40000	-	0.34	GI288	C0544
PPH-20/02-QC20-141	20	141	20	17	-	75	-	-	-	-	40000	-	0.41	GI288	C0544
PPH-25/02-QC25-121	25	121	25	21	-	45	-	-	-	-	40000	-	0.53	GI289	C0545
PPH-25/02-QC25-166	25	166	25	21	-	90	-	-	-	-	37100	-	0.57	GI289	C0545
PPH-32/02-QC32-186	32	186	32	26	-	107	-	-	-	-	32500	-	1.09	GI290	C0546
PPH-32/02-QC32-240	32	240	32	26	-	160	-	-	-	-	14500	-	1.37	GI290	C0546
PPH-08/02-QC12-110HSCW	8	110	12	6.5	19	53	30.1	-	-	✓	40000	-	0.21	GI284	C0540
PPH-08/02-QC12-132HSCW	8	132	12	6.5	19	75	37.1	-	-	✓	23400	-	0.22	GI284	C0540
PPH-10/02-QC12-092HSCW	10	92	12	8	21.9	38.1	90.9	-	-	✓	40000	-	0.20	GI285	C0541
PPH-10/02-QC12-132HSCW	10	132	12	8	21.8	75.1	51.1	-	-	✓	23400	-	0.24	GI285	C0541
PPH-12/02-QC16-145HSCW	12	145	16	10	21.5	85	65.6	-	-	✓	21000	-	0.28	GI286	C0542
PPH-16/02-QC20-166HSCW	16	166	20	14	28.5	100	87.2	-	-	✓	25500	-	0.66	GI287	C0543
PPH-20/02-QC25-191HSCW	20	191	25	17	35	115	75.6	-	-	✓	18500	-	1.07	GI288	C0544
PPH-08/02-QC08-130HSCW	8	130	8	6.5	-	20	-	-	-	✓	40000	-	0.17	GI284	C0540

Product	DCX	OAL	DCONIMS	BD	LB	LU	LUX	LF	TDZ	Carbide					
	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)							
PPH-10/02-QC10-140HSCW	10	140	10	8	-	25	-	-	-	✓	40000	-	0.22	GI285	C0541
PPH-12/02-QC12-083HSCW	12	83	12	10	-	26	-	-	-	✓	40000	-	0.19	GI286	C0542
PPH-12/02-QC12-110HSCW	12	110	12	10	-	53	-	-	-	✓	40000	-	0.22	GI286	C0542
PPH-16/02-QC16-092HSCW	16	92	16	14	-	32	-	-	-	✓	43000	-	0.29	GI287	C0543
PPH-16/02-QC16-123HSCW	16	123	16	14	-	63	-	-	-	✓	43000	-	0.36	GI287	C0543
PPH-20/02-QC20-104HSCW	20	104	20	17	-	38	-	-	-	✓	40000	-	0.50	GI288	C0544
PPH-20/02-QC20-141HSCW	20	141	20	17	-	75	-	-	-	✓	40000	-	0.62	GI288	C0544
PPH-16/02-025-P08	16	-	8.5	-	-	-	-	25	M8	-	-	-	0.10	GI287	C0543
PPH-20/02-030-P10	20	-	10.5	-	-	-	-	30	M10	-	-	-	0.16	GI288	C0544

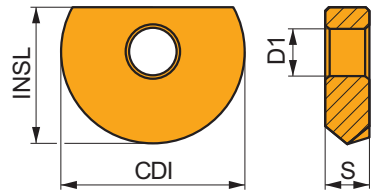
GI284	PPH 08..	-	PPHT 08..	PPHF 08..
GI285	PPH 10..	PPHE 10..	PPHT 10..	PPHF 10..
GI286	PPH 12..	PPHE 12..	PPHT 12..	PPHF 12..
GI287	PPH 16..	PPHE 16..	PPHT 16..	PPHF 16..
GI288	PPH 20..	PPHE 20..	PPHT 20..	PPHF 20..
GI289	PPH 25..	-	PPHT 25..	-
GI290	PPH 32..	-	-	-

C0540	CS 42506-T07P	1.0	M 2.5	6	D-T07P/T09P	FG-15	-	-
C0541	CS 43008-T08P	1.2	M 3	8	D-T08P/T15P	FG-15	-	-
C0542	CS 43509-T10P	2.0	M 3.5	9	-	-	SDRT10P	-
C0543	CS 44013-T15P	3.0	M 4	13	D-T08P/T15P	FG-15	-	-
C0544	CS 45016-T20P	5.0	M 5	16	-	-	SDRT20P	-
C0545	CS 46020-T25P	7.5	M 6	20	-	-	-	SDRT25P-T
C0546	CS 48025-T40P	15.0	M 8	25	-	-	-	SDRT40P-T

PPH



	CDI (mm)	D1 (mm)	INSL (mm)	S (mm)
0800	8.0	2.50	7.0	2.40
1000	10.0	3.00	8.5	2.60
1200	12.0	3.50	10.0	3.00
1600	16.0	4.00	12.0	4.00
2000	20.0	5.00	15.0	5.00
2500	25.0	6.00	18.5	6.00
3000	30.0	8.00	22.5	7.00
3200	32.0	8.00	23.5	7.00



Lämplighet och startvärden för skärhastighet (vc), matning (f) och skärdjup (ap). Vi refererar till vår Dormer Pramet Calculator-app för vidare beräkningar.

Product	RE (mm)	P			M			K			N			S			H		
		vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)



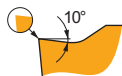
CL1 geometri med vass design.

PPH 0800-CL1:2003	☺	–	285	0.36	0.4	145	0.32	0.4	270	0.36	0.4	–	–	–	–	–	–	–	55	0.18	0.8
PPH 1000-CL1:2003	☺	–	280	0.36	0.5	140	0.32	0.5	265	0.36	0.5	–	–	–	–	–	–	–	55	0.18	1.0
PPH 1200-CL1:2003	☺	–	275	0.36	0.6	140	0.32	0.6	260	0.36	0.6	–	–	–	–	–	–	–	55	0.18	1.2
PPH 1600-CL1:2003	☺	–	265	0.36	0.8	135	0.32	0.8	250	0.36	0.8	–	–	–	–	–	–	–	50	0.18	1.1
PPH 2000-CL1:2003	☺	–	260	0.36	1.0	130	0.32	1.0	245	0.36	1.0	–	–	–	–	–	–	–	50	0.18	1.3
PPH 2500-CL1:2003	☺	–	250	0.36	1.3	125	0.32	1.3	235	0.36	1.3	–	–	–	–	–	–	–	50	0.18	1.7
PPH 3000-CL1:2003	☺	–	245	0.36	1.5	120	0.32	1.5	230	0.36	1.5	–	–	–	–	–	–	–	45	0.18	2.0
PPH 3200-CL1:2003	☺	–	245	0.36	1.6	120	0.32	1.6	230	0.36	1.6	–	–	–	–	–	–	–	45	0.18	2.1



CL4 geometri med vass design för intermittenta skär.

PPH 0800-CL4:8215	☺	–	270	0.36	0.4	–	–	–	255	0.36	0.4	–	–	–	–	–	–	–	50	0.18	0.8
PPH 1000-CL4:8215	☺	–	265	0.36	0.5	–	–	–	250	0.36	0.5	–	–	–	–	–	–	–	50	0.18	1.0
PPH 1200-CL4:8215	☺	–	255	0.36	0.6	–	–	–	240	0.36	0.6	–	–	–	–	–	–	–	50	0.18	1.2
PPH 1600-CL4:8215	☺	–	250	0.36	0.8	–	–	–	235	0.36	0.8	–	–	–	–	–	–	–	50	0.18	1.1
PPH 2000-CL4:8215	☺	–	245	0.36	1.0	–	–	–	230	0.36	1.0	–	–	–	–	–	–	–	45	0.18	1.3



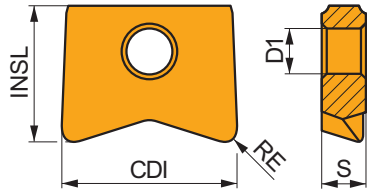
SM1 geometri med vass design.

PPHE 1000-SM1:8215	☺	–	275	0.31	0.5	165	0.28	0.5	260	0.31	0.5	–	–	–	–	–	–	–	55	0.16	1.0
PPHE 1200-SM1:8215	☺	–	255	0.36	0.6	150	0.32	0.6	240	0.36	0.6	–	–	–	–	–	–	–	50	0.18	1.2
PPHE 1600-SM1:8215	☺	–	260	0.31	0.8	155	0.28	0.8	245	0.31	0.8	–	–	–	–	–	–	–	50	0.16	1.1
PPHE 2000-SM1:8215	☺	–	250	0.31	1.0	150	0.28	1.0	235	0.31	1.0	–	–	–	–	–	–	–	50	0.16	1.3

PPHT

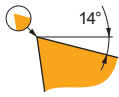


	CDI (mm)	D1 (mm)	INSL (mm)	S (mm)
0800	8.0	2.50	7.0	2.40
1000	10.0	3.00	8.5	2.60
1200	12.0	3.50	10.0	3.00
1600	16.0	4.00	12.0	4.00
2000	20.0	5.00	15.0	5.00
2500	25.0	6.00	18.5	6.00



Lämplighet och startvärden för skärhastighet (vc), matning (f) och skärdjup (ap). Vi refererar till vår Dormer Pramet Calculator-app för vidare beräkningar.

Product	RE (mm)	P			M			K			N			S			H		
		vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)



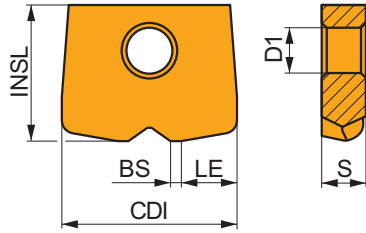
A2 geometri med positiv design för fin till medelfin fräsning.

PPHT 080003-A2:2003	●	0.3	275	0.10	0.3	140	0.09	0.3	260	0.10	0.3	—	—	—	—	—	—	55	0.07	0.3
PPHT 080005-A2:2003	●	0.5	270	0.13	0.3	135	0.12	0.3	255	0.13	0.3	—	—	—	—	—	—	50	0.09	0.5
PPHT 080010-A2:2003	⊕	1.0	315	0.14	0.5	160	0.13	0.5	295	0.14	0.5	—	—	—	—	—	—	60	0.10	1.0
PPHT 100005-A2:2003	●	0.5	270	0.13	0.3	135	0.12	0.3	255	0.13	0.3	—	—	—	—	—	—	50	0.09	0.5
PPHT 100008-A2:2003	⊕	0.8	305	0.14	0.4	155	0.13	0.4	285	0.14	0.4	—	—	—	—	—	—	60	0.10	0.8
PPHT 100010-A2:2003	⊕	1.0	315	0.14	0.5	160	0.13	0.5	295	0.14	0.5	—	—	—	—	—	—	60	0.10	1.0
PPHT 120005-A2:2003	●	0.5	270	0.13	0.3	135	0.12	0.3	255	0.13	0.3	—	—	—	—	—	—	50	0.09	0.5
PPHT 120010-A2:2003	⊕	1.0	315	0.14	0.5	160	0.13	0.5	295	0.14	0.5	—	—	—	—	—	—	60	0.10	1.0
PPHT 120020-A2:2003	⊕	2.0	320	0.14	1.0	160	0.13	1.0	300	0.14	1.0	—	—	—	—	—	—	60	0.10	1.3
PPHT 160010-A2:2003	⊕	1.0	315	0.14	0.5	160	0.13	0.5	295	0.14	0.5	—	—	—	—	—	—	60	0.10	1.0
PPHT 160013-A2:2003	⊕	1.3	300	0.15	0.6	150	0.13	0.6	285	0.15	0.6	—	—	—	—	—	—	60	0.10	1.3
PPHT 160020-A2:2003	⊕	2.0	320	0.14	1.0	160	0.13	1.0	300	0.14	1.0	—	—	—	—	—	—	60	0.10	1.3
PPHT 200010-A2:2003	⊕	1.0	315	0.14	0.5	160	0.13	0.5	295	0.14	0.5	—	—	—	—	—	—	60	0.10	1.0
PPHT 200016-A2:2003	⊕	1.6	310	0.14	0.8	155	0.13	0.8	290	0.14	0.8	—	—	—	—	—	—	60	0.10	1.1
PPHT 200030-A2:2003	⊕	3.0	305	0.14	1.5	155	0.13	1.5	285	0.14	1.5	—	—	—	—	—	—	60	0.10	2.0
PPHT 200040-A2:2003	⊕	4.0	295	0.14	2.0	150	0.13	2.0	280	0.14	2.0	—	—	—	—	—	—	55	0.10	2.7
PPHT 250020-A2:2003	⊕	2.0	320	0.14	1.0	160	0.13	1.0	300	0.14	1.0	—	—	—	—	—	—	60	0.10	1.3

PPHF

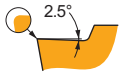


	BS	LE	CDI	D1	INSL	S
	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)
0800	0.40	2.60	8.0	2.50	7.0	2.40
1000	0.50	3.20	10.0	3.00	8.5	2.60
1200	0.60	3.90	12.0	3.50	10.0	3.00
1600	0.80	5.20	16.0	4.00	12.0	4.00
2000	1.00	6.40	20.0	5.00	15.0	5.00



Lämplighet och startvärden för skärhastighet (vc), matning (f) och skärdjup (ap). Vi refererar till vår Dormer Pramet Calculator-app för vidare beräkningar.

Product	RE (mm)	P			M			K			N			S			H		
		vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)



CE1 geometri med stark design för högmatningsfräsning.

PPHF 080004-CE1:M8330	●	–	■	200	0.30	0.3	▣	120	0.27	0.3	■	190	0.30	0.3	–	–	–	▣	50	0.27	0.2	▣	40	0.21	0.2
PPHF 100005-CE1:M8330	●	–	■	190	0.35	0.3	▣	110	0.32	0.3	■	180	0.35	0.3	–	–	–	▣	45	0.32	0.2	▣	35	0.25	0.2
PPHF 120006-CE1:M8330	●	–	■	205	0.45	0.4	▣	120	0.41	0.4	■	190	0.45	0.4	–	–	–	▣	50	0.41	0.3	▣	40	0.32	0.3
PPHF 160008-CE1:M8330	●	–	■	190	0.60	0.5	▣	110	0.54	0.5	■	180	0.60	0.5	–	–	–	▣	45	0.54	0.4	▣	35	0.42	0.4
PPHF 200010-CE1:M8330	●	–	■	185	0.75	0.6	▣	110	0.68	0.6	■	175	0.75	0.6	–	–	–	▣	45	0.68	0.5	▣	35	0.53	0.4



a_e DCX	5 %	10 %	15 %	20 %	25 %	30 %	40 %	50 %	60 %	70 %	75 %	80 %	90 %	100 %
	1.48	1.35	1.27	1.22	1.19	1.16	1.11	1.08	1.05	1.03	1.00	1.00	1.00	1.00
	2.20	1.60	1.35	1.20	1.10	0.95	0.85	0.75	0.85	0.95	1.00	1.00	1.00	1.00
	0.64	0.64	0.64	0.64	0.64	0.65	0.65	0.67	0.68	0.71	0.72	0.74	0.79	1.00

	PPH 08-CL1	PPH 10-CL1	PPH 12-CL1	PPH 16-CL1	PPH 20-CL1	PPH 25-CL1	PPH 30-CL1	PPH 32-CL1
	4.0	5.0	6.0	8.0	10.0	12.5	15.0	16.0
	-	-	-	-	-	-	-	-

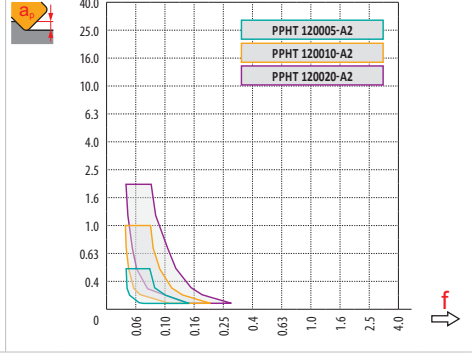
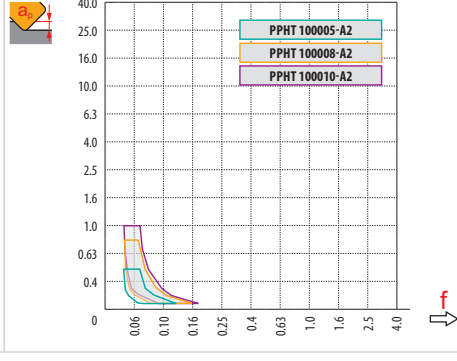
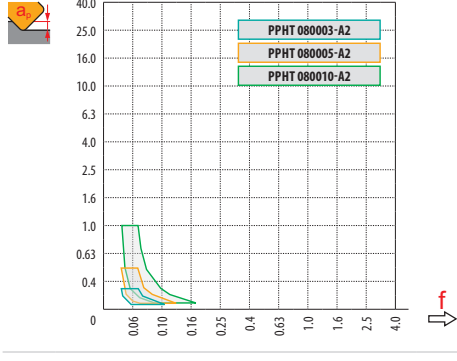
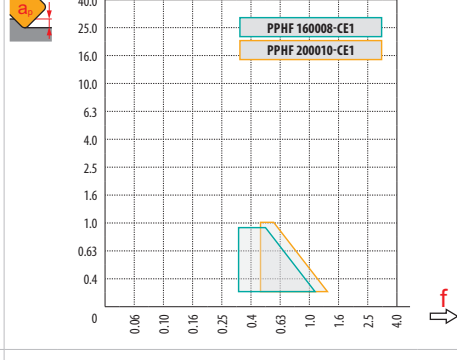
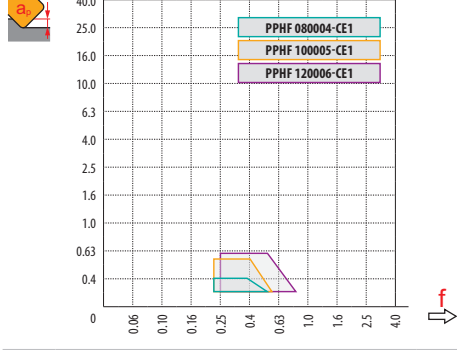
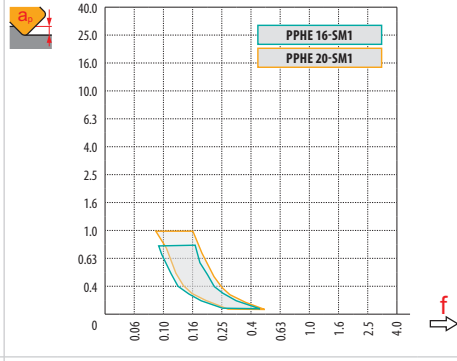
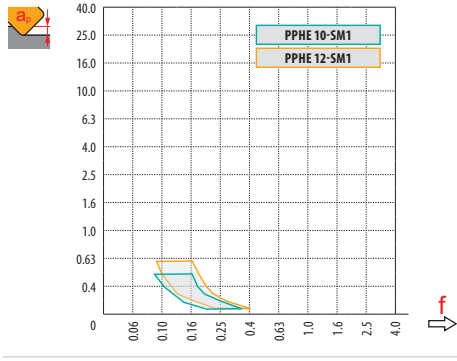
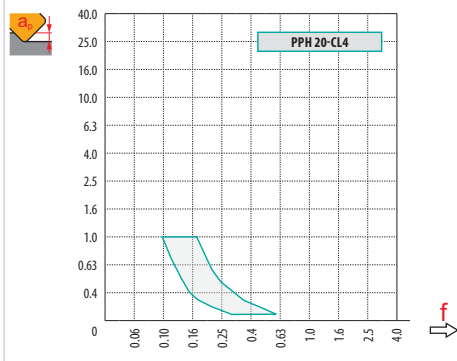
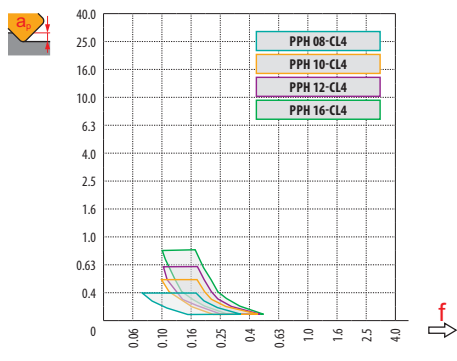
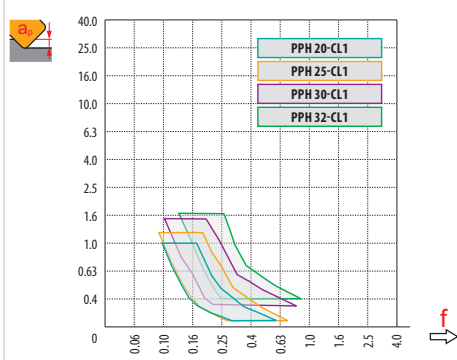
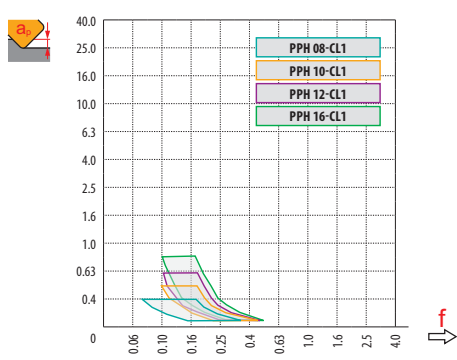
	PPH 08-CL4	PPH 10-CL4	PPH 12-CL4	PPH 16-CL4	PPH 20-CL4
	4.0	5.0	6.0	8.0	10.0
	-	-	-	-	-

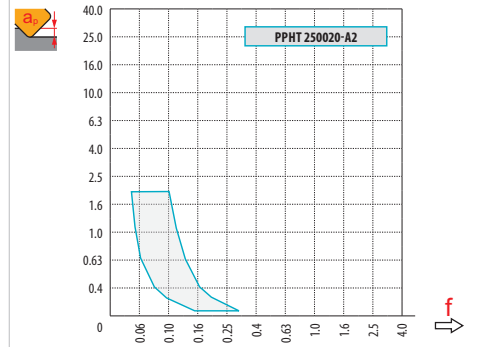
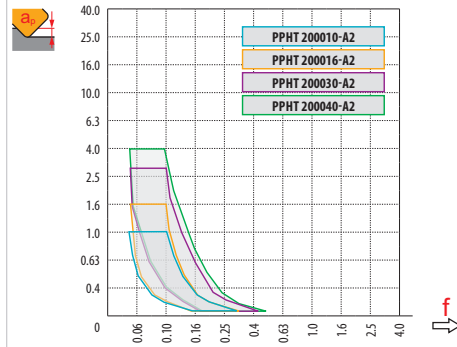
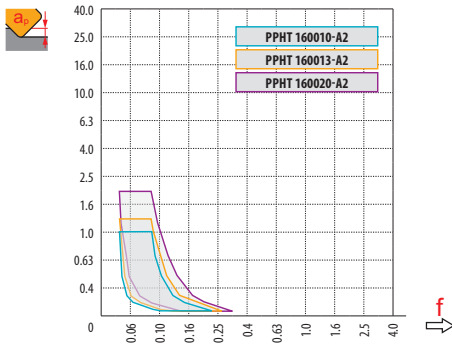
	PPHE 10-SM1	PPHE 12-SM1	PPHE 16-SM1	PPHE 20-SM1
	5.0	6.0	8.0	10.0
	-	-	-	-

	PPHF 08-CE1	PPHF 10-CE1	PPHF 12-CE1	PPHF 16-CE1	PPHF 20-CE1
	0.6	0.8	1.0	1.3	1.6
	0.40	0.50	0.60	0.80	1.00

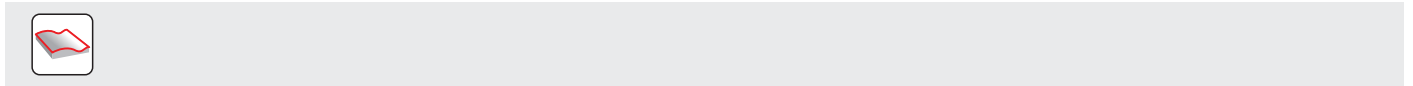
	PPHT 08-A2	PPHT 08-A2	PPHT 08-A2	PPHT 10-A2	PPHT 10-A2	PPHT 10-A2	PPHT 12-A2	PPHT 12-A2	PPHT 12-A2
	0.3	0.5	1.0	0.5	0.8	1.0	0.5	1.0	2.0
	-	-	-	-	-	-	-	-	-

	PPHT 16-A2	PPHT 16-A2	PPHT 16-A2	PPHT 20-A2	PPHT 20-A2	PPHT 20-A2	PPHT 20-A2	PPHT 25-A2
	1.0	1.3	2.0	1.0	1.6	3.0	4.0	2.0
	-	-	-	-	-	-	-	-



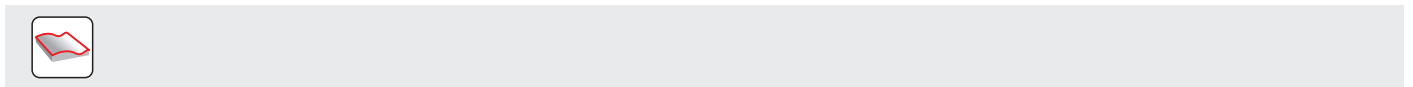


PPH	DCX	DEF	Surface Roughness (a_r) vs. Feed Rate (f)																	
			0.3	0.4	0.5	0.7	1.0	1.25	1.5	2.0	2.5	3.0	4.0	5.0	6.0	8.0	10.0	12.0	15.0	16.0
PPH 08	8		3.0	3.5	3.9	4.5	5.3	5.8	6.2	6.9	7.4	7.7	8.0	-	-	-	-	-	-	-
PPH 10	10		3.4	3.9	4.4	5.1	6.0	6.6	7.1	8.0	8.7	9.2	9.8	10.0	-	-	-	-	-	-
PPH 12	12		3.7	4.3	4.8	5.6	6.6	7.3	7.9	8.9	9.7	10.4	11.3	11.8	12.0	-	-	-	-	-
PPH 16	16		4.3	5.0	5.6	6.5	7.7	8.6	9.3	10.6	11.6	12.5	13.9	14.8	15.5	16.0	-	-	-	-
PPH 20	20		4.9	5.6	6.2	7.4	8.7	9.7	10.5	12.0	13.2	14.3	16.0	17.3	18.3	19.6	20.0	-	-	-
PPH 25	25		5.4	6.3	7.0	8.2	9.8	10.9	11.9	13.6	15.0	16.2	18.3	20.0	21.4	23.3	24.5	25.0	-	-
PPH 32	32		6.17	7.11	7.94	9.36	11.14	12.40	13.53	15.49	17.18	18.65	21.17	23.24	24.98	27.71	29.66	30.98	31.94	32.00



PPH	DCX	μm	Surface Roughness (a_r) vs. Feed Rate (f)										
			3	5	10	15	20	30	40	50	60	80	100
PPH 08	8		0.310	0.400	0.566	0.693	0.800	0.980	1.131	1.265	1.386	1.600	1.789
PPH 10	10		0.346	0.447	0.632	0.775	0.894	1.095	1.265	1.414	1.549	1.789	2.000
PPH 12	12		0.379	0.490	0.693	0.849	0.980	1.200	1.386	1.549	1.697	1.960	2.191
PPH 16	16		0.438	0.566	0.800	0.980	1.131	1.386	1.600	1.789	1.960	2.263	2.530
PPH 20	20		0.490	0.632	0.894	1.095	1.265	1.549	1.789	2.000	2.191	2.530	2.828
PPH 25	25		0.548	0.707	1.000	1.225	1.414	1.732	2.000	2.236	2.449	2.828	3.162
PPH 32	32		0.620	0.800	1.131	1.386	1.600	1.960	2.263	2.530	2.771	3.200	3.578

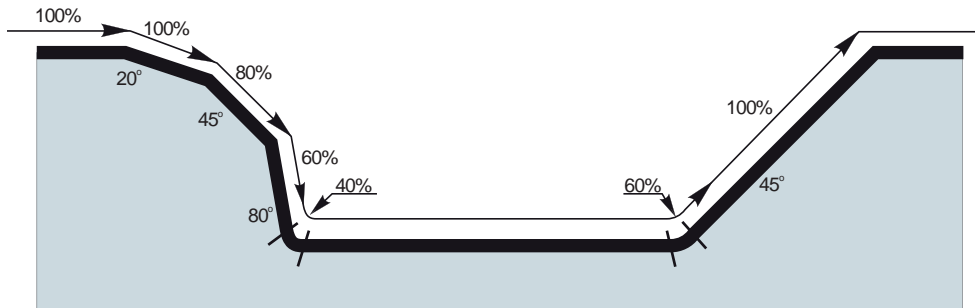
DEF	a _e	1%	2.5%	5%	7.5%	10%	15%	20%	25%	30%	35%	40%	45%	50%	60%	70%	75%	80%	90%	100%
19.9%	1.0%	2.86	1.84	1.33	1.12	1.00	0.89	-	-	-	-	-	-	-	-	-	-	-	-	-
31.2%	2.5%	3.58	2.28	1.64	1.36	1.20	1.01	0.92	0.88	0.91	-	-	-	-	-	-	-	-	-	-
43.6%	5.0%	4.22	2.68	1.92	1.58	1.39	1.16	1.03	0.95	0.90	0.88	0.89	-	-	-	-	-	-	-	-
52.7%	7.5%	4.63	2.95	2.10	1.73	1.51	1.26	1.11	1.02	0.96	0.91	0.89	0.88	0.90	-	-	-	-	-	-
60.0%	10.0%	4.94	3.14	2.24	1.84	1.61	1.33	1.18	1.07	1.00	0.95	0.91	0.89	0.88	1.00	-	-	-	-	-
71.4%	15.0%	5.39	3.42	2.43	2.00	1.74	1.44	1.27	1.15	1.07	1.01	0.96	0.93	0.90	0.88	0.93	-	-	-	-
80.0%	20.0%	5.70	3.62	2.57	2.11	1.84	1.52	1.33	1.21	1.12	1.05	1.00	0.96	0.93	0.89	0.88	0.89	1.00	-	-
86.6%	25.0%	5.93	3.76	2.67	2.20	1.91	1.58	1.38	1.25	1.16	1.08	1.03	0.99	0.95	0.90	0.88	0.88	0.89	-	-
91.7%	30.0%	6.10	3.87	2.75	2.26	1.96	1.62	1.42	1.28	1.18	1.11	1.05	1.01	0.97	0.92	0.89	0.88	0.88	0.93	-
95.4%	35.0%	6.23	3.95	2.80	2.30	2.00	1.65	1.44	1.31	1.20	1.13	1.07	1.02	0.98	0.93	0.89	0.88	0.88	0.90	-
98.0%	40.0%	6.31	4.00	2.84	2.33	2.03	1.67	1.46	1.32	1.22	1.14	1.08	1.03	0.99	0.93	0.90	0.89	0.88	0.89	-
99.5%	45.0%	6.36	4.03	2.86	2.35	2.04	1.68	1.47	1.33	1.23	1.15	1.09	1.04	1.00	0.94	0.90	0.89	0.88	0.88	-
100.0%	50.0%	6.38	4.04	2.87	2.35	2.05	1.69	1.48	1.33	1.23	1.15	1.09	1.04	1.00	0.94	0.90	0.89	0.88	0.88	1.00



DCX	RE	a _e																					
		0.0	0.3	0.4	0.5	0.6	0.7	0.8	0.9	1.0	1.25	1.5	2.0	2.5	3.0	4.0							
PPHT 08-A2	8	0.3	7.4	8.0	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-			
		0.5	7.0	7.9	8.0	8.0	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-		
		0.8	6.4	7.6	7.8	7.9	7.9	8.0	8.0	-	-	-	-	-	-	-	-	-	-	-	-		
		1.0	6.0	7.4	7.6	7.7	7.8	7.9	8.0	8.0	8.0	8.0	-	-	-	-	-	-	-	-	-	-	
PPHT 10-A2	10	0.5	9.0	9.9	10.0	10.0	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-		
		0.8	8.4	9.6	9.8	9.9	9.9	10.0	10.0	-	-	-	-	-	-	-	-	-	-	-	-		
		1.0	8.0	9.4	9.6	9.7	9.8	9.9	10.0	10.0	10.0	-	-	-	-	-	-	-	-	-	-	-	
PPHT 12-A2	12	0.5	11.0	11.9	12.0	12.0	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-		
		1.0	10.0	11.4	11.6	11.7	11.8	11.9	12.0	12.0	12.0	-	-	-	-	-	-	-	-	-	-	-	
		2.0	8.0	10.1	10.4	10.6	10.9	11.0	11.2	11.3	11.5	11.7	11.9	12.0	-	-	-	-	-	-	-	-	
PPHT 16-A2	16	1.0	14.0	15.4	15.6	15.7	15.8	15.9	16.0	16.0	16.0	-	-	-	-	-	-	-	-	-	-	-	
		1.3	13.4	15.1	15.3	15.4	15.6	15.7	15.8	15.9	15.9	16.0	-	-	-	-	-	-	-	-	-	-	
		2.0	12.0	14.1	14.4	14.6	14.9	15.0	15.2	15.3	15.5	15.7	15.9	16.0	-	-	-	-	-	-	-	-	
		3.0	10.0	12.6	13.0	13.3	13.6	13.9	14.1	14.3	14.5	14.9	15.2	15.7	15.9	16.0	-	-	-	-	-	-	-
PPHT 20-A2	20	1.0	18.0	19.4	19.6	19.7	19.8	19.9	20.0	20.0	20.0	-	-	-	-	-	-	-	-	-	-	-	
		1.6	16.8	18.7	18.9	19.1	19.3	19.4	19.6	19.7	19.8	19.9	20.0	-	-	-	-	-	-	-	-	-	
		3.0	14.0	16.6	17.0	17.3	17.6	17.9	18.1	18.3	18.5	18.9	19.2	19.7	19.9	20.0	-	-	-	-	-	-	-
		4.0	12.0	15.0	15.5	15.9	16.2	16.5	16.8	17.1	17.3	17.8	18.2	18.9	19.4	19.7	20.0	-	-	-	-	-	-
PPHT 25-A2	25	2.0	21.0	23.1	23.4	23.6	23.9	24.0	24.2	24.3	24.5	24.7	24.9	25.0	-	-	-	-	-	-	-	-	
PPHF 08-CE1	8	0.6	2.8	6.0	7.1	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	
PPHF 10-CE1	10	0.8	3.6	6.8	7.9	9.0	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	
PPHF 12-CE1	12	1.0	4.2	7.4	8.5	9.6	10.7	11.8	-	-	-	-	-	-	-	-	-	-	-	-	-	-	
PPHF 16-CE1	16	1.3	5.6	8.8	9.9	11.0	12.1	13.2	14.2	15.3	-	-	-	-	-	-	-	-	-	-	-	-	
PPHF 20-CE1	20	1.6	7.2	10.4	11.5	12.6	13.7	14.8	15.8	16.9	18.0	-	-	-	-	-	-	-	-	-	-	-	
PPHF 25-CE1	25	1.9	9.2	12.4	13.5	14.6	15.7	16.8	17.8	18.9	20.0	22.7	-	-	-	-	-	-	-	-	-	-	



	μm	3	5	10	15	20	30	40	50	60	80	100
8		0.310	0.400	0.566	0.693	0.800	0.980	1.131	1.265	1.386	1.600	1.789
10		0.346	0.447	0.632	0.775	0.894	1.095	1.265	1.414	1.549	1.789	2.000
12		0.379	0.490	0.693	0.849	0.980	1.200	1.386	1.549	1.697	1.960	2.191
16		0.438	0.566	0.800	0.980	1.131	1.386	1.600	1.789	1.960	2.263	2.530
20		0.490	0.632	0.894	1.095	1.265	1.549	1.789	2.000	2.191	2.530	2.828
25		0.548	0.707	1.000	1.225	1.414	1.732	2.000	2.236	2.449	2.828	3.162
	μm	3	5	10	15	20	30	40	50	60	80	100
1.3		0.177	0.228	0.322	0.395	0.456	0.559	0.645	0.721	0.790	0.912	1.020
1.6		0.196	0.253	0.358	0.438	0.506	0.620	0.716	0.800	0.876	1.012	1.131
1.9		0.214	0.276	0.390	0.477	0.551	0.675	0.780	0.872	0.955	1.103	1.233
2.0		0.219	0.283	0.400	0.490	0.566	0.693	0.800	0.894	0.980	1.131	1.265
3.0		0.268	0.346	0.490	0.600	0.693	0.849	0.980	1.095	1.200	1.386	1.549
4.0		0.310	0.400	0.566	0.693	0.800	0.980	1.131	1.265	1.386	1.600	1.789



			max
PPHT 08-A2	8	0.3	2.4
PPHT 08-A2		0.5	2.4
PPHT 08-A2		0.8	2.5
PPHT 08-A2		1.0	2.7
PPHT 10-A2	10	0.5	3.2
PPHT 10-A2		0.8	3.3
PPHT 10-A2		1.0	3.4
PPHT 12-A2	12	0.5	4.0
PPHT 12-A2		1.0	4.2
PPHT 12-A2		2.0	4.6
PPHT 16-A2	16	1.0	5.7
PPHT 16-A2		1.3	5.8
PPHT 16-A2		2.0	6.0
PPHT 16-A2		3.0	6.4
PPHT 20-A2	20	1.0	7.2
PPHT 20-A2		1.6	7.4
PPHT 20-A2		3.0	7.8
PPHT 20-A2		4.0	8.2
PPHT 25-A2	25	2.0	9.3

			max
PPHF 08-CE1	8	0.6	2.0
PPHF 10-CE1	10	0.8	2.5
PPHF 12-CE1	12	1.0	3.0
PPHF 16-CE1	16	1.3	4.0
PPHF 20-CE1	20	1.6	5.0
PPHF 25-CE1	25	1.9	6.0



PPHT 08-A2	8	0.3	6.3	1.2/11
PPHT 08-A2		0.5	6.1	1.2/12
PPHT 08-A2		0.8	5.7	1.2/12
PPHT 08-A2		1.0	6.8	1.2/11
PPHT 10-A2	10	0.5	6.9	1.5/13
PPHT 10-A2		0.8	6.6	1.5/13
PPHT 10-A2		1.0	7.5	1.5/12
PPHT 12-A2	12	0.5	7.9	1.8/13
PPHT 12-A2		1.0	7.5	1.8/14
PPHT 12-A2		2.0	9.0	1.8/12
PPHT 16-A2	16	1.0	8.9	2.4/16
PPHT 16-A2		1.3	8.9	2.4/16
PPHT 16-A2		2.0	8.5	2.4/17
PPHT 16-A2		3.0	12.3	2.4/11
PPHT 20-A2	20	1.0	9.3	3/19
PPHT 20-A2		1.6	9.1	3/19
PPHT 20-A2		3.0	8.8	3/20
PPHT 20-A2		4.0	11.4	3/15
PPHT 25-A2	25	2.0	8.3	3.7/26

PPHF 08-CE1	8	0.6	8.0	0.4/3
PPHF 10-CE1	10	0.8	8.0	0.5/4
PPHF 12-CE1	12	1.0	8.0	0.6/5
PPHF 16-CE1	16	1.3	8.0	0.8/6
PPHF 20-CE1	20	1.6	8.0	1.0/8
PPHF 25-CE1	25	1.9	8.0	1.2/9



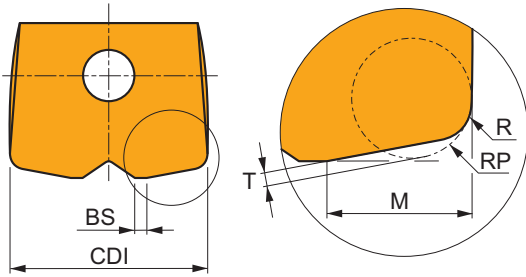
			DMIN	DMAX		
					DMIN	DMAX
PPHT 08-A2	8	0.3	11.0	15.9	0.5	0.5
PPHT 08-A2		0.5	10.9	15.9	0.5	0.5
PPHT 08-A2		0.8	10.7	15.9	0.4	0.4
PPHT 08-A2		1.0	10.3	15.9	0.4	0.4
PPHT 10-A2	10	0.5	13.4	19.9	0.7	0.7
PPHT 10-A2		0.8	13.2	19.9	0.6	0.6
PPHT 10-A2		1.0	12.9	19.9	0.6	0.6
PPHT 12-A2	12	0.5	15.8	23.9	1.0	1.0
PPHT 12-A2		1.0	15.4	23.9	0.8	0.8
PPHT 12-A2		2.0	14.6	23.9	0.7	0.7
PPHT 16-A2	16	1.0	20.4	31.9	1.3	1.3
PPHT 16-A2		1.3	20.2	31.9	1.3	1.3
PPHT 16-A2		2.0	19.7	31.9	1.0	1.0
PPHT 16-A2		3.0	18.9	31.9	1.2	1.2
PPHT 20-A2	20	1.0	25.4	39.9	1.8	1.8
PPHT 20-A2		1.6	24.9	39.9	1.6	1.6
PPHT 20-A2		3.0	24.1	39.9	1.2	1.2
PPHT 20-A2		4.0	23.3	39.9	1.3	1.3
PPHT 25-A2	25	2.0	31.1	49.9	1.8	1.8

			DMIN	DMAX		
					DMIN	DMAX
PPHF 08-CE1	8	0.6	10.0	14.7	0.40	0.40
PPHF 10-CE1	10	0.8	13.0	18.4	0.50	0.50
PPHF 12-CE1	12	1.0	15.7	22.0	0.60	0.60
PPHF 16-CE1	16	1.3	20.9	29.4	0.80	0.80
PPHF 20-CE1	20	1.6	26.2	36.7	1.00	1.00
PPHF 25-CE1	25	1.9	33.0	46.1	1.20	1.20



PPHT 08-A2	8	0.3	0.52
PPHT 08-A2		0.5	0.47
PPHT 08-A2		0.8	0.39
PPHT 08-A2		1.0	0.40
PPHT 10-A2	10	0.5	0.69
PPHT 10-A2		0.8	0.61
PPHT 10-A2		1.0	0.62
PPHT 12-A2	12	0.5	0.97
PPHT 12-A2		1.0	0.79
PPHT 12-A2		2.0	0.68
PPHT 16-A2	16	1.0	1.33
PPHT 16-A2		1.3	1.26
PPHT 16-A2		2.0	1.03
PPHT 16-A2		3.0	1.15
PPHT 20-A2	20	1.0	1.80
PPHT 20-A2		1.6	1.59
PPHT 20-A2		3.0	1.21
PPHT 20-A2		4.0	1.27
PPHT 25-A2	25	2.0	1.83

PPHF 08-CE1	8	0.6	0.40
PPHF 10-CE1	10	0.8	0.50
PPHF 12-CE1	12	1.0	0.60
PPHF 16-CE1	16	1.3	0.80
PPHF 20-CE1	20	1.6	1.00
PPHF 25-CE1	25	1.9	1.20



	R	RP	M	T
08	0.6	1.0	2.6	0.3
10	0.8	1.2	3.2	0.4
12	1.0	1.5	3.9	0.4
16	1.3	2.0	5.2	0.6
20	1.6	2.5	6.4	0.7
25	1.9	3.0	7.9	0.9



Överhäng (multiplar av diametern DCX)	< 3.0	3.0 – 3.5	3.6 – 4.0	4.1 – 4.5	> 4.6
Multiplikationsfaktor för hastighet	1.0	0.9	0.8	0.7	0.5

K3-CXP



PRAMET

C

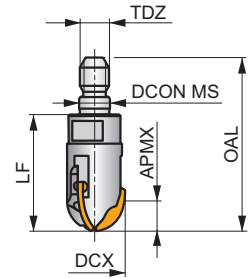
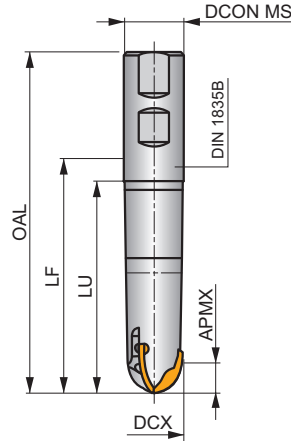
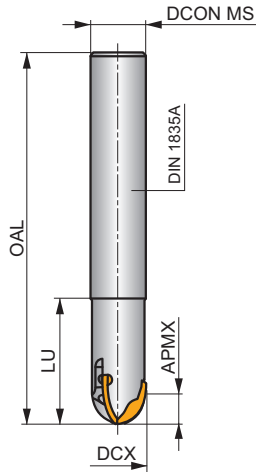
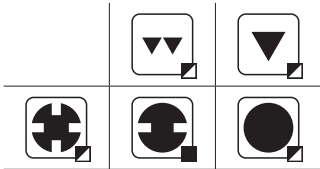
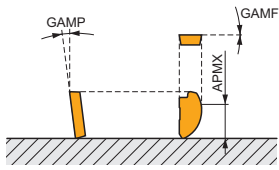


MULTISIDE XP Radiefrärs

Radiefrärs för XP.. -skär med APMX från 8 till 16 mm. Unik inspänning möjliggör användning av tre skär. Behandlad för lång livslängd.

MULTISIDE XP

APMX	8.0 - 16.0 mm
------	---------------



h_m 0.05 - 0.19



Product	DCX (mm)	OAL (mm)	DCON MS (mm)	LU (mm)	LUX (mm)	LF (mm)	TDZ	APMX (mm)	GAMF (°)	GAMP (°)						
16K3R050A16-CXP16	16	200	16	50	-	-	-	8.00	0	-5	3	-	22600	-	0.35	GI267 C0520
16K3R050A20-CXP16	16	200	20	50	-	-	-	8.00	0	-5	3	-	22600	-	0.50	GI267 C0520
20K3R050A20-CXP20	20	200	20	50	-	-	-	10.00	0	-5	3	-	20000	-	0.52	GI268 C0521
20K3R060A25-CXP20	20	250	25	60	-	-	-	10.00	0	-5	3	-	20000	-	0.92	GI268 C0521
25K3R060A25-CXP25	25	250	25	60	-	-	-	12.50	0	-5	3	-	20000	-	0.96	GI269 C0522
32K3R080A32-CXP32	32	250	32	80	-	-	-	16.00	0	-5	3	-	15000	-	1.50	GI270 C0523
16K3R060B20-CXP16	16	111	20	60	-	86.5	-	8.00	0	-5	3	-	22600	-	0.23	GI267 C0520
20K3R070B25-CXP20	20	127	25	70	-	95.5	-	10.00	0	-5	3	-	20000	-	0.41	GI268 C0521
25K3R080B25-CXP25	25	137	25	80	-	105	-	12.50	0	-5	3	-	20000	-	0.49	GI269 C0522
16K3R035M10-CXP16	16	-	10.5	-	-	35	M10	8.00	0	-5	3	-	-	-	0.07	GI267 C0520
20K3R040M10-CXP20	20	-	10.5	-	-	40	M10	10.00	0	-5	3	-	-	-	0.07	GI268 C0521
25K3R045M12-CXP25	25	-	12.5	-	-	45	M12	12.50	0	-5	3	-	-	-	0.16	GI269 C0522

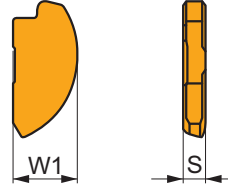
GI267		XP 16..
GI268		XP 20..
GI269		XP 25..
GI270		XP 32..

C0520	US 63009-T09P	1.2	M 3	9	Flag T09P
C0521	US 63513-T15P	3.0	M 3.5	13	Flag T15P
C0522	US 64014-T15P	3.5	M 4	14	Flag T15P
C0523	US 65017-T20P	5.0	M 5	17	Flag T20P

XP



	W1 (mm)	S (mm)
16	16.000	2.00
20	20.000	2.50
25	25.000	3.17
32	32.000	4.00



Lämplighet och startvärden för skärhastighet (vc), matning (f) och skärdjup (ap). Vi refererar till vår Dormer Pramet Calculator-app för vidare beräkningar.

Product	RE (mm)	P			M			K			N			S			H		
		vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)			

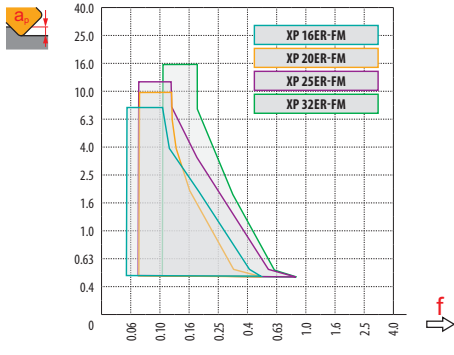


FM geometri med neutral design för finfräsning.

XP 16ER-FM:M8310	☹	-	■	285	0.27	0.8	☑	145	0.24	0.8	■	270	0.27	0.8	-	-	-	-	-	-	■	55	0.19	0.8	
XP 20ER-FM:M8330	☹	-	■	260	0.27	1.0	☑	155	0.24	1.0	■	245	0.27	1.0	-	-	-	☑	65	0.19	1.0	☑	50	0.19	1.0
XP 20ER-FM:M8345	☹	-	■	190	0.27	1.0	☑	110	0.24	1.0	-	-	-	-	-	-	-	☑	45	0.19	1.0	-	-	-	
XP 25ER-FM:M8310	☹	-	■	270	0.27	1.3	☑	135	0.24	1.3	■	255	0.27	1.3	-	-	-	-	-	-	■	50	0.19	1.3	
XP 32ER-FM:M8345	☹	-	■	180	0.27	1.6	☑	105	0.24	1.6	-	-	-	-	-	-	-	☑	45	0.19	1.6	-	-	-	

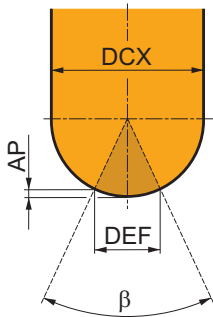


	XP 16-FM	XP 20-FM	XP 25-FM	XP 32-FM
	8.0	10.0	12.5	16.0
	-	-	-	-



		0.3	0.4	0.5	0.7	1.0	1.25	1.5	2.0	2.5	3.0	4.0	5.0	6.0	8.0	10.0	12.0	15.0	
16		4.3	5.0	5.6	6.5	7.7	8.6	9.3	10.6	11.6	12.5	13.9	14.8	15.5	16.0	-	-	-	
20		4.9	5.6	6.2	7.4	8.7	9.7	10.5	12.0	13.2	14.3	16.0	17.3	18.3	19.6	20.0	-	-	
25		5.4	6.3	7.0	8.2	9.8	10.9	11.9	13.6	15.0	16.2	18.3	20.0	21.4	23.3	24.5	25.0	-	-
32		6.2	7.1	7.9	9.4	11.1	12.4	13.5	15.5	17.2	18.7	21.2	23.2	25.0	27.7	29.7	31.2	31.9	-

Effektivt område för skärebben.

