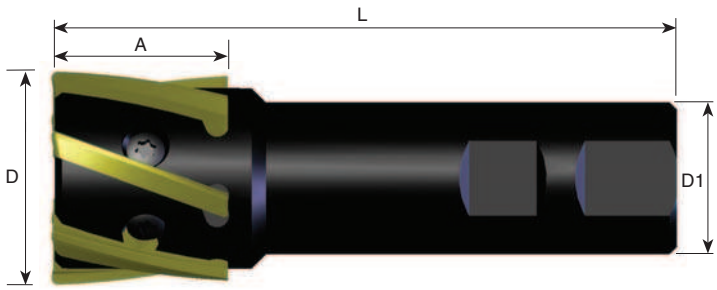
H45 Toolholder

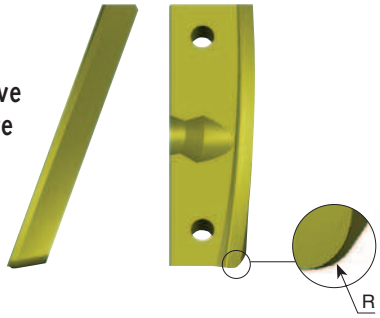


Ordering Code	Insert size A	D	D1	L	No. of Insert	Screw	Key
SRH45-6	37	45	32	130	6	S45	K40

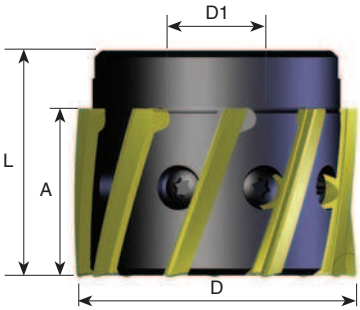
H45F Finishing Inserts

R	Ordering Code
0.2	H45 F R0.2
0.5	H45 F R0.5
1.0	H45 F R1.0
1.5	H45 F R1.5
2.0	H45 F R2.0

Spiral inserts have one cutting edge



H63 Toolholder

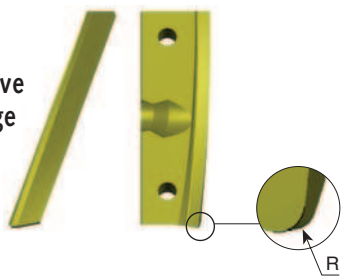


Ordering Code	Insert size A	D	D1	L	No. of Insert	Screw	Key
SRH63-9	38	63	22	50	9	S63	K40

H63F Finishing Inserts

R	Ordering Code
0.2	H63 F R0.2
0.5	H63 F R0.5
1.0	H63 F R1.0
1.5	H63 F R1.5
2.0	H63 F R2.0

Spiral inserts have one cutting edge

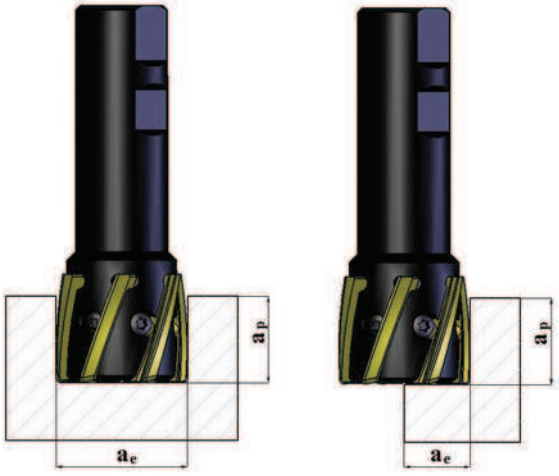


Spiral Finish Speed and Feed Selection

ISO	Materials	V_c (mm)	h_m (mm)
P	Low and Medium Carbon Steels	200-330	0.05-0.15
	High Carbon Steels	170-235	0.05-0.13
	Alloy Steels, Treated Steels	100-195	0.05-0.13
M	Stainless Steels	180-230	0.04-0.13
	Cast Steels	180-230	0.05-0.12
K	Cast Iron	200-350	0.05-0.11
N	Non- Ferrous and Aluminum	500-1100	0.05-0.15
	Synthetics, Duroplastics, Thermoplastics	400-1500	0.05-0.15
S	Nickel Alloys, Titanium Alloys	30-55	0.04-0.07

D = cutting diameter	ø23	ø32	ø45	ø63
a_p max	27	32	37	38

$$f_z = h_m \, x \sqrt{\frac{D}{a_e}}$$

h_m = average chip load f_z = tooth load

D	ø23		ø32		ø45		ø63	
h_m	0.05	0.15	0.05	0.15	0.05	0.15	0.05	0.15
a_e	f_z							
2	0.17	0.51	0.20	0.60	0.24	0.71	0.28	0.84
6	0.10	0.29	0.12	0.35	0.14	0.41	0.16	0.49
12	0.07	0.21	0.08	0.24	0.10	0.29	0.11	0.34
18	0.06	0.17	0.07	0.20	0.08	0.24	0.09	0.28
24	0.05	0.15	0.06	0.17	0.07	0.21	0.08	0.24
30	0.04	0.13	0.05	0.15	0.06	0.18	0.07	0.22
36	0.04	0.12	0.05	0.14	0.06	0.17	0.07	0.20