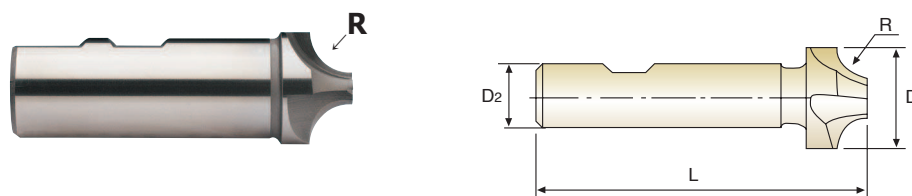


HSSCo8, 4 FLUTE CORNER ROUNDING CUTTERS

HSSCo8, 4 SCHNEIDEN VIERTELKREISFRÄSER

► These tools can be adapted for many screw machine applications as end forming tools to form a specific radius. ► Dieses Werkzeug kann an vielen Scrow maschine als Finishingtool für spezielle Radien montiert werden.



HSS Co8
DIN 6518
N
4
0°
DIN 1835B
P.1294

Unit : mm

EDP No.	Radius	Outside Diameter	Shank Diameter	Overall Length
FLAT	R(H11)	D	D ₂ (h6)	L
E2498010	R1.0	8.0	10	60
E2498015	R1.5	9.0	10	60
E2498020	R2.0	10.0	10	60
E2498025	R2.5	11.0	10	60
E2498030	R3.0	12.0	12	60
E2498035	R3.5	13.0	12	60
E2498040	R4.0	14.0	12	60
E2498045	R4.5	15.0	12	60
E2498050	R5.0	16.0	12	60
E2498055	R5.5	19.0	16	67
E2498060	R6.0	20.0	16	67
E2498065	R6.5	21.0	16	71
E2498070	R7.0	22.0	16	71
E2498075	R7.5	23.0	16	71
E2498080	R8.0	24.0	16	71
E2498085	R8.5	25.0	25	85
E2498090	R9.0	26.0	25	85
E2498095	R9.5	27.0	25	85
E2498100	R10.0	28.0	25	85
E2498105	R10.5	31.0	25	90
E2498110	R11.0	32.0	25	90
E2498120	R12.0	34.0	25	90
E2498125	R12.5	41.0	25	100
E2498130	R13.0	42.0	25	100
E2498140	R14.0	44.0	25	100
E2498150	R15.0	46.0	25	100
E2498160	R16.0	48.0	25	100
E2498180	R18.0	52.0	32	112
E2498200	R20.0	56.0	32	112

Tolerances according to DIN 7160 & 7161
Toleranzen nach DIN 7160 & 7161

► TiN-COATING, TiCN-COATING & TiAlN-COATING is available on your request.

	Nominal-Diameter in mm / Nennmaßbereich in mm					
	from 1 to 3 von 1 bis 3	over 3 to 6 über 3 bis 6	over 6 to 10 über 6 bis 10	over 10 to 18 über 10 bis 18	over 18 to 30 über 18 bis 30	over 30 to 50 über 30 bis 50
	Tolerance range in μm / Toleranzwerte in μm					
H11	+60 0	+75 0	+90 0	+110 0	+130 0	+160 0
h6	0 -6	0 -8	0 -9	0 -11	0 -13	0 -16

◎ : Excellent ○ : Good

Carbon Steels	Alloy Steels	Prehardened Steels	Hardened Steels		High Hardened Steels	Copper	Graphite	Cast Iron	Aluminum	Stainless Steels	Titanium	Inconel	Acrylic	CFRP
~HB225	HB225~325	HRC30~40	HRC40~45	HRC45~55	HRC55~70									
◎	◎	○							○					



HSSCo8, 4 FLUTE CORNER ROUNDING CUTTERS

HSSCo8, 4 SCHNEIDEN VIERTELKREISFRÄSER

E2498 SERIES

MATERIAL		ALUMINUM & ALUMINUM ALLOYS				CARBON STEELS ALLOY STEELS			
HARDNESS									
STRENGTH						~ 500N/mm ²			
OUTSIDE DIAMETER	CORNER RADIUS	RPM	FEED	Vc	fz	RPM	FEED	Vc	fz
8.0	R1	3500	245	90	0.018	800	55	20	0.017
9.0	R1.5	2800	230	80	0.021	630	55	20	0.022
10.0	R2	2800	220	90	0.020	630	50	20	0.020
11.0	R2.5	2400	220	85	0.023	530	45	20	0.021
12.0	R3	2400	210	90	0.022	530	45	20	0.021
14.0	R4	2000	200	90	0.025	450	45	20	0.025
16.0	R5	1600	200	80	0.031	350	40	20	0.029
20.0	R6	1400	190	90	0.034	310	40	20	0.032
24.0	R8	1200	180	90	0.038	260	40	20	0.038
28.0	R10	950	170	85	0.045	210	35	20	0.042
34.0	R12	800	160	85	0.050	180	35	20	0.049
48.0	R16	600	140	90	0.058	130	30	20	0.058

MATERIAL		CARBON STEELS ALLOY STEELS TOOL STEELS				CARBON STEELS ALLOY STEELS TOOL STEELS			
HARDNESS		~ HRc20				HRc20 ~ HRc35			
STRENGTH		500 ~ 800N/mm ²				800 ~ 1100N/mm ²			
OUTSIDE DIAMETER	CORNER RADIUS	RPM	FEED	Vc	fz	RPM	FEED	Vc	fz
8.0	R1	600	35	15	0.015	480	35	10	0.018
9.0	R1.5	470	30	15	0.016	380	35	10	0.023
10.0	R2	470	30	15	0.016	380	30	10	0.020
11.0	R2.5	390	30	15	0.019	315	30	10	0.024
12.0	R3	390	30	15	0.019	315	30	10	0.024
14.0	R4	330	30	15	0.023	270	25	10	0.023
16.0	R5	260	30	15	0.029	210	25	10	0.030
20.0	R6	230	30	15	0.033	185	25	10	0.034
24.0	R8	190	30	15	0.039	155	25	10	0.040
28.0	R10	155	25	15	0.040	125	25	10	0.050
34.0	R12	130	25	15	0.048	105	20	10	0.048
48.0	R16	95	20	15	0.053	75	15	10	0.050

RPM = rev./min.
FEED = mm/min.
Vc = m/min.
fz = mm/t