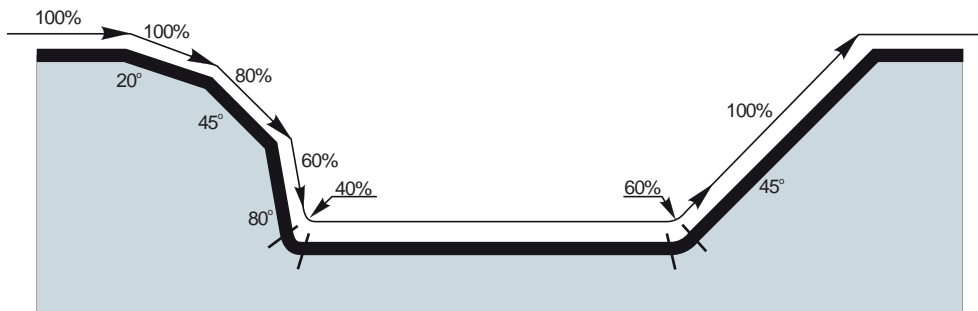


	β		AP
16	41°	5.568	0.51
20	37°	6.314	0.52
25	37°	7.901	0.65
32	37°	10.122	0.83



		3	5	10	15	20	30	40	50	60	80	100
16		0.438	0.566	0.800	0.980	1.131	1.386	1.600	1.789	1.960	2.263	2.530
20		0.490	0.632	0.894	1.095	1.265	1.549	1.789	2.000	2.191	2.530	2.828
25		0.548	0.707	1.000	1.225	1.414	1.732	2.000	2.236	2.449	2.828	3.162
32		0.620	0.800	1.131	1.386	1.600	1.960	2.263	2.530	2.771	3.200	3.578



















DEF	a _e	1.0 %	2.5 %	5.0 %	7.5 %	10 %	15 %	20 %	25 %	30 %	35 %	40 %	45 %	50 %	60 %	70 %	75 %	80 %	90 %	100 %		
19.9 %	1.0 %	2.86	1.84	1.33	1.12	1.00	0.89	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-
31.2 %	2.5 %	3.58	2.28	1.64	1.36	1.20	1.01	0.92	0.88	0.91	-	-	-	-	-	-	-	-	-	-	-	-
43.6 %	5.0 %	4.22	2.68	1.92	1.58	1.39	1.16	1.03	0.95	0.90	0.88	0.89	-	-	-	-	-	-	-	-	-	-
52.7 %	7.5 %	4.63	2.95	2.10	1.73	1.51	1.26	1.11	1.02	0.96	0.91	0.89	0.88	0.90	-	-	-	-	-	-	-	-
60.0 %	10.0 %	4.94	3.14	2.24	1.84	1.61	1.33	1.18	1.07	1.00	0.95	0.91	0.89	0.88	1.00	-	-	-	-	-	-	-
71.4 %	15.0 %	5.39	3.42	2.43	2.00	1.74	1.44	1.27	1.15	1.07	1.01	0.96	0.93	0.90	0.88	0.93	-	-	-	-	-	-
80.0 %	20.0 %	5.70	3.62	2.57	2.11	1.84	1.52	1.33	1.21	1.12	1.05	1.00	0.96	0.93	0.89	0.88	0.89	1.00	-	-	-	-
86.6 %	25.0 %	5.93	3.76	2.67	2.20	1.91	1.58	1.38	1.25	1.16	1.08	1.03	0.99	0.95	0.90	0.88	0.88	0.89	-	-	-	-
91.7 %	30.0 %	6.10	3.87	2.75	2.26	1.96	1.62	1.42	1.28	1.18	1.11	1.05	1.01	0.97	0.92	0.89	0.88	0.88	0.93	-	-	-
95.4 %	35.0 %	6.23	3.95	2.80	2.30	2.00	1.65	1.44	1.31	1.20	1.13	1.07	1.02	0.98	0.93	0.89	0.88	0.88	0.90	-	-	-
98.0 %	40.0 %	6.31	4.00	2.84	2.33	2.03	1.67	1.46	1.32	1.22	1.14	1.08	1.03	0.99	0.93	0.90	0.89	0.88	0.88	0.89	-	-
99.5 %	45.0 %	6.36	4.03	2.86	2.35	2.04	1.68	1.47	1.33	1.23	1.15	1.09	1.04	1.00	0.94	0.90	0.89	0.88	0.88	-	-	-
100.0 %	50.0 %	6.38	4.04	2.87	2.35	2.05	1.69	1.48	1.33	1.23	1.15	1.09	1.04	1.00	0.94	0.90	0.89	0.88	0.88	1.00	-	-



Överhäng (multiplar av diametern DCX)	< 3.0	3.1 – 4.0	4.1 – 6.0	> 6.1
Multiplikationsfaktor för hastighet	1.0	0.9	0.7	0.5

INDEXABLE FACE MILLS – NAVIGATOR

PROFILE MILLING – BULL NOSE

	SVC22C		SCN05C		SWN04C				
	90°		90° (93°)		90° (93°)				
	APMX (mm)	3.0 (16.0)	APMX (mm)	0.5 (1.0)	APMX (mm)	0.5 (2.0)			
	DC (mm)	32 – 80	DC (mm)	12 – 20	DC (mm)	16 – 35			
Cylindrical shank		DC = 32, 40 (mm)		DC = 12 – 20 (mm)		DC = 16 – 32 (mm)			
Weldon									
Modular		DC = 32, 40 (mm)		DC = 12 – 20 (mm)		DC = 16 – 35 (mm)			
Shell mill		DC = 50 – 80 (mm)							
Page	240		243		246				
ISO		N	P	K	H	P	K	H	
Insert shape									
Inserts	VCGT 220530		CN.. 0502		WN.. 0403				
No. of cutting edges	2		4		6				
Kopierfräsning 			■		■				
Planfräsning 			■		■				
Spiralinterpolering 	■								
Progressiv dykfräsning 	■								
Rampning 	▣		■		■				
Grund spårfräsning 	▣								
Hörnfräsning, hög kant 	▣		■		■				
Dykfräsning 			■		■				

SVC22C

N

PRAMET

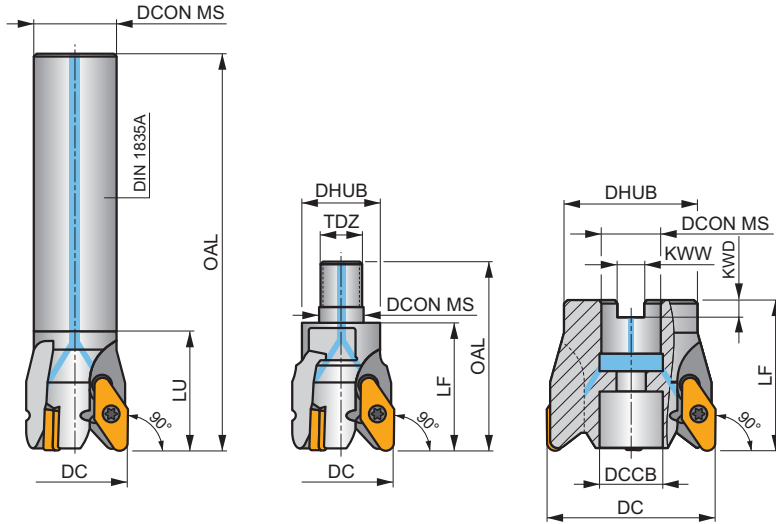
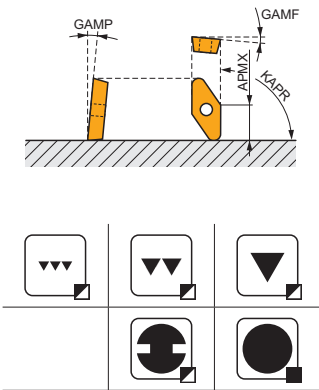
S



Vändskärsfräs för icke-järnmetaller, invändig kylning

Mycket produktiv fräs för VCGT 22-skär med APMX 16 mm. Invändig kylning. För plan-, hörn och spårfräsning, mm i aluminium och icke-järnmetaller. Finns med cyl. skaft, modulärt och för dornmontering. Diametrar från 32 till 80 mm. Behandlad för lång livslängd.

KAPR	90°
APMX	3.0 (16.0) mm



Product	DC	OAL	DCON MS	DCCB	LU	LF	DHUB	TDZ	KWW	KWD	GAMF	GAMP	max.		kg	C0560 C0562 C0563		
	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(°)	(°)						
32A2R045A25-SVC22C	32	120	25	-	45	-	-	-	-	-	4	3	-	10400	✓	0.46	GI141 C0560	
40A3R045A32-SVC22C	40	150	32	-	45	-	-	-	-	-	8	3	-	9300	✓	0.91	GI141 C0560	
32A2R048M16-SVC22C	32	71	17	-	-	48	29	M16	-	-	11	3	2	-	✓	0.17	GI141 C0560	
40A3R048M16-SVC22C	40	71	17	-	-	48	29	M16	-	-	13	3	3	-	✓	0.24	GI141 C0560	
50A03R-S90VC22C	50	-	22	18	-	56	40	-	10	6.3	4	3	3	-	8400	✓	0.42	GI141 C0563
63A04R-S90VC22C	63	-	22	18	-	56	50	-	10	6.3	6	3	4	-	7400	✓	0.68	GI141 C0563
80A05R-S90VC22C	80	-	27	20	-	56	63	-	12	7	8	3	5	-	6600	✓	1.12	GI141 C0562

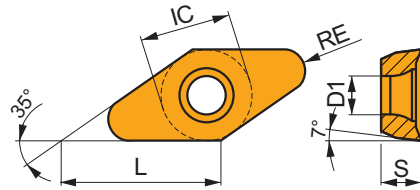
GI141	VCGT 220530F-FA
-------	-----------------

C0560	US 4511-T20	5.0	M 4.5	11	-	-	Flag T20
C0562	US 4511-T20	5.0	M 4.5	11	SDR T20-T	-	-
C0563	US 4511-T20	5.0	M 4.5	11	SDR T20-T	HS 1030C	-

VCGT 22-FA

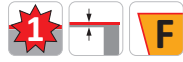
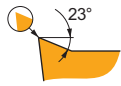


	IC	D1	L	S
	(mm)	(mm)	(mm)	(mm)
2205	12.700	5.20	22.00	5.50



Lämplighet och startvärden för skärhastighet (vc), matning (f) och skärdjup (ap). Vi refererar till vår Dormer Pramet Calculator-app för vidare beräkningar.

Product	RE (mm)	P			M			K			N			S			H		
		vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)



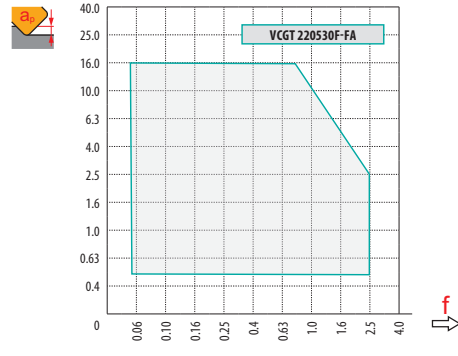
FA geometri med mycket positiv design för medelfin till grovfräsning.

VCGT 220515F-FA:HF7	● 1.5	–	–	–	–	–	–	–	–	–	■ 255	0.24	0.4	–	–	–	–	–	–
VCGT 220520F-FA:HF7	● 2.0	–	–	–	–	–	–	–	–	–	■ 255	0.30	0.5	–	–	–	–	–	–
VCGT 220530F-FA:HF7	● 3.0	–	–	–	–	–	–	–	–	–	■ 210	0.48	1.0	–	–	–	–	–	–



a_e / DC	5%	10%	15%	20%	25%	30%	40%	50%	60%	70%	75%	80%	90%	100%
	1.48	1.35	1.27	1.22	1.19	1.16	1.11	1.08	1.05	1.03	1.00	1.00	1.00	1.00
	2.20	1.60	1.35	1.20	1.10	0.95	0.85	0.75	0.85	0.95	1.00	1.00	1.00	1.00
	0.64	0.64	0.64	0.64	0.64	0.65	0.65	0.67	0.68	0.71	0.72	0.74	0.79	1.00

VCGT 22-FA			
	1.5	2.0	3.0
	-	-	-



a_e	0.5	3.0	12.0
f	0.86	0.31	0.05

DC	RPMX	APMX/II
32	8.0	12.0/87
40	8.0	12.0/87
50	6.0	10.4/100
63	4.2	7.2/100
80	3.1	5.3/100

DC	DMIN	DMAX		
32	42.0	64.0	4.2	12.0
40	58.0	80.0	7.7	12.0
50	78.0	100.0	9.0	12.0
63	104.0	126.0	9.3	12.0
80	138.0	160.0	9.7	12.0

a_e	9
f	

DC	μm	3	5	10	15	20	30	40	50	60	80	100
32		0.620	0.800	1.131	1.386	1.600	1.960	2.263	2.530	2.771	3.200	3.578
40		0.693	0.894	1.265	1.549	1.789	2.191	2.530	2.828	3.098	3.578	4.000
50		0.775	1.000	1.414	1.732	2.000	2.449	2.828	3.162	3.464	4.000	4.472
63		0.869	1.122	1.587	1.944	2.245	2.750	3.175	3.550	3.888	4.490	5.020
80		0.980	1.265	1.789	2.191	2.530	3.098	3.578	4.000	4.382	5.060	5.657
RE	μm	3	5	10	15	20	30	40	50	60	80	100
3.0		0.268	0.346	0.490	0.600	0.693	0.849	0.980	1.095	1.200	1.386	1.549

SCN05C

P **K** **H**

PRAMET

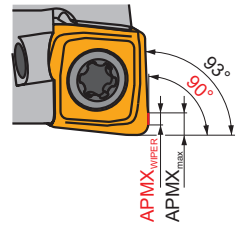
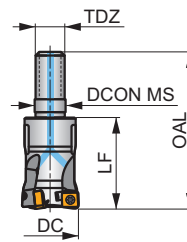
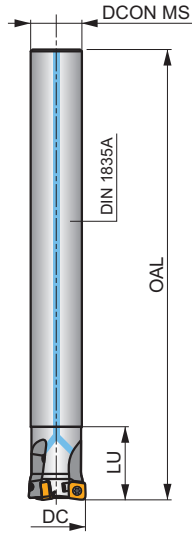
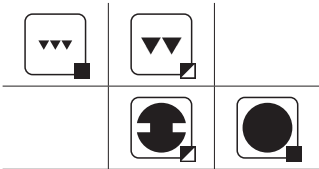
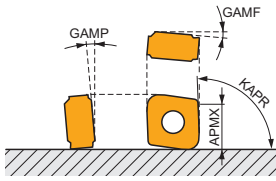
S



Skaffträ för formtillverkning, invändig kylning

Fräs för en rad olika applikationer, t ex formtillverkning. Bestyckad med CNHX 05-skär med fyra eggar får fräsen hög noggrannhet och ekonomi. Finns med cyl. skaft och som modular i diametrar 12 till 20 mm. Behandlad för lång livslängd.

KAPR	90° (93°)
APMX	0.5 (1.0 mm)



h_m 0.02 - 0.07



Product	DC (mm)	OAL (mm)	DCON MS (mm)	LU (mm)	LF (mm)	TDZ	GAMF (°)	GAMP (°)										
12A2R020A10-SCN05C-C	12	100	10	20	-	-	-15	-8	2	-	48700	✓	0.08	GI330	C0601			
16A3R020A14-SCN05C-C	16	130	14	20	-	-	-13.5	-7.8	3	-	42200	✓	0.16	GI330	C0601			
20A5R020A18-SCN05C-C	20	160	18	20	-	-	-12.7	-7.5	5	✓	37700	✓	0.31	GI330	C0601			
12A2R020M06-SCN05C-C	12	35	6.5	-	20	M6	-15	-8	2	-	-	✓	0.04	GI330	C0601			
16A3R025M08-SCN05C-C	16	43	8.5	-	25	M8	-13.5	-7.8	3	-	-	✓	0.05	GI330	C0601			
20A5R030M10-SCN05C-C	20	49	10.5	-	30	M10	-12.7	-7.5	5	✓	-	✓	0.08	GI330	C0601			

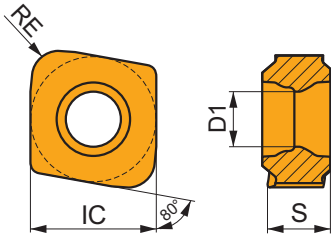
	GI330		CNHX0502..
--	-------	--	------------

	C0601		US 62005-T06P		0.9		M2		4.9		Flag T06P
--	-------	--	---------------	--	-----	--	----	--	-----	--	-----------

CNHX 05

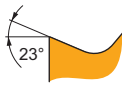


	IC	D1	S
	(mm)	(mm)	(mm)
0502	4.800	2.10	2.40



Lämplighet och startvärden för skärhastighet (vc), matning (f) och skärdjup (ap). Vi refererar till vår Dormer Pramet Calculator-app för vidare beräkningar.

Product	RE (mm)	P			M			K			N			S			H		
		vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)



WM geometri med wiper-design för fin och medelfin fräsning.

CNHX 050205ER-WM:M4310	●	0.5	350	0.10	0.5	–	–	–	335	0.10	0.5	–	–	–	–	–	–	–	70	0.10	0.5
CNHX 050205ER-WM:M8330	⊕	0.5	310	0.10	0.5	–	–	–	290	0.10	0.5	–	–	–	–	–	–	–	60	0.10	0.5
CNHX 050210ER-WM:M4310	⊕	1.0	440	0.10	0.5	–	–	–	420	0.10	0.5	–	–	–	–	–	–	–	85	0.10	0.5
CNHX 050210ER-WM:M8330	⊕	1.0	390	0.10	0.5	–	–	–	370	0.10	0.5	–	–	–	–	–	–	–	75	0.10	0.5

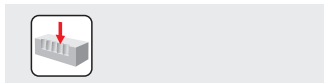
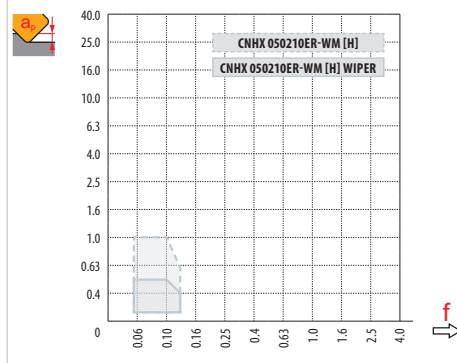
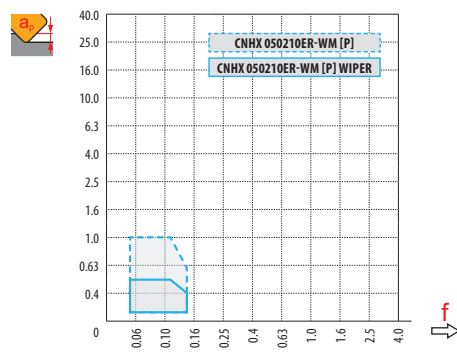


a_e / DC	5 %	10 %	15 %	20 %	25 %	30 %	40 %	50 %	60 %	70 %	75 %	80 %	90 %	100 %
$\times V$	1.48	1.35	1.27	1.22	1.19	1.16	1.11	1.08	1.05	1.03	1.00	1.00	1.00	1.00

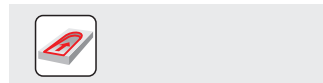


a_e / DC	0.5 %	1.0 %	2.0 %	3.0 %	4.0 %	5.0 %
$\times V$	2.04	1.85	1.68	1.59	1.53	1.48

CNHX 05-WM	
RE	0.5 1.0
BS	0.50 0.50



DC	max
12	0.4
16	0.4
20	0.5



DC	RPMX	APMX/I
12	2.4	1/25
16	1.5	1/40
20	1.1	1/54

SWN04C

P **K** **H**

PRAMET

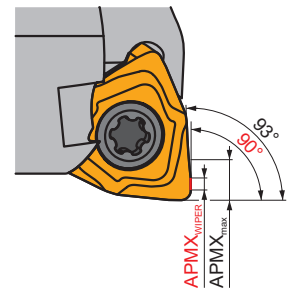
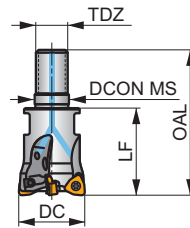
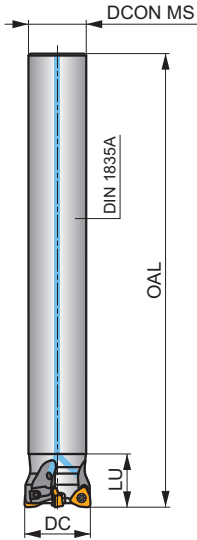
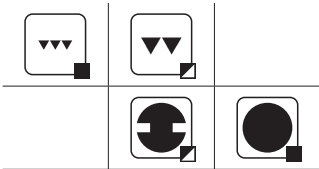
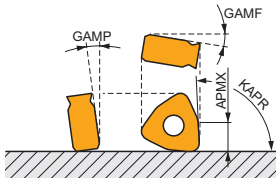
S



Skaffträ för formtillverkning, invändig kylning

Fräs för en rad olika applikationer, t ex formtillverkning. Bestyckad med WNHX 04-skär med sex eggar får fräsen hög noggrannhet och ekonomi. Finns med cyl. skaft och som modular i diametrar 20 till 35 mm. Behandlad för lång livslängd.

KAPR	90° (93°)
APMX	0.5 (2.0 mm)



h_m 0.02 - 0.07



Product	DC (mm)	OAL (mm)	DCON MS (mm)	LU (mm)	LF (mm)	TDZ	GAMF (°)	GAMP (°)					kg		
16A2R020A14-SWN04C-C	16	140	14	20	-	-	-13.5	-8	2	-	33200	✓	0.14	GI331	CO602
20A3R020A18-SWN04C-C	20	160	18	20	-	-	-12	-8	3	-	19700	✓	0.27	GI331	CO602
25A4R020A22-SWN04C-C	25	180	22	20	-	-	-11.5	-8	4	✓	26600	✓	0.45	GI331	CO602
32A6R020A25-SWN04C-C	32	200	25	20	-	-	-11.2	-8	6	✓	23500	✓	0.69	GI331	CO602
16A2R025M08-SWN04C-C	16	43	8.5	-	25	M08	-13.5	-8	2	-	33200	✓	0.05	GI331	CO602
20A3R030M10-SWN04C-C	20	49	10.5	-	30	M10	-12	-8	3	-	-	✓	0.07	GI331	CO602
25A4R033M12-SWN04C-C	25	55	12.5	-	33	M12	-11.5	-8	4	✓	-	✓	0.10	GI331	CO602
32A6R040M16-SWN04C-C	32	63	17	-	40	M16	-11.2	-8	6	✓	-	✓	0.21	GI331	CO602
35A6R043M16-SWN04C-C	35	66	17	-	43	M16	-11.1	-8	6	✓	-	✓	0.22	GI331	CO602

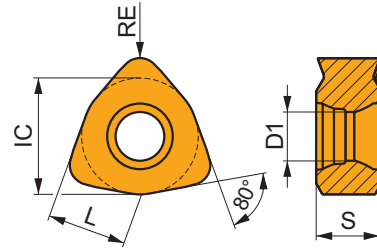
	GI331		WNHX0403..
--	-------	--	------------

	CO602		US 42507-T07P		1.2		M 2.5		7		Flag T07P
--	-------	--	---------------	--	-----	--	-------	--	---	--	-----------

WNHX 04

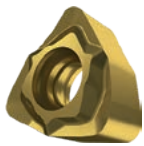


	IC	D1	S
	(mm)	(mm)	(mm)
0403	6.200	2.60	3.38



Lämplighet och startvärden för skärhastighet (vc), matning (f) och skärdjup (ap). Vi refererar till vår Dormer Pramet Calculator-app för vidare beräkningar.

Product	RE (mm)	P			M			K			N			S			H		
		vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)



WM geometri med wiper-design för fin och medelfin fräsning.

WNHX 040305ER-WM:M4310	●	0.5	✓	290	0.15	1.0	–	–	–	■	275	0.15	1.0	–	–	–	–	–	–	■	55	0.10	0.7
WNHX 040305ER-WM:M8330	●	0.5	■	260	0.15	1.0	–	–	–	■	245	0.15	1.0	–	–	–	–	–	–	■	50	0.10	0.7
WNHX 040310ER-WM:M4310	●	1.0	✓	370	0.15	1.0	–	–	–	■	350	0.15	1.0	–	–	–	–	–	–	■	70	0.10	0.7
WNHX 040310ER-WM:M8330	●	1.0	■	330	0.15	1.0	–	–	–	■	310	0.15	1.0	–	–	–	–	–	–	■	65	0.10	0.7
WNHX 040315ER-WM:M4310	●	1.5	✓	390	0.15	1.0	–	–	–	■	370	0.15	1.0	–	–	–	–	–	–	■	75	0.10	0.7
WNHX 040315ER-WM:M8330	●	1.5	■	345	0.15	1.0	–	–	–	■	325	0.15	1.0	–	–	–	–	–	–	■	65	0.10	0.7



a_e / DC	5 %	10 %	15 %	20 %	25 %	30 %	40 %	50 %	60 %	70 %	75 %	80 %	90 %	100 %
$x.v$	1.48	1.35	1.27	1.22	1.19	1.16	1.11	1.08	1.05	1.03	1.00	1.00	1.00	1.00

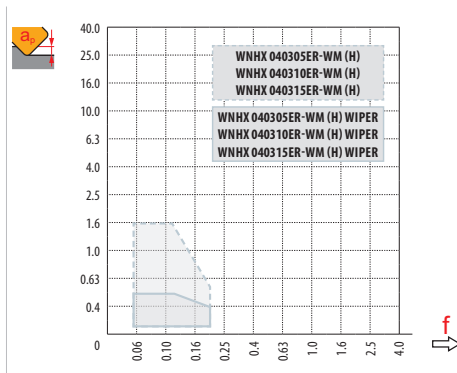
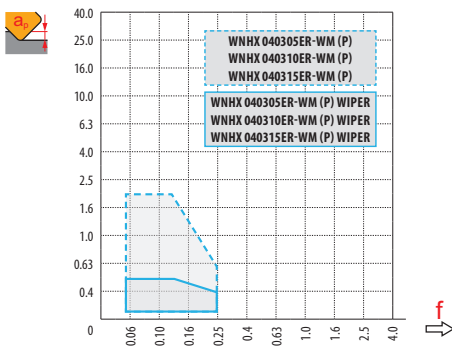


a_e / DC	0.5 %	1.0 %	2.0 %	3.0 %	4.0 %	5.0 %
$x.v$	2.04	1.85	1.68	1.59	1.53	1.48



WNHX 04-WM

RE	0.5	1.0	1.5
BS	0.50	0.50	0.50



DC	max
16	
20	0.4
25	0.5
32	0.5
35	0.5



















DC	RPMX	APMX/I
16		
20	0.7	1.1/100
25	0.5	0.75/100
32	0.3	0.4/100
35	0.3	0.4/100



HÖGMATNINGSFRÄSNING

INDEXABLE FACE MILLS – NAVIGATOR

HIGH FEED MILLING – POSITIVE INSERTS

	SBN10		SSN11							
	20°		18°							
	APMX (mm)	1.0	APMX (mm)	1.7						
	DCX (mm)	16 – 66	DCX (mm)	32 – 125						
Cylindrical shank		DCX = 16 – 35 (mm)		DCX = 32, 35 (mm)						
Weldon										
Modular		DCX = 16 – 40 (mm)		DCX = 32 – 40 (mm)						
Shell mill		DCX = 40 – 66 (mm)		DCX = 40 – 125 (mm)						
Page	252		258							
ISO	P	M	K	S	H	P	M	K	S	H
Insert shape										
Inserts	BNGX 10T3 ANHX 10T3		SNGX 1104							
No. of cutting edges	4 / 2		8							
Face milling		■	■							
Helical interpolation		■	▣							
Shallow shoulder milling		■	■							
Plunge milling		■	■							
Progressive plunging		■	▣							
Ramping		■	▣							
Shape surfaces milling (copy milling)		■	■							
Shallow slot milling		▣	▣							

SBN10



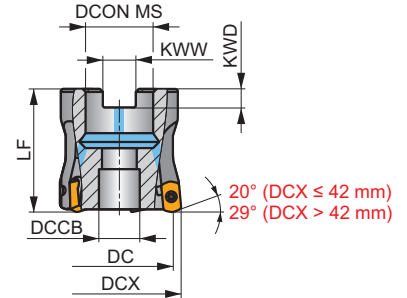
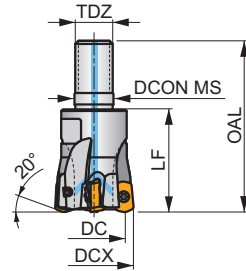
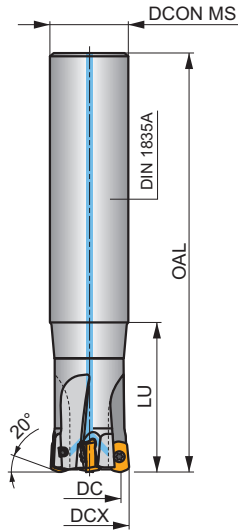
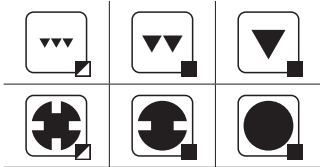
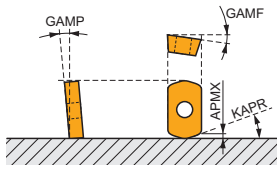
PRAMET



Högmatningsfräs för BN.. 10-skär, invändig kylning, Next Generation

Högmatningsfräs större diametrar med BNGX 10-skär och APMX 1.0 mm. Invändig kylning. Användbara till en mängd applikationer. Finns med cyl. skaft, modulärt eller dornfäste. Diametrar från 16 till 42 mm. Behandlad för lång livslängd.

KAPR	20° (29°)
APMX	1.0 mm



	0.17 - 0.41
	0.17 - 0.41



Product	DCX	DC	OAL	DCON MS	DCCB	LU	LF	TDZ	KWW	KWD	KAPR	GAMF	GAMP				kg		
	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(°)	(°)	(°)	max.					
16E2R030A16-SBN10-C	16	9.4	100	16	-	30	-	-	-	-	20	-12	-10	2	✓	31100	✓	0.13	GI329 C0310
16E2R050A16-SBN10-C	16	9.4	150	16	-	50	-	-	-	-	20	-12	-10	2	-	31100	✓	0.18	GI329 C0310
16E2R030A14-SBN10-C	16	9.4	150	14	-	30	-	-	-	-	20	-12	-10	2	-	31100	✓	0.18	GI329 C0310
18E2R030A16-SBN10-C	18	11.4	150	16	-	30	-	-	-	-	20	-11	-10	2	-	29200	✓	0.23	GI329 C0310
20E3R040A20-SBN10-C	20	13.4	130	20	-	40	-	-	-	-	20	-10	-10	3	-	27700	✓	0.25	GI329 C0310
20E3R080A20-SBN10-C	20	13.4	160	20	-	80	-	-	-	-	20	-10	-10	3	-	27700	✓	0.29	GI329 C0310
20E3R040A18-SBN10-C	20	13.4	180	18	-	40	-	-	-	-	20	-10	-10	3	-	27700	✓	0.29	GI329 C0310
20E4R040A20-SBN10-C	20	13.4	130	20	-	40	-	-	-	-	20	-10	-10	4	-	27700	✓	0.28	GI329 C0310
25E4R050A25-SBN10-C	25	18.4	140	25	-	50	-	-	-	-	20	-9	-10	4	✓	24800	✓	0.42	GI329 C0310
25E4R100A25-SBN10-C	25	18.4	180	25	-	100	-	-	-	-	20	-9	-10	4	✓	24800	✓	0.51	GI329 C0310
25E4R050A22-SBN10-C	25	18.4	220	22	-	50	-	-	-	-	20	-9	-10	4	✓	24800	✓	0.58	GI329 C0310
25E5R050A25-SBN10-C	25	18.4	140	25	-	50	-	-	-	-	20	-9	-10	5	-	24800	✓	0.42	GI329 C0310
32E5R070A32-SBN10-C	32	25.4	150	32	-	70	-	-	-	-	20	-8	-10	5	✓	21900	✓	0.73	GI329 C0310
32E6R070A32-SBN10-C	32	25.4	150	32	-	70	-	-	-	-	20	-8	-10	6	✓	21900	✓	0.76	GI329 C0310
32E5R120A32-SBN10-C	32	25.4	200	32	-	120	-	-	-	-	20	-8	-10	5	✓	21900	✓	0.96	GI329 C0310
35E5R050A32-SBN10-C	35	28.4	200	32	-	50	-	-	-	-	20	-7.5	-10	5	✓	21000	✓	1.08	GI329 C0310
35E6R050A32-SBN10-C	35	28.4	200	32	-	50	-	-	-	-	20	-7.5	-10	6	✓	21000	✓	1.08	GI329 C0310
16E2R025M08-SBN10-C	16	9.4	43	8.5	-	25	M8	-	-	-	20	-12	-10	2	-	31100	✓	0.05	GI329 C0310
18E2R025M08-SBN10-C	18	11.4	43	8.5	-	25	M8	-	-	-	20	-11	-10	2	-	29200	✓	0.05	GI329 C0310
20E3R030M10-SBN10-C	20	13.4	49	10.5	-	30	M10	-	-	-	20	-10	-10	3	-	27700	✓	0.07	GI329 C0310
20E4R030M10-SBN10-C	20	13.4	49	10.5	-	30	M10	-	-	-	20	-10	-10	4	-	27700	✓	0.06	GI329 C0310
25E4R033M12-SBN10-C	25	18.4	55	12.5	-	33	M12	-	-	-	20	-9	-10	4	✓	24800	✓	0.08	GI329 C0310
25E5R033M12-SBN10-C	25	18.4	55	12.5	-	33	M12	-	-	-	20	-9	-10	5	-	24800	✓	0.10	GI329 C0310
28E5R035M12-SBN10-C	28	21.4	57	12.5	-	35	M12	-	-	-	20	-8.5	-10	5	✓	23400	✓	0.12	GI329 C0310
32E5R040M16-SBN10-C	32	25.4	63	17	-	40	M16	-	-	-	20	-8	-10	5	✓	21900	✓	0.21	GI329 C0310
32E6R040M16-SBN10-C	32	25.4	63	17	-	40	M16	-	-	-	20	-8	-10	6	✓	21900	✓	0.21	GI329 C0310
35E6R043M16-SBN10-C	35	28.4	66	17	-	43	M16	-	-	-	20	-7.5	-10	6	✓	21000	✓	0.23	GI329 C0310

Product	DCX	DC	OAL	D CONIMS	DCCB	LU	LF	TDZ	KWW	KWD	KAPR	GAMF	GAMP							
	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(°)	(°)	(°)							
40E6R043M16-SBN10-C	40	33.4	66	17	-	-	43	M16	-	-	20	-7	-10	6	✓	19600	✓	0.27	GI329	C0310
40E7R043M16-SBN10-C	40	33.4	66	17	-	-	43	M16	-	-	20	-7	-10	7	✓	19600	✓	0.26	GI329	C0310
40A05R-SMOBN10-C	40	33.4	-	16	14.1	-	40	-	8.4	5.6	20	-7	-10	5	✓	19600	✓	0.23	GI329	C0312
40A07R-SMOBN10-C	40	33.4	-	16	14.1	-	40	-	8.4	5.6	20	-7	-10	7	✓	19600	✓	0.27	GI329	C0312
42A05R-SMOBN10-C	42	35.4	-	16	14.1	-	40	-	8.4	5.6	20	-7	-10	5	✓	19100	✓	0.23	GI329	C0312
42A07R-SMOBN10-C	42	35.4	-	16	14.1	-	40	-	8.4	5.6	20	-7	-10	7	✓	19100	✓	0.36	GI329	C0312
50A07R-SMOBN10-C	50	45	-	22	18.1	-	40	-	10.4	6.3	29	-6	-7	7	✓	17500	✓	0.46	GI343	C0311
50A08R-SMOBN10-C	50	45	-	22	18.1	-	40	-	10.4	6.3	29	-6	-7	8	✓	17500	✓	0.34	GI343	C0311
52A07R-SMOBN10-C	52	47	-	22	18.1	-	40	-	10.4	6.3	29	-6	-7	7	✓	17200	✓	0.49	GI343	C0311
52A08R-SMOBN10-C	52	47	-	22	18.1	-	40	-	10.4	6.3	29	-6	-7	8	✓	17200	✓	0.37	GI343	C0311
66A08R-SMOBN10-C	66	61	-	27	22.1	-	50	-	12.4	7	29	-6	-7	8	✓	15200	✓	0.89	GI343	C0313

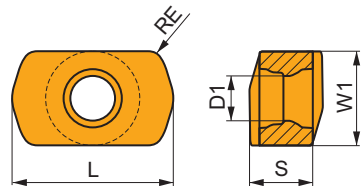
GI329		BNGX 10T3...	ANHX 10T3..
GI343		BNGX 10T3...	-

C0310	US 42507-T07P	1.2	M 2.5	7	Flag T07P	-	-	-	-
C0313	US 42507-T07P	1.2	M 2.5	7	-	D-T07P/T09P	FG-15	HS 1230C	-
C0312	US 42507-T07P	1.2	M 2.5	7	-	D-T07P/T09P	FG-15	HS 0830C	-
C0311	US 42507-T07P	1.2	M 2.5	7	-	D-T07P/T09P	FG-15	HS 1030C	-

BNGX 10

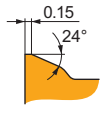


	W1	D1	L	S
	(mm)	(mm)	(mm)	(mm)
10T3	5.800	2.76	9.92	3.90



Lämplighet och startvärden för skärhastighet (vc), matning (f) och skärdjup (ap). Vi refererar till vår Dormer Pramet Calculator-app för vidare beräkningar.

Product	RE (mm)	P			M			K			N			S			H		
		vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)

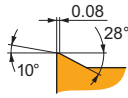
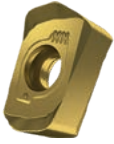


M geometri med positiv design för högmatningsfräsning.

BNGX 10T308SR-M:8215	0.8	240	0.65	0.7	-	-	-	225	0.65	0.7	-	-	-	-	-	-	45	0.36	0.5
BNGX 10T308SR-M:M6330	0.8	210	0.65	0.7	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-
BNGX 10T308SR-M:M8310	0.8	250	0.65	0.7	-	-	-	235	0.65	0.7	-	-	-	-	-	-	50	0.36	0.5
BNGX 10T308SR-M:M8330	0.8	240	0.65	0.7	-	-	-	225	0.65	0.7	-	-	-	-	-	-	45	0.36	0.5
BNGX 10T308SR-M:M8340	0.8	225	0.65	0.7	-	-	-	210	0.65	0.7	-	-	-	-	-	-	-	-	-
BNGX 10T308SR-M:M8345	0.8	180	0.65	0.7	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-
BNGX 10T308SR-M:M9325	0.8	275	0.65	0.7	-	-	-	260	0.65	0.7	-	-	-	-	-	-	55	0.36	0.5

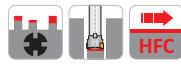
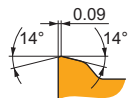
Lämplighet och startvärden för skärhastighet (vc), matning (f) och skärdjup (ap). Vi refererar till vår Dormer Pramet Calculator-app för vidare beräkningar.

Product	RE (mm)	P			M			K			N			S			H		
		vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)



MM geometri med mycket positiv design för högmatningsfräsning.

BNGX 10T308SR-MM:M6330	0.8	215	0.65	0.6	150	0.59	0.6	-	-	-	-	-	-	60	0.46	0.5	-	-	-
BNGX 10T308SR-MM:M8310	0.8	255	0.65	0.6	130	0.59	0.6	-	-	-	-	-	-	-	-	-	-	-	-
BNGX 10T308SR-MM:M8330	0.8	245	0.65	0.6	145	0.59	0.6	-	-	-	-	-	-	60	0.46	0.5	-	-	-
BNGX 10T308SR-MM:M8340	0.8	230	0.65	0.6	135	0.59	0.6	-	-	-	-	-	-	55	0.46	0.5	-	-	-
BNGX 10T308SR-MM:M8345	0.8	180	0.65	0.6	105	0.59	0.6	-	-	-	-	-	-	45	0.46	0.5	-	-	-
BNGX 10T308SR-MM:M9325	0.8	280	0.65	0.6	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-
BNGX 10T308SR-MM:M9340	0.8	250	0.65	0.6	150	0.59	0.6	-	-	-	-	-	-	60	0.46	0.5	-	-	-



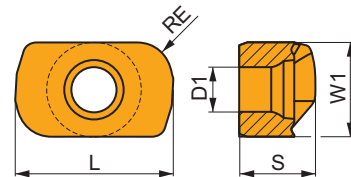
HM geometri med stark design för högmatningsfräsning.

BNGX 10T308SR-HM:8215	0.8	-	-	-	-	-	-	240	0.65	0.4	-	-	-	-	-	-	50	0.65	0.4
BNGX 10T308SR-HM:M8310	0.8	-	-	-	-	-	-	250	0.65	0.4	-	-	-	-	-	-	50	0.65	0.4
BNGX 10T308SR-HM:M8330	0.8	-	-	-	-	-	-	240	0.65	0.4	-	-	-	-	-	-	50	0.65	0.4

ANHX 10

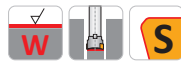
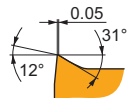
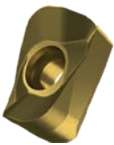


	W1 (mm)	D1 (mm)	L (mm)	S (mm)
10T3	5.800	2.76	9.72	4.70



Lämplighet och startvärden för skärhastighet (vc), matning (f) och skärdjup (ap). Vi refererar till vår Dormer Pramet Calculator-app för vidare beräkningar.

Product	RE (mm)	P			M			K			N			S			H		
		vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)



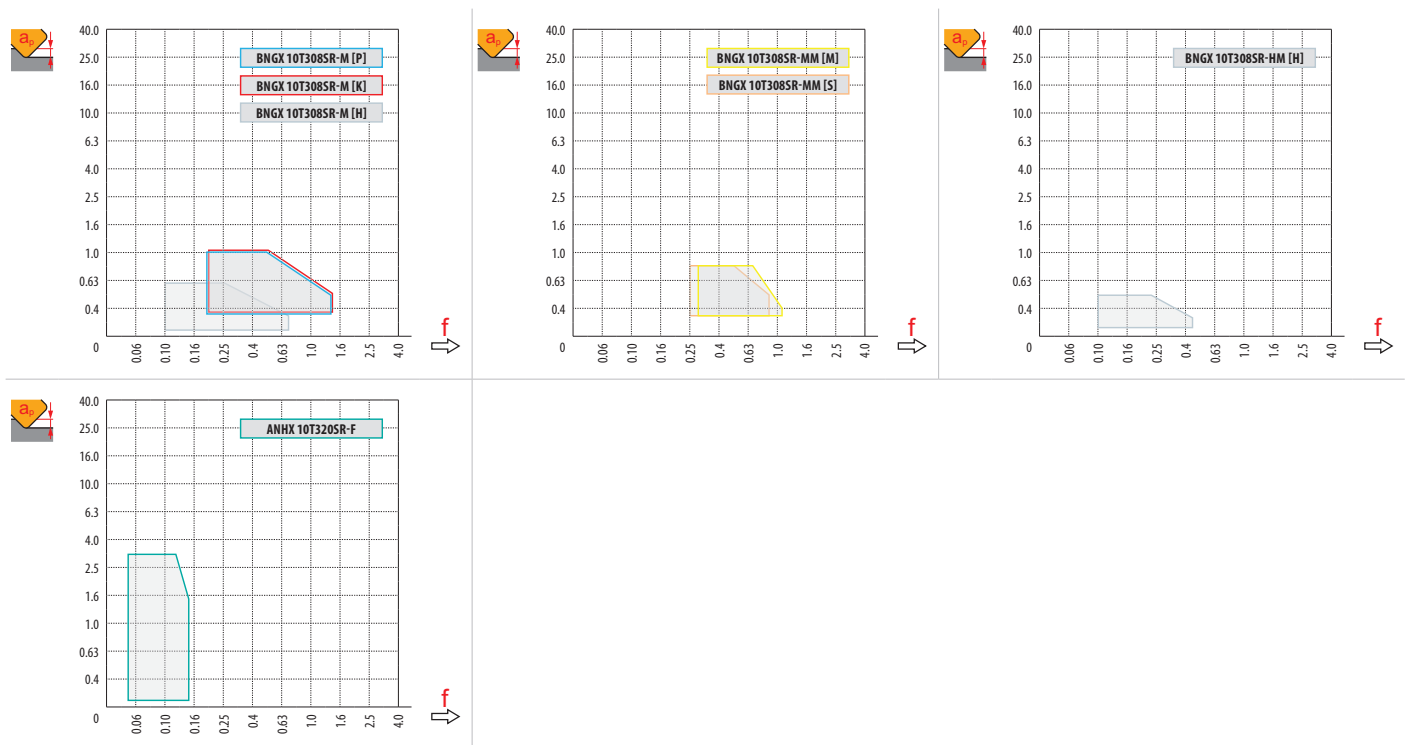
F geometri med positiv design för fin till medelfin fräsning.

ANHX 10T320SR-F:M8310	2.0	380	0.10	2.5	190	0.09	2.5	-	-	-	-	-	-	-	-	-	-	-	-
ANHX 10T320SR-F:M8330	2.0	340	0.10	2.5	200	0.09	2.5	-	-	-	-	-	-	-	-	-	-	-	-



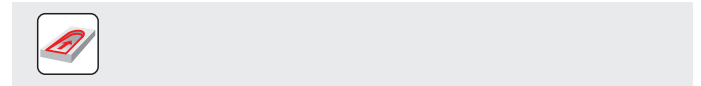
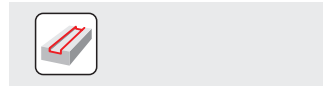
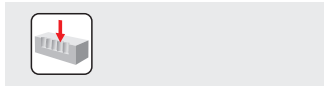
a_e / DCX	5 %	10 %	15 %	20 %	25 %	30 %	40 %	50 %	60 %	70 %	75 %	80 %	90 %	100 %
	1.48	1.35	1.27	1.22	1.19	1.16	1.11	1.08	1.05	1.03	1.00	1.00	1.00	1.00
	2.20	1.60	1.35	1.20	1.10	0.95	0.85	0.75	0.85	0.95	1.00	1.00	1.00	1.00
	0.64	0.64	0.64	0.64	0.64	0.65	0.65	0.67	0.68	0.71	0.72	0.74	0.79	1.00

	BNGX 10-M	BNGX 10-MM	BNGX 10-HM		ANHX 10 - F
	0.8	0.8	0.8		2.0
	-	-	-		0.92



BNGX 10 (HFC)

		0.00	0.30	0.40	0.50	0.60	0.70	0.80	0.90	1.00
16		9.40	12.85	13.36	13.80	14.20	14.56	14.88	15.19	15.47
18		11.40	14.85	15.36	15.80	16.20	16.56	16.88	17.19	17.47
20		13.40	16.85	17.36	17.80	18.20	18.56	18.88	19.19	19.47
25		18.40	21.85	22.36	22.80	23.20	23.56	23.88	24.19	24.47
32		25.40	28.85	29.36	29.80	30.20	30.56	30.88	31.19	31.47
35		28.40	31.85	32.36	32.80	33.20	33.56	33.88	34.19	34.47
40		33.40	36.85	37.36	37.80	38.20	38.56	38.88	39.19	39.47
42		35.40	38.85	39.36	39.80	40.20	40.56	40.88	41.19	41.47
50		43.98	46.09	46.45	46.82	47.18	47.54	47.90	48.26	48.56
52		45.98	48.09	48.45	48.82	49.18	49.54	49.90	50.26	50.56
66		59.98	62.09	62.45	62.82	63.18	63.54	63.90	64.26	64.56
		0.00	0.30	0.40	0.50	0.60	0.70	0.80	0.90	1.00
		–	1.30	1.10	0.90	0.80	0.72	0.68	0.65	0.50



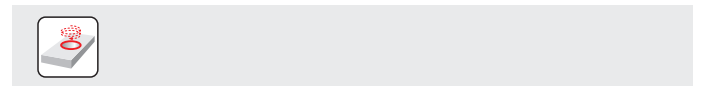
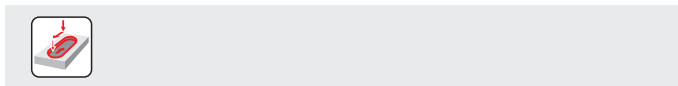
BNGX 10

		f_{max}
16	3.5	0.12
18	3.5	0.12
20	4.0	0.15
25	4.0	0.15
32	4.0	0.17
35	4.0	0.17
40	4.0	0.17
42	4.0	0.17
50	4.5	0.30
52	4.5	0.30
66	4.5	0.30

BNGX 10 (HFC)

	0.3	0.6	1.0
	1.10	0.60	0.30

	BNGX 10 (HFC)		ANHX 10	
	RPMX	APMX/I	RPMX	APMX/I
16	3.8	1/17	1.6°	2.65/100
18	3.8	1/17	1.3°	2.15/100
20	3.8	1/17	1.1°	1.80/100
25	2.6	1/24	0.8°	1.25/100
32	1.8	1/33	0.5°	0.75/100
35	1.6	1/37	0.5°	0.75/100
40	1.3	1/46	0.4°	0.55/100
42	1.3	1/46	0.4°	0.55/100
50	0.4	0.55/100	–	–
52	0.4	0.55/100	–	–
66	0.3	0.4/100	–	–



BNGX 10 (HFC)

		f_{max}
16	0.4	0.15
18	0.7	0.15
20	0.7	0.15
25	0.7	0.15
32	0.7	0.2
35	0.7	0.2
40	0.7	0.2
42	0.7	0.2
50	0.3	0.2
52	0.3	0.2
66	0.3	0.2

BNGX 10 (HFC)

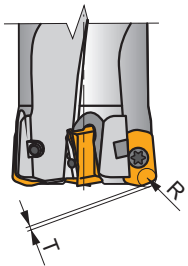
	DMIN	DMAX		
16	22.4	31.8	0.5	0.5
18	25.4	35.8	0.5	0.5
20	29.4	39.8	0.5	0.5
25	39.4	49.8	0.5	0.5
32	53.4	63.8	0.5	0.5
35	59.4	69.8	0.5	0.5
40	69.4	79.8	0.5	0.5
42	73.4	83.8	0.5	0.5
50	89.6	99.6	0.5	0.5
52	93.6	103.6	0.5	0.5
66	121.6	131.6	0.5	0.5



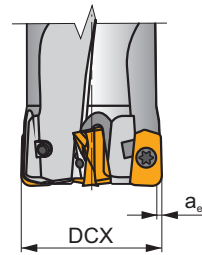
	μm	3	5	10	15	20	30	40	50	60	80	100
16		0.438	0.566	0.800	0.980	1.131	1.386	1.600	1.789	1.960	2.263	2.530
18		0.465	0.600	0.849	1.039	1.200	1.470	1.697	1.897	2.078	2.400	2.683
20		0.490	0.632	0.894	1.095	1.265	1.549	1.789	2.000	2.191	2.530	2.828
25		0.548	0.707	1.000	1.225	1.414	1.732	2.000	2.236	2.449	2.828	3.162
32		0.620	0.800	1.131	1.386	1.600	1.960	2.263	2.530	2.771	3.200	3.578
35		0.648	0.837	1.183	1.449	1.673	2.049	2.366	2.646	2.898	3.347	3.742
40		0.693	0.894	1.265	1.549	1.789	2.191	2.530	2.828	3.098	3.578	4.000
42		0.710	0.917	1.296	1.587	1.833	2.245	2.592	2.898	3.175	3.666	4.099

ANHX 10

	μm	3	5	10	15	20	30	40	50	60	80	100
2.0		0.219	0.283	0.400	0.490	0.566	0.693	0.800	0.894	0.980	1.131	1.265



	R	T
BNGX 10T308	1.60	0.44



	max a _e /DCX
ANHX 10T320	0.05

SSN11

P M K S H

PRAMET

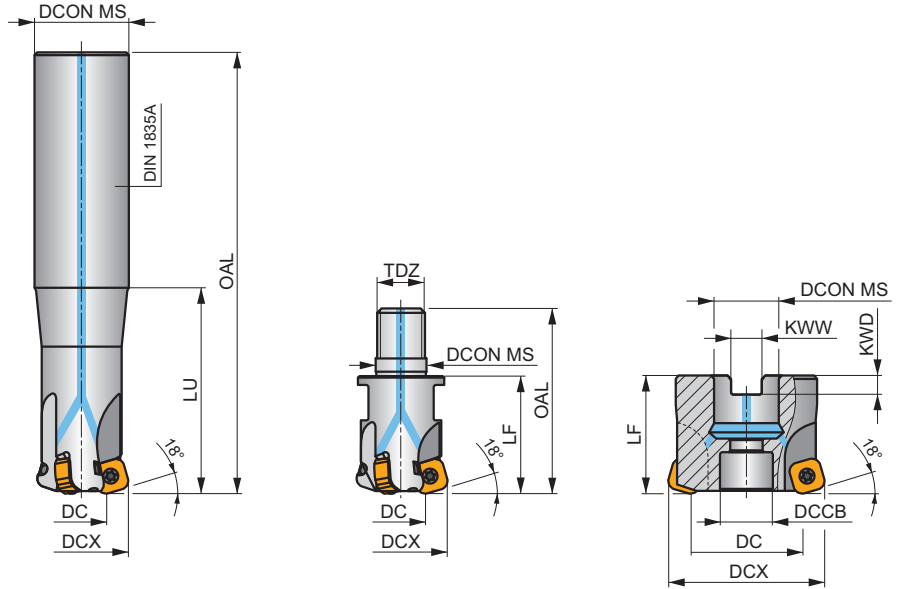
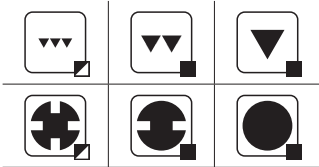
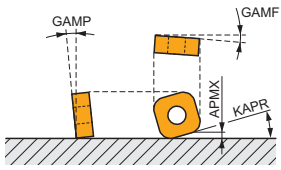
S



Högmatningsfräs för SS.. 11 skär, med invändig kylning, Next Generation

Högmatningsfräs med större diametrar för dubbelsidiga SNGX 11 skär med åtta eggar och APMX på 1.7 mm. Invändig kylning. Passar till en lång rad applikationer. Kroppen är behandlad för längre livslängd.

KAPR	18°
APMX	1.7 mm



Product	DCX	DC	OAL	DCON MS	DCCB	LU	LF	TDZ	KWW	KWD	GAMF	GAMP	max.		kg	Tools				
	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(°)	(°)								
32E3R070A32-SSN11-C	32	18.3	150	32	-	70	-	-	-	-	-11.5	-10	3	-	17500	✓	0.69	GI339	CO314	-
32E3R120A32-SSN11-C	32	18.3	200	32	-	120	-	-	-	-	-11.5	-10	3	-	17500	✓	0.89	GI339	CO314	-
35E3R050A32-SSN11-C	35	21.2	200	32	-	50	-	-	-	-	-11	-10	3	-	16800	✓	1.08	GI339	CO314	-
32E3R040M16-SSN11-C	32	18.3	63	17	-	40	M16	-	-	-	-11.5	-10	3	-	17500	✓	0.19	GI339	CO314	-
35E3R040M16-SSN11-C	35	21.2	63	17	-	40	M16	-	-	-	-11	-10	3	-	16800	✓	0.19	GI339	CO314	-
40E4R043M16-SSN11-C	40	26.2	66	17	-	43	M16	-	-	-	-10.5	-10	4	✓	15700	✓	0.26	GI339	CO314	-
40A04R-SMOSN11-C	40	26.2	-	16	12.4	-	40	-	8.4	5.6	-10.5	-10	4	✓	15700	✓	0.19	GI339	CO316	-
42A04R-SMOSN11-C	42	28.2	-	16	14.1	-	40	-	8.4	5.6	-10.5	-10	4	✓	15300	✓	0.21	GI339	CO318	-
50A05R-SMOSN11-C	50	36.1	-	22	18.1	-	40	-	10.4	6.3	-10	-10	5	✓	14000	✓	0.31	GI339	CO320	-
50A06R-SMOSN11-C	50	36.1	-	22	18.1	-	40	-	10.4	6.3	-10	-10	6	✓	14000	✓	0.43	GI339	CO320	-
52A05R-SMOSN11-C	52	38.1	-	22	18.1	-	40	-	10.4	6.3	-10	-10	5	✓	13800	✓	0.47	GI339	CO320	-
52A06R-SMOSN11-C	52	38.1	-	22	18.1	-	40	-	10.4	6.3	-10	-10	6	✓	13800	✓	0.46	GI339	CO320	-
63A06R-SMOSN11-C	63	49.1	-	22	18.1	-	40	-	10.4	6.3	-10	-10	6	✓	12500	✓	0.46	GI339	CO320	-
63A08R-SMOSN11-C	63	49.1	-	22	18.1	-	40	-	10.4	6.3	-10	-10	8	✓	12500	✓	0.60	GI339	CO320	-
66A06R-SMOSN11-C	66	52.1	-	27	18.1	-	50	-	12.4	7	-10	-10	6	✓	12200	✓	0.88	GI339	CO322	-
66A08R-SMOSN11-C	66	52.1	-	27	18.1	-	50	-	12.4	7	-10	-10	8	✓	12200	✓	0.88	GI339	CO322	-
80A07R-SMOSN11-C	80	66.1	-	27	38.1	-	50	-	12.4	7	-10	-10	7	✓	11100	✓	0.95	GI339	CO324	AC001
80A09R-SMOSN11-C	80	66.1	-	27	38.1	-	50	-	12.4	7	-10	-10	9	✓	11100	✓	1.03	GI339	CO324	AC001
100A08R-SMOSN11-C	100	86.1	-	32	45.1	-	50	-	14.4	8	-10	-10	8	✓	9900	✓	1.83	GI339	CO324	AC002
115A08R-SMOSN11-C	115	101.1	-	32	45.1	-	50	-	14.4	8	-10	-10	8	✓	9200	✓	2.30	GI339	CO324	AC002
125A08R-SMOSN11-C	125	111.1	-	40	56.1	-	63	-	16.4	9	-10	-10	8	✓	8900	✓	3.34	GI339	CO324	AC003

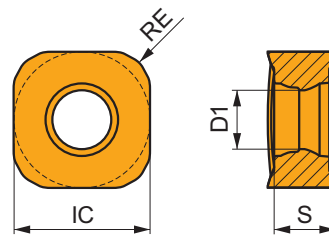
C0314	US 44012-T15P	3.5	M 4	12	–	–	–	Flag T15P	–
C0316	US 44012-T15P	3.5	M 4	12	D-T08P/T15P	FG-15	–	–	HCS 0840C
C0318	US 44012-T15P	3.5	M 4	12	D-T08P/T15P	FG-15	–	–	HS 90835
C0320	US 44012-T15P	3.5	M 4	12	D-T08P/T15P	FG-15	–	–	HS 1030C
C0322	US 44012-T15P	3.5	M 4	12	D-T08P/T15P	FG-15	–	–	HS 1230C
C0324	US 44012-T15P	3.5	M 4	12	D-T08P/T15P	FG-15	–	–	–

AC001		KS 1230		K.FMH27
AC002		KS 1635		K.FMH32
AC003		KS 2040		K.FMH40

SNGX 11

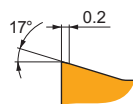


	IC	D1	S
	(mm)	(mm)	(mm)
1104	10.600	4.56	4.76



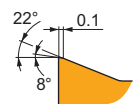
Lämplighet och startvärden för skärhastighet (vc), matning (f) och skärdjup (ap). Vi refererar till vår Dormer Pramet Calculator-app för vidare beräkningar.

Product	RE	P			M			K			N			S			H		
		vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)



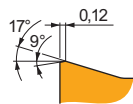
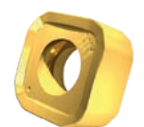
M geometri med positiv design för högmatningsfräsning.

SNGX 110416SR-M:8215	✳	1.6	260	0.60	1.0	–	–	–	245	0.60	1.0	–	–	–	–	–	–	–	–	–
SNGX 110416SR-M:M8310	✳	1.6	275	0.60	1.0	–	–	–	260	0.60	1.0	–	–	–	–	–	–	–	–	–
SNGX 110416SR-M:M8330	✳	1.6	260	0.60	1.0	–	–	–	245	0.60	1.0	–	–	–	–	–	–	–	–	–
SNGX 110416SR-M:M8340	✳	1.6	245	0.60	1.0	–	–	–	230	0.60	1.0	–	–	–	–	–	–	–	–	–
SNGX 110416SR-M:M9325	✳	1.6	305	0.60	1.0	–	–	–	285	0.60	1.0	–	–	–	–	–	–	–	–	–
SNGX 110416SR-M:M9340	✳	1.6	270	0.60	1.0	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–



MM geometri med mycket positiv design för högmatningsfräsning.

SNGX 110416SR-MM:M6330	✳	1.6	175	0.60	1.0	125	0.54	1.0	–	–	–	–	–	–	50	0.42	0.8	–	–	–
SNGX 110416SR-MM:M8340	✳	1.6	190	0.60	1.0	110	0.54	1.0	–	–	–	–	–	–	45	0.42	0.8	–	–	–
SNGX 110416SR-MM:M8345	✳	1.6	150	0.60	1.0	90	0.54	1.0	–	–	–	–	–	–	35	0.42	0.8	–	–	–
SNGX 110416SR-MM:M9340	✳	1.6	210	0.60	1.0	125	0.54	1.0	–	–	–	–	–	–	50	0.42	0.8	–	–	–

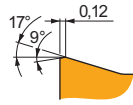
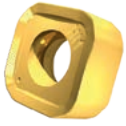


HM geometri med stark design för högmatningsfräsning.

SNGX 110416SR-HM:8215	✳	1.6	230	1.00	1.0	–	–	–	215	1.00	1.0	–	–	–	–	–	–	45	0.70	0.7
SNGX 110416SR-HM:M8310	✳	1.6	240	1.00	1.0	–	–	–	225	1.00	1.0	–	–	–	–	–	–	45	0.70	0.7

Lämplighet och startvärden för skärhastighet (vc), matning (f) och skärdjup (ap). Vi refererar till vår Dormer Pramet Calculator-app för vidare beräkningar.

Product	RE (mm)	P			M			K			N			S			H		
		vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)



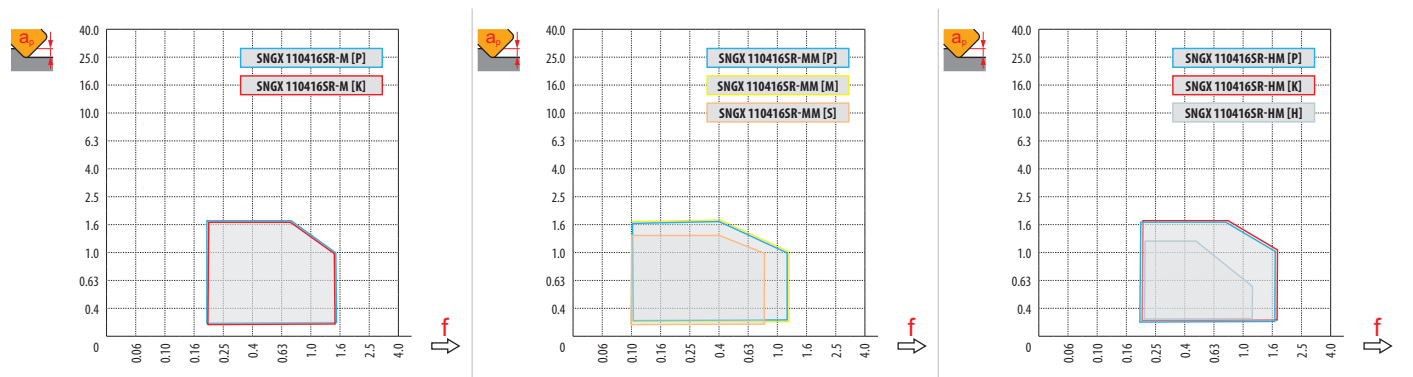
HM geometri med stark design för högmatningsfräsning.

SNGX 110416SR-HM:M8330	1.6	235	1.00	1.0	-	-	-	220	1.00	1.0	-	-	-	-	-	-	45	0.70	0.7
SNGX 110416SR-HM:M9325	1.6	260	1.00	1.0	-	-	-	245	1.00	1.0	-	-	-	-	-	-	50	0.70	0.7

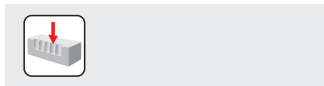


a_e / DCX	5%	10%	15%	20%	25%	30%	40%	50%	60%	70%	75%	80%	90%	100%
	1.48	1.35	1.27	1.22	1.19	1.16	1.11	1.08	1.05	1.03	1.00	1.00	1.00	1.00
	2.20	1.60	1.35	1.20	1.10	0.95	0.85	0.75	0.85	0.95	1.00	1.00	1.00	1.00
	0.64	0.64	0.64	0.64	0.64	0.65	0.65	0.67	0.68	0.71	0.72	0.74	0.79	1.00

	SNGX 11 - M	SNGX 11 - MM	SNGX 11 - HM
	1.6	1.6	1.6
	-	-	-

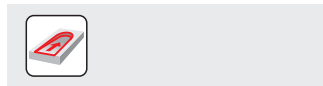


HFC														
		0.00	0.20	0.40	0.60	0.80	1.00	1.10	1.20	1.30	1.40	1.50	1.60	1.70
32		18.30	19.53	20.76	21.99	23.22	24.46	25.07	25.69	26.30	26.92	27.53	28.15	28.76
35		21.20	22.43	23.66	24.89	26.12	27.36	27.97	28.59	29.20	29.82	30.43	31.05	31.66
40		26.20	27.43	28.66	29.89	31.12	32.36	32.97	33.59	34.20	34.82	35.43	36.05	36.66
42		28.20	29.43	30.66	31.89	33.12	34.36	34.97	35.59	36.20	36.82	37.43	38.05	38.66
50		36.10	37.33	38.56	39.79	41.02	42.26	42.87	43.49	44.10	44.72	45.33	45.95	46.56
52		38.10	39.33	40.56	41.79	43.02	44.26	44.87	45.49	46.10	46.72	47.33	47.95	48.56
63		49.10	50.33	51.56	52.79	54.02	55.26	55.87	56.49	57.10	57.72	58.33	58.95	59.56
66		52.10	53.33	54.56	55.79	57.02	58.26	58.87	59.49	60.10	60.72	61.33	61.95	62.56
80		66.10	67.33	68.56	69.79	71.02	72.26	72.87	73.49	74.10	74.72	75.33	75.95	76.56
100		86.10	87.33	88.56	89.79	91.02	92.26	92.87	93.49	94.10	94.72	95.33	95.95	96.56
115		101.10	102.33	103.56	104.79	106.02	107.26	107.87	108.49	109.10	109.72	110.33	110.95	111.56
125		111.10	112.33	113.56	114.79	116.02	117.26	117.87	118.49	119.10	119.72	120.33	120.95	121.56
		-	0.20	0.40	0.60	0.80	1.00	1.10	1.20	1.30	1.40	1.50	1.60	1.70
		-	1.37	0.98	0.81	0.71	0.64	0.62	0.59	0.58	0.56	0.54	0.53	0.52



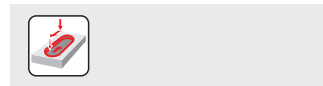
SNGX

32	5.0	0.25
35	5.0	0.25
40	5.2	0.30
42	5.2	0.30
50	5.3	0.30
52	5.3	0.30
63	5.4	0.30
66	5.4	0.30
80	5.5	0.35
100	5.5	0.35
115	5.5	0.35
125	5.5	0.35



SNGX (HFC)

32	0.8	1.4/100
35	0.8	1.4/100
40	0.7	1.2/100
42	0.7	1.2/100
50	0.5	0.9/100
52	0.5	0.9/100
63	0.4	0.7/100
66	0.4	0.7/100
80	0.3	0.5/100
100	0.2	0.3/100
115	0.2	0.3/100
125	0.2	0.3/100



SNGX (HFC)

32	0.2	0.3
35	0.2	0.3
40	0.2	0.3
42	0.2	0.3
50	0.3	0.4
52	0.3	0.4
63	0.3	0.4
66	0.3	0.4
80	0.3	0.4
100	0.3	0.4
115	0.3	0.4
125	0.3	0.4



		3	5	10	15	20	30	40	50	60	80	100
32		0.620	0.800	1.131	1.386	1.600	1.960	2.263	2.530	2.771	3.200	3.578
35		0.648	0.837	1.183	1.449	1.673	2.049	2.366	2.646	2.898	3.347	3.742
40		0.693	0.894	1.265	1.549	1.789	2.191	2.530	2.828	3.098	3.578	4.000
42		0.710	0.917	1.296	1.587	1.833	2.245	2.592	2.898	3.175	3.666	4.099
50		0.775	1.000	1.414	1.732	2.000	2.449	2.828	3.162	3.464	4.000	4.472
52		0.790	1.020	1.442	1.766	2.040	2.498	2.884	3.225	3.533	4.079	4.561
63		0.869	1.122	1.587	1.944	2.245	2.750	3.175	3.550	3.888	4.490	5.020
66		0.890	1.149	1.625	1.990	2.298	2.814	3.250	3.633	3.980	4.596	5.138
80		0.980	1.265	1.789	2.191	2.530	3.098	3.578	4.000	4.382	5.060	5.657
100		1.095	1.414	2.000	2.449	2.828	3.464	4.000	4.472	4.899	5.657	6.325
115		1.175	1.517	2.145	2.627	3.033	3.715	4.290	4.796	5.254	6.066	6.782
125		1.225	1.581	2.236	2.739	3.162	3.873	4.472	5.000	5.477	6.325	7.071

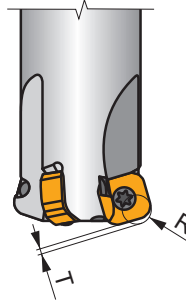


	SNGX			
	0.2	0.5	1.0	1.7
	1.20	1.00	0.50	0.25



SNGX (HFC)










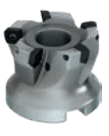














	D _{MIN}	D _{MAX}		
32	48.0	63.8	0.7	1.4
35	54.0	69.8	0.8	1.5
40	64.0	79.8	0.9	1.5
42	68.0	83.8	1.0	1.6
50	84.0	99.8	0.9	1.4
52	88.0	103.8	1.0	1.4
63	109.0	125.8	1.0	1.4
66	115.0	131.8	1.1	1.4
80	143.0	159.8	1.0	1.3
100	183.0	199.8	0.9	1.1
115	213.0	229.8	1.1	1.3
125	233.0	249.8	1.2	1.4



SNGX	R	T
SNGX 110416	4.6	0.92

INDEXABLE FACE MILLS – NAVIGATOR

HIGH FEED MILLING – POSITIVE INSERTS

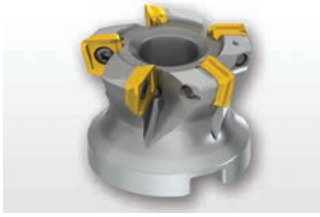
	SSO12		SPD09		SZD07		SZD09		SZD12								
	12°		19°		-		-		-								
	APMX (mm)	1.9	APMX (mm)	2.0	APMX (mm)	1.0	APMX (mm)	1.0	APMX (mm)	1.6							
	DCX (mm)	35 – 125	DCX (mm)	32 – 140	DCX (mm)	16 – 25	DCX (mm)	25 – 63	DCX (mm)	32 – 80							
Cylindrical shank		DC = 35, 40 (mm)		DCX = 32, 40 (mm)		DCX = 16 – 25 (mm)											
Weldon		DC = 35, 40 (mm)						DCX = 25, 32 (mm)									
Modular								DCX = 25, 32 (mm)		DCX = 32, 40 (mm)							
Shell mill		DC = 42 – 125 (mm)		DCX = 42 – 140 (mm)				DCX = 40 – 63 (mm)		DCX = 50 – 80 (mm)							
Page	📖 266		📖 270		📖 276		📖 280		📖 284								
ISO	P	M	K	N	S	H	P	M	K	S	H	P	K	H	P	K	H
Insert shape																	
Inserts	SOHT 1205		PD.. 0905		ZDCW 0703		ZDCW 09T3		ZDEW 1204								
No. of cutting edges	4		5		4		4		4								
Face milling 	■		■		■		■		■								
Helical interpolation 	■		■		▣		▣		▣								
Shallow shoulder milling 	■		■		▣		▣		▣								
Plunge milling 	■		■		▣		▣		▣								
Progressive plunging 	■		■		▣		▣		▣								
Ramping 	■		■														
Shape surfaces milling (copy milling) 			▣		▣		▣		▣								
Shallow slot milling 	■		▣		▣		▣		▣								

SS012

P M K S H

PRAMET

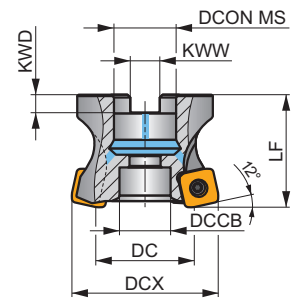
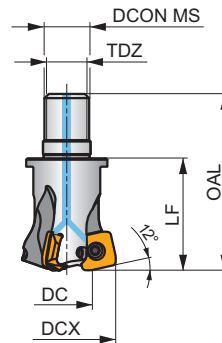
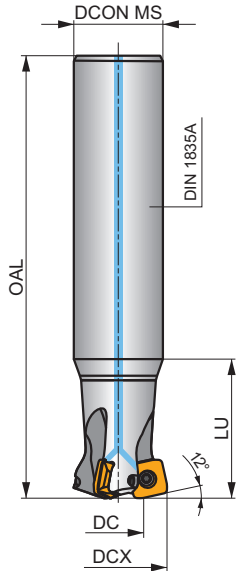
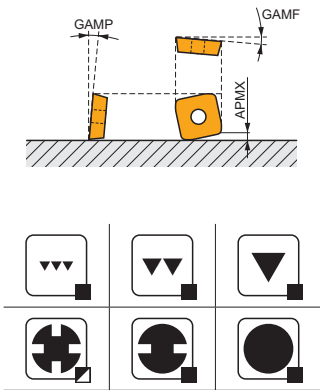
S



VER S012 12° högmattningsfräsning med invändig kylning

Mycket mångsidig 12° högmattningsfräs som använder enkelsidiga SO... 12-skär med APMX på 1.9 mm. Lämplig för ett brett spektrum av applikationer i de flesta material. Cylindriska, modulära och dorn finns tillgängliga, med differentierad tanddelning. Kylvätska genom kanaler och kropp behandlad för längre verktygslivslängd.

KAPR	12°
APMX	1.9 mm



	0.09-0.93
	0.09-0.93



Product	DCX	DC	OAL	DCON MS	DCCB	LU	LF	TDZ	KWW	KWD	GAMF	GAMP				kg				
	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(°)	(°)	max.	✓	✓						
35E3R050A32-SS012-C	35	17.3	200	32	-	50	-	-	-	-	-5	5	3	-	15700	✓	1.07	GI350	SQ501	-
35E3R120A32-SS012-C	35	17.3	200	32	-	120	-	-	-	-	-5	5	3	-	15700	✓	0.95	GI350	SQ501	-
40E4R120A32-SS012-C	40	22.3	200	32	-	120	-	-	-	-	-5	5	4	-	14700	✓	1.00	GI350	SQ501	-
35E3R040M16-SS012-C	35	17.3	63	17	-	-	40	M16	-	-	-5	5	3	-	15700	✓	0.15	GI350	SQ501	-
40E4R043M16-SS012-C	40	22.3	66	17	-	-	43	M16	-	-	-5	5	4	-	14700	✓	0.18	GI350	SQ501	-
42A04R-SM0S012-C	42	24.3	-	16	12.4	-	40	-	8.4	5.6	-5	5	4	-	14300	✓	0.16	GI350	SQ502	-
50A05R-SM0S012-C	50	32.3	-	22	18.1	-	40	-	10.4	6.3	-5	5	5	✓	13100	✓	0.23	GI350	SQ503	-
52A05R-SM0S012-C	52	34.3	-	22	18.1	-	40	-	10.4	6.3	-5	5	5	✓	12800	✓	0.35	GI350	SQ503	-
63A06R-SM0S012-C	63	45.3	-	27	22.1	-	50	-	12.4	7	-5	5	6	✓	11700	✓	0.48	GI350	SQ504	-
66A06R-SM0S012-C	66	48.3	-	27	22.1	-	50	-	12.4	7	-5	5	6	✓	11400	✓	0.51	GI350	SQ504	-
80A07R-SM0S012-C	80	62.3	-	27	22.1	-	50	-	12.4	7	-5	5	7	✓	10400	✓	0.76	GI350	SQ504	-
100A08R-SM0S012-C	100	82.3	-	32	45.1	-	50	-	14.4	8	-5	5	8	✓	9300	✓	1.32	GI350	SQ505	AC002
125A10R-SM0S012-C	125	107.3	-	40	56.1	-	63	-	16.4	9	-5	5	10	✓	8300	✓	2.46	GI350	SQ505	AC003

	GI350		SOHT 1205..
--	-------	--	-------------

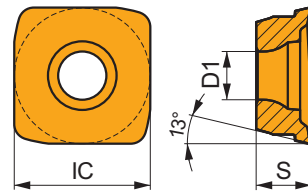
SQ501	US 4011-T15P	3.5	M 4	10.6	FLAG T15P	-	-
SQ502	US 4011-T15P	3.5	M 4	10.6	-	SDR T15P-T	HCS 0840C
SQ503	US 4011-T15P	3.5	M 4	10.6	-	SDR T15P-T	HS 1030C
SQ504	US 4011-T15P	3.5	M 4	10.6	-	SDR T15P-T	HS 1230C
SQ505	US 4011-T15P	3.5	M 4	10.6	-	SDR T15P-T	-

AC002	KS 1635	K.FMH32
AC003	KS 2040	K.FMH40

SOHT 12



	IC	D1	S
	(mm)	(mm)	(mm)
1205	12.700	4.50	5.15



Lämplighet och startvärden för skärhastighet (vc), matning (f) och skärdjup (ap). Vi refererar till vår Dormer Pramet Calculator-app för vidare beräkningar.

Product	RE (mm)	P			M			K			N			S			H		
		vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)



M geometrin är mångsidig för ett brett spektrum av arbetsförhållanden. Utformad med positiv skärvinkel, medium skyddsfas och rundning av skäreppen för jämn HFC-fräsning. Förstahandsval för stål, gjutjärn och härdade stål.

SOHT 120514SR-M:8215	✱	1.4	■	215	1.00	1.0	▣	125	0.90	1.0	■	200	1.00	1.0	—	—	—	▣	50	0.70	0.8	■	40	0.68	0.8
SOHT 120514SR-M:M8310	✱	1.4	■	225	1.00	1.0	▣	110	0.90	1.0	■	210	1.00	1.0	—	—	—	—	—	—	—	■	45	0.68	0.8
SOHT 120514SR-M:M8330	✱	1.4	■	220	1.00	1.0	▣	130	0.90	1.0	■	205	1.00	1.0	—	—	—	▣	55	0.70	0.8	▣	40	0.68	0.8
SOHT 120514SR-M:M8340	✱	1.4	■	205	1.00	1.0	▣	120	0.90	1.0	▣	190	1.00	1.0	—	—	—	▣	50	0.70	0.8	—	—	—	
SOHT 120514SR-M:M9325	✱	1.4	■	245	1.00	1.0	—	—	—	—	■	230	1.00	1.0	—	—	—	—	—	—	—	▣	45	0.68	0.8
SOHT 120514SR-M:M9340	✱	1.4	■	215	1.00	1.0	▣	125	0.90	1.0	—	—	—	—	—	—	—	▣	50	0.70	0.8	—	—	—	



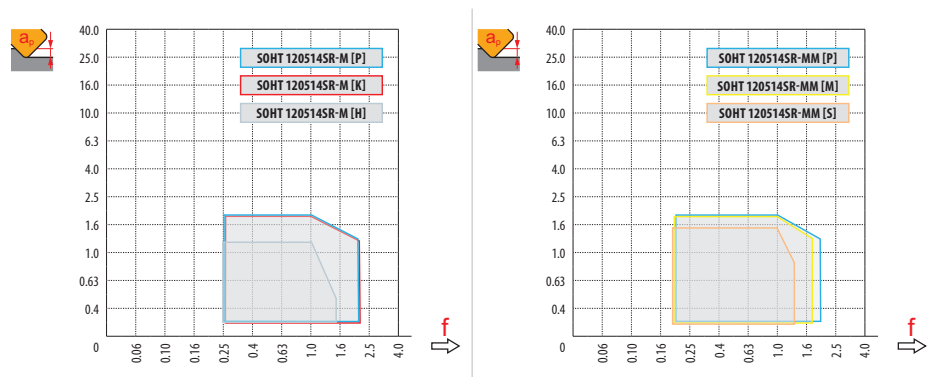
MM geometrin är skarp och lämplig för applikationer med stort överhäng eller tunnväggiga och smala arbetsstycken. Utformad med positiv skärvinkel, smal skyddsfas och rundning av skäreppen för jämn HFC-fräsning. Förstahandsval för rostfritt stål och superlegeringar.

SOHT 120514SR-MM:M6330	✱	1.4	■	190	1.00	1.0	■	135	0.90	1.0	—	—	—	—	—	—	—	■	55	0.70	0.8	—	—	—
SOHT 120514SR-MM:M8340	✱	1.4	■	205	1.00	1.0	■	120	0.90	1.0	—	—	—	—	—	—	—	■	50	0.70	0.8	—	—	—
SOHT 120514SR-MM:M8345	✱	1.4	■	165	1.00	1.0	■	95	0.90	1.0	—	—	—	—	—	—	—	■	40	0.70	0.8	—	—	—
SOHT 120514SR-MM:M9325	✱	1.4	■	245	1.00	1.0	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
SOHT 120514SR-MM:M9340	✱	1.4	■	215	1.00	1.0	■	125	0.90	1.0	—	—	—	—	—	—	—	■	50	0.70	0.8	—	—	—



a_e / DCX	5 %	10 %	15 %	20 %	25 %	30 %	40 %	50 %	60 %	70 %	75 %	80 %	90 %	100 %
	1.48	1.35	1.27	1.22	1.19	1.16	1.11	1.08	1.05	1.03	1.00	1.00	1.00	1.00
	2.20	1.60	1.35	1.20	1.10	0.95	0.85	0.75	0.85	0.95	1.00	1.00	1.00	1.00
	0.64	0.64	0.64	0.64	0.64	0.65	0.65	0.67	0.68	0.71	0.72	0.74	0.79	1.00

	SOHT 12-M	SOHT 12-MM
	1.4	1.4
	2.00	2.00



HFC														
DCX	a_p	0.00	0.20	0.40	0.60	0.80	1.00	1.20	1.40	1.50	1.60	1.70	1.80	1.90
35		17.3	19.2	21.1	22.9	24.8	26.7	28.6	30.5	31.4	32.4	33.1	33.5	33.9
40		22.3	24.2	26.1	27.9	29.8	31.7	33.6	35.5	36.4	37.4	38.1	38.5	38.9
42		24.3	26.2	28.1	29.9	31.8	33.7	35.6	37.5	38.4	39.4	40.1	40.5	40.9
50		32.3	34.2	36.1	37.9	39.8	41.7	43.6	45.5	46.4	47.4	48.1	48.5	48.9
52		34.3	36.2	38.1	39.9	41.8	43.7	45.6	47.5	48.4	49.4	50.1	50.5	50.9
63		45.3	47.2	49.1	50.9	52.8	54.7	56.6	58.5	59.4	60.4	61.1	61.5	61.9
66		48.3	50.2	52.1	53.9	55.8	57.7	59.6	61.5	62.4	63.4	64.1	64.5	64.9
80		62.3	64.2	66.1	67.9	69.8	71.7	73.6	75.5	76.4	77.4	78.1	78.5	78.9
100		82.3	84.2	86.1	87.9	89.8	91.7	93.6	95.5	96.4	97.4	98.1	98.5	98.9
125		107.3	109.2	111.1	112.9	114.8	116.7	118.6	120.5	121.4	122.4	123.1	123.5	123.9
	a_p	0.00	0.20	0.40	0.60	0.80	1.00	1.20	1.40	1.50	1.60	1.70	1.80	1.90
		-	2.20	2.00	1.80	1.60	1.40	1.20	1.10	1.00	0.90	0.80	0.70	0.60

DCX	$d_{e\max}$	f _{max}
35	10.0	0.10
40	10.0	0.10
42	10.0	0.12
50	10.0	0.12
52	10.0	0.12
63	10.0	0.15
66	10.0	0.15
80	10.0	0.20
100	10.0	0.20
125	10.0	0.20

DCX	RPMX	APMX/I
35	9.6	1.9/11
40	6.9	1.9/16
42	6.1	1.9/18
50	4.3	1.9/25
52	4.0	1.9/27
63	2.6	1.9/41
66	2.5	1.9/44
80	1.9	1.9/59
100	1.4	1.9/79
125	1.0	1.9/105

DCX	a	f _{max}
35	1.6	0.17
40	1.6	0.17
42	1.6	0.15
50	1.6	0.10
52	1.6	0.10
63	1.6	0.05
66	1.6	0.05
80	1.6	0.05
100	1.6	0.05
125	1.6	0.05

DCX	μm	3	5	10	15	20	30	40	50	60	80	100
35		0.648	0.837	1.183	1.449	1.673	2.049	2.366	2.646	2.898	3.347	3.742
40		0.693	0.894	1.265	1.549	1.789	2.191	2.530	2.828	3.098	3.578	4.000
42		0.710	0.917	1.296	1.587	1.833	2.245	2.592	2.898	3.175	3.666	4.099
50		0.775	1.000	1.414	1.732	2.000	2.449	2.828	3.162	3.464	4.000	4.472
52		0.790	1.020	1.442	1.766	2.040	2.498	2.884	3.225	3.533	4.079	4.561
63		0.869	1.122	1.587	1.944	2.245	2.750	3.175	3.550	3.888	4.490	5.020
66		0.890	1.149	1.625	1.990	2.298	2.814	3.250	3.633	3.980	4.596	5.138
80		0.980	1.265	1.789	2.191	2.530	3.098	3.578	4.000	4.382	5.060	5.657
100		1.095	1.414	2.000	2.449	2.828	3.464	4.000	4.472	4.899	5.657	6.325
125		1.225	1.581	2.236	2.739	3.162	3.873	4.472	5.000	5.477	6.325	7.071

a	0.2	0.6	1.0	1.5	1.9
f	2.0	1.6	1.2	0.8	0.5

DCX	DMIN	DMAX	SMAX DMIN	SMAX DMAX
35	46.0	69.8	1.9	1.9
40	56.0	79.8	1.9	1.9
42	60.0	83.8	1.9	1.9
50	76.0	99.8	1.9	1.9
52	80.0	103.8	1.9	1.9
63	102.0	125.8	1.9	1.9
66	108.0	131.8	1.9	1.9
80	136.0	159.8	1.9	1.9
100	176.0	199.8	1.9	1.9
125	226.0	249.8	1.9	1.9

SOHT	R	T
SOHT 120514	3.37	1.21

SPD09

P M K S H

PRAMET

S

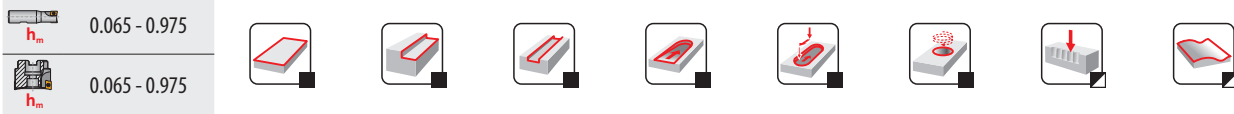
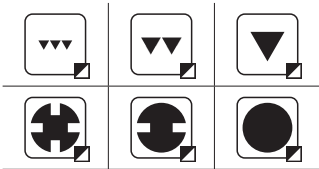
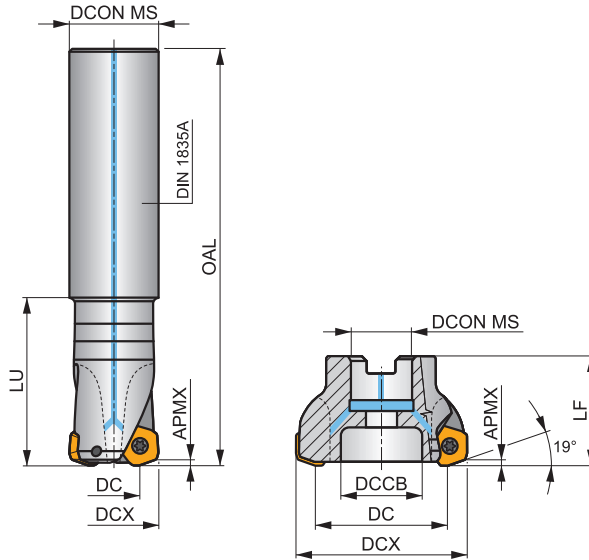
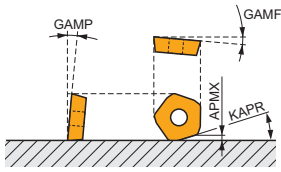


PENTA HF högmatningsfräs, invändig kylning

Högmatningsfräs för enkelsidiga, positiva PD.. 09-skär med fem eggar och APMX 2 mm. Invändig kylning. För en rad olika applikationer. Finns med cylindriskt skaft och dornfäste. Diametrar från 32 till 140 mm. Behandlad för lång livslängd.

PENTA HF

KAPR	19°
APMX	2.0 mm



Product	DCX	DC	OAL	DCON MS	DCCB	LU	LF	GAMP	GAMP	max.			kg	C			
	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(°)	(°)	mm	rpm	m/min		GI245	C0340	AC001	
32E2R060A32-SPD09-C	32	18.4	250	32	-	60	-	-24	10	2	-	13100	✓	1.34	GI245	C0340	-
40E3R060A32-SPD09-C	40	25.5	250	32	-	60	-	-11	10	3	-	11700	✓	1.43	GI245	C0340	-
42A03R-S19PD09-C	42	27.5	-	16	12	-	40	-8	10	3	-	11500	✓	0.18	GI245	C0342	-
50A04R-S19PD09-C	50	35.3	-	22	18	-	40	-3	10	4	-	10500	✓	0.23	GI245	C0343	-
50A05R-S19PD09-C	50	35.3	-	22	18	-	40	-3	10	5	-	10500	✓	0.33	GI245	C0343	-
52A04R-S19PD09-C	52	37.3	-	22	18	-	40	-3	10	4	-	10300	✓	0.25	GI245	C0343	-
63A05R-S19PD09-C	63	48.2	-	22	18	-	40	-1	10	5	-	9400	✓	0.44	GI245	C0343	-
63A06R-S19PD09-C	63	48.2	-	22	18	-	40	-1	10	6	-	9300	✓	0.45	GI245	C0343	-
66A06R-S19PD09-C	66	51.2	-	22	18	-	40	-1	10	6	-	9200	✓	0.35	GI245	C0343	-
66A06R-S19PD09-CF	66	51.2	-	27	22	-	50	-1	10	6	-	9100	✓	0.67	GI245	C0344	-
80A05R-S19PD09-C	80	65.3	-	27	37	-	50	-1	10	5	-	8300	✓	0.84	GI245	C0341	AC001
80A06R-S19PD09-C	80	65.3	-	27	37	-	50	-1	10	6	-	8300	✓	0.86	GI245	C0341	AC001
100A06R-S19PD09-C	100	58.3	-	32	45	-	50	-1	10	6	-	7400	✓	1.46	GI245	C0341	AC002
100A08R-S19PD09-C	100	85.3	-	32	45	-	50	-1	10	8	-	7400	✓	1.40	GI245	C0341	AC002
125A08R-S19PD09-C	125	110.3	-	40	36	-	63	-1	10	8	-	6600	✓	3.10	GI245	C0349	-
125A10R-S19PD09-C	125	110.3	-	40	36	-	63	-1	10	10	-	6600	✓	3.11	GI245	C0349	-
140A08R-S19PD09-C	140	125.3	-	40	36	-	63	-1	10	8	-	6200	✓	3.57	GI245	C0349	-

GI245	PD.X 0905ZE..	PDKT 0905..	PDMW 0905..

C0340	US 45011-T20P	5.0	M 5	11	-	Flag T20P
C0341	US 45011-T20P	5.0	M 5	11	SDR T20P-T	-

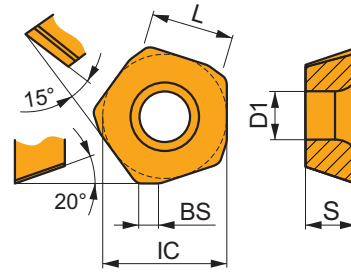
C0342	US 45011-T20P	5.0	M 5	11	SDR T20P-T	HS 90835	-
C0343	US 45011-T20P	5.0	M 5	11	SDR T20P-T	HS 1030C	-
C0344	US 45011-T20P	5.0	M 5	11	SDR T20P-T	HS 1230C	-
C0349	US 45011-T20P	5.0	M 5	11	SDR T20P-T	HSD 2040	-

AC001		KS 1230	K.FMH27
AC002		KS 1635	K.FMH32

PDMX 09

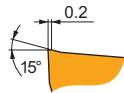


	BS	IC	D1	L	S
	(mm)	(mm)	(mm)	(mm)	(mm)
0905	2.00	13.500	5.50	9.00	5.47



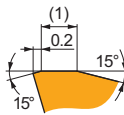
Lämplighet och startvärden för skärhastighet (vc), matning (f) och skärdjup (ap). Vi refererar till vår Dormer Pramet Calculator-app för vidare beräkningar.

Product	RE (mm)	P			M			K			N			S			H		
		vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)



M geometri med positiv design för medelgrov högmatningsfräsning.

PDMX 0905ZEER-M:8215	☹	-	█	215	1.00	1.2	█	125	0.90	1.2	█	200	1.00	1.2	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	
PDMX 0905ZEER-M:M8330	☹	-	█	220	1.00	1.2	█	130	0.90	1.2	█	205	1.00	1.2	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	
PDMX 0905ZEER-M:M8345	☹	-	█	165	1.00	1.2	█	95	0.90	1.2	█	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	
PDMX 0905ZEER-M:M9340	☹	-	█	215	1.00	1.2	█	125	0.90	1.2	█	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-



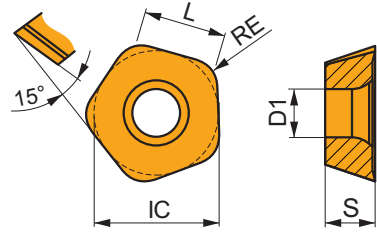
R geometri med stark design för högmatningsfräsning.

PDMX 0905ZESR-R:8215	☹	-	█	215	1.00	1.3	-	-	-	█	200	1.00	1.3	-	-	-	-	-	-	-	-	-	-	-	-	-	-	█	40	0.70	0.9			
PDMX 0905ZESR-R:M8330	☹	-	█	215	1.00	1.3	-	-	-	█	200	1.00	1.3	-	-	-	-	-	-	-	-	-	-	-	-	-	-	█	40	0.70	0.9			
PDMX 0905ZESR-R:M8345	☹	-	█	165	1.00	1.3	-	-	-	█	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-
PDMX 0905ZESR-R:M9325	☹	-	█	245	1.00	1.3	-	-	-	█	230	1.00	1.3	-	-	-	-	-	-	-	-	-	-	-	-	-	-	█	45	0.70	0.9			

PDKT 09

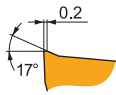


	IC (mm)	D1 (mm)	L (mm)	S (mm)
0905	13.500	5.50	9.00	5.47



Lämplighet och startvärden för skärhastighet (vc), matning (f) och skärdjup (ap). Vi refererar till vår Dormer Pramet Calculator-app för vidare beräkningar.

Product	RE (mm)	P			M			K			N			S			H		
		vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)



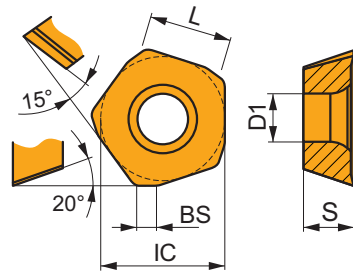
FM geometri med mycket positiv design för fin till medelfin högmatningsfräsning.

PDKT 090530ER-FM:8215	3.0	240	1.00	1.2	140	0.90	1.2	225	1.00	1.2	60	0.70	1.0			
PDKT 090530ER-FM:M6330	3.0	210	1.00	1.2	150	0.90	1.2				60	0.70	1.0			
PDKT 090530ER-FM:M8310	3.0	250	1.00	1.2	125	0.90	1.2	235	1.00	1.2						
PDKT 090530ER-FM:M8330	3.0	245	1.00	1.2	145	0.90	1.2	230	1.00	1.2	60	0.70	1.0			
PDKT 090530ER-FM:M8345	3.0	180	1.00	1.2	105	0.90	1.2				45	0.70	1.0			
PDKT 090530ER-FM:M9325	3.0	275	1.00	1.2				260	1.00	1.2						

PDKX 09

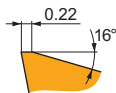


	BS (mm)	IC (mm)	D1 (mm)	L (mm)	S (mm)
0905	2.00	13.500	5.50	9.00	5.47



Lämplighet och startvärden för skärhastighet (vc), matning (f) och skärdjup (ap). Vi refererar till vår Dormer Pramet Calculator-app för vidare beräkningar.

Product	RE (mm)	P			M			K			N			S			H		
		vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)



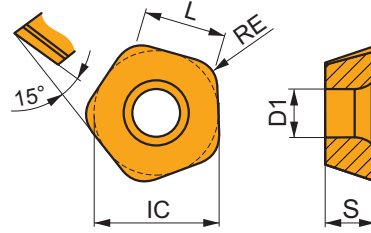
FM geometri med mycket positiv design för medelfin högmatningsfräsning.

PDKX 0905ZEER-FM:M6330		195	1.00	1.2	135	0.90	1.2				55	0.70	1.0			
PDKX 0905ZEER-FM:M8345		165	1.00	1.2	95	0.90	1.2				40	0.70	1.0			
PDKX 0905ZEER-FM:M9340		215	1.00	1.2	125	0.90	1.2				50	0.70	1.0			

PDMW 09

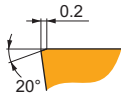


	IC (mm)	D1 (mm)	L (mm)	S (mm)
0905	13.500	5.50	9.00	5.47



Lämplighet och startvärden för skärhastighet (vc), matning (f) och skärdjup (ap). Vi refererar till vår Dormer Pramet Calculator-app för vidare beräkningar.

Product	RE (mm)	P			M			K			N			S			H		
		vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)



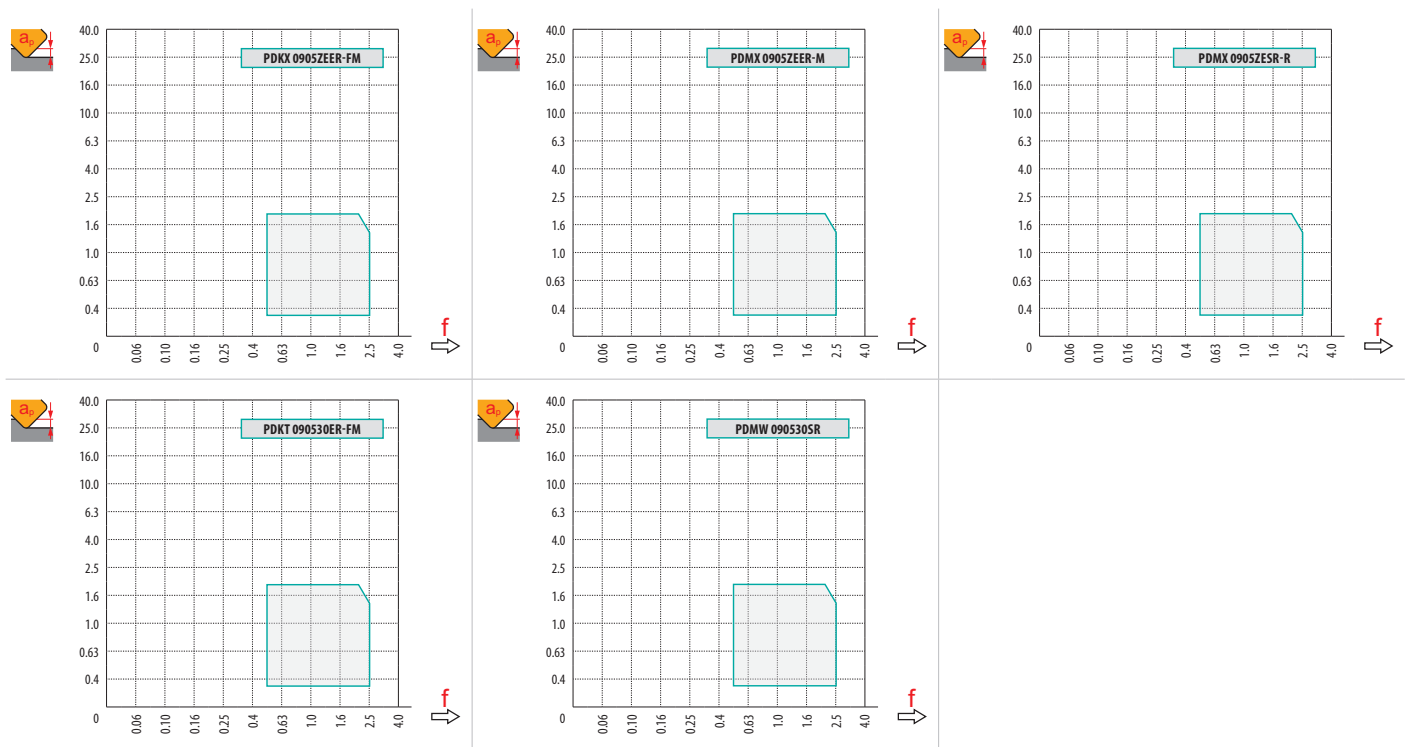
SR neutral spänvinkeldesign för högmatningsfräsning.

PDMW 090530SR:M8310	✱ 3.0	✓ 245	1.00	1.4	–	–	–	■ 230	1.00	1.4	–	–	–	–	–	–	■ 45	0.70	1.0
PDMW 090530SR:M8345	✱ 3.0	✓ 180	1.00	1.4	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
PDMW 090530SR:M9325	✱ 3.0	✓ 270	1.00	1.4	–	–	–	■ 255	1.00	1.4	–	–	–	–	–	–	✓ 50	0.70	1.0



a_e DCX	5 %	10 %	15 %	20 %	25 %	30 %	40 %	50 %	60 %	70 %	75 %	80 %	90 %	100 %
	1.48	1.35	1.27	1.22	1.19	1.16	1.11	1.08	1.05	1.03	1.00	1.00	1.00	1.00
	2.20	1.60	1.35	1.20	1.10	0.95	0.85	0.75	0.85	0.95	1.00	1.00	1.00	1.00
	0.64	0.64	0.64	0.64	0.64	0.65	0.65	0.67	0.68	0.71	0.72	0.74	0.79	1.00

	PDKX 09-FM	PDMX 09-M	PDMX 09-R	PDKT 09-FM	PDMW 09
	-	-	-	3.0	3.0
	2.00	2.00	2.00	-	-



		0.00	0.30	0.40	0.50	0.60	0.70	0.80	0.90	1.00	1.25	1.50	2.00
32		18.4	20.1	20.7	21.3	21.9	22.5	23.0	23.6	24.2	25.7	27.1	30.0
40		25.5	27.2	27.8	28.4	29.0	29.6	30.1	30.7	31.3	32.8	34.2	37.1
42		27.5	29.2	29.8	30.4	31.0	31.6	32.1	32.7	33.3	34.8	36.2	39.1
50		35.3	37.0	37.6	38.2	38.8	39.4	39.9	40.5	41.1	42.6	44.0	46.9
52		37.3	39.0	39.6	40.2	40.8	41.4	41.9	42.5	43.1	44.6	46.0	48.9
63		48.2	49.9	50.5	51.1	51.7	52.3	52.8	53.4	54.0	55.5	56.9	59.8
66		51.2	52.9	53.5	54.1	54.7	55.3	55.8	56.4	57.0	58.5	59.9	62.8
80		65.3	67.0	67.6	68.2	68.8	69.4	69.9	70.5	71.1	72.6	74.0	76.9
100		85.3	87.0	87.6	88.2	88.8	89.4	89.9	90.5	91.1	92.6	94.0	96.9
125		110.3	112.3	112.9	113.5	114.1	114.6	115.2	115.8	116.4	117.9	119.3	122.2
140	125.3	127.3	127.9	128.5	129.1	129.7	130.2	130.8	131.4	132.9	134.3	137.2	
		0.00	0.30	0.40	0.50	0.60	0.70	0.80	0.90	1.00	1.25	1.50	2.00
		-	3.00	3.00	2.90	2.80	2.70	2.60	2.50	2.40	2.25	1.50	1.50



Följ de givna instruktionerna för planfräsning. Vid fräsning intill vertikala sidor minskas tandmatningen (f_z) med 50 % för att undvika vibrationer och skador på eggarna.



DCX	max	f_{max}
32	5.0	0.20
40	5.0	0.20
42	5.0	0.20
50	6.0	0.20
52	6.0	0.20
63	7.0	0.25
66	7.0	0.25
80	8.0	0.30
100	8.0	0.30



DCX	RPMX	APMX/I
40	8.0	1.80/16
42	8.0	2.00/16
50	8.0	2.00/16
52	8.0	2.00/16
63	7.0	2.00/18
66	6.0	2.00/21
80	5.0	2.00/24
100	3.0	2.00/40



HFC			
a_p	0.5	1.0	2.0
f_z	3.0	2.3	1.5



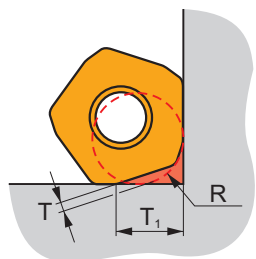
DCX	DMIN	DMAX	SMAX DMIN	SMAX DMAX
40	63.7	80.0	2.00	2.00
42	67.5	84.0	2.00	2.00
50	83.3	100.0	2.00	2.00
52	87.3	104.0	2.00	2.00
63	109.2	126.0	2.00	2.00
66	115.2	132.0	2.00	2.00
80	143.3	160.0	2.00	2.00
100	183.3	200.0	2.00	2.00



DCX	a_p	f_{max}
32	1.8	0.20
40	1.8	0.20
42	2.0	0.20
50	2.0	0.20
52	2.0	0.20
63	2.0	0.25
66	2.0	0.25
80	2.0	0.30
100	2.0	0.30



DCX	μm	3	5	10	15	20	30	40	50	60	80	100
32		0.620	0.800	1.131	1.386	1.600	1.960	2.263	2.530	2.771	3.200	3.578
40		0.693	0.894	1.265	1.549	1.789	2.191	2.530	2.828	3.098	3.578	4.000
42		0.710	0.917	1.296	1.587	1.833	2.245	2.592	2.898	3.175	3.666	4.099
50		0.775	1.000	1.414	1.732	2.000	2.449	2.828	3.162	3.464	4.000	4.472
52		0.790	1.020	1.442	1.766	2.040	2.498	2.884	3.225	3.533	4.079	4.561
63		0.869	1.122	1.587	1.944	2.245	2.750	3.175	3.550	3.888	4.490	5.020
66		0.890	1.149	1.625	1.990	2.298	2.814	3.250	3.633	3.980	4.596	5.138
80		0.980	1.265	1.789	2.191	2.530	3.098	3.578	4.000	4.382	5.060	5.657



DCX	R	T	T ₁
32	4.5	1.1	6.8
40 - 140	4.5	1.1	7.3

SZD07

P **K** **H**

PRAMET

S

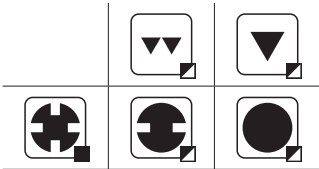
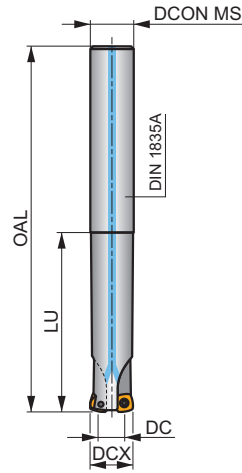
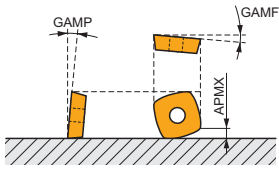


FEED ZD07 högmatningsfräs, invändig kylning

Högmatningsfräs för enkelsidiga ZD. 07-skär med fyra eggar och APMX 1 mm. Invändig kylning. För en rad olika applikationer. Finns med cylindriskt skaft och modulärt fäste. Behandlad för lång livslängd.

FEED ZD

APMX	1.0 mm
------	--------



h_m 0.175 - 0.44



Product	DCX	DC	OAL	DCON MS	LU	LF	GAMP	GAMP							
	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(°)	(°)							
16E2R030A16-SZD07	16	6	100	16	30	-	-5	8	2	-	47400	✓	0.13	GI201	C0350
16E2R065A16-SZD07	16	6	145	16	65	-	-5	8	2	-	47400	✓	0.22	GI201	C0350
20E3R040A20-SZD07	20	10	120	20	40	-	-5	8	3	-	42400	✓	0.25	GI201	C0350
20E3R080A20-SZD07	20	10	165	20	80	-	-5	8	3	-	42400	✓	0.33	GI201	C0350
25E3R050A25-SZD07	25	15	140	25	50	-	-5	8	3	-	37900	✓	0.47	GI201	C0350
25E3R100A25-SZD07	25	15	190	25	100	-	-5	8	3	-	37900	✓	0.60	GI201	C0350

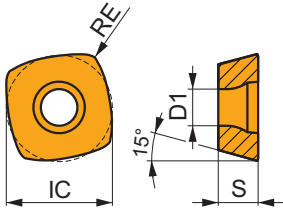
GI201
 ZDCW 0703..

C0350
 US 2205-T07P
 0.9
 M 2.2
 5
 Flag T07P

ZDCW 07

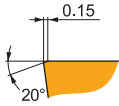
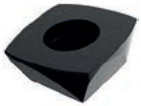


	IC	D1	S
	(mm)	(mm)	(mm)
0703	6.800	2.60	3.18



Lämplighet och startvärden för skärhastighet (vc), matning (f) och skärdjup (ap). Vi refererar till vår Dormer Pramet Calculator-app för vidare beräkningar.

Product	RE (mm)	P			M			K			N			S			H		
		vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)



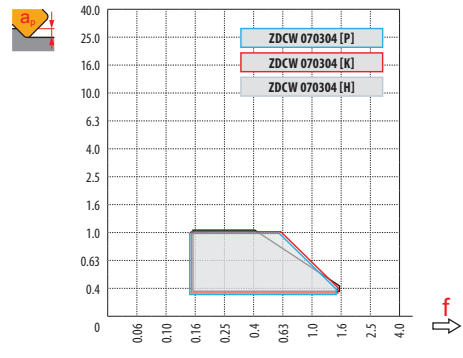
ZDCW speciell design för höghastighetsfräsning.

ZDCW 070304:M8310	0.4	420	0.60	0.4	—	—	—	395	0.60	0.4	—	—	—	—	—	—	80	0.42	0.3
ZDCW 070304:M8325	0.4	325	0.60	0.4	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
ZDCW 070304:M8345	0.4	305	0.60	0.4	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—

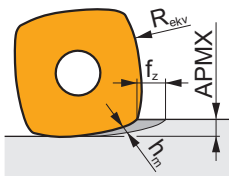


a_e / DCX	5 %	10 %	15 %	20 %	25 %	30 %	40 %	50 %	60 %	70 %	75 %	80 %	90 %	100 %
	1.48	1.35	1.27	1.22	1.19	1.16	1.11	1.08	1.05	1.03	1.00	1.00	1.00	1.00
	2.20	1.60	1.35	1.20	1.10	0.95	0.85	0.75	0.85	0.95	1.00	1.00	1.00	1.00
	0.64	0.64	0.64	0.64	0.64	0.65	0.65	0.67	0.68	0.71	0.72	0.74	0.79	1.00

	ZDCW 07
	0.4
	-



		0.00	0.30	0.40	0.50	0.60	0.70	0.80	0.90	1.00
16		6.0	12.0	12.9	13.7	14.4	15.1	15.7	16.2	16.8
20		10.0	16.0	16.9	17.7	18.4	19.1	19.7	20.2	20.8
25		15.0	21.0	21.9	22.7	23.4	24.1	24.7	25.2	25.8
		0.00	0.30	0.40	0.50	0.60	0.70	0.80	0.90	1.00
		-	1.50	1.50	1.13	1.00	0.88	0.75	0.61	0.60



$$f_z = h_m \times \sqrt{\frac{2R_{ekv}}{APMX}} \quad (\text{mm/z})$$



Följ de givna instruktionerna för planfräsning. Vid fräsning intill vertikala sidor minskas tandmatningen (f_z) med 50 % för att undvika vibrationer och skador på eggarna.

		f_{max}
16	5.6	0.12
20	5.6	0.15
25	5.6	0.17

HFC			
	0.3	0.6	1.0
	1.50	0.80	0.40

	RPMX	APMX/I
16	7.8	1.0/9
20	9.7	1.0/7
25	4.9	1.0/13

	RPMX	APMX/I
16	0.5	0.75/100
20	0.3	0.40/100
25	0.2	0.20/100



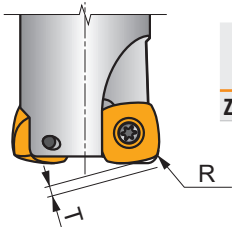
	DMIN	DMAX	SMAX DMIN	SMAX DMAX
16	21.0	32.0	0.10	0.40
20	29.0	40.0	0.10	0.30
25	39.0	50.0	0.15	0.25



		f_{max}
16	0.05	0.12
20	0.05	0.15
25	0.05	0.17



	μm	3	5	10	15	20	30	40	50	60	80	100
16		0.438	0.566	0.800	0.980	1.131	1.386	1.600	1.789	1.960	2.263	2.530
20		0.490	0.632	0.894	1.095	1.265	1.549	1.789	2.000	2.191	2.530	2.828
25		0.548	0.707	1.000	1.225	1.414	1.732	2.000	2.236	2.449	2.828	3.162



	R	T
ZDCW 070304	1.70	0.60

SZD09



PRAMET

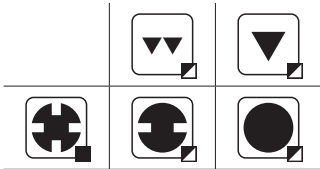
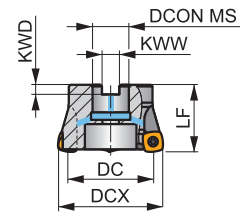
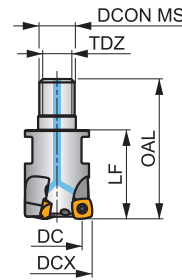
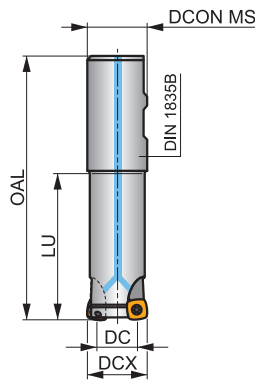
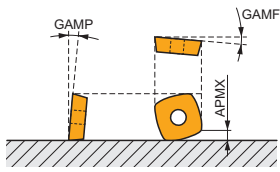


FEED ZD09 högmattningsfräs, invändig kylning

Högmattningsfräs för enkelsidiga ZD.. 09-skär med fyra eggar och APMX 1 mm. Invändig kylning. För en rad olika applikationer. Finns med cylindriskt skaft, modulärt och dornfäste. Behandlad för lång livslängd.

FEED ZD

APMX	1.0 mm
------	--------



	0.31 - 0.618
	0.31 - 0.618



Product	DCX	DC	OAL	DCON MS	LU	LF	TDZ	KWW	KWD	GAMF	GAMP									
	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(°)	(°)									
25E2R080B25-SZD09-C	25	11.6	140	25	80	-	-	-	-	-6	10	2	-	22800	✓	0.46	GI191	SQ400		
25E2R140B25-SZD09-C	25	11.6	200	25	140	-	-	-	-	-6	10	2	-	22800	✓	0.63	GI191	SQ400		
32E2R080B32-SZD09-C	32	18.7	140	32	80	-	-	-	-	-6	10	2	-	20100	✓	0.76	GI191	SQ400		
25E3R032M12-SZD09-C	25	11.6	54	12.5	-	32	M12	-	-	-6	10	3	-	-	✓	0.11	GI191	SQ400		
32E3R040M16-SZD09-C	32	18.7	63	17	-	40	M16	-	-	-6	10	3	-	-	✓	0.21	GI191	SQ400		
40A04R-SMOZD09-C	40	26.7	-	16	-	40	-	8.4	5.6	-6	10	4	✓	18000	✓	0.34	GI191	SQ402		
50A05R-SMOZD09-C	50	36.7	-	22	-	40	-	10.4	6.4	-6	10	5	✓	16000	✓	0.41	GI191	SQ403		
63A06R-SMOZD09-C	63	49.7	-	22	-	40	-	10.4	6.4	-6	10	6	✓	14300	✓	0.60	GI191	SQ403		

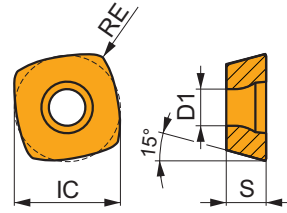
	GI191		ZDCW 09T3..
--	-------	--	-------------

SQ400	US 3006-T09P	2.0	M 3	6	-	-	Flag T09P	-
SQ402	US 3006-T09P	2.0	M 3	6	D-T07P/T09P	FG-15	-	HS 0830C
SQ403	US 3006-T09P	2.0	M 3	6	D-T07P/T09P	FG-15	-	HS 1030C

ZDCW 09

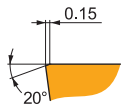
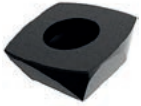


	IC	D1	S
	(mm)	(mm)	(mm)
09T3	9.525	3.40	3.97



Lämplighet och startvärden för skärhastighet (vc), matning (f) och skärdjup (ap). Vi refererar till vår Dormer Pramet Calculator-app för vidare beräkningar.

Product	RE (mm)	P			M			K			N			S			H		
		vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)



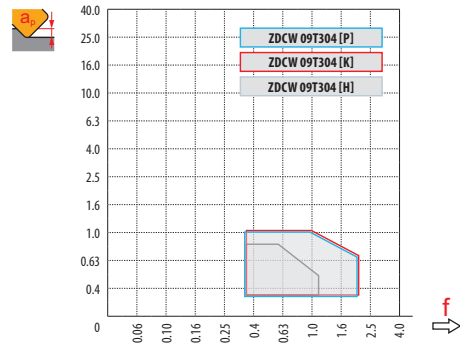
ZDCW speciell design för höghastighetsfräsning.

ZDCW 09T304:M8310	0.4	320	1.00	0.6	–	–	–	300	1.00	0.6	–	–	–	–	–	–	60	0.70	0.4
ZDCW 09T304:M8325	0.4	250	1.00	0.6	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
ZDCW 09T304:M8345	0.4	235	1.00	0.6	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–

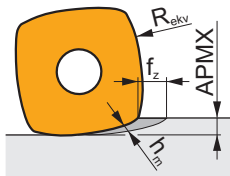


a_e / DCX	5 %	10 %	15 %	20 %	25 %	30 %	40 %	50 %	60 %	70 %	75 %	80 %	90 %	100 %
	1.48	1.35	1.27	1.22	1.19	1.16	1.11	1.08	1.05	1.03	1.00	1.00	1.00	1.00
	2.20	1.60	1.35	1.20	1.10	0.95	0.85	0.75	0.85	0.95	1.00	1.00	1.00	1.00
	0.64	0.64	0.64	0.64	0.64	0.65	0.65	0.67	0.68	0.71	0.72	0.74	0.79	1.00

	ZDCW 09
	0.4
	-



		0.00	0.30	0.40	0.50	0.60	0.70	0.80	0.90	1.00
25		11.6	17.4	18.2	19.0	19.7	20.3	20.9	21.5	22.0
32		18.7	24.5	25.3	26.1	26.8	27.4	28.0	28.6	29.1
40		27.7	33.5	34.3	35.1	35.8	36.4	37.0	37.6	38.1
50		36.7	42.3	43.1	43.8	44.5	45.1	45.7	46.2	46.7
63		49.7	55.3	56.1	56.8	57.5	58.1	58.7	59.2	59.7
		0.00	0.30	0.40	0.50	0.60	0.70	0.80	0.90	1.00
		-	2.00	2.00	2.00	1.75	1.50	1.25	1.13	1.00



$$f_z = h_m \times \sqrt{\frac{2R_{ekv}}{APMX}} \quad (\text{mm/z})$$



Följ de givna instruktionerna för planfräsning. Vid fräsning intill vertikala sidor minskas tandmatningen (f_z) med 50 % för att undvika vibrationer och skador på eggarna.

		f_{max}
25	7.7	0.15
32	7.7	0.17
40	7.7	0.20

	HFC		
	0.3	0.6	1.0
	2.00	1.50	1.00

	HFC		HFC	
	RPMX	APMX/I	RPMX	APMX/I
25	12.0	1.0/6	0.9	1.00/65
32	7.5	1.0/11	0.5	0.75/100
40	3.6	1.0/17	0.4	0.55/100



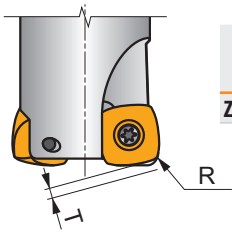
DCX	DMIN	DMAX	SMAX DMIN	SMAX DMAX
25	35.0	50.0	0.45	1.00
32	49.0	64.0	0.45	0.85
40	65.0	80.0	0.50	0.85



DCX	a_p	f_{max}
25	0.15	0.15
32	0.15	0.17
40	0.15	0.20



DCX	μm	3	5	10	15	20	30	40	50	60	80	100	
25		0.548	0.707	1.000	1.225	1.414	1.732	2.000	2.236	2.449	2.828	3.162	
32		0.620	0.800	1.131	1.386	1.600	1.960	2.263	2.530	2.771	3.200	3.578	
40		0.693	0.894	1.265	1.549	1.789	2.191	2.530	2.828	3.098	3.578	4.000	
50													
63													



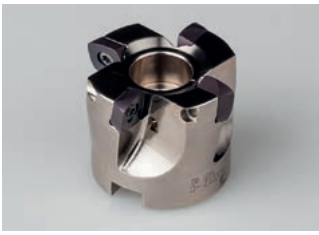
	R	T
ZDCW 09T304	2.27	0.52

SZD12

P **K** **H**

PRAMET

S

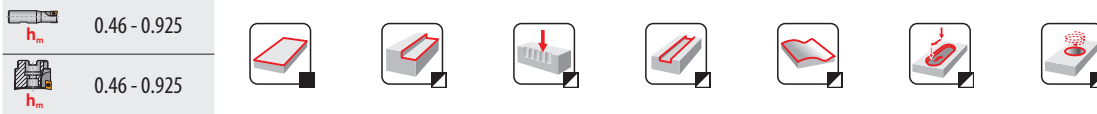
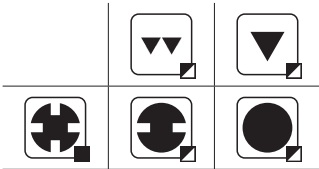
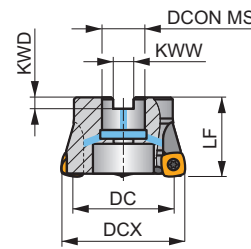
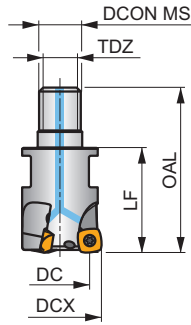
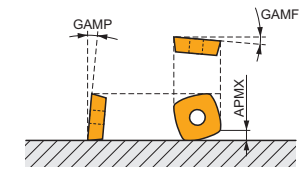


FEED ZD12, högmatningsfräs, invändig kylning

Mycket produktiv högmatningsfräs för enkelsidiga ZD.. 12-skär med APMX 1.6 mm. Invändig kylning. För en mängd olika applikationer. Finns med cyl. skaft, modulärt och för dornmontering. Behandlad för lång livslängd.

FEED ZD

APMX	1.6 mm
------	--------



Product	DCX	DC	OAL	DCON MS	LU	LF	TDZ	KWW	KWD	GAMF	GAMP						
	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(°)	(°)						
32E3R040M16-SZD12-C	32	14.5	63	17	-	40	M16	-	-	-6	10	3	-	✓	0.19	GI192 SQ220 -	
40E4R040M16-SZD12-C	40	22.5	63	17	-	40	M16	-	-	-6	10	4	-	✓	0.22	GI192 SQ220 -	
50A04R-SMOZD12-C	50	32.5	-	22	-	40	-	10.4	6.4	-6	10	4	✓	14000	✓	0.38	GI192 SQ033 -
63A05R-SMOZD12-C	63	45.5	-	22	-	40	-	10.4	6.4	-6	10	5	✓	12500	✓	0.57	GI192 SQ033 -
80A05R-SMOZD12-C	80	62.5	-	27	-	50	-	12	7	-6	10	5	✓	11100	✓	1.07	GI192 C0371 AC001

GI192	ZDEW 1204..

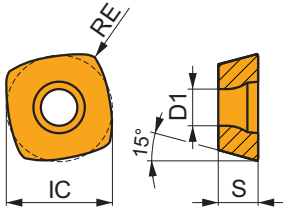
C0371	US 4011-T15P	3.5	M 4	10.6	D-T08P/T15P	FG-15	-	-
SQ033	US 4011-T15P	3.5	M 4	10.6	D-T08P/T15P	FG-15	-	HS 1030C
SQ220	US 4011-T15P	3.5	M 4	10.6	-	-	Flag T15P	-

AC001	KS 1230	K.FMH27

ZDEW 12

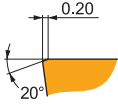
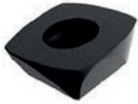


	IC	D1	S
	(mm)	(mm)	(mm)
1204	12.700	4.40	4.76



Lämplighet och startvärden för skärhastighet (vc), matning (f) och skärdjup (ap). Vi refererar till vår Dormer Pramet Calculator-app för vidare beräkningar.

Product	RE (mm)	P			M			K			N			S			H		
		vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)



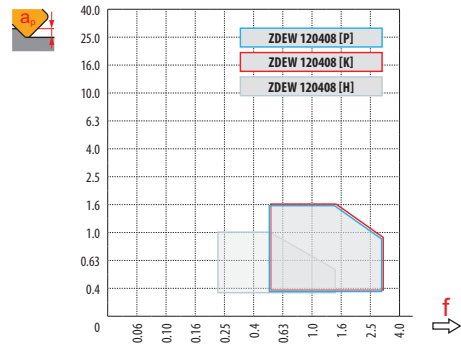
ZDEW speciell design för höghastighetsfräsning.

ZDEW 120408:M8310	0.8	270	1.00	1.0	—	—	—	255	1.00	1.0	—	—	—	—	—	—	—	50	0.70	0.7
ZDEW 120408:M8325	0.8	205	1.00	1.0	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—
ZDEW 120408:M8345	0.8	195	1.00	1.0	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—

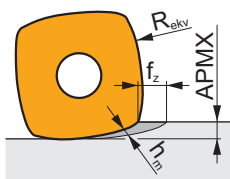


a_e DCX	5 %	10 %	15 %	20 %	25 %	30 %	40 %	50 %	60 %	70 %	75 %	80 %	90 %	100 %
	1.48	1.35	1.27	1.22	1.19	1.16	1.11	1.08	1.05	1.03	1.00	1.00	1.00	1.00
	2.20	1.60	1.35	1.20	1.10	0.95	0.85	0.75	0.85	0.95	1.00	1.00	1.00	1.00
	0.64	0.64	0.64	0.64	0.64	0.65	0.65	0.67	0.68	0.71	0.72	0.74	0.79	1.00

	ZDEW 12
	0.8
	-



		0.00	0.50	0.60	0.70	0.80	0.90	1.00	1.10	1.20	1.30	1.40	1.50	1.60
32		14.5	22.7	23.5	24.2	24.8	25.4	26.0	26.5	27.0	27.5	28.0	28.5	28.9
40		22.5	30.7	31.5	32.2	32.8	33.4	34.0	34.5	35.0	35.5	36.0	36.5	36.9
50		32.5	40.7	41.5	42.2	42.8	43.4	44.0	44.5	45.0	45.5	46.0	46.5	46.9
63		45.5	53.7	54.5	55.2	55.8	56.4	57.0	57.5	58.0	58.5	59.0	59.5	59.9
80		62.5	70.7	71.5	72.2	72.8	73.4	74.0	74.5	75.0	75.5	76.0	76.5	76.9
		0.00	0.50	0.60	0.70	0.80	0.90	1.00	1.10	1.20	1.30	1.40	1.50	1.60
		-	3.00	3.00	3.00	3.00	3.00	3.00	2.50	2.25	2.00	1.80	1.65	1.50



$$f_z = h_m \times \sqrt{\frac{2R_{ekv}}{APMX}} \quad (\text{mm/z})$$



Följ de givna instruktionerna för planfräsning. Vid fräsning intill vertikala sidor minskas tandmatningen (f_z) med 50 % för att undvika vibrationer och skador på eggarna.

	f_{max}	f_{max}
32	10.0	0.15
40	10.0	0.17
50	10.0	0.20
63	10.0	0.20
80	10.0	0.25

	HFC		
	0.5	1.0	1.6
	3.00	2.00	1.50

	RPMX	APMX/l	RPMX	APMX/l
32	10	1.6/11	1.2	1.60/78
40	5.5	1.6/18	0.7	1.10/100
50	3.3	1.6/29	0.5	0.75/100
63	2.2	1.6/43	0.3	0.40/100
80	1.5	1.6/63	0.2	0.20/100



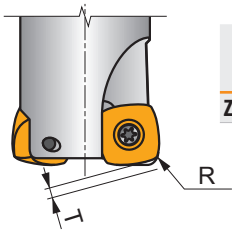
DCX	D _{MIN}	D _{MAX}	S _{MAX} D _{MIN}	S _{MAX} D _{MAX}
32	44.0	64.0	0.75	1.60
40	60.0	80.0	0.75	1.50
50	80.0	100.0	0.80	1.35
63	106.0	126.0	0.70	1.00
80	140.0	160.0	0.65	0.85



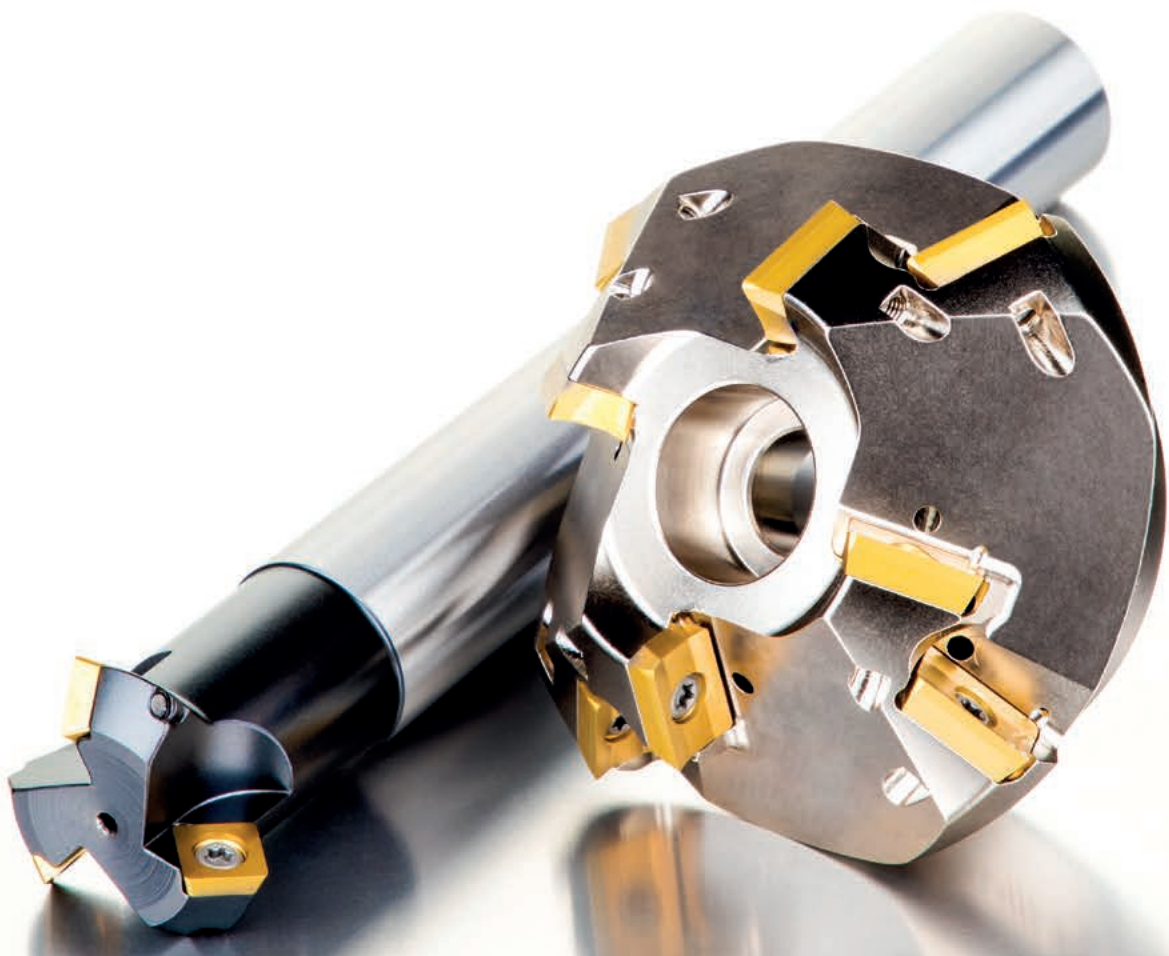
DCX	a_p	f_{max}
32	0.25	0.15
40	0.25	0.17
50	0.25	0.20
63	0.25	0.20
80	0.25	0.25



DCX	μm	3	5	10	15	20	30	40	50	60	80	100
32		0.620	0.800	1.131	1.386	1.600	1.960	2.263	2.530	2.771	3.200	3.578
40		0.693	0.894	1.265	1.549	1.789	2.191	2.530	2.828	3.098	3.578	4.000
50		0.775	1.000	1.414	1.732	2.000	2.449	2.828	3.162	3.464	4.000	4.472
63		0.869	1.122	1.587	1.944	2.245	2.750	3.175	3.550	3.888	4.490	5.020
80		0.980	1.265	1.789	2.191	2.530	3.098	3.578	4.000	4.382	5.060	5.657


















	R	T
ZDEW 120408	3.52	0.64



FASNING

INDEXABLE FACE MILLS – NAVIGATOR

	SSD09		N-SSO09		STC		2516		2636		J(T)-SXP16		
	45°		45°		45°		45°		10°–80°		15°–75°		
	APMX (mm)	4.5	APMX (mm)	4.5	APMX (mm)	8.0	APMX (mm)	8.5	APMX (mm)	8.5	APMX (mm)	7.0–28.0	
	DC (mm)	10–25	DC (mm)	8–25	DC (mm)	20	DC (mm)	11–19	DC (mm)	5–23	DC (mm)	35–45	
	 DC = 16, 25 (mm)												
	 DC = 10–25 (mm)												
	 DC = 16, 25 (mm)												
													
	📖 292		📖 295		📖 298		📖 301		📖 304		📖 307		
	P	M	K	S	H	P	M	K	S	P	M	K	N
													
	SDE. 0903		SOMT 09T3		TCTX 16 STC		TCMT 16T3		TCMT 16T3		XPHT 1604		
	4		4		3		3		3		2		
	■		■		■		■		■		■		

SSD09

P **M** **K** **S** **H**

PRAMET

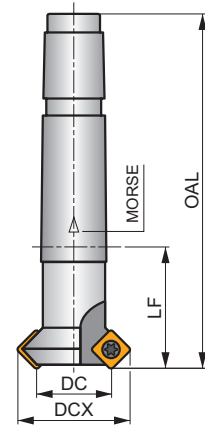
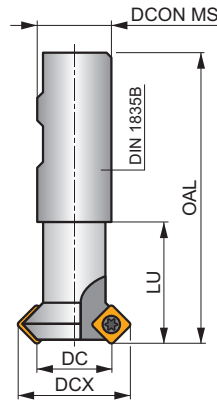
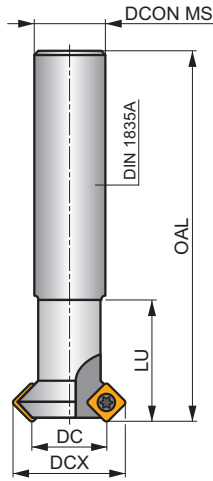
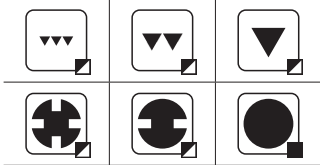
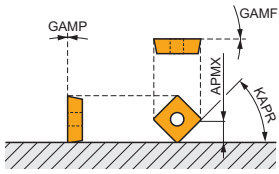
S



45° fasfräs för SD.. 09-skär

45° fasfräs för enkelsidiga SD.. 09-skär med APMX 4.5 mm. Passar för fram- och bakfasning. Finns med cyl. skaft, Weldonskaft och morsekonfäste. Behandlad för lång livslängd.

KAPR	45°
APMX	4.5 mm



h_m 0.095 - 0.15



Product	DC (mm)	DCX (mm)	OAL (mm)	DCON MS (mm)	LU (mm)	LF (mm)	CZC MS	GAMF (°)	GAMP (°)							
16N2R027A16-SSD09	16	28	200	16	27	-	-	0	0	2	-	32200	-	0.34	GI129	C0070
25N3R042A25-SSD09	25	37	200	25	42	-	-	0	0	3	-	25800	-	0.77	GI129	CH011
10N1R027B16-SSD09-A	10	22	75	16	27	-	-	0	0	1	-	40700	-	0.13	GI129	C0070
16N2R027B16-SSD09-A	16	28	75	16	27	-	-	0	0	2	-	32200	-	0.14	GI129	C0070
25N3R042B25-SSD09-A	25	37	98	25	42	-	-	0	0	3	-	25800	-	0.37	GI129	CH011
16N2R030E02-SSD09-A	16	28	94	-	-	30	2	0	0	2	-	32200	-	0.14	GI129	C0070
25N3R043E03-SSD09-A	25	37	124	-	-	43	3	0	0	3	-	25800	-	0.38	GI129	CH011

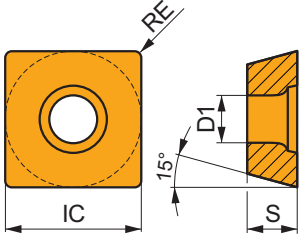
GI129	SDEW 0903..	SDEX 0903..

C0070	US 3507-T15	3.0	M 3.5	7	Flag T15
CH011	US 3509-T15	3.0	M 3.5	9	Flag T15

SDEW 09



	IC (mm)	D1 (mm)	S (mm)
0903	9.525	4.40	3.18



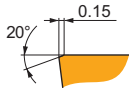
Lämplighet och startvärden för skärhastighet (vc), matning (f) och skärdjup (ap). Vi refererar till vår Dormer Pramet Calculator-app för vidare beräkningar.

Product	RE (mm)	P			M			K			N			S			H		
		vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)



EN geometri med neutral spånvinkel för 45° fasfräsning.

SDEW 090308EN:M8330	0.8	235	0.10	4.5	–	–	–	220	0.10	4.5	–	–	–	–	–	–	–	45	0.09	0.7
SDEW 090308EN:M8340	0.8	210	0.10	4.5	–	–	–	195	0.10	4.5	–	–	–	–	–	–	–	–	–	–



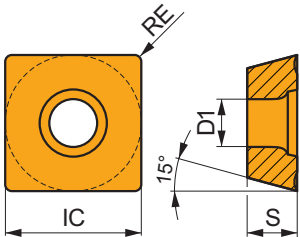
SN geometri med neutral spånvinkel för 45° fasfräsning.

SDEW 090308SN:M8330	0.8	215	0.15	4.5	–	–	–	200	0.15	4.5	–	–	–	–	–	–	–	40	0.11	0.7
SDEW 090308SN:M8340	0.8	195	0.15	4.5	–	–	–	185	0.15	4.5	–	–	–	–	–	–	–	–	–	–

SDEX 09

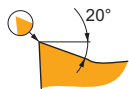


	IC (mm)	D1 (mm)	S (mm)
0903	9.525	4.40	3.18



Lämplighet och startvärden för skärhastighet (vc), matning (f) och skärdjup (ap). Vi refererar till vår Dormer Pramet Calculator-app för vidare beräkningar.

Product	RE (mm)	P			M			K			N			S			H		
		vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)

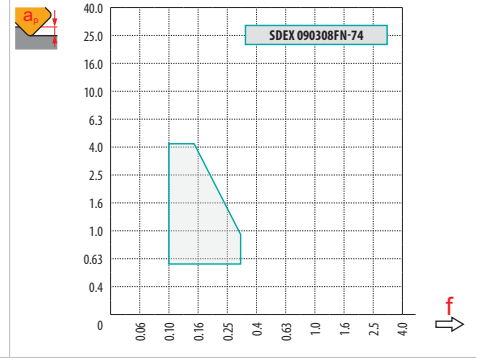
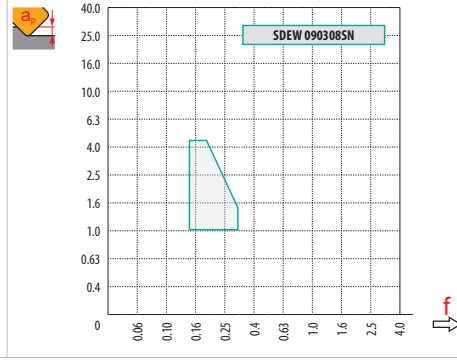
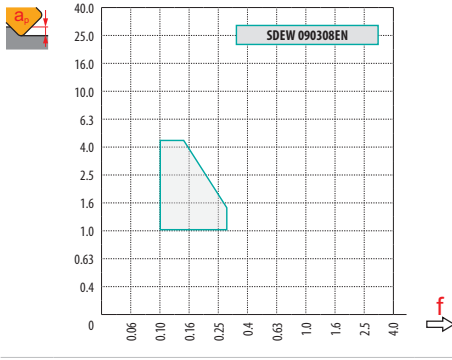


74 geometri med positiv design för 45° fasfräsning.

SDEX 090308FN-74:M8330	0.8	305	0.12	4.5	180	0.11	4.5	285	0.12	4.5	–	–	–	75	0.11	3.6	–	–	–
------------------------	-----	-----	------	-----	-----	------	-----	-----	------	-----	---	---	---	----	------	-----	---	---	---



	SDEW 09 EN	SDEW 09 SN	SDEX 09-74
	0.8	0.8	0.8
	-	-	-



DC	DCX	X.V	f _{min}	f _{max}
10	22	1.09	0.20	0.30
16	28	1.17	0.25	0.34
25	37	1.24	0.32	0.39



a _e / DC	0.10	0.15	0.20	0.25	0.30	0.35	0.40	0.50 – 1.00																
45°	0.42	0.54	0.67	0.35	0.44	0.55	0.30	0.38	0.47	0.27	0.34	0.42	0.25	0.31	0.39	0.23	0.29	0.36	0.21	0.27	0.34	0.19	0.24	0.30
X.V	1.35		1.27		1.22		1.19		1.16		1.13		1.11		1.00									

N-SS09

P M K S

PRAMET

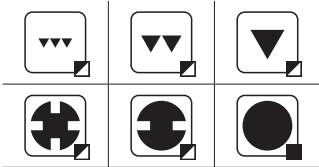
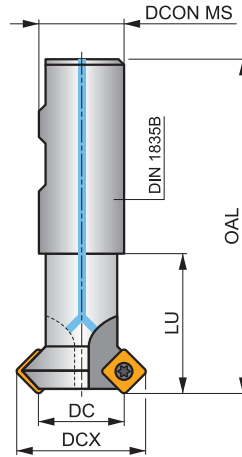
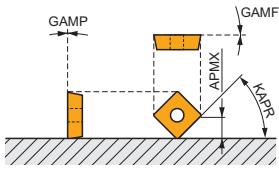
S



45° fasfräs för SOMT 09-skär, med invändig kylning

45° fasfräs för enkelsidiga SOMT 09-skär med APMX 4.5 mm. Invändig kylning. Passar för fram- och bakfasning. Finns med Weldonskaft. Behandlad för lång livslängd.

KAPR	45°
APMX	4.5 mm



h_m 0.095 - 0.18



Product	DC	DCX	OAL	DCON MS	LU	GAMF	GAMP							
	(mm)	(mm)	(mm)	(mm)	(mm)	(°)	(°)							
16N2R027B16-SS009-C	16	28.8	110	16	27	0	0	2	-	26600	✓	0.23	G1146	SQ500
25N3R042B25-SS009-C	25	37.8	125	25	42	0	0	3	-	21300	✓	0.49	G1146	SQ500
8N1R027B16-SS009-C	8	20.5	90	16	27	0	0	1	-	37700	✓	0.16	G1146	SQ500

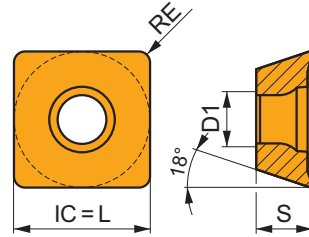
G1146	SOMT 09T3..

SQ500	US 3006-T09P	2.0	M3	6	Flag T09P

SOMT 09

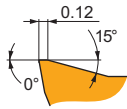
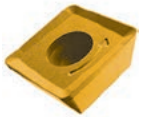


	IC	D1	L	S
	(mm)	(mm)	(mm)	(mm)
09T3	9.550	3.50	9.55	3.97



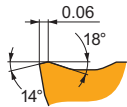
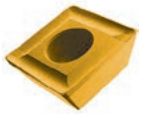
Lämplighet och startvärden för skärhastighet (vc), matning (f) och skärdjup (ap). Värden gäller för angreppsvinkel 90°. Refererar till vår Dormer Pramet Calculator-app för vidare beräkningar.

Product	RE (mm)	P			M			K			N			S			H		
		vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)



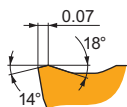
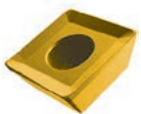
M geometri med positiv design för medelgrov fräsning.

SOMT 09T308-M:8215	● 0.8	■ 275	■ 0.14	■ 2.5	■ 165	■ 0.13	■ 2.5	■ 260	■ 0.14	■ 2.5	■ -	■ -	■ -	■ 65	■ 0.13	■ 2.0	■ -	■ -	■ -
SOMT 09T308-M:M5315	● 0.8	■ 390	■ 0.14	■ 2.5	■ -	■ -	■ -	■ 370	■ 0.14	■ 2.5	■ -	■ -	■ -	■ -	■ -	■ -	■ -	■ -	■ -
SOMT 09T308-M:M8330	● 0.8	■ 270	■ 0.14	■ 2.5	■ 160	■ 0.13	■ 2.5	■ 255	■ 0.14	■ 2.5	■ -	■ -	■ -	■ 65	■ 0.13	■ 2.0	■ -	■ -	■ -
SOMT 09T308-M:M8340	● 0.8	■ 250	■ 0.14	■ 2.5	■ 150	■ 0.13	■ 2.5	■ 235	■ 0.14	■ 2.5	■ -	■ -	■ -	■ 60	■ 0.13	■ 2.0	■ -	■ -	■ -
SOMT 09T308-M:M9315	● 0.8	■ 380	■ 0.14	■ 2.5	■ -	■ -	■ -	■ 360	■ 0.14	■ 2.5	■ -	■ -	■ -	■ -	■ -	■ -	■ -	■ -	■ -



MI geometri med stabilt positiv design för medelfin fräsning.

SOMT 09T304-MI:8215	● 0.4	■ 230	■ 0.14	■ 2.5	■ 135	■ 0.13	■ 2.5	■ 215	■ 0.14	■ 2.5	■ -	■ -	■ -	■ 55	■ 0.10	■ 2.0	■ -	■ -	■ -
SOMT 09T304-MI:M8310	● 0.4	■ 255	■ 0.14	■ 2.5	■ 130	■ 0.13	■ 2.5	■ 240	■ 0.14	■ 2.5	■ -	■ -	■ -	■ -	■ -	■ -	■ -	■ -	■ -
SOMT 09T304-MI:M8330	● 0.4	■ 230	■ 0.14	■ 2.5	■ 135	■ 0.13	■ 2.5	■ 215	■ 0.14	■ 2.5	■ -	■ -	■ -	■ 55	■ 0.10	■ 2.0	■ -	■ -	■ -
SOMT 09T304-MI:M8340	● 0.4	■ 210	■ 0.14	■ 2.5	■ 125	■ 0.13	■ 2.5	■ 195	■ 0.14	■ 2.5	■ -	■ -	■ -	■ 50	■ 0.10	■ 2.0	■ -	■ -	■ -
SOMT 09T304-MI:M9315	● 0.4	■ 320	■ 0.14	■ 2.5	■ -	■ -	■ -	■ 300	■ 0.14	■ 2.5	■ -	■ -	■ -	■ -	■ -	■ -	■ -	■ -	■ -
SOMT 09T304-MI:M9340	● 0.4	■ 265	■ 0.14	■ 2.5	■ 155	■ 0.13	■ 2.5	■ -	■ -	■ -	■ -	■ -	■ -	■ 65	■ 0.10	■ 2.0	■ -	■ -	■ -

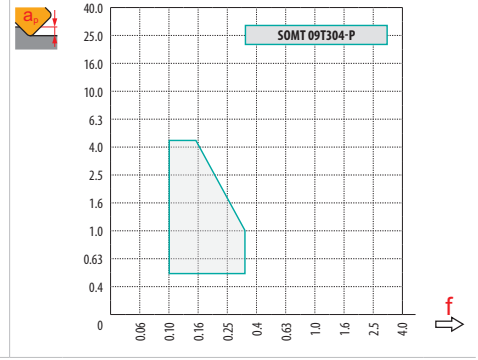
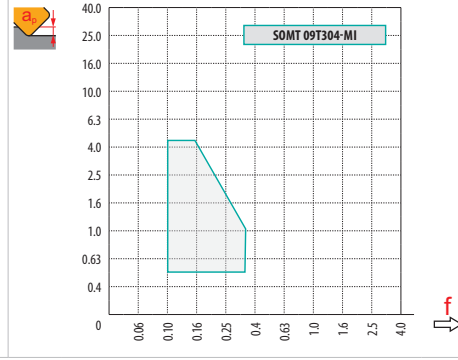
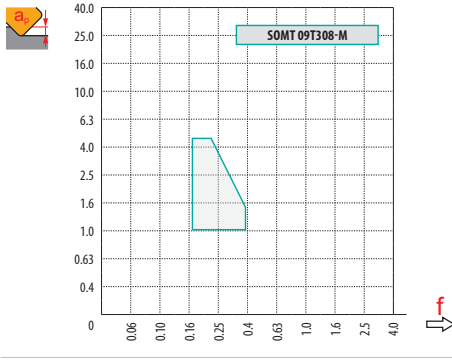


P geometri med mycket positiv design för medelfin fräsning.

SOMT 09T304-P:M8330	● 0.4	■ 250	■ 0.14	■ 2.5	■ 150	■ 0.13	■ 2.5	■ 235	■ 0.14	■ 2.5	■ -	■ -	■ -	■ 60	■ 0.10	■ 2.0	■ -	■ -	■ -
SOMT 09T304-P:M8340	● 0.4	■ 230	■ 0.14	■ 2.5	■ 135	■ 0.13	■ 2.5	■ 215	■ 0.14	■ 2.5	■ -	■ -	■ -	■ 55	■ 0.10	■ 2.0	■ -	■ -	■ -
SOMT 09T304-P:M9325	● 0.4	■ 320	■ 0.14	■ 2.5	■ -	■ -	■ -	■ 300	■ 0.14	■ 2.5	■ -	■ -	■ -	■ -	■ -	■ -	■ -	■ -	■ -



	SOMT 09-M	SOMT 09-MI	SOMT 09-P
	0.8	0.4	0.4
	-	-	-



			f_{min}	f_{max}
8	20.5	1.06	0.18	0.29
16	28.8	1.17	0.25	0.34
25	37.8	1.24	0.32	0.39



a_e / DC	0.10		0.15		0.20		0.25		0.30		0.35		0.40		0.50 – 1.00									
	f																							
45°	0.42	0.63	0.80	0.35	0.51	0.66	0.30	0.44	0.57	0.27	0.40	0.51	0.25	0.36	0.46	0.23	0.33	0.43	0.21	0.31	0.40	0.19	0.28	0.36
	1.35		1.27		1.22		1.19		1.16		1.13		1.11		1.00									

STC

P
M
K
N

PRAMET

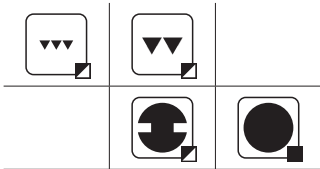
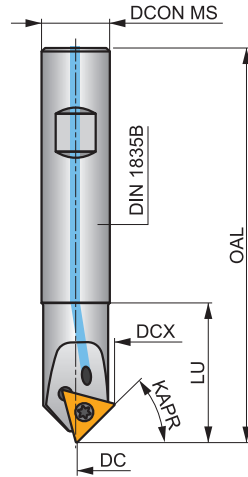
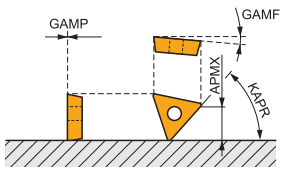
S



45° avfasnings- och graveringsfräs för TC.T 16-skär med Invändig kylning

En 45° avfasnings- och graveringsfräs för enkelsidiga TC.T 16-skär med APMX 8,5 mm. Invändig kylning. Passar för fram- och bakfasning. Finns med Weldonskraft. Behandlad för lång livslängd.

KAPR	45°
------	-----



Product	DCX (mm)	DC (mm)	OAL (mm)	DCON MS (mm)	LU (mm)					
20N1R040B20-STC-000887	22.8	1.1	114	20	40	1	✓	0.26	GI223	SQ222

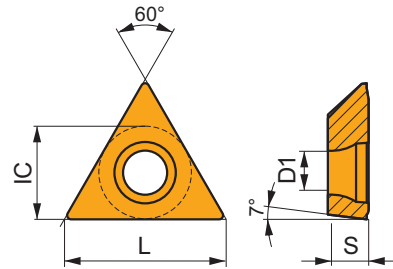
	GI223		TC.T 16 STC
--	-------	--	-------------

SQ222	US 2002-T15P	3.0	4	8.5	Flag T15P

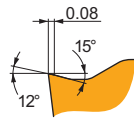
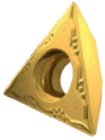
TCXT 16 STC



	IC	D1	L	S
	(mm)	(mm)	(mm)	(mm)
16	9.525	4.60	16.50	3.97

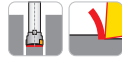


Product	Intermittent/ Continuous cut	RE (mm)	P			M			K			N			S			H		
			vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)



328 spånbrytare är vass och förstahandsvalet för finbearbetning av stål. Den har en något positiv spånvinkel utan T-land. Den är också lämplig för gjutjärn.

TCMT 16-001328:M8330	–	0.4	■	150	0.13	8.5	■	90	0.12	8.5	■	140	0.13	8.5	■	–	–	–	■	–	–	–	■	–	–	–
-----------------------------	---	-----	---	-----	------	-----	---	----	------	-----	---	-----	------	-----	---	---	---	---	---	---	---	---	---	---	---	---

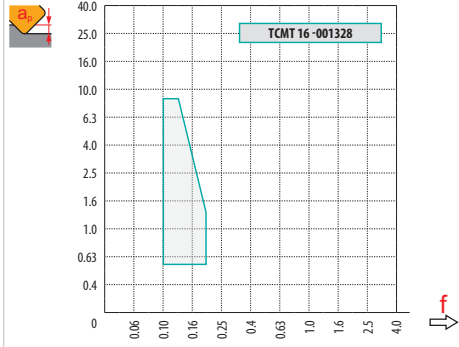
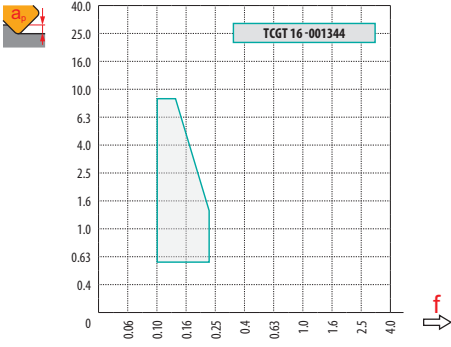


344 spånbrytare är vass och förstahandsvalet för allroundbearbetning av icke-järnhaltiga legeringar. Den har en mycket positiv spånvinkel utan skärfas. Den är också lämpligt för superlegeringar.

TCGT 16-001344:HF7	–	0.4	■	–	–	–	■	–	–	–	■	225	0.10	8.5	■	–	–	–	■	–	–	–	■	–	–	–
---------------------------	---	-----	---	---	---	---	---	---	---	---	---	-----	------	-----	---	---	---	---	---	---	---	---	---	---	---	---



	TCGT 16-001344	TCMT 16-001328
	0.4	0.4
	-	-



			f_{min}	f_{max}
1.1	22.8	1.1	0.1	.018

2516

P **M** **K** **N**

PRAMET

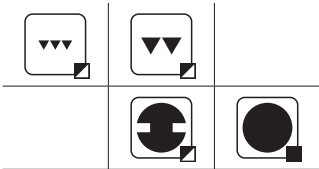
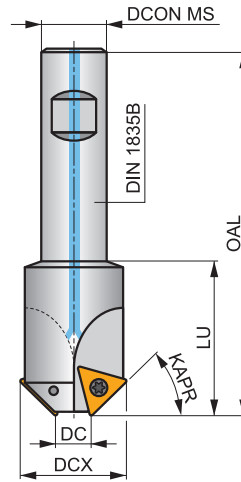
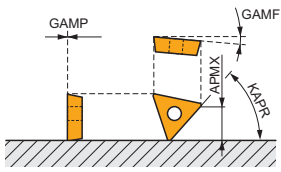
S



45° fasfräs för TCMT 16-skär, med invändig kylning

45° fasfräs för enkelsidiga TCMT 16-skär med APMX 8.5 mm. Invändig kylning. Passar för fram- och bakfasning. Finns med Weldonskaft. Behandlad för lång livslängd.

KAPR	45°
APMX	8.5 mm



h_m 0.065 - 0.095

Product	DCX	DC	OAL	DCON MS	LU							
	(mm)	(mm)	(mm)	(mm)	(mm)					kg		
2516-45-11	31	11	100	16	30	2	-	18100	✓	0.20	G155	SQ220
2516-45-19	39	19	100	20	30	2	-	16200	✓	0.31	G155	SQ220

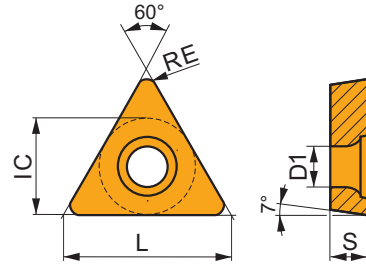
G155 TCMT 16T308E-FM:T8..

SQ220	US 4011-T15P	3.5	M 4	10.6	Flag T15P

TCMT

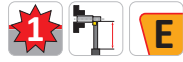
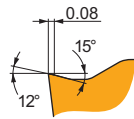
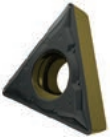


	IC (mm)	D1 (mm)	L (mm)	S (mm)
16T3	9.525	4.40	16.50	3.97



Lämplighet och startvärden för skärhastighet (vc), matning (f) och skärdjup (ap). Vi refererar till vår Dormer Pramet Calculator-app för vidare beräkningar.

Product	RE (mm)	P			M			K			N			S			H		
		vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)

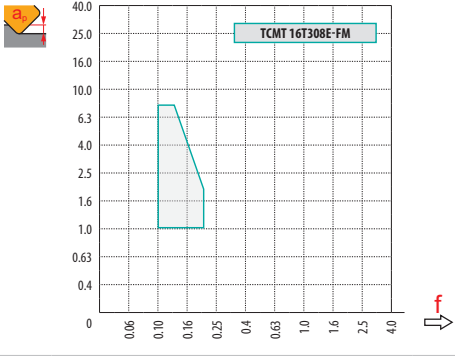


FM spånbrytare är mångsidig och förstahandsvalet för efterbearbetning av stål. Den har positiv spånvinkel och positiv, smal skyddsfas. Den är också lämplig för rostfritt stål och med vissa förbehåll för gjutjärn och icke-järnhaltiga legeringar.

TCMT 16T308E-FM:T8315	● 0.8	✓ 170	0.17	1.7	■ 100	0.15	1.7	✗ 160	0.17	1.7	✓ 510	0.20	1.7	—	—	—	—	—	—
TCMT 16T308E-FM:T8415	● 0.8	■ 210	0.17	1.7	■ 110	0.15	1.7	✗ 190	0.17	1.7	✓ 525	0.20	1.7	—	—	—	—	—	—
TCMT 16T308E-FM:T8430	● 0.8	■ 185	0.17	1.7	■ 100	0.15	1.7	✗ 150	0.17	1.7	✓ 510	0.20	1.7	—	—	—	—	—	—



	TCMT 16-FM
	0.8
	-



			f_{min}	f_{max}
11.0	31.0	1.02	0.10	0.18
19.0	39.0	1.10	0.14	0.20

2636



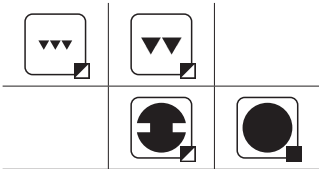
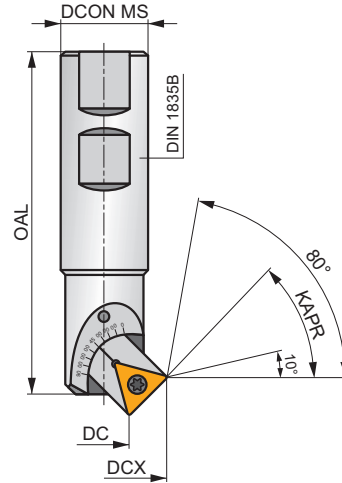
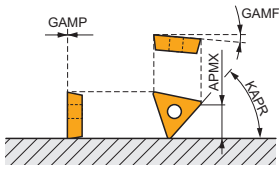
PRAMET



Justerbar skaffräis för TCMT 16-skär

Justerbar fasräis för enkelsidiga TCMT 16-skär med APMX 8.5 mm. Justerbar mellan 10° och 80°. Finns endast med Weldonskaft. Behandlad för lång livslängd.

KAPR	10° – 80°
APMX	8.5 mm



h_m 0.03 – 0.08



Product	DCN (mm)	DCX (mm)	OAL (mm)	DCON MS (mm)	KAPR (°)	GAMF (°)	GAMP (°)					kg		
2636-05-25	5.0	31.0			10									
	5.5	31.0			15									
	7.0	29.5			30									
	11.0	29.5	100	25	45	-8	0	1	-	18100	-	0.35	GI294	CH040
	16.0	28.5			60									
	21.0	26.5			75									
	23.0	26.0			80									

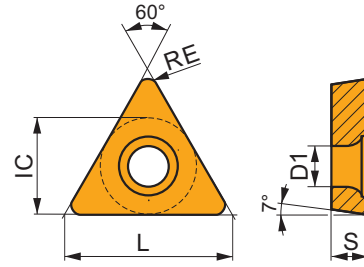
GI294	TCMT 16T304E-FM:T8...	TCMT 16T308E-FM:T8...

CH040	USI 0614	CA 2669	US 4011-T15P	3.5	M 4	10.6	Flag T15

TCMT

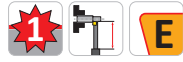
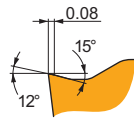


	IC (mm)	D1 (mm)	L (mm)	S (mm)
16T3	9.525	4.40	16.50	3.97



Lämplighet och startvärden för skärhastighet (vc), matning (f) och skärdjup (ap). Vi refererar till vår Dormer Pramet Calculator-app för vidare beräkningar.

Produkt	RE (mm)	P			M			K			N			S			H		
		vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)	vc (m/min)	f (mm/rev)	ap (mm)

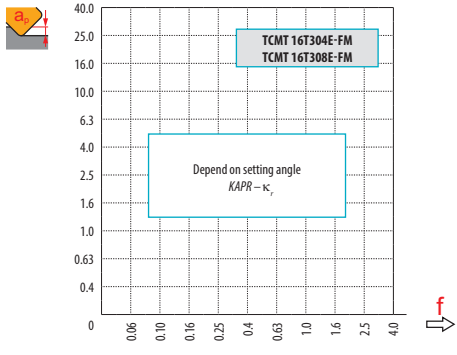


FM spånbrytare är mångsidig och förstahandsvalet för efterbearbetning av stål. Den har positiv spånvinkel och positiv, smal skyddsfas. Den är också lämplig för rostfritt stål och med vissa förbehåll för gjutjärn och icke-järnhaltiga legeringar.

TCMT 16T304E-FM:T8315	● 0.4	✓ 155	0.12	1.7	■ 90	0.11	1.7	✗ 145	0.12	1.7	✗ 465	0.14	1.7	–	–	–	–	–	–
TCMT 16T304E-FM:T8415	● 0.4	■ 190	0.12	1.7	■ 100	0.11	1.7	✗ 170	0.12	1.7	✗ 480	0.14	1.7	–	–	–	–	–	–
TCMT 16T304E-FM:T8430	● 0.4	■ 180	0.12	1.7	■ 95	0.11	1.7	✗ 145	0.12	1.7	✗ 495	0.14	1.7	–	–	–	–	–	–
TCMT 16T308E-FM:T8315	● 0.8	✓ 170	0.17	1.7	■ 100	0.15	1.7	✗ 160	0.17	1.7	✗ 510	0.20	1.7	–	–	–	–	–	–
TCMT 16T308E-FM:T8415	● 0.8	■ 210	0.17	1.7	■ 110	0.15	1.7	✗ 190	0.17	1.7	✗ 525	0.20	1.7	–	–	–	–	–	–
TCMT 16T308E-FM:T8430	● 0.8	■ 185	0.17	1.7	■ 100	0.15	1.7	✗ 150	0.17	1.7	✗ 510	0.20	1.7	–	–	–	–	–	–



TCMT 16-FM		
	0.8	0.4
	-	-



10°	2.6	5.0	31.0	1.38	0.24	0.59
15°	3.9	5.5	31.0	1.30	0.17	0.40
30°	7.6	7.0	29.5	1.18	0.10	0.20
45°	10.7	11.0	29.5	1.13	0.09	0.14
60°	13.2	16.0	28.5	1.09	0.09	0.11
75°	14.7	21.0	26.5	1.06	0.09	0.10
80°	15.0	23.0	26.0	1.06	0.09	0.10



a_p / DC	0.10	0.15	0.20	0.25	0.30	0.35	0.40	0.50 - 1.00																
10°	0.55	0.91	1.46	0.45	0.74	1.19	0.39	0.64	1.03	0.35	0.58	0.92	0.32	0.53	0.84	0.29	0.49	0.78	0.27	0.46	0.73	0.24	0.41	0.65
15°	0.37	0.61	0.98	0.30	0.50	0.80	0.26	0.43	0.69	0.23	0.39	0.62	0.21	0.35	0.56	0.20	0.33	0.52	0.18	0.31	0.49	0.16	0.27	0.44
30°	0.19	0.32	0.51	0.15	0.26	0.41	0.13	0.22	0.36	0.12	0.20	0.32	0.11	0.18	0.29	0.10	0.17	0.27	0.09	0.16	0.25	0.08	0.14	0.23
45°	0.13	0.22	0.36	0.11	0.18	0.29	0.09	0.16	0.25	0.08	0.14	0.23	0.08	0.13	0.21	0.07	0.12	0.19	0.07	0.11	0.18	0.06	0.10	0.16
60°	0.11	0.18	0.29	0.09	0.15	0.24	0.08	0.13	0.21	0.07	0.12	0.18	0.06	0.11	0.17	0.06	0.10	0.16	0.05	0.09	0.15	0.05	0.08	0.13
75°	0.10	0.16	0.26	0.08	0.13	0.21	0.07	0.12	0.19	0.06	0.10	0.17	0.06	0.09	0.15	0.05	0.09	0.14	0.05	0.08	0.13	0.04	0.07	0.12
80°	0.10	0.16	0.26	0.08	0.13	0.21	0.07	0.11	0.18	0.06	0.10	0.16	0.06	0.09	0.15	0.05	0.09	0.14	0.05	0.08	0.13	0.04	0.07	0.11
	1.35		1.27		1.22		1.19		1.16		1.13		1.11		1.00									

J(T)-SXP16



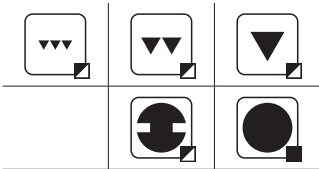
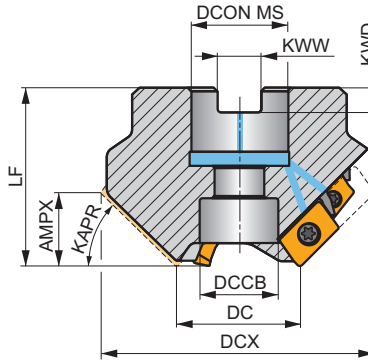
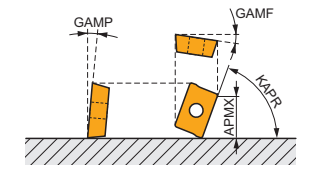
PRAMET



Fasfräs med lång skärlängd för XPHT16-skär, invändig kylning

Fasfräs för enkelsidiga XPHT 16-skär med APMX från 7 till 28 mm. Invändig kylning. Finns endast för dormmontering. Fasvinklar 15°, 25°, 30°, 35°, 40°, 45°, 50°, 55°, 60° och 75°. Behandlad för lång livslängd.

KAPR	15° - 75°
APMX	7.0 - 28.0 mm



0.05 - 0.11



Product	DC	DCX	LF	DCON MS	DCCB	KAPR	KWW	KWD	APMX	GAMF	GAMP	NOF							
	(mm)	(mm)	(mm)	(mm)	(mm)	(°)	(mm)	(mm)	(mm)	(°)	(°)						kg		
35T03R-S15XP1607-C	35	90.6	50	27	22	15	12.4	7	7.00	-6	-1	3	6	-	15200	✓	1.32	GI208	CH050
35T03R-S25XP1612-C	35	87.3	50	27	22	25	12.4	7	12.00	-6	0	3	6	-	15200	✓	1.15	GI208	CH050
35T03R-S30XP1614-C	35	85.1	50	27	22	30	12.4	7	14.00	-6	0	3	6	-	15200	✓	1.11	GI208	CH050
35T03R-S35XP1616-C	35	82.4	50	27	22	35	12.4	7	16.00	-6	0	3	6	-	15200	✓	1.04	GI208	CH050
35T03R-S40XP1618-C	35	79.4	50	27	22	40	12.4	7	18.00	-6	1	3	6	-	15200	✓	0.96	GI208	CH050
35T03R-S45XP1620-C	35	76.1	50	27	22	45	12.4	7	20.00	-6	2	3	6	-	15200	✓	0.90	GI208	CH050
35T03R-S50XP1622-C	35	72.4	50	27	22	50	12.4	7	22.00	-6	2	3	6	-	15200	✓	0.83	GI208	CH050
35T03R-S55XP1623-C	35	68.4	50	27	22	55	12.4	7	23.00	-6	2	3	6	-	15200	✓	0.72	GI208	CH050
35T03R-S60XP1625-C	35	64.2	50	27	22	60	12.4	7	25.00	-5	4	3	6	-	15200	✓	0.63	GI208	CH050
45T03R-S75XP1628-C	45	60.1	50	27	22	75	12.4	7	28.00	-5	5	3	6	-	13400	✓	0.64	GI208	CH050
45T04R-S25XP1612-C	45	97.3	50	27	22	25	12.4	7	12.00	-6	0	4	8	✓	13400	✓	1.24	GI208	CH050
45T04R-S30XP1614-C	45	95.1	50	27	22	30	12.4	7	14.00	-6	0	4	8	✓	13400	✓	1.21	GI208	CH050
45T04R-S35XP1616-C	45	92.4	50	27	22	35	12.4	7	16.00	-6	2	4	8	✓	13400	✓	1.30	GI208	CH050
45T04R-S40XP1618-C	45	89.5	50	27	22	40	12.4	7	18.00	-6	2	4	8	✓	13400	✓	1.08	GI208	CH050
45T04R-S45XP1620-C	45	86.1	50	27	22	45	12.4	7	20.00	-6	2	4	8	✓	13400	✓	1.03	GI208	CH050
45T04R-S50XP1622-C	45	82.4	50	27	22	50	12.4	7	22.00	-6	2	4	8	✓	13400	✓	0.96	GI208	CH050
45T04R-S55XP1623-C	45	78.4	50	27	22	55	12.4	7	23.00	-6	2	4	8	✓	13400	✓	0.88	GI208	CH050
45T04R-S60XP1625-C	45	74.2	50	27	22	60	12.4	7	25.00	-5	4	4	8	✓	13400	✓	0.78	GI208	CH050

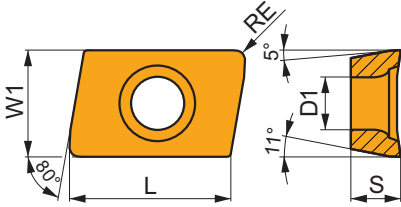
	GI208		XPHT 1604..
--	-------	--	-------------

	CH050		US 3509-T15		3.0		M 3.5		9		D-T07/T15		FG-15		HS 1230C
--	-------	--	-------------	--	-----	--	-------	--	---	--	-----------	--	-------	--	----------

XPHT 16-FA

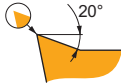
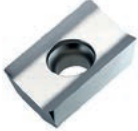


	W1	D1	L	S
	(mm)	(mm)	(mm)	(mm)
1604	9.525	4.40	15.88	4.76



Lämplighet och startvärden för skärhastighet (vc), matning (f) och skärdjup (ap). Vi refererar till vår Dormer Pramet Calculator-app för vidare beräkningar.

Product	RE (mm)	P			M			K			N			S			H		
		vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)



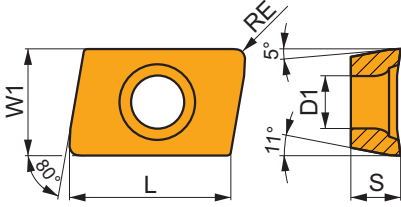
FA geometri med mycket positiv design för fasfräsning.

XPHT 160408F-FA:HF7	● 0.8	-	-	-	-	-	-	-	-	-	■ 255	0.12	15.0	-	-	-	-	-	-
----------------------------	-------	---	---	---	---	---	---	---	---	---	-------	------	------	---	---	---	---	---	---

XPHT 16

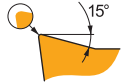


	W1	D1	L	S
	(mm)	(mm)	(mm)	(mm)
1604	9.525	4.40	15.88	4.76



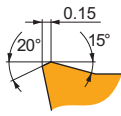
Lämplighet och startvärden för skärhastighet (vc), matning (f) och skärdjup (ap). Vi refererar till vår Dormer Pramet Calculator-app för vidare beräkningar.

Product	RE (mm)	P			M			K			N			S			H		
		vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)



E geometri med mycket positiv design för fasfräsning.

XPHT 160412E:8215	● 1.2	■ 225	0.10	15.0	■ 135	0.09	15.0	■ 210	0.10	15.0	-	-	-	-	-	-	-	-	-
XPHT 160412E:M6330	● 1.2	■ 190	0.10	15.0	■ 135	0.09	15.0	-	-	-	-	-	-	-	-	-	-	-	-
XPHT 160412E:M8330	● 1.2	■ 220	0.10	15.0	■ 130	0.09	15.0	■ 205	0.10	15.0	-	-	-	-	-	-	-	-	-
XPHT 160412E:M8340	● 1.2	■ 195	0.10	15.0	■ 115	0.09	15.0	■ 185	0.10	15.0	-	-	-	-	-	-	-	-	-

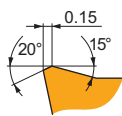


S geometri med vass positiv design för fasfräsning.

XPHT 160412S:8215	● 1.2	■ 210	0.12	15.0	■ 125	0.11	15.0	■ 195	0.12	15.0	-	-	-	-	-	-	-	-	-
XPHT 160412S:M8330	● 1.2	■ 210	0.12	15.0	■ 125	0.11	15.0	■ 195	0.12	15.0	-	-	-	-	-	-	-	-	-
XPHT 160412S:M8340	● 1.2	■ 190	0.12	15.0	■ 110	0.11	15.0	■ 180	0.12	15.0	-	-	-	-	-	-	-	-	-

Lämplighet och startvärden för skärhastighet (vc), matning (f) och skärdjup (ap). Vi refererar till vår Dormer Pramet Calculator-app för vidare beräkningar.

Product	RE (mm)	P			M			K			N			S			H		
		vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)

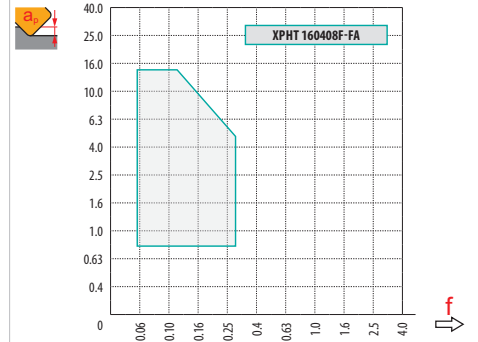
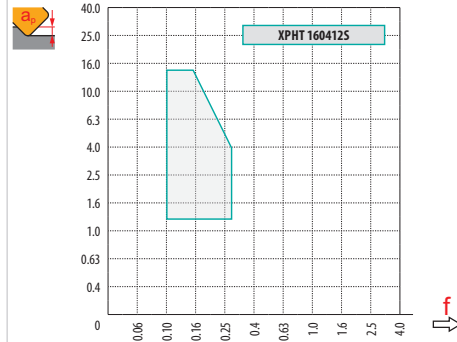
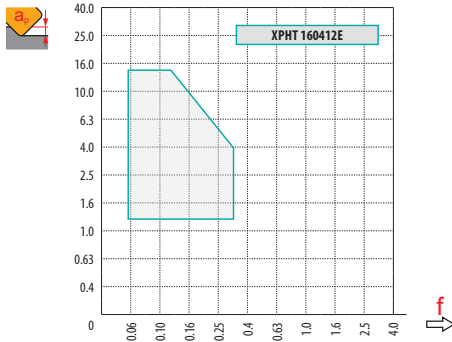


S geometri med vass positiv design för fasfräsning.

XPHT 160412S:M9325	1.2	270	0.12	15.0	–	–	–	255	0.12	15.0	–	–	–	–	–	–	–	–
XPHT 160412S:M9340	1.2	245	0.12	15.0	145	0.11	15.0	–	–	–	–	–	–	–	–	–	–	–



	XPHT 16 E	XPHT 16 S	XPHT 16-FA
	1.2	1.2	0.8
	-	-	-



a_e / DC	0.10	0.15	0.20	0.25	0.30	0.35	0.40	0.50 - 1.00																
	f																							
15°	0.61	0.98	1.34	0.50	0.80	1.10	0.43	0.69	0.95	0.39	0.62	0.85	0.35	0.56	0.78	0.33	0.52	0.72	0.31	0.49	0.67	0.27	0.44	0.60
25°	0.37	0.60	0.82	0.31	0.49	0.67	0.26	0.42	0.58	0.24	0.38	0.52	0.22	0.35	0.48	0.20	0.32	0.44	0.19	0.30	0.41	0.17	0.27	0.37
30°	0.32	0.51	0.70	0.26	0.41	0.57	0.22	0.36	0.49	0.20	0.32	0.44	0.18	0.29	0.40	0.17	0.27	0.37	0.16	0.25	0.35	0.14	0.23	0.31
35°	0.28	0.44	0.61	0.23	0.36	0.50	0.19	0.31	0.43	0.17	0.28	0.38	0.16	0.25	0.35	0.15	0.24	0.32	0.14	0.22	0.30	0.12	0.20	0.27
40°	0.25	0.39	0.54	0.20	0.32	0.44	0.17	0.28	0.38	0.16	0.25	0.34	0.14	0.23	0.31	0.13	0.21	0.29	0.12	0.20	0.27	0.11	0.18	0.24
45°	0.22	0.36	0.49	0.18	0.29	0.40	0.16	0.25	0.35	0.14	0.23	0.31	0.13	0.21	0.28	0.12	0.19	0.26	0.11	0.18	0.25	0.10	0.16	0.22
50°	0.21	0.33	0.45	0.17	0.27	0.37	0.15	0.23	0.32	0.13	0.21	0.29	0.12	0.19	0.26	0.11	0.18	0.24	0.10	0.17	0.23	0.09	0.15	0.20
55°	0.19	0.31	0.42	0.16	0.25	0.35	0.14	0.22	0.30	0.12	0.20	0.27	0.11	0.18	0.25	0.10	0.17	0.23	0.10	0.15	0.21	0.09	0.14	0.19
60°	0.18	0.29	0.40	0.15	0.24	0.33	0.13	0.21	0.28	0.12	0.18	0.25	0.11	0.17	0.23	0.10	0.16	0.21	0.09	0.15	0.20	0.08	0.13	0.18
75°	0.16	0.26	0.36	0.13	0.21	0.29	0.12	0.19	0.25	0.10	0.17	0.23	0.09	0.15	0.21	0.09	0.14	0.19	0.08	0.13	0.18	0.07	0.12	0.16
	1.35		1.27		1.22		1.19		1.16		1.13		1.11		1.00									



	a_p	DC	DCX	X.V	f_{min}	f_{max}
15°	7	35.0	90.6	1.16	0.43	0.70
25°	12	35.0	87.3	1.16	0.20	0.32
30°	14	35.0	85.1	1.17	0.16	0.25
35°	16	35.0	82.4	1.17	0.13	0.20
40°	18	35.0	79.4	1.17	0.11	0.16
45°	20	35.0	76.0	1.18	0.09	0.14
50°	22	35.0	72.4	1.18	0.08	0.12
55°	23	35.0	68.4	1.20	0.08	0.11
60°	25	35.0	64.1	1.20	0.07	0.09
25°	12	45.0	97.3	1.18	0.23	0.34
30°	14	45.0	95.0	1.18	0.18	0.26
35°	16	45.0	92.4	1.19	0.15	0.21
40°	18	45.0	89.5	1.19	0.12	0.17
45°	20	45.0	86.0	1.20	0.11	0.15
50°	22	45.0	82.4	1.21	0.09	0.13

	a_p	DC	DCX	X.V	f_{min}	f_{max}
55°	23	45.0	78.4	1.22	0.09	0.11
60°	25	45.0	74.1	1.23	0.08	0.10
75°	28	45.0	60.1	1.31	0.07	0.08
















Cutters with setting angle 15° can be used as HFC. Use feeds from chamfers table.



FRÄSNING AV SPÅR

INDEXABLE FACE MILLS – NAVIGATOR

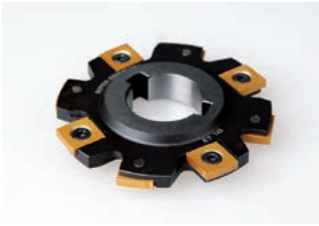
FACE MILLING

	S90SN	S90CN(XN)	F-SCC			
	90°		90°		90°	
	APMX (mm) 4.0 – 14.0	APMX (mm) 14.0 – 30.5	APMX (mm) 11.0 – 18.0			
	DC (mm) 63 – 200	DC (mm) 125 – 315	DC (mm) 25 – 40			
Cylindrical shank	 DC = 80 – 200 (mm)	 DC = 125 – 315 (mm)				
Weldon	 DC = 63 – 160 (mm)	 DC = 125 – 200 (mm)				
Modular						
Shell mill						
Page	314	320	325			
ISO	P M K	P M K	P M K			
Insert shape						
Inserts	SNHQ 11 SNHQ 12	CNHQ 1005 XNHQ 1205 XNHQ 1606	CCMX			
No. of cutting edges	4	2	2			
Djup spårfräsning 	■	■				
Hörnfräsning, hög kant 	▣	▣				
Planfräsning 	▣	▣				
Fräsning av bakomliggande yta 	▣	▣	■			
T-spårfräsning 			■			
Grund hörnfräsning 			▣			
Grund spårfräsning 			▣			

S90SN



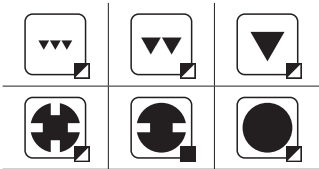
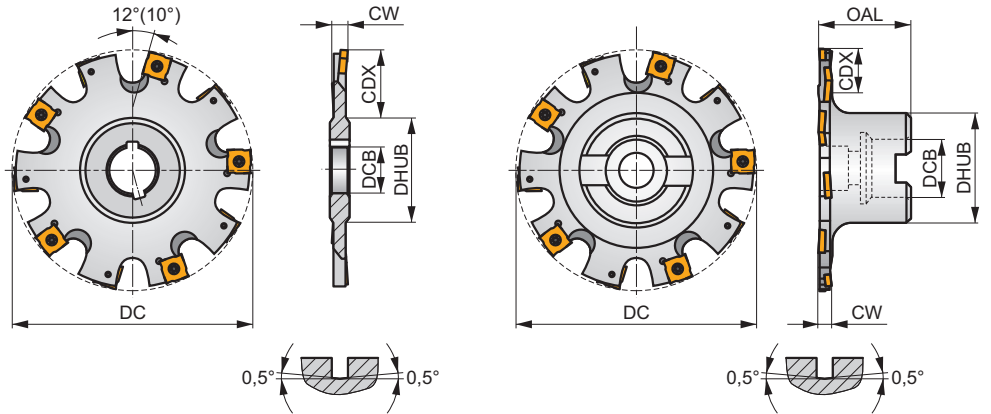
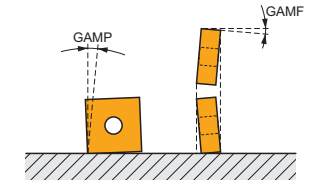
PRAMET



Skivfräs för plan- och sidfräsning

90° disc mill utilising SNHQ inserts. Suitable for slot, shoulder, rear side and face milling. Available in arbor or stub arbor style. Body treated for longer tool life.

KAPR	90°
CW	4.0 – 14.0 mm



	0.07 – 0.09				
	0.07 – 0.09				

Product	DC	OAL	DCB	DHUB	CDX	CW	α	GAMF	GAMP					kg			
	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(°)	(°)	(°)								
80F8N-S90SN11N4	80	-	27	42	16	4.00	-	2.5	-0.5	8	-	12300	-	0.21	G1151	DI011	-
80F8N-S90SN11N5	80	-	27	42	16	5.00	-	2.5	-0.5	8	-	12300	-	0.22	G1152	DI019	-
80F8N-S90SN12N6	80	-	27	42	16	6.00	-	2.5	-0.5	8	-	8400	-	0.25	G1153	DI012	-
80F8N-S90SN12N8	80	-	27	42	16	8.00	-	2.5	-0.5	8	-	8400	-	0.25	G1157	DI013	-
100G10N-S90SN12N6	100	-	32	48	24	6.00	-	2.5	-0.5	10	-	7500	-	0.43	G1153	DI012	-
100G10N-S90SN12N8	100	-	32	48	24	8.00	-	2.5	-0.5	10	-	7500	-	0.42	G1157	DI013	-
100G10N-S90SN12N10	100	-	32	48	24	10.00	-	2.5	-0.5	10	-	7500	-	0.46	G1154	DI014	-
100G10N-S90SN12N12	100	-	32	48	24	12.00	-	2.5	-0.5	10	-	7500	-	0.66	G1158	DI015	-
125H12N-S90SN12N6	125	-	40	58	31	6.00	-	2.5	-0.5	12	-	6700	-	0.62	G1153	DI012	-
125H12N-S90SN12N8	125	-	40	58	31	8.00	-	2.5	-0.5	12	-	6700	-	0.73	G1157	DI013	-
125H12N-S90SN12N10	125	-	40	58	31	10.00	-	2.5	-0.5	12	-	6700	-	0.66	G1154	DI014	-
125H12N-S90SN12N12	125	-	40	58	31	12.00	-	2.5	-0.5	12	-	6700	-	0.76	G1158	DI015	-
160H16N-S90SN12N6	160	-	40	58	43	6.00	-	2.5	-0.5	16	-	5900	-	0.86	G1153	DI012	-
160H16N-S90SN12N8	160	-	40	58	43	8.00	-	2.5	-0.5	16	-	5900	-	1.10	G1157	DI013	-
160H16N-S90SN12N10	160	-	40	58	43	10.00	-	2.5	-0.5	16	-	5900	-	1.14	G1154	DI014	-
160H16N-S90SN12N12	160	-	40	58	43	12.00	-	2.5	-0.5	16	-	5900	-	1.30	G1158	DI015	-
160H15N-S90SN12N14	160	-	40	58	43	14.00	-	2.5	-0.5	15	-	5900	-	1.40	G1158	DI015	-
200J18N-S90SN12N6	200	-	50	72	62	6.00	-	2.5	-0.5	18	-	5300	-	1.40	G1153	DI012	-
200J18N-S90SN12N8	200	-	50	72	62	8.00	-	2.5	-0.5	18	-	5300	-	1.78	G1157	DI013	-
200J18N-S90SN12N10	200	-	50	72	62	10.00	-	2.5	-0.5	18	-	5300	-	1.89	G1154	DI014	-
200J18N-S90SN12N12	200	-	50	72	62	12.00	-	2.5	-0.5	18	-	5300	-	2.23	G1158	DI015	-
200J18N-S90SN12N14	200	-	50	72	62	14.00	-	2.5	-0.5	18	-	5300	-	2.67	G1158	DI015	-
63A03R-S90SN11N4	63	40	16	34	10.5	4.00	3	2.5	-0.5	6	-	13900	-	0.37	G1151	DI021	-
63A03R-S90SN11N5	63	40	16	34	10.5	5.00	3	2.5	-0.5	6	-	13900	-	0.36	G1152	DI021	-
63A03R-S90SN12N6	63	40	16	34	10.5	6.00	3	2.5	-0.5	6	-	9500	-	0.37	G1153	DI022	-
80A04R-S90SN11N5	80	40	22	40	17.5	5.00	4	2.5	-0.5	8	-	12300	-	0.48	G1152	DI023	-
80A04R-S90SN12N6	80	40	22	40	17.5	6.00	4	2.5	-0.5	8	-	8400	-	0.50	G1153	DI024	-

Product	DC	OAL	DCB	DHUB	CDX	CW		GAMF	GAMP									
	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(°)	(°)									
100A05R-S90SN12N6	100	50	27	48	23.5	6.00	5	2.5	-0.5	10	-	7500	-	0.86	G1153	DI025	-	-
125B06R-S90SN12N6	125	50	40	56	24	6.00	6	2.5	-0.5	12	-	6700	-	1.20	G1153	DI012	AC003	-
160B08R-S90SN12N10	160	50	40	70	41	10.00	8	2.5	-0.5	16	-	5900	-	1.83	G1154	DI014	-	-

G1151	SNHQ 1102..
G1152	SNHQ 1103..
G1153	SNHQ 1203..
G1154	SNHQ 1205..
G1157	SNHQ 1204..
G1158	SNHQ 1207

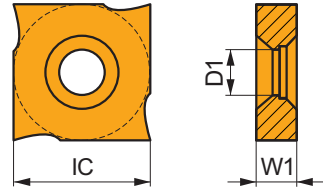
DI011	US 3504-T09P	3.0	M 3.5	4	D-T07P/T09P	FG-15	-
DI012	US 70	5.0	M 4	5	D-T07/T15	FG-15	-
DI013	US 71	5.0	M 4	7	D-T07/T15	FG-15	-
DI014	US 72	5.0	M 4	9	D-T07/T15	FG-15	-
DI015	US 73	5.0	M 4	11	D-T07/T15	FG-15	-
DI019	US 3505-T09P	3.0	M 3.5	5	D-T07P/T09P	FG-15	HS 0830
DI021	US 3504-T09P	3.0	M 3.5	4	D-T07P/T09P	FG-15	HS 0830
DI022	US 70	5.0	M 4	5	D-T07/T15	FG-15	HS 0830
DI023	US 3505-T09P	3.0	M 3.5	5	D-T07P/T09P	FG-15	HS 1030
DI024	US 70	5.0	M 4	5	D-T07/T15	FG-15	HS 1030
DI025	US 70	5.0	M 4	5	D-T07/T15	FG-15	HS 1230

AC003	KS 2040	K.FMH40

SNHQ AZ

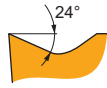
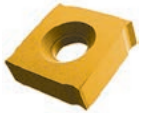


	IC (mm)	D1 (mm)	W1 (mm)
1102	11.000	4.30	2.300
1103	11.000	4.30	2.700
1203	12.700	5.00	3.200
1204	12.700	5.00	4.500
1205	12.700	5.00	5.400
1207	12.700	5.00	7.000
12T3	12.700	5.00	3.400



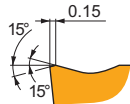
Lämplighet och startvärden för skärhastighet (vc), matning (f) och skärdjup (ap). Vi refererar till vår Dormer Pramet Calculator-app för vidare beräkningar.

Product	RE (mm)	P			M			K			N			S			H		
		vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)



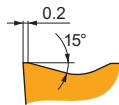
EN geometri med speciell design för spårfräsning.

SNHQ 1203AZEN:8215	☺	-	415	0.10	-	245	0.10	-	390	0.10	-	-	-	-	-	-	-	-	-
SNHQ 1203AZEN:M8340	☺	-	370	0.10	-	220	0.10	-	350	0.10	-	-	-	-	-	-	-	-	-
SNHQ 1204AZEN:8215	☺	-	405	0.10	-	240	0.10	-	380	0.10	-	-	-	-	-	-	-	-	-
SNHQ 1204AZEN:M8340	☺	-	355	0.10	-	210	0.10	-	335	0.10	-	-	-	-	-	-	-	-	-
SNHQ 1205AZEN:8215	☺	-	390	0.10	-	230	0.10	-	370	0.10	-	-	-	-	-	-	-	-	-
SNHQ 1205AZEN:M8340	☺	-	345	0.10	-	205	0.10	-	325	0.10	-	-	-	-	-	-	-	-	-
SNHQ 1207AZEN:8215	☺	-	380	0.10	-	225	0.10	-	360	0.10	-	-	-	-	-	-	-	-	-
SNHQ 1207AZEN:M8340	☺	-	335	0.10	-	200	0.10	-	315	0.10	-	-	-	-	-	-	-	-	-



TN geometri med speciell design för spårfräsning.

SNHQ 1102AZTN:M8330	☺	-	365	0.20	-	215	0.18	-	345	0.20	-	-	-	-	-	-	-	-	-
SNHQ 1102AZTN:M8340	☺	-	335	0.20	-	200	0.18	-	315	0.20	-	-	-	-	-	-	-	-	-
SNHQ 1103AZTN:M8330	☺	-	345	0.20	-	205	0.18	-	325	0.20	-	-	-	-	-	-	-	-	-
SNHQ 1103AZTN:M8340	☺	-	315	0.20	-	185	0.18	-	295	0.20	-	-	-	-	-	-	-	-	-



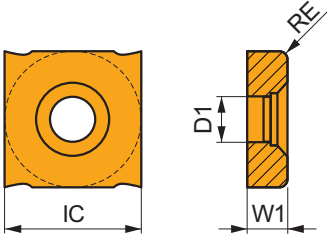
TN geometri med speciell design för spårfräsning.

SNHQ 1203AZTN:M8330	☺	-	345	0.20	-	205	0.18	-	325	0.20	-	-	-	-	-	-	-	-	-
SNHQ 1203AZTN:M8340	☺	-	315	0.20	-	185	0.18	-	295	0.20	-	-	-	-	-	-	-	-	-
SNHQ 1204AZTN:M8330	☺	-	335	0.20	-	200	0.20	-	315	0.20	-	-	-	-	-	-	-	-	-
SNHQ 1204AZTN:M8340	☺	-	300	0.20	-	180	0.20	-	285	0.20	-	-	-	-	-	-	-	-	-
SNHQ 1205AZTN:M8330	☺	-	330	0.20	-	195	0.20	-	310	0.20	-	-	-	-	-	-	-	-	-
SNHQ 1205AZTN:M8340	☺	-	295	0.20	-	175	0.20	-	280	0.20	-	-	-	-	-	-	-	-	-
SNHQ 1207AZTN:M8330	☺	-	320	0.20	-	190	0.20	-	300	0.20	-	-	-	-	-	-	-	-	-
SNHQ 1207AZTN:M8340	☺	-	290	0.20	-	170	0.20	-	275	0.20	-	-	-	-	-	-	-	-	-
SNHQ 12T3AZTN:M8340	☺	-	300	0.20	-	180	0.18	-	285	0.20	-	-	-	-	-	-	-	-	-

SNHQ TRL

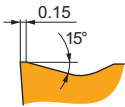
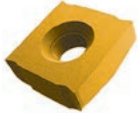


	IC (mm)	D1 (mm)	L (mm)	W1 (mm)
1203	12.700	5.00	12.70	3.200
1204	12.700	5.00	12.70	4.500
1205	12.700	5.00	12.70	5.400
1207	12.700	5.00	12.70	7.000



Lämplighet och startvärden för skärhastighet (vc), matning (f) och skärdjup (ap). Vi refererar till vår Dormer Pramet Calculator-app för vidare beräkningar.

Product	RE (mm)	P			M			K			N			S			H		
		vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)



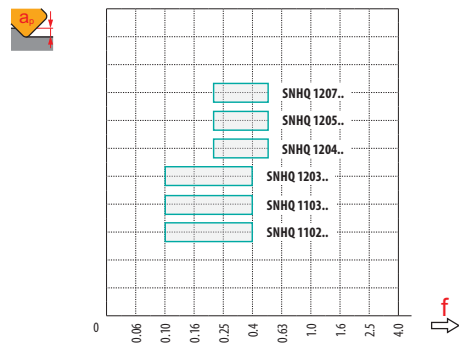
TRL geometri med speciell design för spårfräsning.

SNHQ 120305TRL:M8340	0.5	230	0.20	135	0.18	215	0.20	-	-	-	-	-	-	-	-	-	-	-
SNHQ 120310TRL:M8340	1.0	285	0.20	170	0.18	270	0.20	-	-	-	-	-	-	-	-	-	-	-
SNHQ 120315TRL:M8340	1.5	300	0.20	180	0.18	285	0.20	-	-	-	-	-	-	-	-	-	-	-
SNHQ 120405TRL:M8340	0.5	220	0.20	130	0.20	205	0.20	-	-	-	-	-	-	-	-	-	-	-
SNHQ 120415TRL:M8340	1.5	290	0.20	170	0.20	275	0.20	-	-	-	-	-	-	-	-	-	-	-
SNHQ 120505TRL:M8340	0.5	215	0.20	125	0.20	200	0.20	-	-	-	-	-	-	-	-	-	-	-
SNHQ 120515TRL:M8340	1.5	280	0.20	165	0.20	265	0.20	-	-	-	-	-	-	-	-	-	-	-
SNHQ 120705TRL:M8340	0.5	210	0.20	125	0.20	195	0.20	-	-	-	-	-	-	-	-	-	-	-
SNHQ 120710TRL:M8340	1.0	265	0.20	155	0.20	250	0.20	-	-	-	-	-	-	-	-	-	-	-



a_e / DC	0.05	0.10	0.15	0.20	0.25	0.30	0.40	0.50	0.60	0.70	0.75	0.80	0.90	1.00
	1.48	1.35	1.27	1.22	1.19	1.16	1.11	1.08	1.05	1.03	1.00	1.00	1.00	1.00













	SNHQ AZEN	SNHQ AZTN	SNHQ 12TRL
	-	-	0.5 – 1.5
	-	-	-











	80	4	16	16
	100	5	24	24
	125	6	31	31
	160	5	43	43
	200	9	62	62
	63	3	10.5	63
	80	4	17.5	80
	100	5	23.5	100
	125	6	24	125
	160	8	41	160



	a_e	5		10		15		20		25	
		f_{min}	f_{max}	f_{min}	f_{max}	f_{min}	f_{max}	f_{min}	f_{max}	f_{min}	f_{max}
	80	0.28	0.36	0.20	0.26	0.17	0.21	-	-	-	-
	100	0.32	0.41	0.23	0.29	0.19	0.24	0.16	0.21	-	-
	125	0.35	0.45	0.25	0.32	0.21	0.27	0.18	0.23	0.16	0.21
	160	0.40	0.51	0.28	0.36	0.23	0.30	0.20	0.26	0.18	0.23
	200	0.44	0.57	0.32	0.41	0.26	0.33	0.23	0.29	0.20	0.26
	63	0.25	0.32	0.18	0.23	0.15	0.19	0.13	0.17	0.12	0.15
	80	0.28	0.36	0.20	0.26	0.17	0.21	0.15	0.19	0.13	0.17
	100	0.32	0.41	0.23	0.29	0.19	0.24	0.16	0.21	0.15	0.19
	125	0.35	0.45	0.25	0.32	0.21	0.27	0.18	0.23	0.16	0.21
	160	0.40	0.51	0.28	0.36	0.23	0.30	0.20	0.26	0.18	0.23

	a _e	32		40		50		63		80	
			f_{min} 	f_{max} 	f_{min} 	f_{max} 	f_{min} 	f_{max} 	f_{min} 	f_{max} 	f_{min} 
	80	-	-	-	-	-	-	-	-	-	-
	100	-	-	-	-	-	-	-	-	-	-
	125	-	-	-	-	-	-	-	-	-	-
	160	0.16	0.21	0.15	0.19	-	-	-	-	-	-
	200	0.18	0.23	0.16	0.21	0.15	0.19	-	-	-	-
	63	0.11	0.14	0.10	0.13	0.10	0.12	0.10	0.11	-	-
	80	0.12	0.15	0.11	0.14	0.10	0.13	0.10	0.12	0.10	0.11
	100	0.13	0.17	0.12	0.15	0.11	0.14	0.10	0.13	0.10	0.12
	125	0.15	0.19	0.13	0.17	0.12	0.15	0.11	0.14	0.10	0.13
	160	0.16	0.21	0.15	0.19	0.13	0.17	0.12	0.16	0.11	0.14

	a _e	100		125		160	
			f_{min} 	f_{max} 	f_{min} 	f_{max} 	f_{min} 
	80	-	-	-	-	-	-
	100	-	-	-	-	-	-
	125	-	-	-	-	-	-
	160	-	-	-	-	-	-
	200	-	-	-	-	-	-
	63	-	-	-	-	-	-
	80	-	-	-	-	-	-
	100	0.10	0.11	-	-	-	-
	125	0.10	0.12	0.10	0.11	-	-
	160	0.10	0.13	0.10	0.12	0.10	0.11

S90CN(XN)



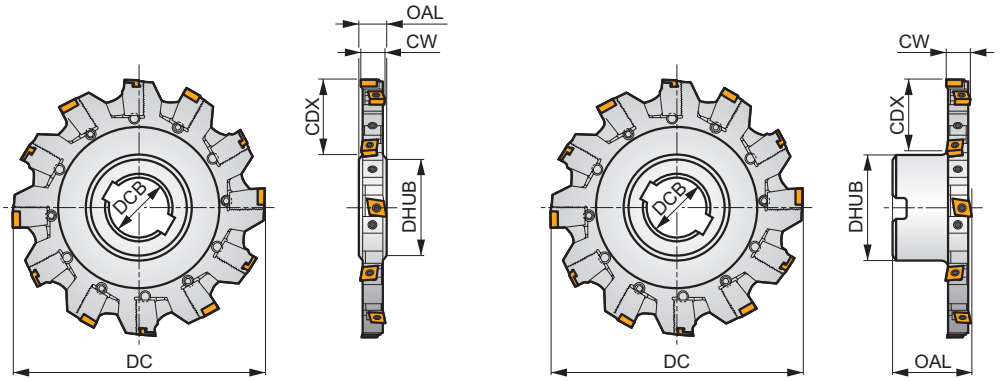
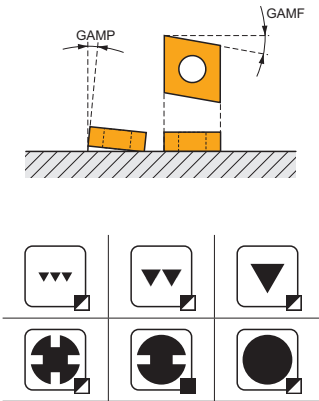
PRAMET



Skivfräs för plan- och sidfräsning med justerbar bredd

90° disc mill utilising CNHQ and XNHQ inserts. Suitable for slot, shoulder, rear side and face milling. Available in arbor or stub arbor style. Body treated for longer tool life.
















KAPR	90°
CW	14.0 – 30.5 mm






h_m	0.07 – 0.09				
h_m	0.07 – 0.09				

Product	DC (mm)	OAL (mm)	DCB (mm)	DHUB (mm)	CDX (mm)	CW (mm)	GAMF (°)	GAMP (°)	λ			max.		kg			
125H04N-S90CN10N18	125	18	40	56	34	14.0 – 18.5	-10	4	4	8	-	7800	-	1.19	GI195	DI051	-
160H06N-S90CN10N18	160	18	40	56	50	14.0 – 18.5	-8	4	6	12	-	6900	-	1.80	GI195	DI052	-
160H05N-S90XN12N24	160	24	40	56	50	19.0 – 24.3	-8	5	5	10	-	5200	-	2.50	GI196	DI056	-
200J07N-S90CN10N18	200	18	50	71	60	14.0 – 18.5	-8	4	7	14	-	6100	-	2.85	GI195	DI053	-
200J06N-S90XN12N24	200	24	50	71	60	19.0 – 24.3	-8	5	6	12	-	4700	-	3.60	GI196	DI057	-
200J06N-S90XN16N30	200	30	50	71	60	24.5 – 30.5	-9	5	6	12	-	4000	-	6.00	GI197	DI060	-
250J09N-S90CN10N18	250	18	50	71	85	14.0 – 18.5	-8	4	9	18	-	5500	-	5.30	GI195	DI054	-
250J08N-S90XN12N24	250	24	50	71	85	19.0 – 24.3	-8	5	8	16	-	4200	-	7.50	GI196	DI058	-
250J08N-S90XN16N30	250	30	50	71	85	24.5 – 30.5	-8	5	8	16	-	3600	-	8.00	GI197	DI061	-
315J12N-S90CN10N18	315	18	50	71	110	14.0 – 18.5	-8	4	12	24	-	4900	-	7.80	GI195	DI055	-
315J10N-S90XN12N24	315	24	50	71	110	19.0 – 24.3	-8	5	10	20	-	3700	-	10.70	GI196	DI059	-
315K10N-S90XN16N30	315	30	60	85	110	24.5 – 30.5	-8	5	10	20	-	3200	-	13.00	GI197	DI062	-
125B04R-S90CN10N18	125	50	40	70	25	14.0 – 18.5	-10	4	4	8	-	7800	-	1.65	GI195	DI071	AC003
160B06R-S90CN10N18	160	50	40	70	44	14.0 – 18.5	-8	5	6	12	-	6900	-	2.55	GI195	DI072	-
160B05R-S90XN12N24	160	50	40	70	44	19.0 – 24.3	-8	5	5	10	-	5200	-	2.50	GI196	DI074	-
200C06R-S90XN12N24	200	50	40	90	52	19.0 – 24.3	-8	5	6	12	-	6100	-	4.70	GI196	DI075	-
200C07R-S90CN10N18	200	50	40	90	52	14.0 – 18.5	-8	4	7	14	-	6100	-	4.05	GI195	DI073	-

	GI195	CNHQ 1005..
	GI196	XNHQ 1205..
	GI197	XNHQ 1606..

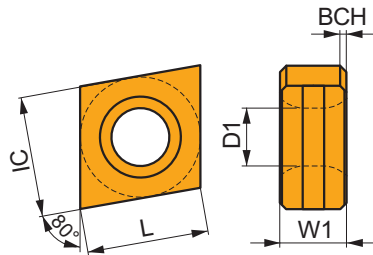
															
DI051	125H04N-S-14-08	KL-1418-CN10	KR-1418-CN10	KS 613F	DS 6018F	SDR T20	SS 6005-T09P	SDR T09	US 4011-T15P	3.5	M 4	10.6	SDR T15P	-	
DI052	160H06N-S-14-12	KL-1418-CN10	KR-1418-CN10	KS 613F	DS 6018F	SDR T20	SS 6005-T09P	SDR T09	US 4011-T15P	3.5	M 4	10.6	SDR T15P	-	
DI053	200J07N-S-14-14	KL-1418-CN10	KR-1418-CN10	KS 613F	DS 6018F	SDR T20	SS 6005-T09P	SDR T09	US 4011-T15P	3.5	M 4	10.6	SDR T15P	-	
DI054	250J09N-S-14-18	KL-1418-CN10	KR-1418-CN10	KS 613F	DS 6018F	SDR T20	SS 6005-T09P	SDR T09	US 4011-T15P	3.5	M 4	10.6	SDR T15P	-	
DI055	315J12N-S-14-24	KL-1418-CN10	KR-1418-CN10	KS 613F	DS 6018F	SDR T20	SS 6005-T09P	SDR T09	US 4011-T15P	3.5	M 4	10.6	SDR T15P	-	
DI056	160H05N-S-19-10	KL-1924-XN12	KR-1924-XN12	KS 617M	DS 6500	-	SS 6005-T09P	SDR T09	US 4011-T15P	3.5	M 4	10.6	SDR T15P	HXX 4	
DI057	200J06N-S-19-12	KL-1924-XN12	KR-1924-XN12	KS 617M	DS 6500	-	SS 6005-T09P	SDR T09	US 4011-T15P	3.5	M 4	10.6	SDR T15P	HXX 4	
DI058	250J08N-S-19-16	KL-1924-XN12	KR-1924-XN12	KS 617M	DS 6500	-	SS 6005-T09P	SDR T09	US 4011-T15P	3.5	M 4	10.6	SDR T15P	HXX 4	
DI059	315J10N-S-19-20	KL-1924-XN12	KR-1924-XN12	KS 617M	DS 6500	-	SS 6005-T09P	SDR T09	US 4011-T15P	3.5	M 4	10.6	SDR T15P	HXX 4	
DI060	200J06N-S-25-12	KL-2530-XN16	KR-2530-XN16	KS 623M	DS 6500	-	SS 6005-T09P	SDR T09	US 4011-T15P	3.5	M 4	10.6	SDR T15P	HXX 4	
DI061	250J08N-S-25-16	KL-2530-XN16	KR-2530-XN16	KS 623M	DS 6500	-	SS 6005-T09P	SDR T09	US 4011-T15P	3.5	M 4	10.6	SDR T15P	HXX 4	
DI062	315K10N-S-25-20	KL-2530-XN16	KR-2530-XN16	KS 623M	DS 6500	-	SS 6005-T09P	SDR T09	US 4011-T15P	3.5	M 4	10.6	SDR T15P	HXX 4	
DI071	125B04R-S-14-08	KL-1418-CN10	KR-1418-CN10	KS 613F	DS 6018F	SDR T20	SS 6005-T09P	SDR T09	US 4011-T15P	3.5	M 4	10.6	SDR T15P	-	
DI072	160B06R-S-14-12	KL-1418-CN10	KR-1418-CN10	KS 613F	DS 6018F	SDR T20	SS 6005-T09P	SDR T09	US 4011-T15P	3.5	M 4	10.6	SDR T15P	-	
DI073	200C07R-S-14-14	KL-1418-CN10	KR-1418-CN10	KS 613F	DS 6018F	SDR T20	SS 6005-T09P	SDR T09	US 4011-T15P	3.5	M 4	10.6	SDR T15P	-	
DI074	160B05R-S-19-10	KL-1924-XN12	KR-1924-XN12	KS 617M	DS 6500	-	SS 6005-T09P	SDR T09	US 4011-T15P	3.5	M 4	10.6	SDR T15P	HXX 4	
DI075	200C06R-S-19-12	KL-1924-XN12	KR-1924-XN12	KS 617M	DS 6500	-	SS 6005-T09P	SDR T09	US 4011-T15P	3.5	M 4	10.6	SDR T15P	HXX 4	

		
AC003	KS 2040	K.FMH40

CNHQ

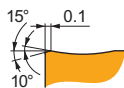
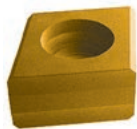


	BCH	IC	D1	L	W1
	(mm)	(mm)	(mm)	(mm)	(mm)
1005	0.50	10.000	4.70	10.00	5.400



Lämplighet och startvärden för skärhastighet (vc), matning (f) och skärdjup (ap). Vi refererar till vår Dormer Pramet Calculator-app för vidare beräkningar.

Product	RE (mm)	P			M			K			N			S			H		
		vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)



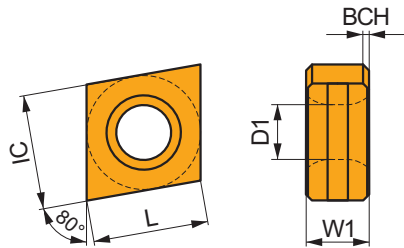
TN speciell design för spårfräsning under lätta till svåra förhållanden.

CNHQ 1005AZTN:M8330	☺	–	■	310	0.15	–	▣	185	0.14	–	■	290	0.15	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
CNHQ 1005AZTN:M8340	☺	–	■	280	0.15	–	▣	165	0.14	–	■	265	0.15	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–

XNHQ

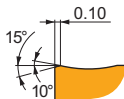


	BCH	IC	D1	L	W1
	(mm)	(mm)	(mm)	(mm)	(mm)
1205	0.50	10.000	4.70	12.70	5.400
1606	0.50	12.000	5.90	16.00	6.400



Lämplighet och startvärden för skärhastighet (vc), matning (f) och skärdjup (ap). Vi refererar till vår Dormer Pramet Calculator-app för vidare beräkningar.

Product	RE (mm)	P			M			K			N			S			H		
		vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)



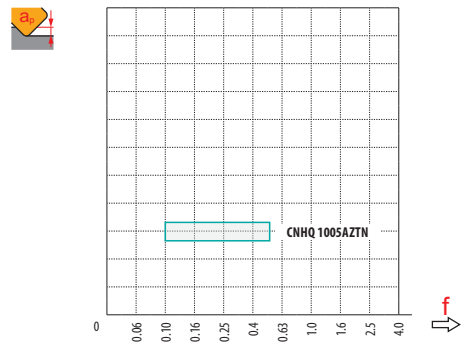
TN speciell design för spårfräsning.

XNHQ 1205AZTN:M8330	☺	–	■	310	0.15	–	▣	185	0.14	–	■	290	0.15	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–		
XNHQ 1205AZTN:M8340	☺	–	■	275	0.15	–	▣	165	0.14	–	■	260	0.15	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	
XNHQ 1606AZTN:M8330	☺	–	■	300	0.15	–	▣	180	0.14	–	■	285	0.15	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	
XNHQ 1606AZTN:M8340	☺	–	■	270	0.15	–	▣	160	0.14	–	■	255	0.15	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–



a_e / DC	0.05	0.10	0.15	0.20	0.25	0.30	0.40	0.50	0.60	0.70	0.75	0.80	0.90	1.00
$X.V$	1.48	1.35	1.27	1.22	1.19	1.16	1.11	1.08	1.05	1.03	1.00	1.00	1.00	1.00














	XNHQ 10
	-
	-














			\varnothing_{max}
	125	4	34
	160	6	50
	200	7	60
	250	9	85
	315	12	110
	125	4	25
	160	6	44
	200	7	52



	a_e	5		10		15		20		25	
		f_{min}	f_{max}	f_{min}	f_{max}	f_{min}	f_{max}	f_{min}	f_{max}	f_{min}	f_{max}
	125	0.35	0.45	0.25	0.32	0.21	0.27	0.18	0.23	0.16	0.21
	160	0.40	0.51	0.28	0.36	0.23	0.30	0.20	0.26	0.18	0.23
	200	0.44	0.57	0.32	0.41	0.26	0.33	0.23	0.29	0.20	0.26
	250	0.50	0.64	0.35	0.45	0.29	0.37	0.25	0.32	0.23	0.29
	315	0.56	0.72	0.39	0.51	0.32	0.42	0.28	0.36	0.25	0.32
	125	0.35	0.45	0.25	0.32	0.21	0.27	0.18	0.23	0.16	0.21
	160	0.40	0.51	0.28	0.36	0.23	0.30	0.20	0.26	0.18	0.23
	200	0.44	0.57	0.32	0.41	0.26	0.33	0.23	0.29	0.20	0.26

	a _e	32		40		50		63		80		
			f_{min} 	f_{max} 	f_{min} 	f_{max} 	f_{min} 	f_{max} 	f_{min} 	f_{max} 	f_{min} 	f_{max} 
	125		0.15	0.19	–	–	–	–	–	–	–	
	160		0.16	0.21	0.15	0.19	–	–	–	–	–	
	200		0.18	0.23	0.16	0.21	0.15	0.19	–	–	–	
	250		0.20	0.26	0.18	0.23	0.16	0.21	0.15	0.19	0.13	0.17
	315		0.22	0.29	0.20	0.26	0.18	0.23	0.16	0.21	0.15	0.19
	125		0.15	0.19	0.13	0.17	0.12	0.15	0.11	0.14	0.10	0.13
	160		0.16	0.21	0.15	0.19	0.13	0.17	0.12	0.16	0.11	0.14
	200		0.18	0.23	0.16	0.21	0.15	0.19	0.13	0.17	0.12	0.15

	a _e	100		125		160		200		
			f_{min} 	f_{max} 	f_{min} 	f_{max} 	f_{min} 	f_{max} 	f_{min} 	f_{max} 
	125		–	–	–	–	–	–	–	–
	160		–	–	–	–	–	–	–	–
	200		–	–	–	–	–	–	–	–
	250		–	–	–	–	–	–	–	–
	315		0.13	0.17	–	–	–	–	–	–
	125		0.10	0.12	0.10	0.11	–	–	–	–
	160		0.10	0.13	0.10	0.12	0.10	0.11	–	–
	200		0.11	0.14	0.10	0.13	0.10	0.12	0.10	0.11

F-SCC

P M K

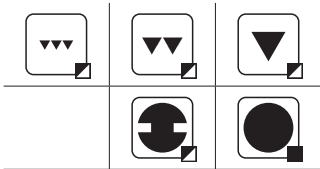
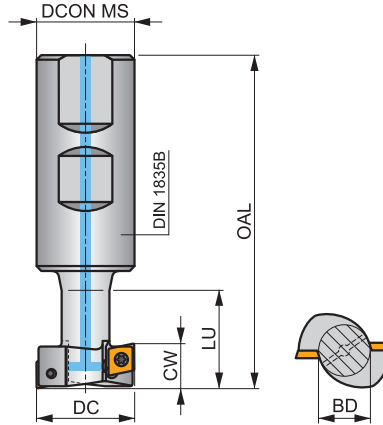
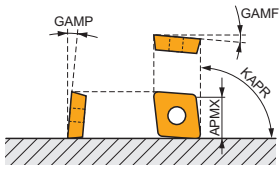
PRAMET

S



T-sparsfräs för CCMX-skär, med invändig kylning
 T-sparsfräs för enkelsidiga CCMX-skär. Invändig kylning.

KAPR	90°
APMX	11.0 – 18.0 mm



h_m 0.05 – 0.08



Product	DC (mm)	BD (mm)	OAL (mm)	DCON MS (mm)	LU (mm)	CW (mm)	χ 1					kg		
25F1R030B25-SCC06-C	25	12	86	25	25	11.00	1	2	–	28100	✓	0.26	GI148	SQ213
32F1R038B32-SCC08-C	32	16	98	32	33	14.00	1	2	–	19100	✓	0.50	GI149	SQ212
40F2R046B32-SCC09-C	40	20	105	32	41	18.00	2	4	–	14900	✓	0.56	GI150	SQ212

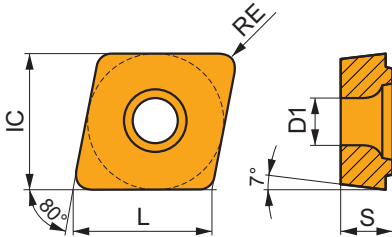
GI148													CCMX 060304	
GI149													CCMX 08T308	
GI150													CCMX 09T308	

SQ212	US 3007-T09P		2.0		M 3			7.3					Flag T09P	
SQ213	US 2506-T07P		1.2		M 2.5			6.3					Flag T07P	

CCMX

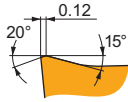


	IC (mm)	D1 (mm)	L (mm)	S (mm)
0603	6.350	2.80	6.40	3.50
08T3	8.030	3.50	8.10	4.40
09T3	9.525	3.50	9.70	3.97



Lämplighet och startvärden för skärhastighet (vc), matning (f) och skärdjup (ap). Vi refererar till vår Dormer Pramet Calculator-app för vidare beräkningar.

Product	RE (mm)	P			M			K			N			S			H		
		vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)

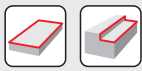
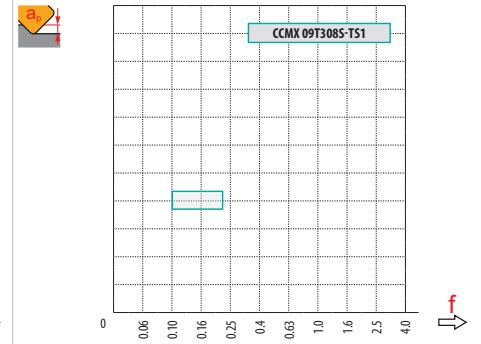
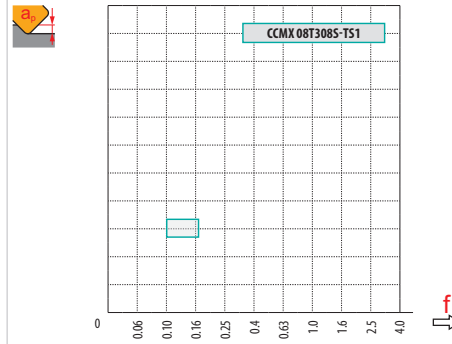
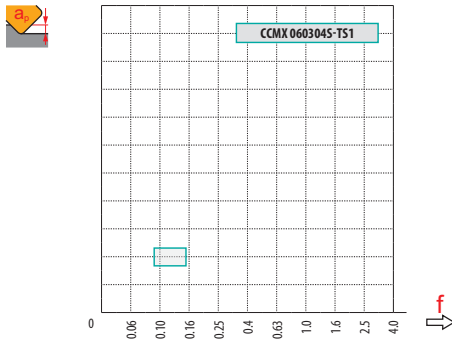


TS1 speciell design för T-spårfräsning under lätta till medelsvåra förhållanden.

CCMX 060304S-TS1:M8330	●	0.4	■	240	0.10	—	▣	140	0.09	—	■	225	0.10	—	—	—	—	—	—	—	—	—	—	—
CCMX 060304S-TS1:M8340	●	0.4	■	215	0.10	—	▣	125	0.09	—	▣	200	0.10	—	—	—	—	—	—	—	—	—	—	—
CCMX 08T308S-TS1:M8330	●	0.8	■	275	0.10	—	▣	165	0.10	—	■	260	0.10	—	—	—	—	—	—	—	—	—	—	—
CCMX 09T308S-TS1:M8330	●	0.8	■	270	0.10	—	▣	160	0.10	—	■	255	0.10	—	—	—	—	—	—	—	—	—	—	—
CCMX 09T308S-TS1:M8340	●	0.8	■	240	0.10	—	▣	140	0.10	—	▣	225	0.10	—	—	—	—	—	—	—	—	—	—	—



	CCMX 06-TS1	CCMX 08-TS1	CCMX 09-TS1
	0.4	0.8	0.8
	-	-	-



a_e / DC	5 %	10 %	15 %	20 %	25 %	30 %	40 %	50 %	60 %	70 %	75 %	80 %	90 %	100 %
	1.48	1.35	1.27	1.22	1.19	1.16	1.11	1.08	1.05	1.03	1.00	1.00	1.00	1.00



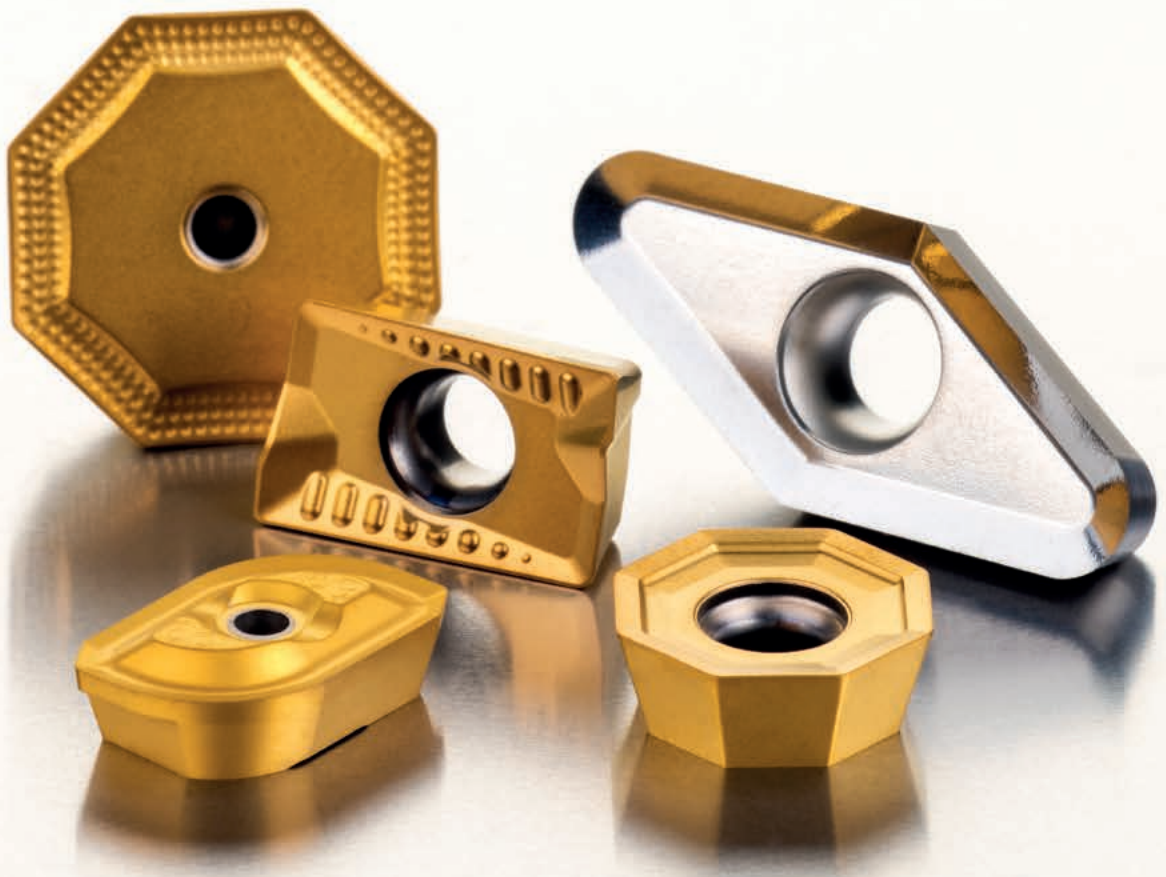
	$a_e = 1$		$a_e = 2$		$a_e = 3$		$a_e = 4$		$a_e = 5$		$a_e = 8$		$a_e = 10$	
	f_{min}	f_{max}	f_{min}	f_{max}	f_{min}	f_{max}	f_{min}	f_{max}	f_{min}	f_{max}	f_{min}	f_{max}	f_{min}	f_{max}
25	0.25	0.40	0.18	0.29	0.15	0.24	0.13	0.21	0.12	0.19	0.09	0.15	0.09	0.14
32	0.28	0.45	0.20	0.32	0.17	0.27	0.14	0.23	0.13	0.21	0.10	0.17	0.09	0.15
40	0.32	0.51	0.23	0.36	0.18	0.30	0.16	0.26	0.14	0.23	0.12	0.19	0.10	0.17

	$a_e = 12$		$a_e = 16$		$a_e = 20$		$a_e = 25$		$a_e = 32$		$a_e = 40$	
	f_{min}	f_{max}	f_{min}	f_{max}	f_{min}	f_{max}	f_{min}	f_{max}	f_{min}	f_{max}	f_{min}	f_{max}
25	0.08	0.13	0.07	0.12	0.07	0.11	0.08	0.13	-	-	-	-
32	0.09	0.14	0.08	0.13	0.07	0.12	0.07	0.11	0.08	0.13	-	-
40	0.10	0.15	0.09	0.14	0.08	0.13	0.07	0.12	0.07	0.11	0.08	0.13

- Valid for T-slot milling
- Valid for shoulder and inverse face milling
- Valid for shoulder milling



25	1	11	6.4
32	1	14	8.0
40	2	18	9.7

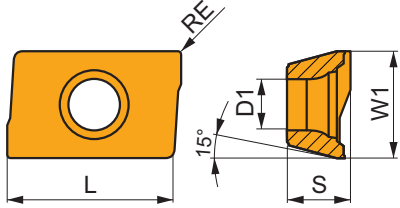


ANDRA FRÄSSKÄR

ADKT 15

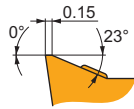


	W1 (mm)	D1 (mm)	L (mm)	S (mm)
1505	9.525	4.40	15.55	5.60



Lämplighet och startvärden för skärhastighet (vc), matning (f) och skärdjup (ap). Vi refererar till vår Dormer Pramet Calculator-app för vidare beräkningar.

Product	RE (mm)	P			M			K			N			S			H		
		vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)



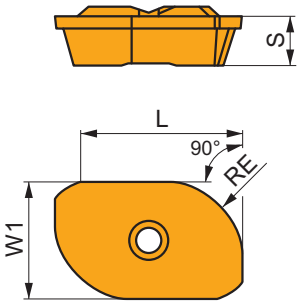
M geometri med mycket positiv design för medelfin fräsning.

ADKT 1505PDER-M:M8330	0.8	235	0.20	5.0	140	0.18	5.0	220	0.20	5.0	-	-	-	55	0.16	4.0	-	-	-
ADKT 1505PDER-M:M8340	0.8	210	0.20	5.0	125	0.18	5.0	195	0.20	5.0	-	-	-	50	0.16	4.0	-	-	-
ADKT 1505PDER-M:M9325	0.8	290	0.20	5.0	-	-	-	275	0.20	5.0	-	-	-	-	-	-	-	-	-

ADKX 15

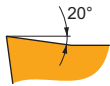


	W1 (mm)	L (mm)	S (mm)
15T3	9.525	12.20	3.97



Lämplighet och startvärden för skärhastighet (vc), matning (f) och skärdjup (ap). Vi refererar till vår Dormer Pramet Calculator-app för vidare beräkningar.

Product	RE (mm)	P			M			K			N			S			H		
		vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)



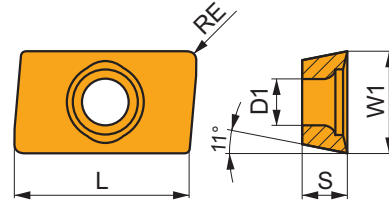
F geometri med mycket vass positiv design för fin till medelfin fräsning.

ADKX 15T308ER-F:M8345	0.8	170	0.10	10.0	100	0.09	10.0	-	-	-	-	-	-	40	0.07	8.0	-	-	-
------------------------------	-----	-----	------	------	-----	------	------	---	---	---	---	---	---	----	------	-----	---	---	---

APMT 16

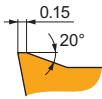


	W1 (mm)	D1 (mm)	L (mm)	S (mm)
1604	9.600	4.50	17.00	4.76



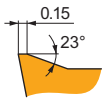
Lämplighet och startvärden för skärhastighet (vc), matning (f) och skärdjup (ap). Vi refererar till vår Dormer Pramet Calculator-app för vidare beräkningar.

Product	RE (mm)	P			M			K			N			S			H		
		vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)



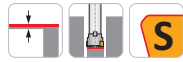
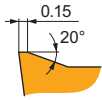
F geometri med positiv design för finfräsning.

APMT 1604PDER-F:M8330	☉	-	■	320	0.10	2.0	■	190	0.09	2.0	■	300	0.10	2.0	■	80	0.07	1.6	■	-	-	-
------------------------------	---	---	---	-----	------	-----	---	-----	------	-----	---	-----	------	-----	---	----	------	-----	---	---	---	---



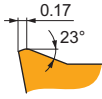
FM geometri med positiv design för fin till medelfin fräsning.

APMT 1604PDER-FM:M8330	☉	-	■	285	0.16	2.0	■	170	0.14	2.0	■	270	0.16	2.0	■	70	0.13	1.6	■	-	-	-
APMT 1604PDER-FM:M8345	☉	-	■	205	0.16	2.0	■	120	0.14	2.0	■	-	-	-	■	50	0.13	1.6	■	-	-	-



ER-R geometri med positiv design för grovfräsning.

APMT 1604PDER-R:M8330	☉	-	■	255	0.16	5.0	■	-	-	-	■	240	0.16	5.0	■	-	-	-	■	-	-	-
------------------------------	---	---	---	-----	------	-----	---	---	---	---	---	-----	------	-----	---	---	---	---	---	---	---	---



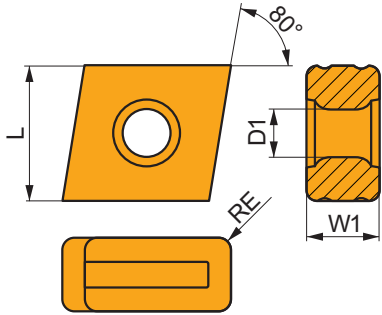
SR-R geometri med positiv design för grovfräsning.

APMT 1604PDSR-R:M8330	☉	-	■	255	0.18	5.0	■	-	-	-	■	240	0.18	5.0	■	-	-	-	■	-	-	-
------------------------------	---	---	---	-----	------	-----	---	---	---	---	---	-----	------	-----	---	---	---	---	---	---	---	---

CNM

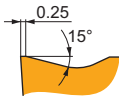


	D1 (mm)	L (mm)	S (mm)
63	5.50	15.00	8.00



Lämplighet och startvärden för skärhastighet (vc), matning (f) och skärdjup (ap). Vi refererar till vår Dormer Pramet Calculator-app för vidare beräkningar.

Product	RE (mm)	P			M			K			N			S			H		
		vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)



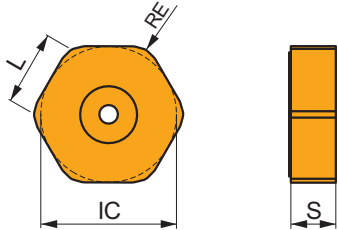
563 universell geometri.

CNM 563:M8330	●	1.2	185	0.30	10.0	–	–	–	175	0.30	10.0	–	–	–	–	–	–	–	–
CNM 563:M8340	⊕	1.2	220	0.30	10.0	–	–	–	205	0.30	10.0	–	–	–	–	–	–	–	–

HNEF 09

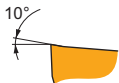


	IC (mm)	L (mm)	S (mm)
0905	16.200	9.40	5.64



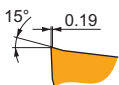
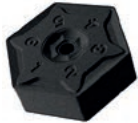
Lämplighet och startvärden för skärhastighet (vc), matning (f) och skärdjup (ap). Vi refererar till vår Dormer Pramet Calculator-app för vidare beräkningar.

Product	RE (mm)	P			M			K			N			S			H		
		vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)



R geometri med negativ design för fin till medelfin fräsning.

HNEF 090516SN-R:8215	●	1.6	–	–	–	–	–	–	380	0.15	1.5	–	–	–	–	–	–	–	–
HNEF 090516SN-R:M5315	⊕	1.6	–	–	–	–	–	–	265	0.30	3.0	–	–	–	–	–	–	–	–



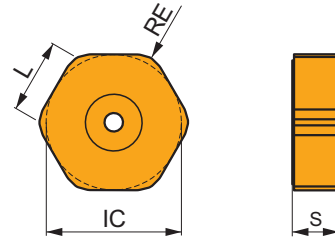
M geometri med positiv design för fin till medelfin fräsning.

HNEF 090508EN-M:M5315	⊕	0.8	–	–	–	–	–	–	290	0.18	3.0	–	–	–	–	–	–	–	–
-----------------------	---	-----	---	---	---	---	---	---	-----	------	-----	---	---	---	---	---	---	---	---

HNMF 09

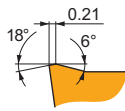


	IC (mm)	L (mm)	S (mm)
0905	16.200	9.40	5.64



Lämplighet och startvärden för skärhastighet (vc), matning (f) och skärdjup (ap). Vi refererar till vår Dormer Pramet Calculator-app för vidare beräkningar.

Product	RE (mm)	P			M			K			N			S			H		
		vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)



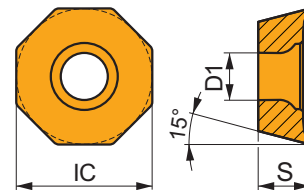
R geometri med negativ design för fin till medelfin fräsning.

HNMF 090516SN-R:8215	✳	1.6	-	-	-	-	-	-	210	0.30	3.0	-	-	-	-	-	-	-	-
HNMF 090516SN-R:M5315	✳	1.6	-	-	-	-	-	-	265	0.30	3.0	-	-	-	-	-	-	-	-

ODMT 05

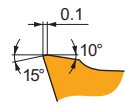


	IC (mm)	D1 (mm)	S (mm)
0504	12.700	4.40	4.76



Lämplighet och startvärden för skärhastighet (vc), matning (f) och skärdjup (ap). Vi refererar till vår Dormer Pramet Calculator-app för vidare beräkningar.

Product	RE (mm)	P			M			K			N			S			H		
		vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)



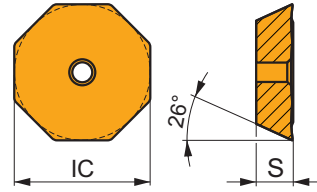
ZZN något positiv design för medelfin fräsning.

ODMT 0504ZZN:M8340	✳	-	195	0.25	1.5	-	-	-	185	0.25	1.5	-	-	-	-	-	-	-	-
---------------------------	---	---	-----	------	-----	---	---	---	-----	------	-----	---	---	---	---	---	---	---	---

OFKR 07

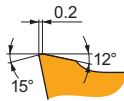
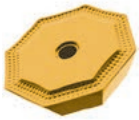


	IC (mm)	D1 (mm)	S (mm)
0704	17.845	2.65	4.56



Lämplighet och startvärden för skärhastighet (vc), matning (f) och skärdjup (ap). Vi refererar till vår Dormer Pramet Calculator-app för vidare beräkningar.

Product	RE (mm)	P			M			K			N			S			H		
		vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)



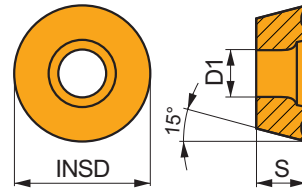
M geometri med positiv design för fin till medelfin fräsning.

OFKR 0704SN-M:M8330	☼	–	■	235	0.25	1.5	■	140	0.23	1.5	■	220	0.25	1.5	■	–	–	–	■	–	–	–
OFKR 0704SN-M:M8340	☼	–	■	215	0.25	1.5	■	125	0.23	1.5	■	200	0.25	1.5	■	–	–	–	■	–	–	–

RDET

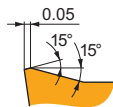


	INSD (mm)	D1 (mm)	S (mm)
0802	8.000	3.40	2.38
1003	10.000	4.40	3.18
12T3	12.000	4.40	3.97



Lämplighet och startvärden för skärhastighet (vc), matning (f) och skärdjup (ap). Vi refererar till vår Dormer Pramet Calculator-app för vidare beräkningar.

Product	RE (mm)	P			M			K			N			S			H		
		vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)



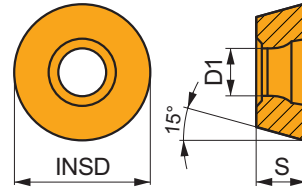
SN positiv design för finfräsning.

RDET 0802MOSN:M8340	☼	–	■	335	0.15	0.5	■	200	0.14	0.5	■	315	0.15	0.5	■	80	0.12	0.4	■	–	–	–
RDET 1003MOSN:M8340	☼	–	■	310	0.15	1.0	■	185	0.14	1.0	■	290	0.15	1.0	■	75	0.12	0.8	■	–	–	–
RDET 12T3MOSN:M8340	☼	–	■	280	0.20	1.5	■	165	0.18	1.5	■	265	0.20	1.5	■	70	0.14	1.2	■	–	–	–

RDHX 20

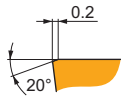


	INSD	D1	S
	(mm)	(mm)	(mm)
2006	20.000	5.20	6.35



Lämplighet och startvärden för skärhastighet (vc), matning (f) och skärdjup (ap). Vi refererar till vår Dormer Pramet Calculator-app för vidare beräkningar.

Product	RE (mm)	P			M			K			N			S			H		
		vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
		(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)



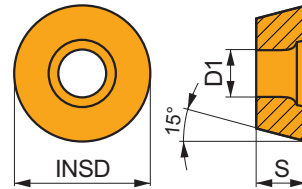
MOT neutral spånvinkel för finfräsning.

RDHX 2006MOT:M8310	✳	–	240	0.35	3.0	–	–	–	225	0.35	3.0	–	–	–	–	–	–	–	–	45	0.18	1.3
RDHX 2006MOT:M8325	✳	–	180	0.35	3.0	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–

RPET 12

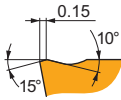


	INSD	D1	S
	(mm)	(mm)	(mm)
1204	12.000	4.40	4.76



Lämplighet och startvärden för skärhastighet (vc), matning (f) och skärdjup (ap). Vi refererar till vår Dormer Pramet Calculator-app för vidare beräkningar.

Product	RE (mm)	P			M			K			N			S			H		
		vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
		(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)



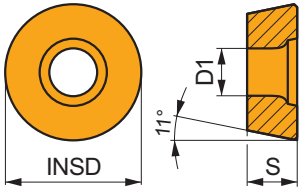
MOSN positiv design för finfräsning.

RPET 1204MOSN:8215	✳	–	325	0.20	1.5	195	0.18	1.5	305	0.20	1.5	–	–	–	80	0.14	1.2	–	–	–
RPET 1204MOSN:M8330	✳	–	320	0.20	1.5	190	0.18	1.5	300	0.20	1.5	–	–	–	80	0.14	1.2	–	–	–
RPET 1204MOSN:M8340	✳	–	295	0.20	1.5	175	0.18	1.5	280	0.20	1.5	–	–	–	70	0.14	1.2	–	–	–

RPEW 12

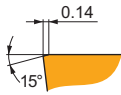


	INSD	D1	S
	(mm)	(mm)	(mm)
1204	12.000	4.40	4.76



Lämplighet och startvärden för skärhastighet (vc), matning (f) och skärdjup (ap). Vi refererar till vår Dormer Pramet Calculator-app för vidare beräkningar.

Product	RE (mm)	P			M			K			N			S			H		
		vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)



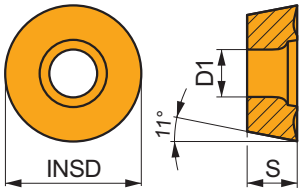
MOSN neutral spänvinkel för finfräsning.

RPEW 1204MOSN:M8330	✳	-	285	0.20	1.5	-	-	-	270	0.20	1.5	-	-	-	-	-	-	55	0.10	0.8
RPEW 1204MOSN:M8340	✳	-	265	0.20	1.5	-	-	-	250	0.20	1.5	-	-	-	-	-	-	-	-	-

RPEX

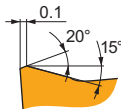


	INSD	D1	S
	(mm)	(mm)	(mm)
1204	12.000	4.40	4.76



Lämplighet och startvärden för skärhastighet (vc), matning (f) och skärdjup (ap). Vi refererar till vår Dormer Pramet Calculator-app för vidare beräkningar.

Product	RE (mm)	P			M			K			N			S			H		
		vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)



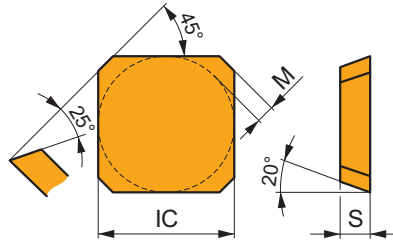
12 positiv design för finfräsning.

RPEX 1204MOSN-12:M8340	✳	-	215	0.30	1.5	125	0.27	1.5	200	0.30	1.5	-	-	-	50	0.21	1.2	-	-	-
------------------------	---	---	-----	------	-----	-----	------	-----	-----	------	-----	---	---	---	----	------	-----	---	---	---

SEEN



	IC (mm)	M (mm)	S (mm)
1203	12.700	1.6	3.18
1504	15.875	2.0	4.76



Lämplighet och startvärden för skärhastighet (vc), matning (f) och skärdjup (ap). Vi refererar till vår Dormer Pramet Calculator-app för vidare beräkningar.

Product	RE (mm)	P			M			K			N			S			H		
		vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)

AFFN eggpreparering, neutral geometri för fin till medelfin fräsning.

SEEN 1203AFFN:M8330	☹	–	■	270	0.15	2.0	■	160	0.14	2.0	■	255	0.15	2.0	–	–	–	–	–	–
SEEN 1203AFFN:M8340	☹	–	■	245	0.15	2.0	■	145	0.14	2.0	■	230	0.15	2.0	–	–	–	–	–	–

AFSN eggpreparering, neutral geometri för medelfin till grovfräsning.

SEEN 1203AFSN:8215	☹	–	■	255	0.20	2.0	–	–	–	■	240	0.20	2.0	–	–	–	–	–	■	50	0.13	1.0
SEEN 1203AFSN:M8330	☹	–	■	255	0.20	2.0	–	–	–	■	240	0.20	2.0	–	–	–	–	–	■	50	0.13	1.0
SEEN 1203AFSN:M8340	☹	–	■	230	0.20	2.0	–	–	–	■	215	0.20	2.0	–	–	–	–	–	–	–	–	–
SEEN 1203AFSN:M9315	☹	–	■	340	0.20	2.0	–	–	–	■	320	0.20	2.0	–	–	–	–	–	■	65	0.13	1.0
SEEN 1203AFSN:M9325	☹	–	■	315	0.20	2.0	–	–	–	■	295	0.20	2.0	–	–	–	–	–	■	60	0.13	1.0

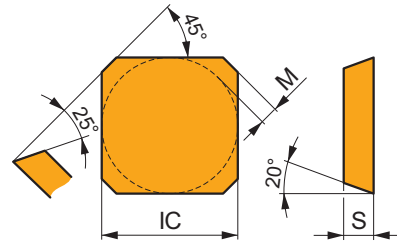
AFSN eggpreparering, neutral geometri för medelfin till grovfräsning.

SEEN 1504AFSN:M8330	☹	–	■	240	0.20	3.0	–	–	–	■	225	0.20	3.0	–	–	–	–	–	■	45	0.13	1.3
SEEN 1504AFSN:M8340	☹	–	■	225	0.20	3.0	–	–	–	■	210	0.20	3.0	–	–	–	–	–	–	–	–	–

SEER

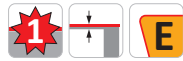
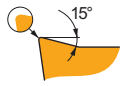


	IC (mm)	M (mm)	S (mm)
	12.700	1.6	3.18
	12.700	1.6	4.76
	15.875	2.0	4.76



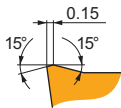
Lämplighet och startvärden för skärhastighet (vc), matning (f) och skärdjup (ap). Vi refererar till vår Dormer Pramet Calculator-app för vidare beräkningar.

Product	RE (mm)	P			M			K			N			S			H		
		vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)



AFEN eggpreparering, spånbrytargeometri för medelfin till grov fräsning.

SEER 1203AFEN:M8330	☺	–	■	265	0.24	2.5	■	155	0.22	2.5	■	250	0.24	2.5	■	65	0.22	2.0	■	–	–	–
SEER 1203AFEN:M8340	☺	–	■	245	0.24	2.5	■	145	0.22	2.5	■	230	0.24	2.5	■	60	0.22	2.0	■	–	–	–



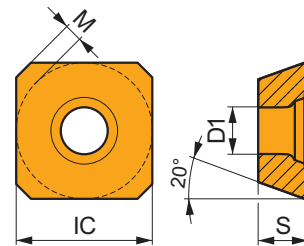
AFSN eggpreparering, spånbrytargeometri för medelfin till grov fräsning.

SEER 1203AFSN:M8330	☺	–	■	265	0.25	2.5	■	155	0.23	2.5	■	250	0.25	2.5	■	65	0.20	2.0	■	–	–	–
SEER 1203AFSN:M8340	☺	–	■	240	0.25	2.5	■	140	0.23	2.5	■	225	0.25	2.5	■	60	0.20	2.0	■	–	–	–
SEER 1204AFSN:M8330	☺	–	■	265	0.25	2.5	■	155	0.23	2.5	■	250	0.25	2.5	■	65	0.20	2.0	■	–	–	–
SEER 1504AFSN:M8330	☺	–	■	255	0.25	3.5	■	150	0.23	3.5	■	240	0.25	3.5	■	60	0.20	2.8	■	–	–	–
SEER 1504AFSN:M8340	☺	–	■	230	0.25	3.5	■	135	0.23	3.5	■	215	0.25	3.5	■	55	0.20	2.8	■	–	–	–

SEET 12

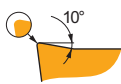


	IC (mm)	D1 (mm)	M (mm)	S (mm)
	12.700	5.50	1.6	4.76



Lämplighet och startvärden för skärhastighet (vc), matning (f) och skärdjup (ap). Vi refererar till vår Dormer Pramet Calculator-app för vidare beräkningar.

Product	RE (mm)	P			M			K			N			S			H		
		vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)

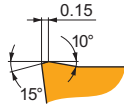
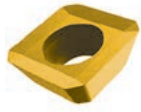


AFEN eggpreparering, positiv geometri för allmän fräsning.

SEET 1204AFEN:M8330	☺	–	■	265	0.24	2.5	■	155	0.22	2.5	■	250	0.24	2.5	■	65	0.22	2.0	■	–	–	–
---------------------	---	---	---	-----	------	-----	---	-----	------	-----	---	-----	------	-----	---	----	------	-----	---	---	---	---

Lämplighet och startvärden för skärhastighet (vc), matning (f) och skärdjup (ap). Vi refererar till vår Dormer Pramet Calculator-app för vidare beräkningar.

Product	RE (mm)	P			M			K			N			S			H		
		vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)



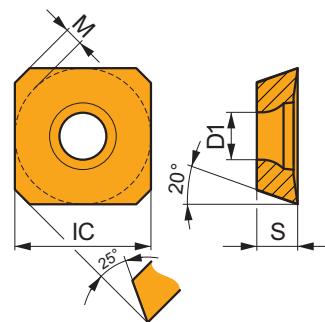
AFSN eggpreparering, positiv geometri för allmän fräsning.

SEET 1204AFSN:8215	☹	–	■	265	0.23	2.5	▣	155	0.21	2.5	■	250	0.23	2.5	–	–	–	▣	65	0.21	2.0	–	–	–
SEET 1204AFSN:M8330	☹	–	■	265	0.24	2.5	▣	155	0.22	2.5	■	250	0.24	2.5	–	–	–	▣	65	0.22	2.0	–	–	–
SEET 1204AFSN:M8340	☹	–	■	240	0.25	2.5	▣	140	0.23	2.5	▣	225	0.25	2.5	–	–	–	▣	60	0.23	2.0	–	–	–
SEET 1204AFSN:M9325	☹	–	■	340	0.20	2.5	–	–	–	–	■	320	0.20	2.5	–	–	–	–	–	–	–	–	–	–

SEET 12-PM

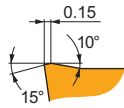
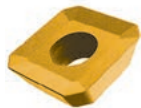


	IC (mm)	D1 (mm)	M (mm)	S (mm)
12T3	13.400	4.20	1.5	3.97



Lämplighet och startvärden för skärhastighet (vc), matning (f) och skärdjup (ap). Vi refererar till vår Dormer Pramet Calculator-app för vidare beräkningar.

Product	RE (mm)	P			M			K			N			S			H		
		vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)



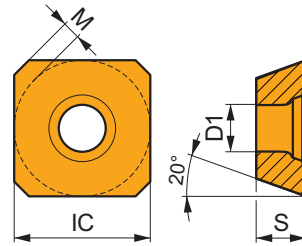
PM geometri med positiv design för allmän fräsning.

SEET 12T3M-PM:M8330	☹	–	■	265	0.25	2.0	▣	155	0.23	2.0	■	250	0.25	2.0	–	–	–	▣	65	0.20	1.6	–	–	–
SEET 12T3M-PM:M8340	☹	–	■	245	0.25	2.0	▣	145	0.23	2.0	▣	230	0.25	2.0	–	–	–	▣	60	0.20	1.6	–	–	–
SEET 12T3M-PM:M9325	☹	–	■	325	0.25	2.0	–	–	–	–	■	305	0.25	2.0	–	–	–	–	–	–	–	–	–	–
SEET 12T3M-PM:M9340	☹	–	■	290	0.25	2.0	▣	170	0.23	2.0	–	–	–	–	–	–	–	▣	70	0.20	1.6	–	–	–

SEET 12-FA

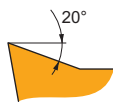
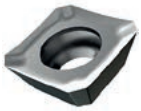


	IC (mm)	D1 (mm)	M (mm)	S (mm)
1204	12.700	5.50	1.6	4.76



Lämplighet och startvärden för skärhastighet (vc), matning (f) och skärdjup (ap). Vi refererar till vår Dormer Pramet Calculator-app för vidare beräkningar.

Product	RE (mm)	P			M			K			N			S			H		
		vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)



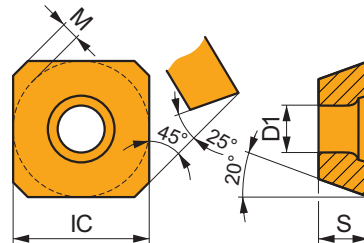
FA geometri med mycket positiv design för fin till medelfin fräsning.

SEET 1204AFN-FA:HF7	●	-	-	-	-	-	-	-	-	■	330	0.18	3.0	-	-	-	-	-	-
---------------------	---	---	---	---	---	---	---	---	---	---	-----	------	-----	---	---	---	---	---	---

SEEW 12

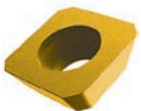


	IC (mm)	D1 (mm)	M (mm)	S (mm)
1204	12.700	5.50	1.6	4.76



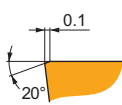
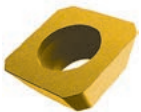
Lämplighet och startvärden för skärhastighet (vc), matning (f) och skärdjup (ap). Vi refererar till vår Dormer Pramet Calculator-app för vidare beräkningar.

Product	RE (mm)	P			M			K			N			S			H		
		vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)



AFEN eggpreparering, neutral geometri för fin till medelfin fräsning.

SEEW 1204AFEN:M8330	●	-	■	265	0.15	2.5	-	-	-	■	250	0.15	2.5	-	-	-	-	-	-
SEEW 1204AFEN:M8340	●	-	■	240	0.15	2.5	-	-	-	■	225	0.15	2.5	-	-	-	-	-	-



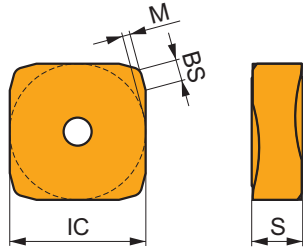
AFSN eggpreparering, neutral geometri för fin till medelfin fräsning.

SEEW 1204AFSN:8215	●	-	■	250	0.20	2.5	-	-	-	■	235	0.20	2.5	-	-	-	-	-	■	50	0.13	1.0
SEEW 1204AFSN:M8330	●	-	■	245	0.20	2.5	-	-	-	■	230	0.20	2.5	-	-	-	-	-	■	45	0.13	1.0
SEEW 1204AFSN:M8340	●	-	■	225	0.20	2.5	-	-	-	■	210	0.20	2.5	-	-	-	-	-	-	-	-	-
SEEW 1204AFSN:M9325	●	-	■	305	0.20	2.5	-	-	-	■	285	0.20	2.5	-	-	-	-	-	■	60	0.13	1.0

SNHF

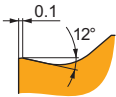


	BS (mm)	IC (mm)	M (mm)	S (mm)
1204	2.00	12.700	0.5	4.76
1504	1.40	15.875	1.1	4.76



Lämplighet och startvärden för skärhastighet (vc), matning (f) och skärdjup (ap). Vi refererar till vår Dormer Pramet Calculator-app för vidare beräkningar.

Product	RE (mm)	P			M			K			N			S			H		
		vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)



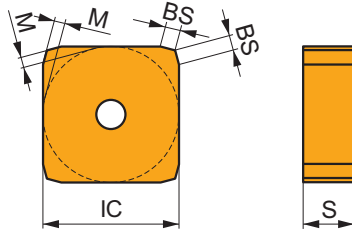
M geometri med positiv design för fin till medelfin fräsning.

SNHF 1204ENSR-M:M8330	☼	–	■	235	0.15	4.0	–	–	–	▣	220	0.15	4.0	–	–	–	–	–	–
SNHF 1504ENSR-M:M8340	☼	–	■	220	0.15	6.0	–	–	–	▣	205	0.15	6.0	–	–	–	–	–	–

SNHN

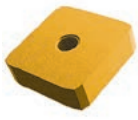


	BS (mm)	IC (mm)	M (mm)	S (mm)
1204	1.40	12.700	0.9	4.76
1504	1.40	15.875	1.3	4.76



Lämplighet och startvärden för skärhastighet (vc), matning (f) och skärdjup (ap). Vi refererar till vår Dormer Pramet Calculator-app för vidare beräkningar.

Product	RE (mm)	P			M			K			N			S			H		
		vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)



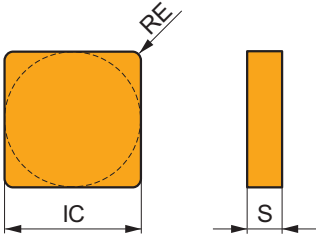
ENEN standard negativ fräsgeometri för 75° planfräsning.

SNHN 1204ENEN:8215	☼	–	▣	275	0.15	6.0	–	–	–	■	260	0.15	6.0	–	–	–	–	–	▣	55	0.11	1.0
SNHN 1204ENEN:M8330	☼	–	▣	270	0.15	6.0	–	–	–	■	255	0.15	6.0	–	–	–	–	–	▣	50	0.11	1.0
SNHN 1204ENEN:M8340	☼	–	▣	245	0.15	6.0	–	–	–	▣	230	0.15	6.0	–	–	–	–	–	–	–	–	–
SNHN 1204ENEN:S26	☼	–	▣	110	0.15	6.0	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	
SNHN 1504ENEN:8215	☼	–	▣	260	0.15	9.0	–	–	–	■	245	0.15	9.0	–	–	–	–	–	▣	50	0.11	1.3
SNHN 1504ENEN:M8330	☼	–	▣	260	0.15	9.0	–	–	–	■	245	0.15	9.0	–	–	–	–	–	▣	50	0.11	1.3
SNHN 1504ENEN:M8340	☼	–	▣	235	0.15	9.0	–	–	–	▣	220	0.15	9.0	–	–	–	–	–	–	–	–	–
SNHN 1504ENEN:S26	☼	–	▣	105	0.15	9.0	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	

SNUN

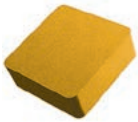


	IC (mm)	S (mm)
1204	12.700	4.76
1504	15.875	4.76



Lämplighet och startvärden för skärhastighet (vc), matning (f) och skärdjup (ap). Vi refererar till vår Dormer Pramet Calculator-app för vidare beräkningar.

Product	RE (mm)	P			M			K			N			S			H		
		vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)



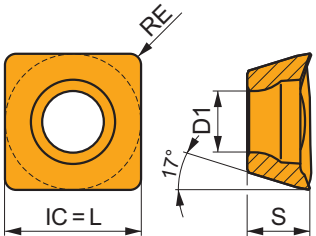
N fräskär med negativ geometri som också kan användas till svarvning.

SNUN 120408:M8330	0.8	260	0.13	4.5	–	–	–	245	0.13	4.5	–	–	–	–	–	–	50	0.10	1.0
SNUN 120412:M8330	1.2	275	0.13	4.5	–	–	–	260	0.13	4.5	–	–	–	–	–	–	55	0.10	1.0
SNUN 150412:M8330	1.2	255	0.15	6.0	–	–	–	240	0.15	6.0	–	–	–	–	–	–	50	0.12	1.3

SOMT 05

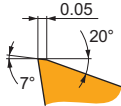


	IC (mm)	D1 (mm)	L (mm)	S (mm)
0502	5.570	2.50	5.57	2.63



Lämplighet och startvärden för skärhastighet (vc), matning (f) och skärdjup (ap). Vi refererar till vår Dormer Pramet Calculator-app för vidare beräkningar.

Product	RE (mm)	P			M			K			N			S			H		
		vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)



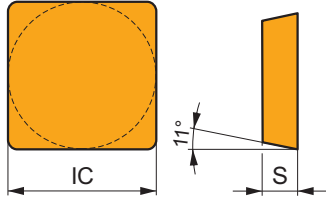
M geometri med positiv design för fin till medelfin fräsning.

SOMT 050204SR-M:M6330	0.4	255	0.05	2.5	180	0.05	2.5	–	–	–	–	–	–	75	0.04	2.0	–	–	–
SOMT 050204SR-M:M8330	0.4	290	0.05	2.5	170	0.05	2.5	275	0.05	2.5	–	–	–	70	0.04	2.0	–	–	–
SOMT 050208SR-M:M8330	0.8	350	0.05	2.5	210	0.05	2.5	330	0.05	2.5	–	–	–	85	0.04	2.0	–	–	–

SPGN

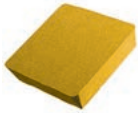


	IC (mm)	S (mm)
0903	9.525	3.18
1203	12.700	3.18
1504	15.875	4.76



Lämplighet och startvärden för skärhastighet (vc), matning (f) och skärdjup (ap). Vi refererar till vår Dormer Pramet Calculator-app för vidare beräkningar.

Product	RE (mm)	P			M			K			N			S			H		
		vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)



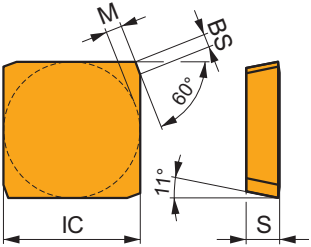
N vändskär med neutral spänvinkeldesign som också kan användas till svarvning.

SPGN 090308:M8340	0.8	225	0.15	2.0	–	–	–	210	0.15	2.0	–	–	–	–	–	–	–	–
SPGN 120308:M8330	0.8	230	0.15	4.0	–	–	–	215	0.15	4.0	–	–	–	–	–	–	–	–
SPGN 150412:M8330	1.2	225	0.20	5.0	–	–	–	210	0.20	5.0	–	–	–	–	–	–	–	–

SPGN 25 DZ

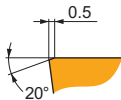
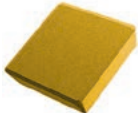


	IC (mm)	M (mm)	S (mm)	BS (mm)
2506	25.000	3.5	6.35	2.40



Lämplighet och startvärden för skärhastighet (vc), matning (f) och skärdjup (ap). Vi refererar till vår Dormer Pramet Calculator-app för vidare beräkningar.

Product	RE (mm)	P			M			K			N			S			H		
		vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)



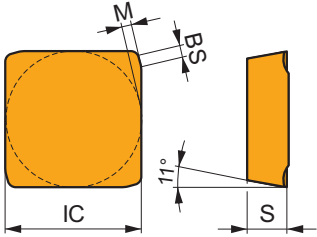
DZ geometri med neutralspänvinkel för grovfräsning.

SPGN 2506DZSR:M8326	–	110	0.50	12.0	–	–	–	100	0.50	12.0	–	–	–	–	–	–	–	–
SPGN 2506DZSR:M8346	–	90	0.50	12.0	–	–	–	–	–	–	–	–	–	–	–	–	–	–

SPKR

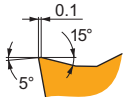
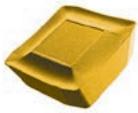


	IC (mm)	L (mm)	M (mm)	S (mm)
1203	12.700	12.70	0.9	3.18
1504	15.875	15.88	1.2	4.76



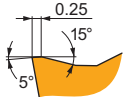
Lämplighet och startvärden för skärhastighet (vc), matning (f) och skärdjup (ap). Vi refererar till vår Dormer Pramet Calculator-app för vidare beräkningar.

Product	RE (mm)	P			M			K			N			S			H		
		vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)



EDSR eggpreparering, spånbrytargeometri för medel till grovfräsning.

SPKR 1203EDSR:M8330	☺	–	■	265	0.20	4.0	▣	155	0.18	4.0	■	250	0.20	4.0	–	–	–	–	–	–
SPKR 1203EDSR:M8340	☺	–	■	240	0.20	4.0	▣	140	0.18	4.0	■	225	0.20	4.0	–	–	–	–	–	–



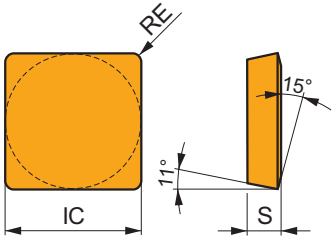
EDSR eggpreparering, spånbrytargeometri för medel till grovfräsning.

SPKR 1504EDSR:M8330	☺	–	■	245	0.25	5.0	▣	145	0.25	5.0	■	230	0.25	5.0	–	–	–	–	–	–
SPKR 1504EDSR:M8340	☺	–	■	225	0.25	5.0	▣	135	0.25	5.0	■	210	0.25	5.0	–	–	–	–	–	–

SPUN



	IC (mm)	S (mm)
1203	12.700	3.18
1504	15.875	4.76
1904	19.050	4.76
2506	25.400	6.35



Lämplighet och startvärden för skärhastighet (vc), matning (f) och skärdjup (ap). Vi refererar till vår Dormer Pramet Calculator-app för vidare beräkningar.

Product	RE (mm)	P			M			K			N			S			H		
		vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)



N vändskär med neutral spåninkeldesign som också kan användas till svarvning.

SPUN 120304:M8330	☺	0.4	■	195	0.15	4.0	–	–	–	▣	185	0.15	4.0	–	–	–	–	–	–	–
SPUN 120308:M8330	☺	0.8	■	230	0.15	4.0	–	–	–	▣	215	0.15	4.0	–	–	–	–	–	–	–
SPUN 120308:S26	☺	0.8	■	95	0.15	4.0	–	–	–	–	–	–	–	–	–	–	–	–	–	–
SPUN 120312:M8330	☺	1.2	■	245	0.15	4.0	–	–	–	▣	230	0.15	4.0	–	–	–	–	–	–	–

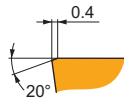
Lämplighet och startvärden för skärhastighet (vc), matning (f) och skärdjup (ap). Vi refererar till vår Dormer Pramet Calculator-app för vidare beräkningar.

Product	RE (mm)	P			M			K			N			S			H		
		vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)



N vändskär med neutral spåninkeldesign som också kan användas till svarvning.

SPUN 150412:M8330	✳	1.2	225	0.20	5.0	–	–	–	210	0.20	5.0	–	–	–	–	–	–	–	–
SPUN 190408:M8330	✳	0.8	210	0.20	6.0	–	–	–	195	0.20	6.0	–	–	–	–	–	–	–	–
SPUN 190412:M8330	✳	1.2	220	0.20	6.0	–	–	–	205	0.20	6.0	–	–	–	–	–	–	–	–



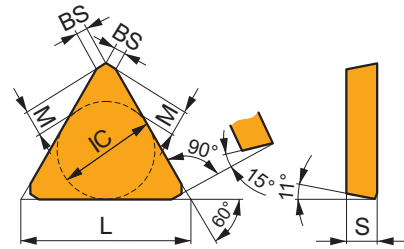
N vändskär med neutral spåninkeldesign som också kan användas till svarvning.

SPUN 250616S:M8326	✳	1.6	115	0.40	12.0	–	–	–	105	0.40	12.0	–	–	–	–	–	–	–	–
SPUN 250620S:M5326	✳	2.0	145	0.40	12.0	–	–	–	135	0.40	12.0	–	–	–	–	–	–	–	–
SPUN 250620S:M8326	✳	2.0	120	0.40	12.0	–	–	–	110	0.40	12.0	–	–	–	–	–	–	–	–
SPUN 250620S:M8346	✳	2.0	100	0.40	12.0	–	–	–	–	–	–	–	–	–	–	–	–	–	–
SPUN 250620S:S26	✳	2.0	45	0.40	12.0	–	–	–	–	–	–	–	–	–	–	–	–	–	–

TPCN 16

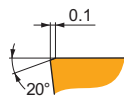
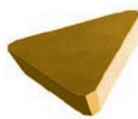


	BS (mm)	IC (mm)	L (mm)	M (mm)	S (mm)
1603	1.20	9.530	16.10	2.5	3.18



Lämplighet och startvärden för skärhastighet (vc), matning (f) och skärdjup (ap). Vi refererar till vår Dormer Pramet Calculator-app för vidare beräkningar.

Product	RE (mm)	P			M			K			N			S			H		
		vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)



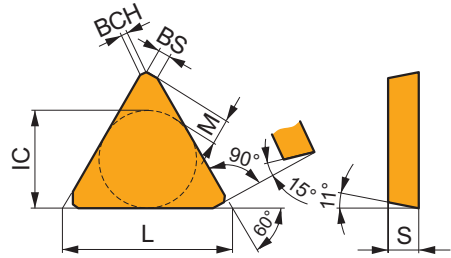
XNCB speciell design för skivfräsning.

TPCN 1603PDSN:M8330	✳	–	195	0.20	–	–	–	–	185	0.20	–	–	–	–	–	–	–	–	–
---------------------	---	---	-----	------	---	---	---	---	-----	------	---	---	---	---	---	---	---	---	---

TPKN

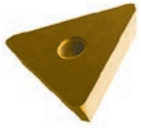


	IC (mm)	L (mm)	M (mm)	S (mm)	BCH (mm)	BS (mm)
1603	9.530	16.50	2.5	3.18	1.20	1.30
2204	12.700	22.00	3.5	4.76	1.20	1.50



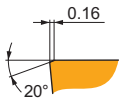
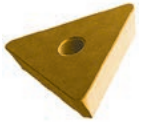
Lämplighet och startvärden för skärhastighet (vc), matning (f) och skärdjup (ap). Vi refererar till vår Dormer Pramet Calculator-app för vidare beräkningar.

Product	RE (mm)	P			M			K			N			S			H		
		vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)



PDER eggpreparering, neutral spånvinkel för fin till medelfin fräsning.

TPKN 1603PDER:M8330	●	–	✓	195	0.15	4.0	–	–	–	✓	185	0.15	4.0	–	–	–	–	–	–	–	–	–	–
TPKN 1603PDER:M8340	●	–	✓	175	0.15	4.0	–	–	–	✓	165	0.15	4.0	–	–	–	–	–	–	–	–	–	–
TPKN 2204PDER:8215	●	–	✓	190	0.15	5.5	–	–	–	✓	180	0.15	5.5	–	–	–	–	–	–	–	–	–	–
TPKN 2204PDER:M8330	●	–	✓	190	0.15	5.5	–	–	–	✓	180	0.15	5.5	–	–	–	–	–	–	–	–	–	–
TPKN 2204PDER:M8340	●	–	✓	170	0.15	5.5	–	–	–	✓	160	0.15	5.5	–	–	–	–	–	–	–	–	–	–



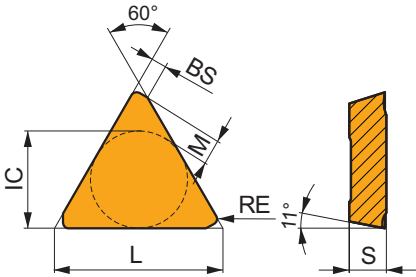
PDSR eggpreparering, neutral spånvinkel för medelfin fräsning.

TPKN 1603PDSR:M8330	●	–	✓	185	0.20	4.0	–	–	–	✓	175	0.20	4.0	–	–	–	–	–	–	–	–	–	–	–		
TPKN 1603PDSR:M8340	●	–	✓	165	0.20	4.0	–	–	–	✓	155	0.20	4.0	–	–	–	–	–	–	–	–	–	–	–		
TPKN 1603PDSR:S26	●	–	✓	75	0.20	4.0	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–		
TPKN 2204PDSR:M8310	●	–	✓	195	0.20	5.5	–	–	–	✓	185	0.20	5.5	–	–	–	–	–	–	–	–	–	✓	35	0.13	1.0
TPKN 2204PDSR:M8330	●	–	✓	175	0.20	5.5	–	–	–	✓	165	0.20	5.5	–	–	–	–	–	–	–	–	–	✓	35	0.13	1.0
TPKN 2204PDSR:M8340	●	–	✓	160	0.20	5.5	–	–	–	✓	150	0.20	5.5	–	–	–	–	–	–	–	–	–	–	–	–	
TPKN 2204PDSR:M9325	●	–	✓	220	0.20	5.5	–	–	–	✓	205	0.20	5.5	–	–	–	–	–	–	–	–	–	✓	40	0.13	1.0
TPKN 2204PDSR:S26	●	–	✓	75	0.20	5.5	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	

TPKR

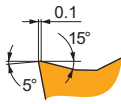


	IC (mm)	L (mm)	M (mm)	S (mm)	BS (mm)
1603	9.530	16.50	2.5	3.18	1.40
2204	12.700	22.00	3.5	4.76	1.40



Lämplighet och startvärden för skärhastighet (vc), matning (f) och skärdjup (ap). Vi refererar till vår Dormer Pramet Calculator-app för vidare beräkningar.

Product	RE (mm)	P			M			K			N			S			H		
		vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)



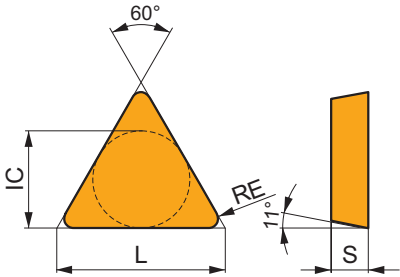
PDSR eggpreparering, spånbrytargeometri för medel till grov fräsning.

TPKR 1603PDSR:M8330	●	–	■	185	0.20	4.0	▣	110	0.18	4.0	■	175	0.20	4.0	–	–	–	–	–	–
TPKR 1603PDSR:M8340	●	–	■	165	0.20	4.0	▣	95	0.18	4.0	■	155	0.20	4.0	–	–	–	–	–	–
TPKR 2204PDSR:M8330	●	–	■	175	0.20	5.5	▣	105	0.18	5.5	■	165	0.20	5.5	–	–	–	–	–	–
TPKR 2204PDSR:M8340	●	–	■	160	0.20	5.5	▣	95	0.18	5.5	■	150	0.20	5.5	–	–	–	–	–	–
TPKR 2204PDSR:M9325	●	–	■	220	0.20	5.5	–	–	–	–	■	205	0.20	5.5	–	–	–	–	–	–

TPUN



	IC (mm)	L (mm)	S (mm)
1103	6.350	11.00	3.18
1603	9.525	16.50	3.18
2204	12.700	22.00	4.76



Lämplighet och startvärden för skärhastighet (vc), matning (f) och skärdjup (ap). Vi refererar till vår Dormer Pramet Calculator-app för vidare beräkningar.

Product	RE (mm)	P			M			K			N			S			H		
		vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)



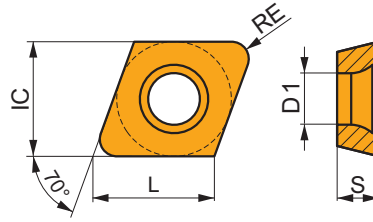
N vändskär med neutral spåninkeldesign som också kan användas till svarvning.

TPUN 110304:M8330	●	0.4	–	–	–	–	–	–	–	■	150	0.10	1.2	–	–	–	–	–	–	▣	30	0.10	0.4	
TPUN 160304:R215	●	0.4	▣	155	0.15	4.0	–	–	–	■	145	0.15	4.0	–	–	–	–	–	–	–	–	–	–	
TPUN 160304:H10	●	0.4	–	–	–	–	–	–	–	▣	65	0.15	4.0	–	–	–	–	–	–	–	–	–	–	
TPUN 160304:M8330	●	0.4	▣	155	0.15	4.0	–	–	–	■	145	0.15	4.0	–	–	–	–	–	–	–	–	–	–	
TPUN 160304:S26	●	0.4	▣	65	0.15	4.0	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	
TPUN 160308:R215	●	0.8	▣	185	0.15	4.0	–	–	–	■	175	0.15	4.0	–	–	–	–	–	–	–	–	–	–	
TPUN 160308:M8330	●	0.8	–	–	–	–	–	–	–	■	155	0.18	1.5	–	–	–	–	–	–	–	▣	30	0.11	0.6
TPUN 160312:M8330	●	1.2	–	–	–	–	–	–	–	■	155	0.20	1.5	–	–	–	–	–	–	–	▣	30	0.11	0.8
TPUN 220408:M8330	●	0.8	▣	170	0.20	5.0	–	–	–	■	160	0.20	5.0	–	–	–	–	–	–	–	–	–	–	
TPUN 220412:M8330	●	1.2	–	–	–	–	–	–	–	■	155	0.20	2.0	–	–	–	–	–	–	–	▣	30	0.11	1.0

XDHW

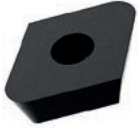


	IC (mm)	D1 (mm)	L (mm)	S (mm)
0702	6.500	2.95	6.90	2.38
10T3	10.000	3.95	10.60	3.97



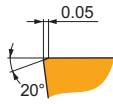
Lämplighet och startvärden för skärhastighet (vc), matning (f) och skärdjup (ap). Vi refererar till vår Dormer Pramet Calculator-app för vidare beräkningar.

Product	RE (mm)	P			M			K			N			S			H		
		vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)



EN geometri med neutral spånvinkel för spårfräsning.

XDHW 070210EN:M8310	1.0	310	0.10	1.0	–	–	–	290	0.10	1.0	–	–	–	–	–	–	60	0.05	1.0
----------------------------	-----	-----	------	-----	---	---	---	-----	------	-----	---	---	---	---	---	---	----	------	-----



SN geometri med neutral spånvinkel för spårfräsning.

XDHW 070210SN:M8310	1.0	310	0.10	1.0	–	–	–	290	0.10	1.0	–	–	–	–	–	–	60	0.05	1.0
XDHW 070210SN:M8325	1.0	230	0.10	1.0	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
XDHW 10T310SN:M8310	1.0	275	0.15	1.0	–	–	–	260	0.15	1.0	–	–	–	–	–	–	55	0.08	1.0
XDHW 10T310SN:M8325	1.0	210	0.15	1.0	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–



ANVISNINGAR

INDEXABLE MILLS – PAGE OVERVIEW

1 SAD11E

P M K N S H 2

PRAMET 3 S

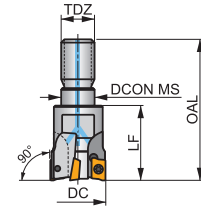
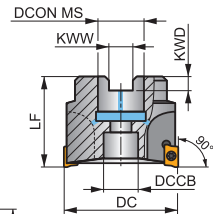
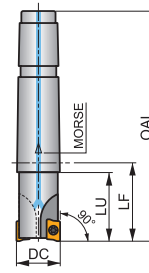
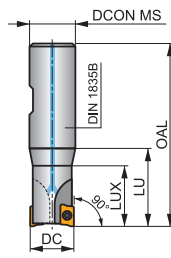
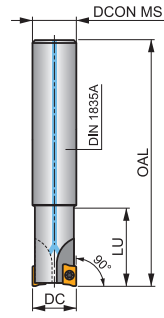
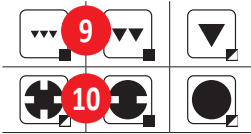
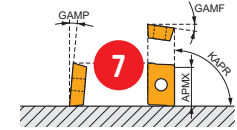


FORCE AD11 Rak hörnfräs med invändig kylning

90° hörn- och planfräs för positiva AD.. 11-skär med APMX 9 mm. Passar för en rad olika applikationer, bl a rampning, trochoidalfräsning och dykfräsning. Finns med cyl. skaft, Weldon-skaft, morse-kona, modulärt eller dornfäste (med differentiell tanddelning). Behandlad för lång livslängd.

FORCE AD

KAPR	90°
APMX	9.0 mm



h_a	0.06 – 0.13
h_b	0.08 – 0.16



Product	DC	OAL	DCON MS	DCCB	LU	LUX	LF	TDZ	CZC MS	KWW	KWD	GAMF	GAMP	16	18	20	22
	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(°)	(°)				
16A2R024A14-SAD11E-C	16	160	14	-	24	-	-	-	-	-	-	-12.8	4	2	30100	0.19	G1169 SQ025
16A2R024A16-SAD11E-C	16	135	16	-	24	-	-	-	-	-	-	-12.8	4	2	01000	0.19	G1169 SQ025
16A2R050A16-SAD11E-C	16	135	16	-	50	-	-	-	-	-	-	-12.8	4	2	30100	0.20	G1169 SQ025
18A2R029A20-SAD11E-C	18	150	20	-	29	-	-	-	-	-	-	-12	4.5	2	28400	✓	0.35 G1169 SQ025
20A2R029A20-SAD11E-C	20	150	20	-	29	-	-	-	-	-	-	-11.5	5	2	27000	✓	0.33 G1169 SQ020
20A2R077A20-SAD11E-C	20	150	20	-	70	-	-	-	-	-	-	-11.5	5	2	27000	✓	0.32 G1169 SQ020
20A3R018A20-SAD11E-C	20	200	18	-	29	-	-	-	-	-	-	-11.5	5	3	27000	✓	0.36 G1169 SQ025
20A3R029A20-SAD11E-C	20	150	20	-	29	-	-	-	-	-	-	-11.5	5	3	27000	✓	0.31 G1169 SQ025
22A3R029A20-SAD11E-C	22	200	20	-	29	-	-	-	-	-	-	-11.5	5	3	25600	✓	0.45 G1169 SQ025
25A3R034A25-SAD11E-C	25	170	25	-	34	-	-	-	-	-	-	-10.2	5	3	24100	✓	0.42 G1169 SQ020
25A3R080A25-SAD11E-C	25	170	25	-	80	-	-	-	-	-	-	-10.2	5	3	24100	✓	0.52 G1169 SQ020
25A4R034A25-SAD11E-C	25	170	25	-	34	-	-	-	-	-	-	-10.2	5	4	24100	✓	0.56 G1169 SQ025
25A4R040A25-SAD11E-C	25	250	25	-	40	-	-	-	-	-	-	-10.2	5	4	24100	✓	0.85 G1169 SQ025
30A3R080A32-SAD11E-C	30	200	32	-	80	-	-	-	-	-	-	-9.3	7	3	22000	✓	0.98 G1169 SQ020

G1169	ADMX 11T3..	24	ADEX 11T3..
-------	-------------	----	-------------

SQ020	US 62S06-T07P	1.2	M 2.5	6	25	-	-	Flag T07P	-
SQ021	US 62S06-T07P	1.2	M 2.5	6	-	D-T07P/T09P	FG-15	-	-
SQ022	US 62S06-T07P	1.2	M 2.5	6	-	D-T07P/T09P	FG-15	-	HS 0830C
SQ023	US 62S06-T07P	1.2	M 2.5	6	-	D-T07P/T09P	FG-15	-	HS 1030C
SQ025	US 62S05-T07P	1.2	M 2.5	5	-	-	-	Flag T07P	-

AC001	KS 1230	26	K.FMH27
AC002	KS 1635	-	K.FMH32
AC003	KS 2040	-	K.FMH40

INDEXABLE MILLS – PAGE OVERVIEW

Pos.	Description	Pos.	Description
1	Designation of cutter	14	ISO code of cutter
2	Material group recommendations	15	Dimensions (mm), angles ¹⁾ (°) and connection size code
3	Clamping system of insert	16	Number of teeth
4	Illustrative picture	17	Irregular teeth pitch
5	Tool description	18	Maximum revolutions of cutter
6	Setting angle and maximum theoretical depth of cut (mm)	19	Internal supply of coolant
7	Tool geometry	20	Weight (kg)
8	Schematic drawing of tool	21	Group of compatible inserts ²⁾
9	Achievable quality of surface	22	Group of spare parts ²⁾
10	Character of cut/working conditions	23	Group of special accessories ²⁾
11	Maximum range of mean chip thickness (mm) for end milling cutters and/or shell milling cutters	24	Compatible inserts
12	Product applications	25	Spare parts
13	Shank type	26	Special accessories

¹⁾ γ_f = Radial rake setting angle (GAMF) of insert pocket – see indexable mills technical information

γ_p = Axial rake setting angle (GAMP) of insert pocket – see indexable mills technical information

²⁾ Spare parts and special accessories icons are designed schematically for their ease of understanding. They aren't included in the list of icons. Screws are, in some cases, completed with info on torque value in Nm, length of screw and size of thread.

MILLING INSERTS – PAGE OVERVIEW

1

ADMX 11

	W1	D1	L	S
	(mm)	(mm)	(mm)	(mm)
11T3	6.530	2.90	11.00	3.97

Lämplighet och startvärden för skärhastighet (vc), matning (f) och skärdjup (ap). Vi refererar till vår Dormer Pramet Calculator-app för vidare beräkningar.

Product	RE (mm)	P			M			K			N			S			H			
		vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	
		(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	

F geometri med mycket vass positiv design för finfräsning.

ADMX 11T304SR-F:8215	● 0.4	■ 245	0.10	2.0	▲ 145	0.09	2.0	■ 230	0.10	2.0	▲ 735	0.12	2.0	■ 60	0.08	1.6	–	–	–
ADMX 11T304SR-F:M8330	● 0.4	■ 240	0.10	2.0	▲ 140	0.09	2.0	■ 225	0.10	2.0	▲ 720	0.12	2.0	■ 60	0.08	1.6	–	–	–
ADMX 11T304SR-F:M8340	● 0.4	■ 220	0.10	2.0	▲ 130	0.09	2.0	■ 205	0.10	2.0	▲ –	–	–	■ 55	0.08	1.6	–	–	–
ADMX 11T308SR-F:M9340	● 0.8	■ 285	0.10	2.0	▲ 170	0.09	2.0	■ –	–	–	▲ –	–	–	■ 70	0.08	1.6	–	–	–
ADMX 11T308SR-F:8215	● 0.8	■ 290	0.10	2.0	▲ 170	0.09	2.0	■ 275	0.10	2.0	▲ 870	0.12	2.0	■ 70	0.08	1.6	–	–	–
ADMX 11T308SR-F:M8330	● 0.8	■ 285	0.10	2.0	▲ 170	0.09	2.0	■ 270	0.10	2.0	▲ 855	0.12	2.0	■ 70	0.08	1.6	–	–	–
ADMX 11T308SR-F:M8340	● 0.8	■ 260	0.10	2.0	▲ 155	0.09	2.0	■ 245	0.10	2.0	▲ –	–	–	■ 65	0.08	1.6	–	–	–
ADMX 11T308SR-F:M9340	● 0.8	■ 340	0.10	2.0	▲ 200	0.09	2.0	■ –	–	–	▲ –	–	–	■ 85	0.08	1.6	–	–	–

Pos.	Description
1	Designation of insert
2	Table with insert sizes (mm)
3	Schematic drawing of insert
4	Picture of representative insert
5	Profile of main cutting edge
6	Icons – specific features and cutting edge type

Pos.	Description
7	ISO insert code:Grade
8	Working conditions
9	Insert radii (mm)
10	Geometry description
11	Application area of insert ¹⁾

¹⁾ Recommendations for cutting speed corrections can be found at the end of Milling chapter in the technical section.

Technical information follows immediately after the milling cutter pages, their compatible inserts and info on starting cutting speeds. These will help you to use the tools in the correct way. If you are unsure how to use or interpret this information, either refer to the technical section at the end of the milling chapter or contact your Dormer Pramet representative.

Typical page with milling inserts displayed – specific page details will differ. Most of inserts can be found in this catalogue just immediately after the relevant milling cutter or, alternatively, in the separate inserts chapter.

IKONÖVERSIKT

General Icons

	Förstaval		Finsvarvning		Passar vid stabila arbetsförhållanden
	Möjlig användning		Medelfin svarvning		Passar vid instabila arbetsförhållanden
			Grovsvarvning		Passar vid mycket instabila arbetsförhållanden

Milling operations

	Planfräsning		Dykfräsning		Fasfräsning
	Grund hörnfräsning		Progressiv dykfräsning		T-spårsfräsning
	Hörnfräsning, hög kant		Rampning		Fräsning av bakomliggande yta
	Grund spårfräsning		Spiralinterpolering		Kopierfräsning
	Djup spårfräsning		Spiralinterpolering i förborrat hål		

Features

	Förstaval		Tunnväggiga och slanka arbetsstycken		Tunga arbetsförhållanden
	Universalalternativ för de flesta jobb		Långt överhäng		
	Vändskär med wipergeometri		Högmatningsbearbetning		

Skäreggskod (CECC)

	Vass egg		Egg med fasett		Rundad egg med dubbla fasetter
	Rundad egg		Rundad egg med fasett		

Inspänningskod (MTP)

	S – Skruvspänning		System F		Skruvens åtdragningsmoment (Nm)
	C – Toppinspanning		System SC		

IKONÖVERSIKT

Skaft

DIN 1835A	DIN 1835A Cylindriskt skaft	ISO/DIS 7388-1	Dorn DIN 69871-1	ISO 6462 DIN 8030	Dornfräs DIN 8030 – konisk fräs
DIN 1835B	DIN 1835B Weldon-skaft	ISO 297	Dorn DIN 2080-1	ISO 6462 DIN 8030	Dornfräs DIN 8030 – skivfräs
DIN 228A	Morse-skaft DIN 228-1	JIS B 6339	Dorn MAS BT (JIS-B-6339)		
MODULAR	Gängat fäste	ISO 6462 DIN 8030	Dornfräs DIN 8030		

Technical parts

$\frac{a_e}{DC}$	Ratio (%) of radial width of cut to cutting diameter	a_p	Depth of cut (mm)	Z	Number of teeth
$\frac{a_e}{DCX}$	Ratio (%) of radial width of cut to maximal cutting diameter	DC	Diameter of cutter (mm)	APLX	Effective working length of tool (mm)
X.V	Multiplication factor for cutting speed	DCX	Maximum diameter of cutter (mm)	S	Number of teeth (helical cutters)
X.f	Multiplication factor for feed (machining on centre line)	DEF	Effective diameter of cutter (mm)	ODX	Effective reach of tool (mm)
X.f	Multiplication factor for feed (machining off centre line)	e_{max}	Maximum width of machined area (mm)	K	Effective number of teeth
Chipbreaker		max	Cutting depth for plunging (mm)	Chamfering angle (°)	
RE	Corner radius of insert (mm)	RPMX	Maximal angle for ramping (°)	Number of edges in use	
BS	Wiper edge length (mm)	APMX/I	Maximum cutting depth over the length of cut (mm)	Hole diameter (mm)	
f	Feed (mm/tooth)	SMAX	Maximal depth per revolution for maximal diameter of hole (mm)	R_a (mm)	
Starting feed	(mm/tooth)	DMIN	Maximal depth per revolution for minimal diameter of hole (mm)	Thread pitch	
f_{min}	Minimal feed (mm/tooth)	FE	Contouring step in conventional milling (mm)	Threads per inch	
f_{max}	Maximal feed (mm/tooth)	FE	Contouring step in up/down cross milling (mm)	Time (min)	

ISO-KODER – PLANFRÄSKROPPAR

ISO	1	2	3	4	-	5	6	7	8	9	10	11	12
	63	A	06	R	-		S	90	A	D	16	E	
ANSI	1	2	3	4	-	5	6	7	8	9	10	11	12
	300	F	04	N	-	I	S	90	S	N	12	N	4

1	1	2			3	3	5	6	6	7	7
Fräsdiameter	Frästyp, beteckning och/eller inspänningsmått	Antal skär			Standard	Inspänningsmetod	Ingreppsvinkel (KAPR)				
		4			I	C	90°				
	A ISO 6462/A DIN 8030/A	4			(")	S	75°				
	B ISO 6462/B DIN 8030/B	Skärriktning			R	W	60°				
	C ISO 6462/C DIN 8030/C				L	F	45°				
	F DC = 27 mm DC = 1.000	R			N		MO				
	G DC = 32 mm DC = 1.250	L					DC [mm]				
	H DC = 40 mm	N									
	J DC = 50 mm										
	K DC = 60 mm										
	M DC = 80 mm										
	T										

8				8			
Vändskärsform				Släppningsvinkel			
H	O	P	R	A	B	C	D
S	T	C	D	E	F	G	N
E	M	V	W	P	O		
L	A	B	K				

9		9	
Släppningsvinkel			
A	B	C	D
E	F	G	N
P	O		

10												10														
Skärkantlängd												Skärkantlängd														
IC		H	O	P	S	T	C	D	E	M	V	W	R	K												
(mm)	(")																									
3.97					03	06		04			06	02														
	5/32"																									
4.76					04	08	04	05	04	04	08	L3														
	3/16"																									
5.56					05	09	05	06	05	05	09	03														
	7/32"																									
6.35		03	02	04	08	11	06	07	08	08	11	04	06													
	1/4"																									
7.94		04	03	05	07	13	08	09	06	07	13	05	07													
	5/16"																									
9.525		05	04	07	09	16	09	11	09	09	16	06	09	19												
	3/8"																									
12.7		07	05	09	12	22	12	15	13	12	22	08	12													
	1/2"																									
15.875		09	06	11	15	27	16	19	16	15	27	10	15													
	5/8"																									
19.05		11	07	13	19	33	19	23	19	19	33	13	19													
	3/4"																									
25.4		14	10	18	25	44	25	31	26	25	44	17	25													
	5/1"																									
31.75		18	13	23	31	54	32	38	32	31	54	21	31													
	1 1/4"																									

11		11	
Släppningsvinkel			
N ALP = 0°	C ALP = 7°	P ALP = 11°	
D ALP = 15°	E ALP = 20°	F ALP = 25°	

12		12	
Skärbredd (-längd)			
CW (mm) / (")		APMX	
CW	1/16"		
0.156	2.5		
0.187	3		
0.250	4		
0.313	5		
0.375	6		

ISO-KODER – HÖRNFRÄSAR

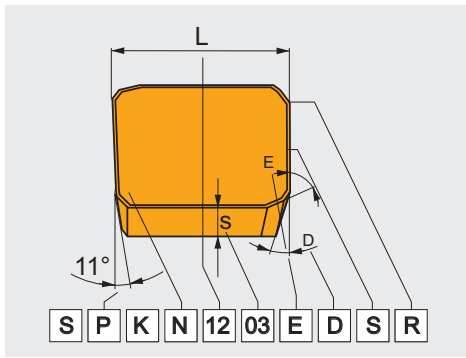
ISO	1	2	3	4	5	6	7	-	8	9	10	11	12	13
	32	A	4	R	042	B	32	-		S	A	D	11	E
ANSI	1	2	3	4	5	6	7	-	8	9	10	11	12	13
	125	A	4	R	150	W	125	-	I	S	A	D	11	E

1	1	2	2					5	5	6	6				7	7
Fräsdiameter		Frästyp och ingreppsvinkel						Överhäng		Skaftbeteckning				Skaftstorlek		
		A	E	J	N	H	K	(mm)		A	C	DIN 1835A		6–40 mm	.250"–1.250"	
								(")		B	W	ISO 3338-2, DIN 1835B		6–50 mm	.375"–2.000"	
		3			4					E	-	ISO 296, DIN 228-1		1–6	-	
		Antal skär			Skärriktning					G	-	ISO 297, DIN 208-1		40–50 mm	-	
					R	L	N			H	-	ISO/DIS 7388-1, DIN 69871-1		30–50 mm	-	
										N	-	ISO 12 164-1, DIN 69893		25–100 mm	-	
										-	R8	R8		-	1.250"	
										X	-	MAS BT		30–50	-	
										XC	-	CAPTO		3–10	-	
										-	CA	ANSI B5.50		-	40/50	

10	10				11	11		12	12												
Vändskärsform					Släppningsvinkel			Skärkantslängd													
H	O	P	R		A	B	IC	H	O	P	S	T	C	D	E	M	V	W	R	K	
							(mm)														
					3°	5°	(")														
S	T	C	D		C	D	3.97				03	06		04			06	02			
							5/32"							1.2"							
					7°	15°	4.76				04	08	04	05	04	04	08	L3			
E	M	V	W		E	F	3/16"				05	09	05	06	05	05	09	03			
							5.56							1.5"							
					20°	25°	7/32"							1.8"							
L	A	B	K		G	N	6.35	03	02	04	08	11	06	07	08	08	11	04	06		
							1/4"							2"							
					30°	0°	7.94	04	03	05	07	13	08	09	06	07	13	05	07		
L	A	B	K		P	O	5/16"							2.5"							
							9.525	05	04	07	09	16	09	11	09	09	16	06	09	19	
					11°	Special	3/8"							3"							
							12.7	07	05	09	12	22	12	15	13	12	22	08	12		
							15.875	09	06	11	15	27	16	19	16	15	27	10	15		
							5/8"							4"							
							19.05	11	07	13	19	33	19	23	19	19	33	13	19		
							3/4"							6"							
							25.4	14	10	18	25	44	25	31	26	25	44	17	25		
							5/1"							8"							
							31.75	18	13	23	31	54	32	38	32	31	54	21	31		
							1 1/4"							10"							

8	9				13	13	
Standard	Inspänningsmetod				Släppningsvinkel		
I	C		W				
(")					N ALP = 0°	C ALP = 7°	
					P ALP = 11°	D ALP = 15°	
					E ALP = 20°	F ALP = 25°	

ISO-KODER – VÄNDSKÄR



ISO	1	2	3	4
	S	P	G	N
	S	P	K	N
ANSI	1	2	3	4
	S	P	G	
	S	P	K	N

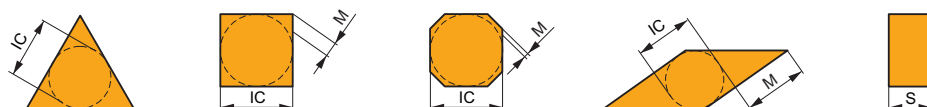
1		1	
Vändskärsform			
H	O	P	R
S	T	C	D
E	M	V	W
L	A	B	K

2		2	
Släppningsvinkel			
A		B	
C		D	
E		F	
G		N	
P		O	Special

4		4	
Skärtyp			
N			
R			
F			
A			
M			
G			
W	40–60°		
T			
Q			
U			
B	70–90°		
H			
C			
J			
X	Special		

3 3 Toleranser

	(mm)			(")		
	M(±)	S(±)	IC(±)	M(±)	S(±)	IC(±)
A	0.005	0.025	0.025	0.0002"	0.001"	0.0010"
F	0.005	0.025	0.013	0.0002"	0.001"	0.0005"
C	0.013	0.025	0.025	0.0005"	0.001"	0.0010"
H	0.013	0.025	0.013	0.0005"	0.001"	0.0005"
E	0.025	0.025	0.025	0.0010"	0.001"	0.0010"
G	0.025	0.130	0.025	0.0010"	0.005"	0.0010"
J	0.005	0.025	0.05–0.13	0.0002"	0.001"	0.002"–0.005"
K	0.013	0.025	0.05–0.13	0.0005"	0.001"	0.002"–0.005"
L	0.025	0.025	0.05–0.13	0.0010"	0.001"	0.002"–0.005"
M	0.08–0.18	0.130	0.05–0.13	0.003"–0.007"	0.005"	0.002"–0.005"
N	0.08–0.18	0.025	0.05–0.13	0.003"–0.007"	0.001"	0.002"–0.005"
U	0.05–0.38	0.130	0.05–0.13	0.005"–0.015"	0.005"	0.003"–0.010"



ISO-KODER – VÄNDSKÄR

5	6	7	8	9	10
12	03	08			
12	03	ED	S	R	-
5a	6a	7a	8	9	
4	2	2			
4	2	ED	S	R	-

5		5												
Skärkantslängd														
I.C.	H	O	P	S	T	C	D	E	M	V	W	R	K	
(mm)	(")													
3.97				03	06		04				06	02		
	5/32"						1.2"							
4.76				04	08	04	05	04	04	08	L3			
	3/16"						1.5"							
5.56				05	09	05	06	05	05	09	03			
	7/32"						1.8"							
6.35		03	02	04	08	11	06	07	08	08	11	04	06	
	1/4"						2"							
7.94		04	03	05	07	13	08	09	06	07	13	05	07	
	5/16"						2.5"							
9.525		05	04	07	09	16	09	11	09	09	16	06	09	19
	3/8"						3"							
12.7		07	05	09	12	22	12	15	13	12	22	08	12	
	1/2"						4"							
15.875		09	06	11	15	27	16	19	16	15	27	10	15	
	5/8"						5"							
19.05		11	07	13	19	33	19	23	19	19	33	13	19	
	3/4"						6"							
25.4		14	10	18	25	44	25	31	26	25	44	17	25	
	5/1"						8"							
31.75		18	13	23	31	54	32	38	32	31	54	21	31	
	1 1/4"						10"							

6	7																																																																													
Tjocklek	Hörnvinkel Släppningsvinkel																																																																													
<table border="1"> <thead> <tr> <th rowspan="2">Symbol</th> <th colspan="2">S</th> </tr> <tr> <th>(mm)</th> <th>(")</th> </tr> </thead> <tbody> <tr><td>01</td><td>1.59</td><td>1/16"</td></tr> <tr><td>T1</td><td>1.98</td><td>5/64"</td></tr> <tr><td>02</td><td>2.38</td><td>3/32"</td></tr> <tr><td>03</td><td>3.18</td><td>1/8"</td></tr> <tr><td>T3</td><td>3.97</td><td>5/32"</td></tr> <tr><td>04</td><td>4.76</td><td>3/16"</td></tr> <tr><td>05</td><td>5.56</td><td>7/32"</td></tr> <tr><td>06</td><td>6.35</td><td>1/4"</td></tr> <tr><td>07</td><td>7.94</td><td>5/16"</td></tr> <tr><td>09</td><td>9.52</td><td>3/8"</td></tr> </tbody> </table>	Symbol	S		(mm)	(")	01	1.59	1/16"	T1	1.98	5/64"	02	2.38	3/32"	03	3.18	1/8"	T3	3.97	5/32"	04	4.76	3/16"	05	5.56	7/32"	06	6.35	1/4"	07	7.94	5/16"	09	9.52	3/8"	<table border="1"> <thead> <tr> <th></th> <th>KAPR</th> <th></th> <th>ALP</th> </tr> </thead> <tbody> <tr><td>A</td><td>45°</td><td>A</td><td>3°</td></tr> <tr><td>D</td><td>60°</td><td>B</td><td>5°</td></tr> <tr><td>E</td><td>75°</td><td>C</td><td>7°</td></tr> <tr><td>F</td><td>85°</td><td>D</td><td>15°</td></tr> <tr><td>P</td><td>90°</td><td>E</td><td>20°</td></tr> <tr><td rowspan="4">Z</td><td rowspan="4">Special</td><td>F</td><td>25°</td></tr> <tr><td>G</td><td>30°</td></tr> <tr><td>N</td><td>0°</td></tr> <tr><td>P</td><td>11°</td></tr> <tr><td>Z</td><td>Special</td><td>Z</td><td>Special</td></tr> <tr><td colspan="4">ZZ – Special</td></tr> </tbody> </table>		KAPR		ALP	A	45°	A	3°	D	60°	B	5°	E	75°	C	7°	F	85°	D	15°	P	90°	E	20°	Z	Special	F	25°	G	30°	N	0°	P	11°	Z	Special	Z	Special	ZZ – Special			
Symbol		S																																																																												
	(mm)	(")																																																																												
01	1.59	1/16"																																																																												
T1	1.98	5/64"																																																																												
02	2.38	3/32"																																																																												
03	3.18	1/8"																																																																												
T3	3.97	5/32"																																																																												
04	4.76	3/16"																																																																												
05	5.56	7/32"																																																																												
06	6.35	1/4"																																																																												
07	7.94	5/16"																																																																												
09	9.52	3/8"																																																																												
	KAPR		ALP																																																																											
A	45°	A	3°																																																																											
D	60°	B	5°																																																																											
E	75°	C	7°																																																																											
F	85°	D	15°																																																																											
P	90°	E	20°																																																																											
Z	Special	F	25°																																																																											
		G	30°																																																																											
		N	0°																																																																											
		P	11°																																																																											
Z	Special	Z	Special																																																																											
ZZ – Special																																																																														

ANSI																																																																																																																																																		
5a	6a	7a																																																																																																																																																
Inskrivnen cirkel	Tjocklek	Nosradie																																																																																																																																																
<table border="1"> <thead> <tr> <th rowspan="2">Symbol</th> <th colspan="2">I.C.</th> </tr> <tr> <th>(mm)</th> <th>(")</th> </tr> </thead> <tbody> <tr><td>1</td><td>3.175</td><td>1/8"</td></tr> <tr><td>1.2</td><td>3.969</td><td>5/32"</td></tr> <tr><td>1.5</td><td>4.763</td><td>3/16"</td></tr> <tr><td>1.8</td><td>5.556</td><td>7/32"</td></tr> <tr><td>2</td><td>6.350</td><td>1/4"</td></tr> <tr><td>2.5</td><td>7.938</td><td>5/16"</td></tr> <tr><td>3</td><td>9.525</td><td>3/8"</td></tr> <tr><td>4</td><td>12.700</td><td>1/2"</td></tr> <tr><td>5</td><td>15.875</td><td>5/8"</td></tr> <tr><td>6</td><td>19.050</td><td>3/4"</td></tr> <tr><td>7</td><td>22.225</td><td>7/8"</td></tr> <tr><td>8</td><td>25.400</td><td>1"</td></tr> <tr><td>10</td><td>31.750</td><td>5/4"</td></tr> <tr><td>12</td><td>38.100</td><td>6/4"</td></tr> </tbody> </table>	Symbol	I.C.		(mm)	(")	1	3.175	1/8"	1.2	3.969	5/32"	1.5	4.763	3/16"	1.8	5.556	7/32"	2	6.350	1/4"	2.5	7.938	5/16"	3	9.525	3/8"	4	12.700	1/2"	5	15.875	5/8"	6	19.050	3/4"	7	22.225	7/8"	8	25.400	1"	10	31.750	5/4"	12	38.100	6/4"	<table border="1"> <thead> <tr> <th rowspan="2">Symbol</th> <th colspan="2">S</th> </tr> <tr> <th>(mm)</th> <th>(")</th> </tr> </thead> <tbody> <tr><td>1</td><td>1.588</td><td>1/16"</td></tr> <tr><td>1.2</td><td>1.984</td><td>5/64"</td></tr> <tr><td>1.5</td><td>2.381</td><td>3/32"</td></tr> <tr><td>2</td><td>3.175</td><td>1/8"</td></tr> <tr><td>2.5</td><td>3.969</td><td>5/32"</td></tr> <tr><td>3</td><td>4.763</td><td>3/16"</td></tr> <tr><td>3.5</td><td>5.556</td><td>7/32"</td></tr> <tr><td>4</td><td>6.350</td><td>1/4"</td></tr> <tr><td>5</td><td>7.938</td><td>5/16"</td></tr> <tr><td>6</td><td>9.525</td><td>3/8"</td></tr> <tr><td>7</td><td>11.113</td><td>7/16"</td></tr> <tr><td>8</td><td>12.700</td><td>1/2"</td></tr> <tr><td>9</td><td>14.288</td><td>9/16"</td></tr> <tr><td>10</td><td>15.875</td><td>5/8"</td></tr> </tbody> </table>	Symbol	S		(mm)	(")	1	1.588	1/16"	1.2	1.984	5/64"	1.5	2.381	3/32"	2	3.175	1/8"	2.5	3.969	5/32"	3	4.763	3/16"	3.5	5.556	7/32"	4	6.350	1/4"	5	7.938	5/16"	6	9.525	3/8"	7	11.113	7/16"	8	12.700	1/2"	9	14.288	9/16"	10	15.875	5/8"	<table border="1"> <thead> <tr> <th rowspan="2">Symbol</th> <th colspan="2">RE</th> </tr> <tr> <th>(mm)</th> <th>(")</th> </tr> </thead> <tbody> <tr><td>0</td><td>0</td><td>0"</td></tr> <tr><td>0.2</td><td>0.099</td><td>1/256"</td></tr> <tr><td>0.5</td><td>0.198</td><td>1/128"</td></tr> <tr><td>1</td><td>0.397</td><td>1/64"</td></tr> <tr><td>2</td><td>0.794</td><td>1/32"</td></tr> <tr><td>3</td><td>1.191</td><td>3/64"</td></tr> <tr><td>4</td><td>1.588</td><td>1/16"</td></tr> <tr><td>5</td><td>1.984</td><td>5/64"</td></tr> <tr><td>6</td><td>2.381</td><td>3/32"</td></tr> <tr><td>7</td><td>2.778</td><td>7/64"</td></tr> <tr><td>8</td><td>3.175</td><td>1/8"</td></tr> <tr><td>10</td><td>3.969</td><td>5/32"</td></tr> <tr><td>12</td><td>4.763</td><td>3/16"</td></tr> <tr><td>14</td><td>5.556</td><td>7/32"</td></tr> <tr><td>16</td><td>6.350</td><td>1/4"</td></tr> </tbody> </table>	Symbol	RE		(mm)	(")	0	0	0"	0.2	0.099	1/256"	0.5	0.198	1/128"	1	0.397	1/64"	2	0.794	1/32"	3	1.191	3/64"	4	1.588	1/16"	5	1.984	5/64"	6	2.381	3/32"	7	2.778	7/64"	8	3.175	1/8"	10	3.969	5/32"	12	4.763	3/16"	14	5.556	7/32"	16	6.350	1/4"
Symbol		I.C.																																																																																																																																																
	(mm)	(")																																																																																																																																																
1	3.175	1/8"																																																																																																																																																
1.2	3.969	5/32"																																																																																																																																																
1.5	4.763	3/16"																																																																																																																																																
1.8	5.556	7/32"																																																																																																																																																
2	6.350	1/4"																																																																																																																																																
2.5	7.938	5/16"																																																																																																																																																
3	9.525	3/8"																																																																																																																																																
4	12.700	1/2"																																																																																																																																																
5	15.875	5/8"																																																																																																																																																
6	19.050	3/4"																																																																																																																																																
7	22.225	7/8"																																																																																																																																																
8	25.400	1"																																																																																																																																																
10	31.750	5/4"																																																																																																																																																
12	38.100	6/4"																																																																																																																																																
Symbol	S																																																																																																																																																	
	(mm)	(")																																																																																																																																																
1	1.588	1/16"																																																																																																																																																
1.2	1.984	5/64"																																																																																																																																																
1.5	2.381	3/32"																																																																																																																																																
2	3.175	1/8"																																																																																																																																																
2.5	3.969	5/32"																																																																																																																																																
3	4.763	3/16"																																																																																																																																																
3.5	5.556	7/32"																																																																																																																																																
4	6.350	1/4"																																																																																																																																																
5	7.938	5/16"																																																																																																																																																
6	9.525	3/8"																																																																																																																																																
7	11.113	7/16"																																																																																																																																																
8	12.700	1/2"																																																																																																																																																
9	14.288	9/16"																																																																																																																																																
10	15.875	5/8"																																																																																																																																																
Symbol	RE																																																																																																																																																	
	(mm)	(")																																																																																																																																																
0	0	0"																																																																																																																																																
0.2	0.099	1/256"																																																																																																																																																
0.5	0.198	1/128"																																																																																																																																																
1	0.397	1/64"																																																																																																																																																
2	0.794	1/32"																																																																																																																																																
3	1.191	3/64"																																																																																																																																																
4	1.588	1/16"																																																																																																																																																
5	1.984	5/64"																																																																																																																																																
6	2.381	3/32"																																																																																																																																																
7	2.778	7/64"																																																																																																																																																
8	3.175	1/8"																																																																																																																																																
10	3.969	5/32"																																																																																																																																																
12	4.763	3/16"																																																																																																																																																
14	5.556	7/32"																																																																																																																																																
16	6.350	1/4"																																																																																																																																																

8	8
Eggdesign	
Vass skjær	Rundad egg
Egg med förstärkningfas	Rundad egg med förstärkningfas
Egg med dubbel förstärkningfas	Rundad egg med dubbel förstärkningfas

9	9
Matningsriktning	

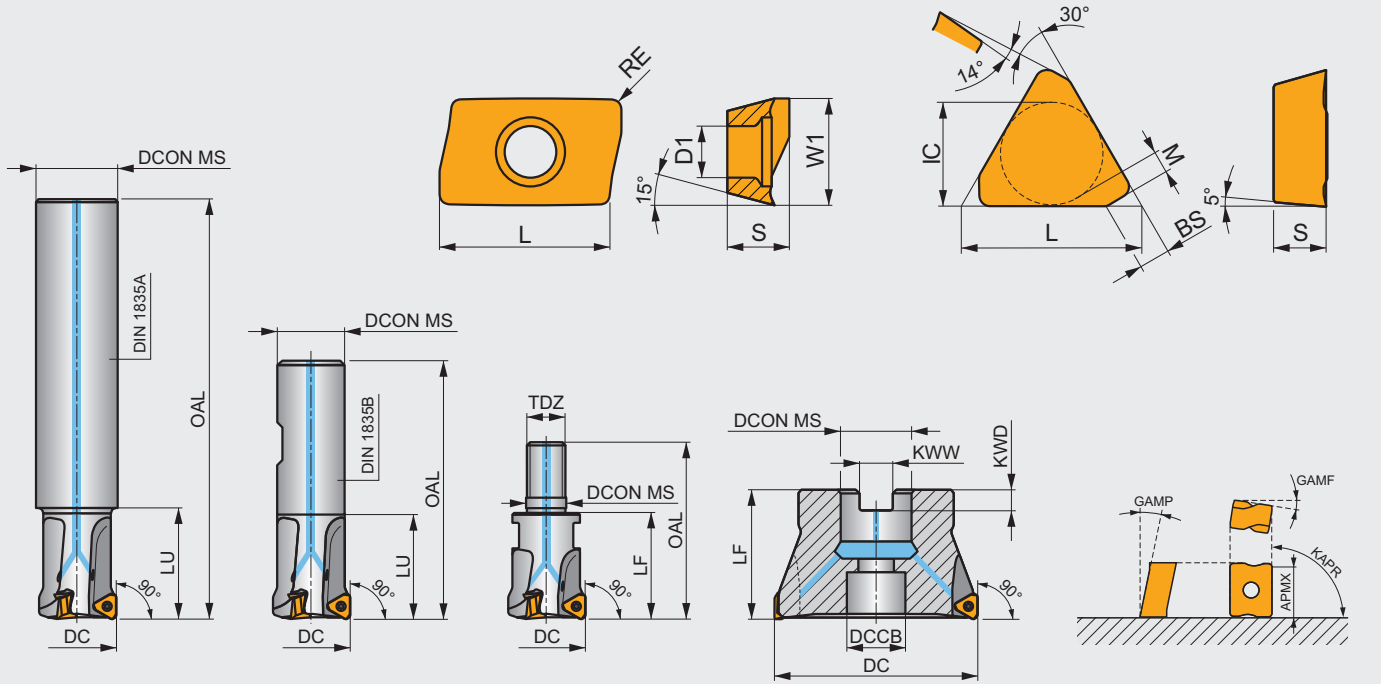
10	10
Spånbrytarbeteckning	

CUTTING TOOL PARAMETERS ACCORDING TO ISO 13399

All cutting tools are defined by a number of parameters according to the standard ISO 13399. This list contains all the parameters used in this catalogue and their definitions.

ISO 13399 is an international cutting tool information standard. It provides dimensions and parameters in a neutral format that is independent of any particular system or company nomenclature. When cutting tools are clearly defined according to a global standard, all types of software can process the electronic data more quickly, improving the quality of communication and helping to make the exchange of information run smoothly. Supporting a common language in our cutting tool descriptions this will assist system to system communication. It will save you a significant amount of time, providing an easier gathering of high-quality data across our 40,000 solid and indexable tools. By using an ISO 13399 compliant system, there will be no need to manually interpret data and key-enter it into your system.

EXAMPLES ONLY!



ISO 13399 code	Description
APMX	Depth of cut maximum
BD	Body diameter
BDX	Body diameter maximum
BCH	Corner chamfer length
BS	Wiper edge length
CBDP	Connection bore depth
CDI	Insert cutting diameter
CDX	Cutting depth maximum
CW	Cutting width
CZC MS	Connection size code machine side
D1	Fixing hole diameter
DAH4	Diameter access hole
DAH5	Diameter access hole
DAH6	Diameter access hole
DBC1	Diameter bolt circle 1
DBC2	Diameter bolt circle 2
DBC4	Diameter bolt circle
DBC5	Diameter bolt circle
DBC6	Diameter bolt circle

ISO 13399 code	Description
DC	Cutting diameter
DCB	Connection bore diameter
DCCB	Counterbore diameter connection bore
DCN	Cutting diameter minimum
DCON MS	Connection diameter
DCX	Cutting diameter maximum
DHUB	Hub diameter
DN	Neck diameter
GAMF	Radial rake angle
GAMP	Axial rake angle
CHW	Corner chamfer width
IC	Inscribed circle diameter
INSD	Insert diameter
INSL	Insert length
KAPR	Tool cutting edge angle
KWD	Keyway depth
KWW	Keyway width
L	Cutting edge length
LB	Body length
LE	Cutting edge effective length

ISO 13399 code	Description
LF	Functional length
LH	Head length
LU	Usable length
LUX	Usable length maximum
M	M-dimension
NOF	Number of flutes
OAL	Overall length
P	Pitch of the blade
PRFA	Profile angle
PRFRAD(2)	Profile radius
RE	Radius
S	Insert thickness
S1	Insert thickness total
TDZ	Thread diameter size
TP	Thread pitch
TPI	Threads per inch
W1	Insert width
ZNP	Number of peripheral edges in the tool

MILLING GRADES – OVERVIEW

Grupp	Cementerad hårdmetall med MTCVD	Cementerad hårdmetall med PVD	Obelagd
P01			
P05		M8310	
P10	M9315		
P15		8215	
P20	M9325		
P25		M8330	
P30		M8340	
P35		M8345	
P40			
P45			
P50			

Grupp	Cementerad hårdmetall med MTCVD	Cementerad hårdmetall med PVD	Obelagd
M01			
M05			
M10			
M15			
M20			
M25		M6330	
M30		M8340	
M35	M9340	M8345	
M40			
M45			
M50			

Grupp	Cementerad hårdmetall med MTCVD	Cementerad hårdmetall med PVD	Obelagd
K01		M4303	
K05		M8310	
K10		M4310	
K15	M5315		
K20		8215	
K25			
K30		M8330	
K35			
K40			
K45			
K50			

Grupp	Cementerad hårdmetall med MTCVD	Cementerad hårdmetall med PVD	Obelagd
N01			
N05			
N10		M0315	
N15		8215	
N20			HF7
N25			
N30			
N35			
N40			
N45			
N50			

Grupp	Cementerad hårdmetall med MTCVD	Cementerad hårdmetall med PVD	Obelagd
S01			
S05			
S10			
S15			
S20	M9340		
S25		M6330	
S30		M8340	
S35		M8345	
S40			
S45			
S50			

Grupp	Cementerad hårdmetall med MTCVD	Cementerad hårdmetall med PVD	Obelagd
H01			
H05		M4303	
H10		2003	
H15	M5315	M4310	
H20		M8310	
H25		8215	
H30			
H35			
H40			
H45			
H50			

MILLING GRADES – OVERVIEW

Grade Identification	Area of Application	Application	Feed	Cutting speed	Resistance to adverse Working Conditions	Coating	Colour	Substrate	Coolant benefit	Grade description
M8345	P30 – P50	■	▴	▴	▴	PVD	█	H	-	This grade has exceptional operational reliability and is designed for heavy cuts in unfavourable conditions in difficult and tough materials.
	M30 – M40	■	▴	▴	▴					
M6330	P20 – P35	■	▴	▴	▴	PVD	█	H	+ / -	Milling grade with extraordinary service reliability. Especially suitable for machining of hard to machine materials. Powerful in applications where unfavourable conditions and heavy cuts dominate.
	M20 – M35	■	▴	▴	▴					
	S20 – S30	■	▴	▴	▴					
M4303	P01 – P10	▣	▴	▴	▴	PVD	█	ultra submicron H	-	The most wear resistant grade for mold & die applications. Offers exceptional performance at high cutting speeds and low feeds in stable cutting conditions. Suitable for finishing operations in difficult workpiece materials.
	K01 – K10	■	▴	▴	▴					
	N01 – N10	▣	▴	▴	▴					
	H01 – H10	■	▴	▴	▴					
M4310	P05 – P15	▣	▴	▴	▴	PVD	█	ultra submicron H	-	Universal grade for mold & die applications. Suitable for finishing as well as semi-roughing operations. This grade combines high wear resistance with extraordinary operational reliability.
	M05 – M15	▣	▴	▴	▴					
	K05 – K15	■	▴	▴	▴					
	S05 – S10	■	▴	▴	▴					
	H05 – H15	■	▴	▴	▴					
2003	P01 – P10	▣	▴	▴	▴	PVD	█	ultra submicron H	-	Milling grade with excellent wear resistance. Most suitable in a machining of hard and high strength materials under stable cutting conditions and moderate/higher cutting speeds. Suitable for cutting other workpiece group materials except non-ferrous metals.
	M01 – M10	▣	▴	▴	▴					
	K01 – K10	■	▴	▴	▴					
	S05 – S10	■	▴	▴	▴					
M0315	N05 – N25	■	▴	▴	▴	PVD	█	submicron H	-	Submicron grade for milling non-ferrous metals and their alloys with a balanced ratio of wear resistance and toughness. It is provided with a unique coating with excellent friction properties.
M8326	P20 – P40	■	▴	▴	▴	PVD	█	H	-	Special grade for heavy duty. The main application area of this grade is machining all kinds of steels (including stainless) in the „soft state“. It can also be used for machining softer cast irons. Suitable for M15 – M30 machining at medium speeds under average cutting conditions.
	M15 – M30	▣	▴	▴	▴					
M8346	P30 – P50	■	▴	▴	▴	PVD	█	H	-	Special grade for heavy duty. This grade has exceptional operational reliability and is designed for heavy cuts in unfavourable conditions in difficult and tough materials.
	M30 – M40	■	▴	▴	▴					
S26	P15 – P30	■	▴	▴	▴	-	█	S	++	Uncoated milling grade with excellent resistance to erosion of the cutting face. It is intended solely for machining carbon and alloy steels at low cutting speeds.
S45	P30 – P45	■	▴	▴	▴	-	█	S	++	Uncoated, tough cutting grade suitable for machining applications where low cutting speed and unfavourable cutting conditions dominate
HF7	M10 – M20	▣	▴	▴	▴	-	█	submicron H	++	Uncoated grade which is primarily designed for machining non-ferrous metals; can also be used for other machined materials (except steel). This grade can be used in turning, milling, and even boring.
	K10 – K25	■	▴	▴	▴					
	N10 – N25	■	▴	▴	▴					

MILLING GRADES – OVERVIEW

Grade Identification	Area of Application	Application	Feed	Cutting speed	Resistance to adverse Working Conditions	Coating	Colour	Substrate	Coolant benefit	Grade description
M9315	P05 – P25	■				MT-CVD	█	H	---	Milling grade with high abrasion resistance even at high thermal loads, main application area is higher cutting speeds with medium or small depths of cut.
	K10 – K30	■	▄	▄	▄					
	H10 – H20	▣								
M9325	P10 – P30	■				MT-CVD	█	H	---	This grade has an ideal balance between wear resistance and toughness, it is mainly designed for roughing operations. Advantages are excellent wear resistance even at relatively high cutting speeds with excellent reliability, this grade is more suitable for applications using higher speeds and lower feed rates.
	K10 – K30	■	▄	▄	▄					
	H15 – H20	▣								
M9340	P35 – P50	■				MT-CVD	█	H	---	A very tough grade, where the main advantage is the high strength of the cutting edge and resistance to adverse cutting conditions. Although this material has an MT-CVD M30 – M40 coating, it is possible to use emulsion cooling for its application, especially in optimum cutting conditions.
	M30 – M40	■	▄	▄	▄					
	S15 – S20	■								
M5315	P05 – P20	▣				MT-CVD	█	H	---	One of the most abrasion-resistant milling grades which should be used under stable conditions. Its main advantage is the extremely high resistance to thermal stress and abrasive K05 – K25 wear. It is mainly used for machining hard and very hard materials, particularly cast iron.
	K05 – K25	■	▄	▄	▄					
	H05 – H20	■								
M8310	P01 – P10	■				PVD	█	ultra submicron H	-	Grade specially developed for copy milling, featuring high resistance to abrasion. It is suitable for machining at higher cutting speeds under stable cutting conditions, and for machining virtually all groups of machined materials (particularly stronger and harder materials).
	M01 – M10	▣	▄	▄	▄					
	K01 – K10	■	▄	▄	▄					
	H05 – H15	▣								
8215	P10 – P20	■				PVD	█	submicron H	+/-	One of the most versatile milling grades, in terms of both the range of workpiece materials and the range of possible applications. It is characterised by high wear resistance and operational reliability. Its other advantages include excellent resistance to cracking induced by temperature shock. With its unique properties, this material is undoubtedly one of the pillars of the milling range.
	M10 – M20	▣	▄	▄	▄					
	K10 – K25	■	▄	▄	▄					
	N10 – N25	■	▄	▄	▄					
	S10 – S15	▣								
M8325	P20 – P40	■				PVD	█	S	-	The main application area of this grade is machining all kinds of steels (including stainless) in the “soft state”. It can also be used for machining softer cast irons. Suitable for M15 – M30 machining at medium speeds under average cutting conditions.
	M15 – M30	▣	▄	▄	▄					
M8330	P20 – P40	■				PVD	█	submicron H	+/-	This grade is universal and can be used for machining various types of materials. However, it's priority application area lies within steels and ductile cast irons. It is recommended for milling at medium speeds under unstable cutting conditions.
	M20 – M35	■	▄	▄	▄					
	K20 – K40	■	▄	▄	▄					
	N15 – N30	▣	▄	▄	▄					
	S15 – S25	▣								
M8340	P25 – P50	■				PVD	█	submicron H	+/-	One of the toughest grade dedicated for machining with lower cutting speed and unfavorable conditions. This grade is ideal for all operations where the main requirement is for a tough cutting edge.
	M20 – M40	■	▄	▄	▄					
	K20 – K40	▣	▄	▄	▄					
	S20 – S30	■								

MILLING GRADES – OVERVIEW

Marking of grades

M		9		3		2		5	
Applikation		Beläggning/Substrat		Generation		ISO-område			
D	Borring	0 PVD 1 CVD	Specialapplikation	1–9			01–05		
M	Fräsning	2 PVD 3 CVD	Fri				05–10		
T	Svarvning	4 PVD 5 CVD	Grupp K, H				10–20		
G	Grooving and Parting off	6 PVD 7 CVD	Grupp M, S				20–30		
		8 PVD 9 CVD	Universell				30–40		
		B	CBN				40–50		
		D	PCD						

Substrate

H	WC-Co based substrate
submicron H	WC-Co based substrate, fine-grained (< 1 µm)
ultra submicron H	WC-Co based substrate, very fine-grained (< 0.5 µm)
S	Substrate with cubic carbides

Coating

MT-CVD	Medium-temperature chemical method of coating
PVD	Low-temperature physical method of coating
–	Uncoated grade

Coolant Benefit

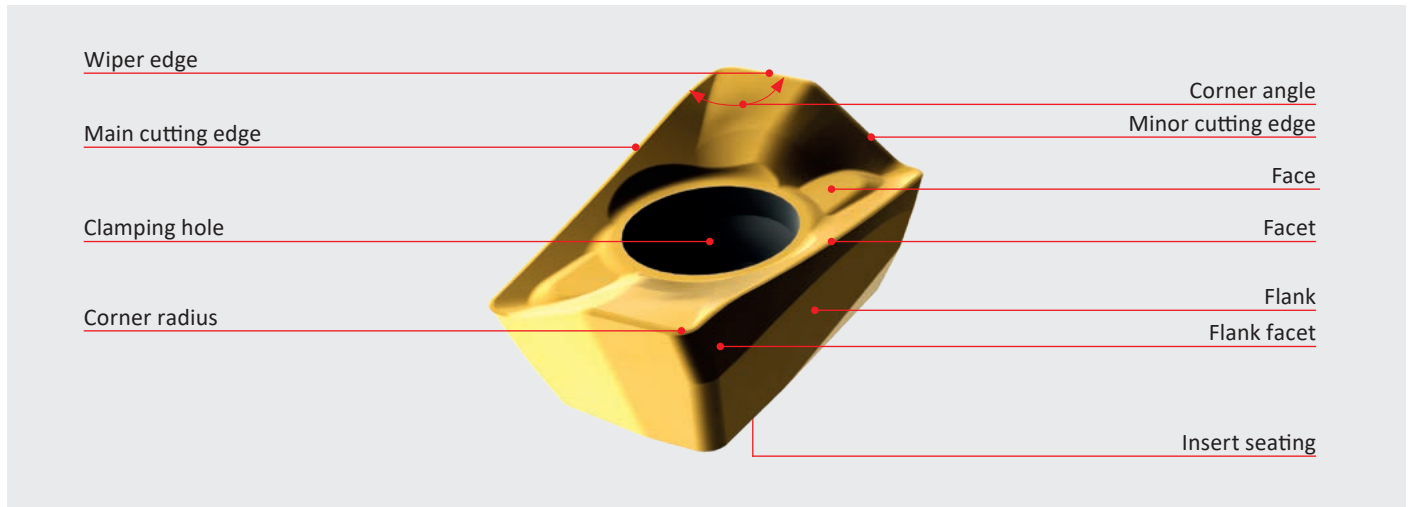
---	Very negative effect on tool life – cooling is not recommended
-	Slightly negative effect on tool life
+ / -	Influence of cooling may be both positive and negative – decisive factor is specific working conditions
++	Positive effect on tool life – cooling is recommended

Attribute Strength



DEFINITION OF BASIC TERMS

Parts of an Indexable Insert



Geometry of milling tool

Constructional angles determine the basic orientation of the seat position that the cutting insert is clamped in and are therefore important for the design of the milling cutter body. There are two angles: axial face angle $GAMP - \gamma_p$ (tool back rake) and radial face angle $GAMF - \gamma_f$ (tool side rake) – see picture below.

Working angles are the setting angle $KAPR - \kappa_r$, the orthogonal face angle $GAMO - \gamma_o$ and the rake angle of the cutting edge $LAMS - \lambda_s$.

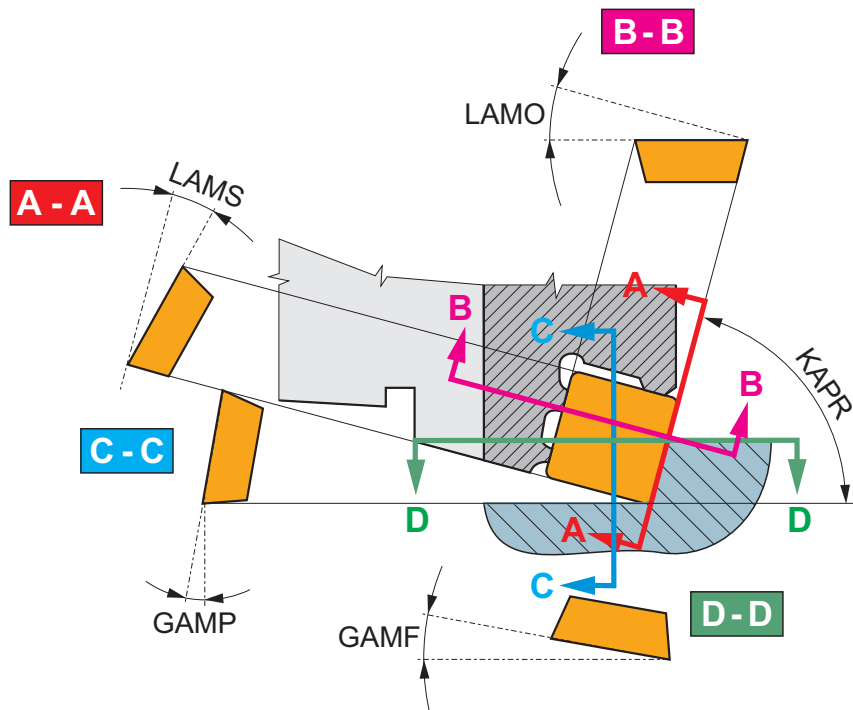
- **Orthogonal face angle** $GAMO - \gamma_o$ affects not only the extent of plastic deformation of the cut chip but also the cutting force and temperature. The bigger the rake angle $GAMO - \gamma_o$, the lower the cutting force and power demand of the spindle motor (and vice versa).
- **Setting angle** $KAPR - \kappa_r$ determines the thickness of the chip at a specific feed per tooth f_z and axial depth of cut a_p . It therefore affects cutting forces, specifically load, wear and tool service life.

Reducing the setting angle $KAPR - \kappa_r$ at a constant feed f_z causes a decrease in the chip thickness h .

- **Rake angle of cutting edge** $LAMS - \lambda_s$ together with setting angle $KAPR - \kappa_r$ and face angle $GAMO - \gamma_o$, this determines the point of first contact between the edge and work piece. That is why it affects the resistance of the edge to chipping during interrupted cut. At the same time, it affects the direction of chip evacuation.

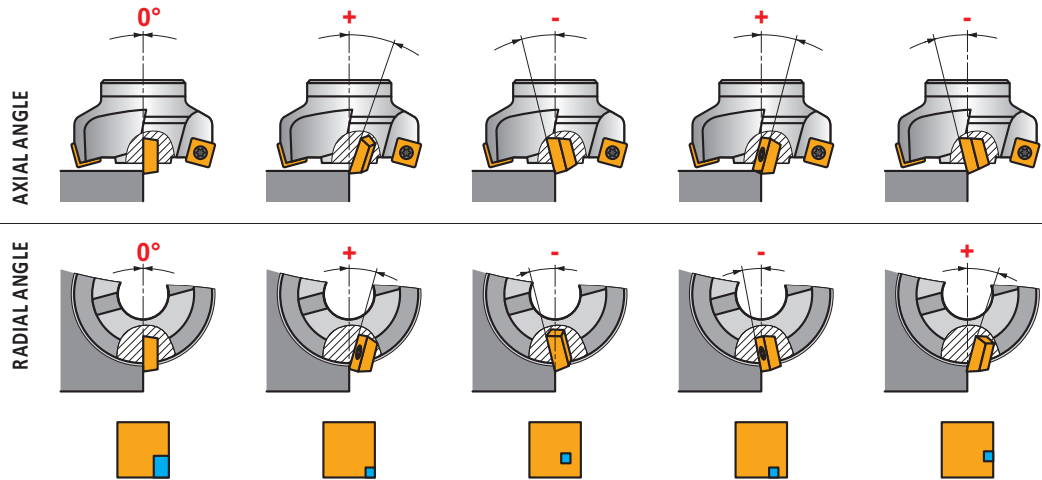
Working angles of the tool you can determine the bed using the formulas or diagrams below.

Working and constructional angles of milling tool



CHOICE OF TOOL

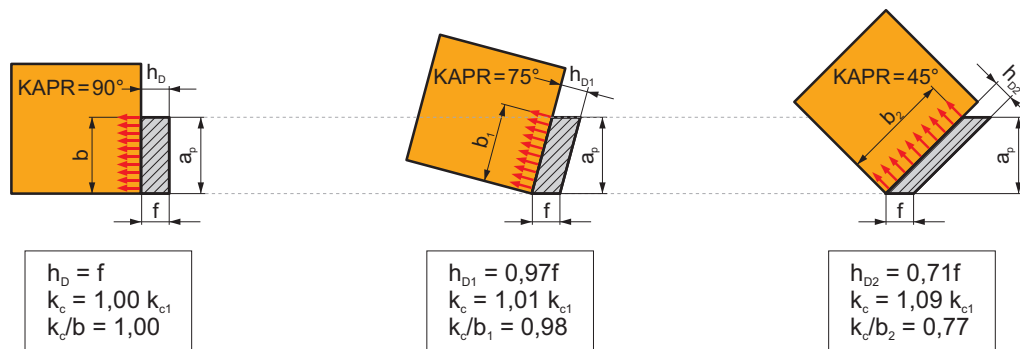
Milling Cutter Geometry



When choosing a tool, it is necessary to take many criteria into account. One of the primary requirements is that the place of first contact between the cutting wedge and the workpiece lie further away from the tip and the cutting edge. That, however, is dependent on the basic geometry of the cutting wedge i.e. angles $GAMO - \gamma$, $LAMS - \lambda_s$, $KAPR - \kappa_r$, as well as the mutual position of the milling cutter and the entry edge of the workpiece. The following figure shows individual milling cutter geometries (or rather, the combinations of radial and axial angles) at some of the most adverse engagement conditions (i.e. when the axis of the milling cutter is in line with the edge of the workpiece). At the bottom of the figure is a depiction of the indexable insert with an indication of the area where the insert makes first contact with the workpiece. The figure shows that in such adverse engagement conditions, tools with negative – negative

geometry perform the best, while tools with positive – positive geometry will be the most problematic. Another criterion is chip removal. Negative – negative tools push the chip into the work surface (towards the workpiece) while positive – positive tools do the opposite, leading the chip away from the work surface, i.e. away from the workpiece. It is thus an optimal compromise to combine negative and positive angles.

Entering Angle



When choosing the entering angle for face milling, you should, among other things, account for the power and rigidity of the machine (size and type of tool holder), its dynamic capabilities and maximum depth of removal. For instance, if you have a high-performance (50 – 100 kW) machine at your disposal with an ISO 50 tool holder and you cut at high depth, your first choice should be a milling cutter with an entering angle between 90° – 58°. On the other hand, if you have a low-power machine (up to 10 kW) with an ISO 40 (HSK 63) tool holder and you expect to cut at 2 – 3 mm depth, you should choose a tool with an entering angle of 45° – 10° (i.e. HFC) or with round inserts. It would thus be an ideal compromise to choose a tool with an entering angle of 45°, which can also handle higher depths of cut and, when compared to a tool with an entering angle of 90°, can cut at the same depth at up to 30% higher feed and at approximately the same

load. Finally, it is important to emphasise that the lower the entering angle, the thinner the chip and the longer the engaged section of the cutting wedge, which is important with regard to heat dissipation and the distribution of force across the edge of the insert. Also worth mentioning is the change in the direction of the resultant cutting forces, which, in simplified terms, can be visualised as perpendicular to the edge. (Decreasing the entering angle increases the passive component of the cutting force leading into the spindle and decreases the active radial component of the cutting force).

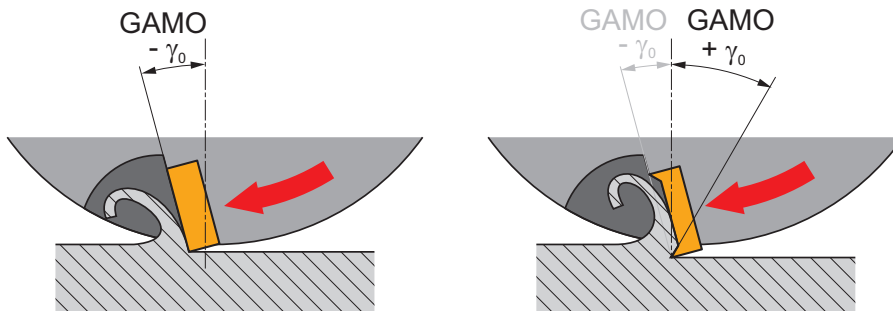
CHOICE OF TOOL

The following figure shows the assortment of Pramet milling cutters with regard to the entering angle and the basic geometry of the cutter body (i.e. the axial and radial angle of the face). However, it must be pointed out that insert geometry may change the resulting geometry of the tool as indicated in the following figure.

	Negative – Negative	Negative – Positive	Positive – Positive
93°	SWN04C SCN05C		
90°	STN10 STN16 SLN12 SLN16 SLN12X J(T)-SLSN	SAD07D SAD11E SAD16E SAP10D SAP16D SS009 SSD12 FTB27X F-SCC S90SN S90CN(XN) J(T)-SAD11E J(T)-SAD16E J(T)-SSAP J(T)-CSD12X	SAP10D SVC22C
57° – 60°	SPN13	FSB22X	
45°	SHN06C SHN09C SSD09 N-SS009 2516	SSF13F SOD05 SOD06D SSE09 SSN12Z	
43°	SON06C		SOE06Z
12° – 20°	SBN10 SSN11	SPD09 SS012	
I	SRC10 SRC12 SRC16 SRC20 SRD10 SRD12 L2-SZP K3-CXP K2-PPH K2-SLC K2-SRC	SRD05 SRD07 SRD10 SRD12 SRD16 SZD07 SZD09 SZD12 2636 J(T)-SXP16	

CHOICE OF TOOL

Resulting Geometry (Milling Cutter + Indexable Insert)

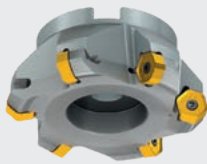







The following table lists the three basic milling cutter geometries and the approximate priority of their use with regard to the type of machined material. More detailed information about individual tool families with consideration of insert geometries can be found in the catalogue section.

Conditions		Selection of cutter geometry according to application		
		Negative – Negative	Negative – Positive	Positive – Positive
Structural parameter of the body	GAMP (A.R.)	-	+	+
	GAMF (R.R.)	-	-	+
	GAMO	-	+	+
Machined material	Carbon steels, alloy steels (< 300 HB)	■	■	■
	Stainless steels (< 300 HB)		■	■
	Stainless steels (> 300 HB)		■	■
	Cast iron, ductile iron	■	■	■
	Al alloys		■	■
	Copper and its alloys		■	■
	Titanium and its alloys		■	■
	Hardened steels (40 – 55 HRC)	■	■	

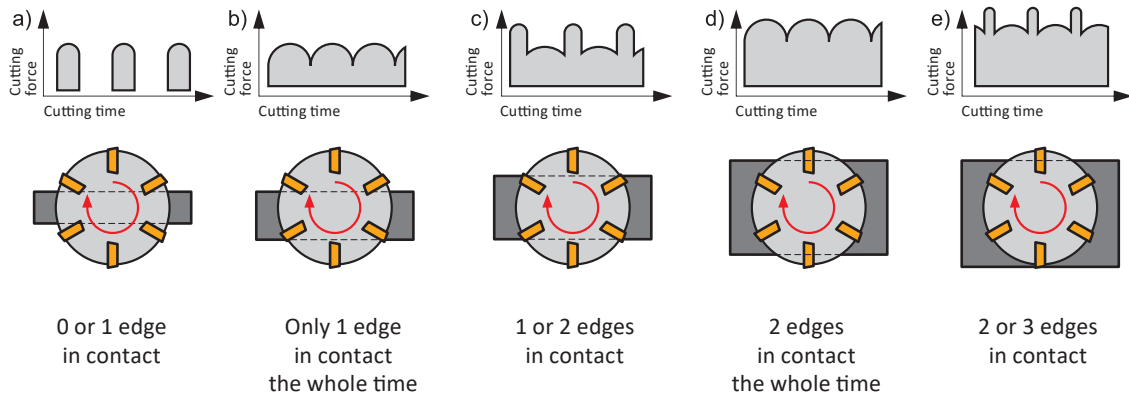
Number of Teeth on the Milling Cutter

The number of teeth on the milling cutter is also important in relation to the width of the milled surface, where it determines the force (and acoustic) characteristics of the cut, as indicated in the following figure.

			
Feed per minute	+	++	+++
Tough materials	+++	++	+
Power requirement	+	++	+++
Resulting roughness	+++	++	+
			

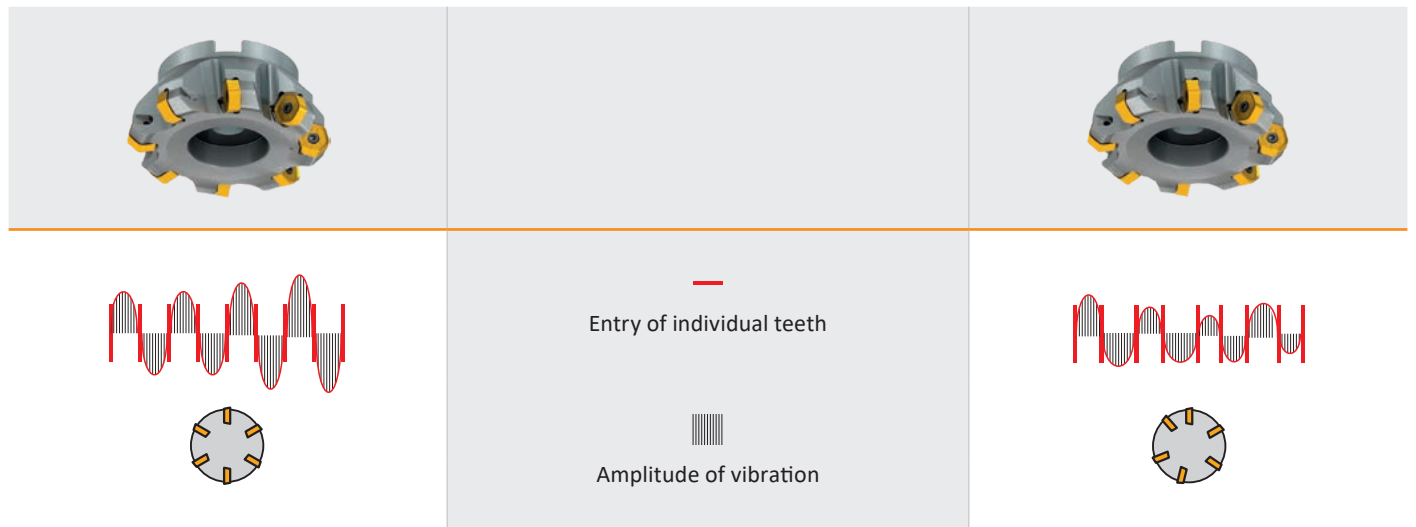
CHOICE OF TOOL

Tooth Pitch



In addition, some tool families offer the option to choose between even and uneven tooth pitch. Using a tool with an uneven tooth pitch interferes with harmonic oscillation and, as a result, helps improve stability and reduce the risk of vibration. That means you should choose uneven tooth pitch if you anticipate a risk of vibration, i.e.

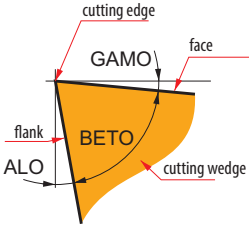
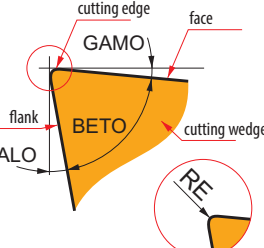
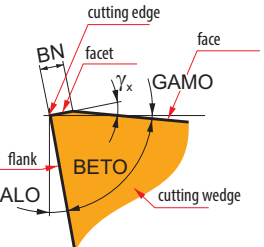
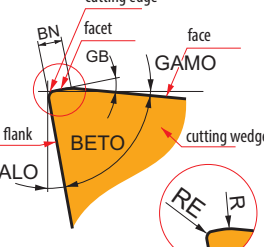
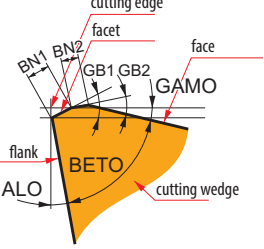
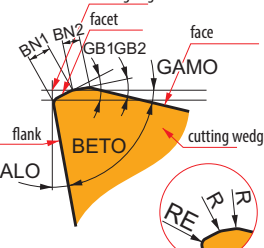
primarily when working at higher overhang or when machining at high radial depth of cut and under conditions which are not entirely stable.



CHOICE OF CUTTING INSERT

When choosing an indexable insert, please also pay attention to its microgeometry, which is indicated by icons directly in the catalogue section. Below is an overview of the types of cutting edges you can find on our inserts.

Overview of Cutting Edge Designs

<p>F</p>		<p>Sharp cutting edges – recommended for inserts designed for use with milling cutters for Al alloys. Sharp cutting wedges result in minimal deformation of the cut layer, reduced build-up on the edge and a lower cutting force requirement. However, the strength of the cutting wedge is lower compared to other types.</p>
<p>E</p>		<p>Rounded cutting edges – a slight rounding of the wedge with the aim of eliminating micro-imperfections on its surface. Rectifying the wedge at a certain very low radius (RE) improves the cutting edge's resistance to mechanical damage, i.e. brittle fracture or so-called micro-crumbling. This modification is currently used on all indexable inserts without a facet (F modification previously), which are used for milling almost all types of material.</p>
<p>T</p>		<p>Faceted cutting edges – a facet with width of x and angle of γ_x increases the angle γ_n of the cutting wedge in the immediate vicinity of the cutting edge, thus also increasing its strength, i.e. its resistance to mechanical load, brittle damage or fracture. Currently used only rarely, as it has been replaced by the S modification.</p>
<p>S</p>		<p>Rounded edges with facet – compared to the T modification, the insert has undergone rectification which results in rounding of the cutting edge and thickening by a facet. This modification increases the resistance of the wedge against mechanical damage to a greater degree.</p>
<p>K</p>		<p>Edges with double facet – double facet with widths of x_1, x_2 and angle of γ_{x1}, γ_{x2} further increases the strength of the edge, i.e. its resistance to mechanical stress, brittle damage or fracture. Rarely used for milling inserts, only for the most difficult cuts.</p>
<p>P</p>		<p>Rounded edges with double facet – compared to the K modification, the insert has undergone rectification which results in rounding of the cutting edge and thickening by a double facet. This modification provides the wedge with maximum resistance to mechanical damage.</p>

CORRECTION FACTORS

Correction factors for specific type of cutter and operation C_{VcO}

Face mills with <i>KAPR</i> 45° – 60° and negative inserts (SON06C, SHN06C, SHN09C)	1.15	1.00	0.85
Face mills with <i>KAPR</i> 45° and positive inserts (SSD13F, SSE09, SSN12Z, FSB22X, SOD05, SOD06D, SOE06Z)	1.15	1.00	0.85
Shoulder mills with <i>KAPR</i> 90° (SAD07/10/16, STN10/16, SLN12/16, SAP10/16, SS009, SSD12)	1.10	1.00	0.90
Copy face mills (SRC10 – SRC20, SRD05 – SRD16, ...)	1.10	1.00	0.90
Copy end mills (K2-PPH, K2-SLC, K2-SRC, K3-CXP...)	1.10	1.00	0.90
Disc mills (S90CN(XN), S90SN...)	1.10	1.00	0.90
Shoulder mills with extended flute J(T)-CSD12X, J(T)-SAD11E, J(T)-SAD16E...)	1.25	1.00	0.80
Face mills for heavy duty (FSB22X, SPN13..)	1.30	1.00	0.85
Shoulder mills for heavy duty (FTB27X..)	1.25	1.00	0.85

Correction factors for required durability C_{VcT}

	minutes	15	20	30	45	60	90	120
General machining operations (fine finishing up to roughing)		1.23	1.13	1.00	0.89	0.81	0.72	–
Heavy machining operations (heavy roughing)		–	–	1.23	1.13	1.00	0.89	0.81

Additional correction factors C_{VcA}

Machining environment	C_{VcA}
Condition of the work-material (hard skin due to forging or casting)	0.70
Unstable machining conditions	0.85
Common machining conditions	1.00
Stable machining conditions	1.20

Correction factors for cutting speed when face and shoulder milling with < 100 % radial immersion C_{VcRCT}

a_e / DC	5 %	10 %	15 %	20 %	25 %	30 %	40 %	50 %	60 %	70 %	75 %	80 %	90 %	100 %
	1.48	1.35	1.27	1.22	1.19	1.16	1.11	1.08	1.05	1.03	1.00	1.00	1.00	1.00

Correction factors to compensate for chip-thinning when face and shoulder milling with < 100 % radial immersion C_{fzRCT}

a_e / DC	5 %	10 %	15 %	20 %	25 %	30 %	40 %	50 %	60 %	70 %	75 %	80 %	90 %	100 %
	2.20	1.60	1.35	1.20	1.10	0.95	0.85	0.75	0.85	0.95	1.00	1.00	1.00	1.00
	0.64	0.64	0.64	0.64	0.64	0.65	0.65	0.67	0.68	0.71	0.72	0.74	0.79	1.00

Resulting corrected cutting speed v_{cc}

$$v_{cc} = v_c \times k_{VG} \times C_{VcO} \times C_{VcT} \times C_{VcA} \times C_{VcRCT} \times C_{fzRCT}$$

k_{VG} – coefficient of used material

v_c – starting speed from catalogue page

FORMLER

Värde	Enhet	Formel
Varvtal	(varv/min)	$n = \frac{v_c \times 1000}{DC \times \pi}$
Skärhastighet	(m/min)	$v_c = \frac{\pi \times DC \times n}{1000}$
Matning per varv	(mm/varv)	$f_{rev} = \frac{f_{min}}{n} = f_z \times z$
Matning per minut	(mm/min)	$f_{min} = v_f = f_{rev} \times n = f_z \times z \times n$
Tandmatning	(mm/z)	$f_z = \frac{f_{rev}}{z} = \frac{f_{min}}{n \times z}$
Spånarea	(mm ²)	$A = f_z \times a_p$
Spåntjocklek (för skär med rak kant)	(mm)	$h = f_z \times \sin KAPR$
Spåntjocklek (för runda skär)	(mm)	$h = f_z \times \sqrt{\frac{a_p}{INSD}}$
Avverkningshastighet	(cm ³ /min)	$Q = \frac{a_p \times a_e \times f_{min}}{1000}$
Effektbehov	(kW)	$P_c = \frac{a_p \times a_e \times f_{min}}{60 \times 10^6 \times \eta} \times k_c \times k_y$
Ungefärligt effektbehov	(kW)	$P_c = \frac{a_p \times a_e \times f_{min}}{x}$

Beteckning:

	Kvantitet	Enhet
n	Antal varv per minut	(varv/min)
DC	Arbetsstyckets, eller verktygets diameter	(mm)
v_c	Skärhastighet	(m/min)
f_{rev}	Matning per varv	(mm/varv)
A	Spånarea	(mm ²)
a_p	Axiellt skärdjup	(mm)
a_e	Radiellt skärdjup	(mm)
$KAPR$	Ingreppsvinkel	(°)
f_{min}	Matning per minut	(mm/min)
f_z	Tandmatning	(mm/tand)
z	Antal skär	(-)
$INSD$	Diameter för skär	(mm)

	Kvantitet	Enhet
h	Spåntjocklek	(mm)
Q	Avverkningshastighet	(cm ³ /min)
P_c	Effektbehov	(kW)
k_c	Specifik skärkraft per mm ²	(MPa)
k_y	Koefficient för vinkeln γ_0 inflytande	(°)
η	Utnyttjandegrad $\eta = 0.75$	(-)
x	Inflytelsekoefficient för arbetsmaterialet	(-)


Material	Stål	Gjutjärn	Al
Koefficient x	24 000	30 000	120 000

REKOMMENDERADE ÅTDRAGNINGSMOMENT

Spännskruv	Moment	Gänga	Längd
	(Nm)	–	(mm)
US 20	0.9	M 2	3
US 2205-T07P	0.9	M 2.2	5
US 25	1.2	M 2.5	5
US 2505-T08P	1.2	M 2.5	5
US 2506-T07P	1.2	M 2.5	6
US 3006-T09P	2	M 3	6
US 3007-T09P	2	M 3	7
US 3504-T09P	3	M 3.5	4
US 3507-T15	3	M 3.5	7
US 3509-T15	3	M 3.5	9
US 3511-T15	3	M 3.5	11
US 3512-T15P	3	M 3.5	12
US 4008-T15P	3.5	M 4	8
US 4011-T15P	3.5	M 4	11
US 4511-T20	5	M 4.5	11
US 5012-T15P	5	M 5	12
US 70	5	M 4	5
US 71	5	M 4	7
US 72	5	M 4	9
US 73	5	M 4	11
CS 3007-T08P	1.2	M 3	7
CS 4008-T15P	3	M 4	8
CS 42506-T07P	1	M 2.5	6
CS 43008-T08P	1.2	M 3	8
CS 43509-T10P	2	M 3.5	9
CS 44013-T15P	3	M 4	13
CS 45016-T20P	5	M 5	16
CS 46020-T25P	7.5	M 6	20
CS 48025-T40P	15	M 8	25
CS 5009-T20P	5	M 5	9
CS 5013-T20P	5	M 5	13
CS 5015-T20P	5	M 5	15
CS 6020-T20P	7.5	M 6	20
CS 8025-T30P	15	M 8	25
US 2505-T07P	1.2	M 2.5	5
US 2506-T07P	1.2	M 2.5	6
US 3007-T09P	2	M 3	7
US 3505-T09P	3	M 3.5	5
US 4011A-T15P	3.5	M 4	11
US 4011-T15P	3.5	M 4	11
US 44010-T15P	3.5	M 4	10
US 44012-T15P	3.5	M 4	12
US 45011-T20P	5	M 5	11
US 45012-T20P	5	M 5	12
US 5011-T20P	5	M 5	11
US 5018-T20P	5	M 5	18
US 52506-T07P	0.8	M 2.5	6
US 54511-T15P	5	M 4.5	11
US 62003A-T06P	0.6	M 2	3
US 62004A-T06P	0.6	M 2	4
US 62004-T06P	0.6	M 2	4
US 62505-T07P	1.2	M 2.5	5
US 62506-T07P	1.2	M 2.5	6
US 62506-T08P	1.2	M 2.5	6
US 62508-T08P	1.2	M 2.5	7
US 63009-T09P	1.2	M 3	9
US 63509-T15P	3	M 3.5	10
US 63510-T10P	2	M 3.5	9
US 63511D-T15P	3	M 3.5	11

Spännskruv	Moment	Gänga	Längd
	(Nm)	–	(mm)
US 63513-T15P	3	M 3.5	12
US 64014-T15P	3.5	M 4	14
US 65013-T20	5	M 5	13
US 65014-T20P	5	M 5	14
US 65017-T20P	5	M 5	17
US 66015-T25P	7.5	M 6	15
US 68020-T30P	15	M 8	20
US 68026-T30P	15	M 8	26
US 74016-T15P	3.5	M 4	16

Momentmejslar

Moment-handtag 	Vridmoment (Nm)	Skruvdimension
MR-0.8-2.0 Vario	0.5 – 2.0	M 2 – M 3
MR-1.0-5.0 Vario	0.8 – 5.0	M 2.5 – M 5
MR-0.9 fix	0.9	M 2
MR-2.0 fix	2.0	M 3
MR-3.0 fix	3.0	M 3.5
MR-3.5 fix	3.5	M 4
MR-5.0 fix	5.0	M 5

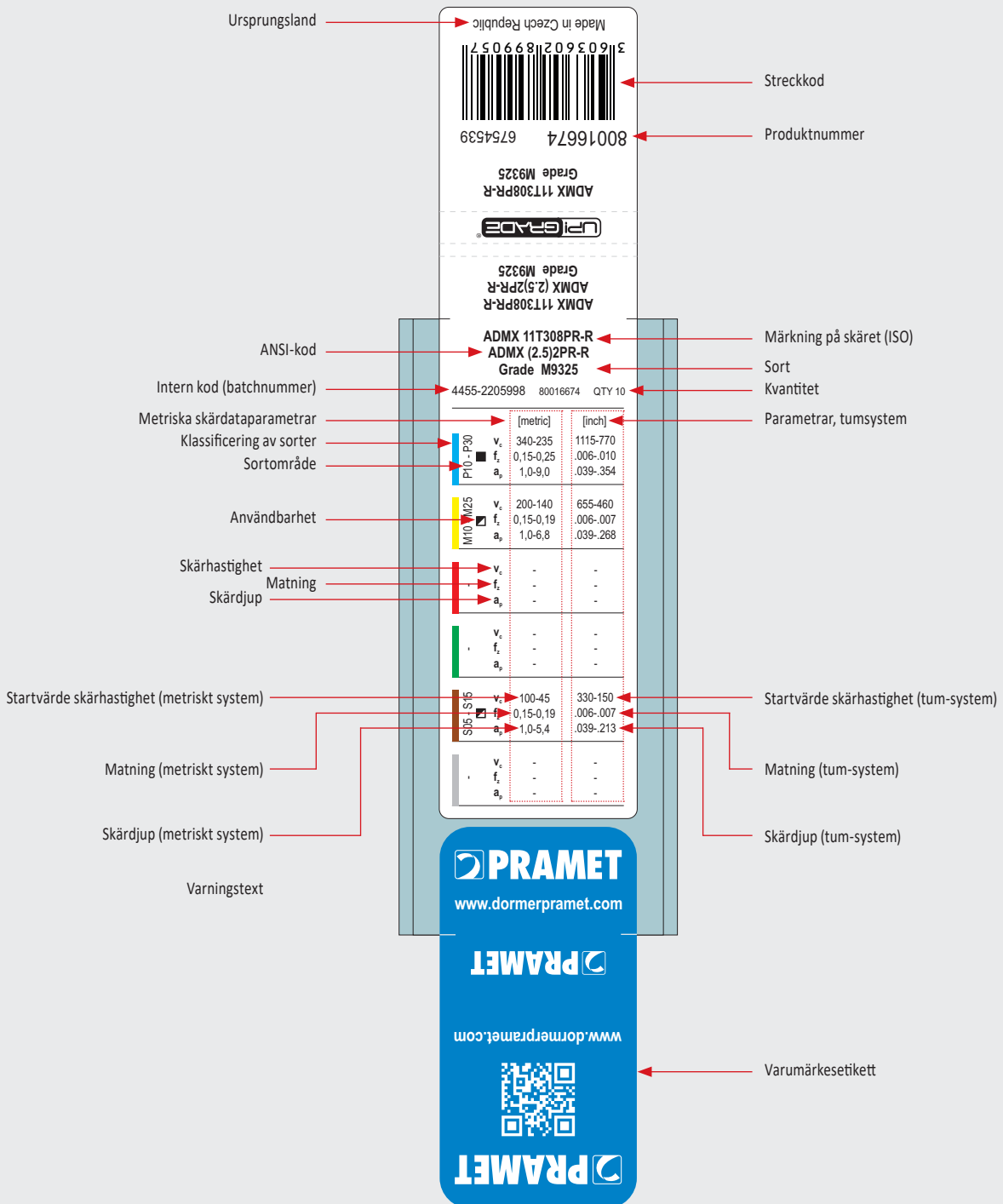
Utbytbara mejslar

Utbytesmejslar 
D-T6
D-T6P
D-T7
D-T7P
D-T8
D-T8P
D-T9
D-T9P
D-T15
D-T15P
D-T20
D-T20P

Smörjning

Spännskruvarna utsätts för höga värmepåkänningar. De bör därför smörjas med en högvärdig pasta som t.ex. MOLYCOTE 1000.

TEKNISK INFORMATION PÅ ASKARNA



WMG (WORK MATERIALGRUPP)

ISO group	WMG (Work Materialgrupp)	Hardness (HB or HRC)	Ultimate Tensile Strength (MPa)	Correction factor kvG		
P	P1.1	Svavlat	< 240 HB	≤ 830	1.33	
	P1.2	Olegerat stål med hög skärbarhet, automatstål och lågkolhaltigt stål	Svavlat och fosforiserat	< 180 HB	≤ 620	1.49
	P1.3		Svavlat/fosforiserat och blyat	< 180 HB	≤ 620	1.53
	P2.1	Olegerat kolstål	Innehåller <0.25%C	< 180 HB	≤ 620	1.14
	P2.2	(stål innehållande främst järn och kol)	Innehåller <0.55%C	< 240 HB	≤ 830	1.00
	P2.3		Innehåller >0.55%C	< 300 HB	≤ 1030	0.89
	P3.1	Legerat stål	Anlöpt	< 180 HB	≤ 620	0.92
	P3.2	(kolstål med legeringsinnehåll ≤10%)	Härdat och anlöpt	180 – 260 HB	> 620 ≤ 900	0.74
	P3.3			260 – 360 HB	> 900 ≤ 1240	0.63
	P4.1	Verktygsstål	Anlöpt	< 26 HRC	≤ 900	0.55
P4.2	(Legeringar för verktyg, formverktyg, mm)	Härdat och anlöpt	26 – 39 HRC	> 900 ≤ 1240	0.47	
P4.3			39 – 45 HRC	> 1240 ≤ 1450	0.38	
M	M1.1	Ferritiskt rostfritt stål	< 160 HB	≤ 520	1.22	
	M1.2	kromlegerat, icke härdbart	160 – 220 HB	> 520 ≤ 700	1.03	
	M2.1	Martensitiskt rostfritt stål	Anlöpt	< 200 HB	≤ 670	1.08
	M2.2	(kromlegerat, härdbart)	Släckt och anlöpt	200 – 280 HB	> 670 ≤ 950	0.89
	M2.3		Utskiljningshärdat	280 – 380 HB	> 950 ≤ 1300	0.75
	M3.1	Austenitiskt rostfritt stål	< 200 HB	≤ 750	1.00	
	M3.2	(kromnickel och krom-nickel-manganlegeringar)	200 – 260 HB	> 750 ≤ 870	0.86	
	M3.3		260 – 300 HB	> 870 ≤ 1040	0.77	
	M4.1	Austenit-ferritiskt (DUPLEX) eller austenitiskt rostfritt stål	< 300 HB	≤ 990	0.75	
	M4.2	Utskiljningshärdat, austenitiskt rostfritt stål	300 – 380 HB	≤ 1320	0.64	
K	K1.1	Gråjärn (ASTM A48) eller Automotiv-gråjärn (ASTM A159)	Ferritiskt eller ferrit-perlitiskt	< 180 HB	≤ 190	1.35
	K1.2	(järn-kol gjöt med lamellära grafitmikrostruktur)	Ferrit-perlitiskt eller perlitiskt	180 – 240 HB	> 190 ≤ 310	1.00
	K1.3		Perlitiskt	240 – 280 HB	> 310 ≤ 390	0.75
	K2.1	Smidbart gjutjärn (ASTM A602)	Ferritiskt	< 160 HB	≤ 400	1.39
	K2.2	(järn-kol gjöt med grafitfri mikrostruktur)	Ferritiskt eller perlitiskt	160 – 200 HB	> 400 ≤ 550	1.13
	K2.3		Perlitiskt	200 – 240 HB	> 550 ≤ 660	0.90
	K3.1	Formbart järn (ASTM A536)	Ferritiskt	< 180 HB	≤ 560	1.23
	K3.2	(järn-kol gjöt med en nodulär grafitmikrostruktur)	Ferritiskt eller perlitiskt	180 – 220 HB	> 560 ≤ 680	0.94
	K3.3		Ferritiskt	220 – 260 HB	> 680 ≤ 800	0.76
	K4.1	Austenitiskt gråjärn (ASTM A436)		< 180 HB	≤ 190	1.14
K4.2	(järn-kol gjöt med en austenitisk, lamellära grafitmikrostruktur)		< 240 HB	≤ 740	0.86	
K4.3	Värmebehandlat smide (ASTM A897)		< 280 HB	> 840 ≤ 980	0.63	
K4.4	(järn-kollegerat smide med en ausferrit mikrostruktur)		280 – 320 HB	> 980 ≤ 1130	0.54	
K4.5			320 – 360 HB	> 1130 ≤ 1280	0.45	
K5.1	Kompaktgrafitjärn CGI (ASTM A842)	Ferritiskt	< 180 HB	≤ 400	1.29	
K5.2	(järn-kol gjöt med en vermiculär grafitstruktur)	Ferritiskt eller perlitiskt	180 – 220 HB	> 400 ≤ 450	0.97	
K5.3		Ferritiskt	220 – 260 HB	> 450 ≤ 500	0.75	
N	N1.1	Smidd aluminium, handelskvalitet	< 60 HB	≤ 240	1.33	
	N1.2		60 – 100 HB	> 240 ≤ 400	1.00	
	N1.3	Smidda Al-legeringar	Härdade	100 – 150 HB	> 400 ≤ 590	0.67
	N2.1		< 75 HB	≤ 240	0.67	
	N2.2	Gjutna Al-legeringar	75 – 90 HB	> 240 ≤ 270	0.60	
	N2.3		90 – 140 HB	> 270 ≤ 440	0.43	
	N3.1	Renkoppar och kopparlegeringar, lättbearbetade	–	–	0.70	
	N3.2	Kortspånande kopparlegeringar, mässing	–	–	0.41	
	N3.3	Elektrolytkoppar och långspånande kopparlegeringar, svårbearbetade	–	–	0.21	
	N4.1	Termoplast	–	–	0.70	
N4.2	Härdplaster	–	–	0.27		
N4.3	Armerade plaster eller komposit	–	–	0.29		
N5.1	Grafit	–	–	1.00		
S	S1.1	Titan och titanlegeringar	< 200 HB	≤ 660	1.94	
	S1.2		200 – 280 HB	> 660 ≤ 950	1.72	
	S1.3		280 – 360 HB	> 950 ≤ 1200	1.44	
	S2.1	Fe-baserade varmhållfasta legeringar	< 200 HB	≤ 690	1.33	
	S2.2		200 – 280 HB	> 690 ≤ 970	1.17	
	S3.1	Ni-baserade varmhållfasta legeringar	< 280 HB	≤ 940	1.00	
	S3.2		280 – 360 HB	> 940 ≤ 1200	0.83	
	S4.1	Co-baserade varmhållfasta legeringar	< 240 HB	≤ 800	0.78	
S4.2		240 – 320 HB	> 800 ≤ 1070	0.67		
H	H1.1	Segjärn	< 440 HB	–	1.52	
	H2.1	Härdat gjutjärn	< 55 HRC	–	0.90	
	H2.2		> 55 HRC	–	0.77	
	H3.1	Härdat stål <55HRC	< 51 HRC	–	1.00	
	H3.2		51 – 55 HRC	–	0.82	
	H4.1	Härdat stål >55HRC	55 – 59 HRC	–	0.64	
H4.2		> 59 HRC	–	0.54		

OMVANDLINGSTABELL FÖR HÅRDHET

Styrka (MPa)	Hårdhet			
	BRINELL	VICKERS	ROCKWELL	ROCKWELL
R_m	HB	HV	HRB	HRC
285	86	90	1190	–
320	95	100	56.2	–
350	105	110	62.3	–
385	114	120	66.7	–
415	124	130	71.2	–
450	133	140	75.0	–
480	143	150	78.7	–
510	152	160	81.7	–
545	162	170	85.8	–
575	171	180	87.1	–
610	181	190	89.5	–
640	190	200	91.5	–
675	199	210	93.5	–
705	209	220	95	–
740	219	230	96.7	–
770	228	240	98.1	–
800	238	250	99.5	–
820	242	255	–	23.1
850	252	265	–	24.8
880	261	275	–	26.4
900	266	280	–	27.1
930	276	290	–	28.5
950	280	295	–	29.2
995	295	310	–	31.0
1030	304	320	–	32.2
1060	314	330	–	33.3
1095	323	340	–	34.4
1125	333	350	–	35.5
1155	342	360	–	36.6

Styrka (MPa)	Hårdhet			
	BRINELL	VICKERS	ROCKWELL	ROCKWELL
R_m	HB	HV	HRB	HRC
1190	352	370	–	37.7
1220	361	380	–	38.8
1255	371	390	–	39.8
1290	380	400	–	40.8
1320	390	410	–	41.8
1350	399	420	–	42.7
1385	409	430	–	43.6
1420	418	440	–	44.5
1455	428	450	–	45.3
1485	437	460	–	46.1
1520	447	470	–	46.9
1555	456	480	–	47.7
1595	466	490	–	48.4
1630	475	500	–	49.1
1665	485	510	–	49.8
1700	494	520	–	50.5
1740	504	530	–	51.1
1775	513	540	–	51.7
1810	523	550	–	52.3
1845	532	560	–	53.0
1880	542	570	–	53.6
1920	551	580	–	54.1
1955	561	590	–	54.7
1995	570	600	–	55.2
2030	580	610	–	55.7
2070	589	620	–	56.3
2105	599	630	–	56.8
2145	608	640	–	57.3
2180	618	650	–	57.8

SIMPLY RELIABLE

Som yrkesman kan du bedöma kvaliteten på ett arbete enbart genom att studera spånan. Spånan har en ren och okomplicerad form som berättar en historia. Det är därför vi använder denna symbol för att illustrera vår pålitlighet, "Simply reliable".

DORMER PRAMET

www.dormerpramet.com



**KONTAKTA DIN LOKALA
KUNDSUPPORT.
ALLTID UPPDATERAD!**



DP-CAT-INDEXMILL-2024-SE

FOLLOW US...



ONLINE



SEGMENTS



LIBRARY APP.



CALCULATOR APP.

