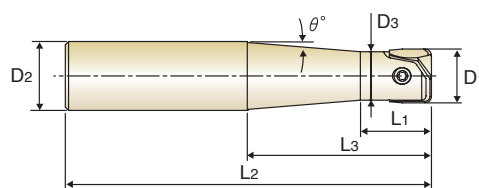


i-Xmill CORNER RADIUS HOLDERS - STEEL
i-Xmill HALTER für WECHSELPLATTE mit GERADER STIRN UND ECKRADIU

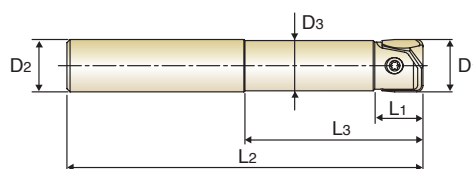
- ▶ Premium alloy steel with excellent strength.
- ▶ Precise shank, Tolerance (h6).
- ▶ Nickel plated, to prevent corrosion and improve lubricity.

- ▶ Premium legierter Stähle mit großer Festigkeit.
- ▶ Hochgenauer Schaft, Tol h6.
- ▶ Vernickelt, verhindert Korrosion und verbessert die Schmierfähigkeit.


TAPER NECK TYPE

Unit : mm

EDP No.	Mill Diameter	Shank Diameter	Length of Cut	Length Below Shank	Overall Length	Neck Diameter	Taper Angle	Length Type	Wrench No.	Screw No.
	D1	D2	L1	L3	L2	D3	θ°			
ZRT0801120	8.0	12	10	22	100	6.7	9°	Regular	TWFT07	TX2508T07
ZRT0802120				50	130		2° 43'	Long		
ZRT1001120	10.0	12	13	25	100	8.6	4° 45'	Regular	TWFT08	TX3010T08
ZRT1002120				50	150		1° 32'	Long		
ZRT1202160	12.0 13.0	16	15	60	160	10.2	2° 32'	Long	TWFT10	TX3512T10


STRAIGHT NECK TYPE

Unit : mm

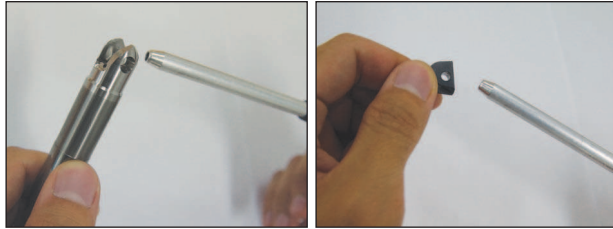
EDP No.	Mill Diameter	Shank Diameter	Length of Cut	Length Below Shank	Overall Length	Neck Diameter	Length Type	Wrench No.	Screw No.
	D1	D2	L1	L3	L2	D3			
ZRS1201120	12.0, 13.0	12	13	30	110	11	Regular	TWFT10	TX3512T10
ZRS1601160				50	130	15	Regular		
ZRS1602160	16.0, 17.0	16	15	65	165		19	Intermediate	TWFT15
ZRS2001200				60	140	19		Regular	
ZRS2002200	20.0, 21.0	20	18	80	180		24	Intermediate	TWBT20
ZRS2501250				70	150	24		Regular	
ZRS2502250	25.0, 26.0	25	23	90	200		29	Intermediate	TWBT25
ZRS3001320				80	160	29		Regular	
ZRS3002320	30.0	32	27	100	220		31	Intermediate	TWBT30
ZRS3201320				80	160	31		Regular	
ZRS3202320	32.0	32	28	100	220		31	Intermediate	TWBT30

- Required to use T-HANDLE (TWH600)

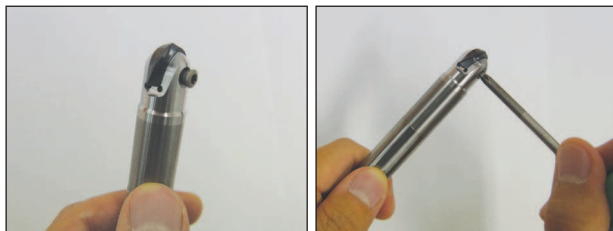


**RECOMMENDED CUTTING CONDITIONS
EMPFOHLENE SCHNEIDKONDITIONEN**

**ASSEMBLY OF *i-Xmill*
MONTAGE DES *i-Xmill***



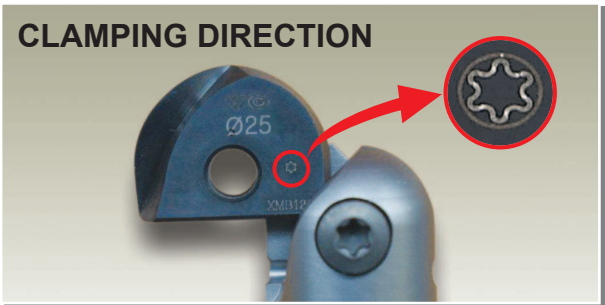
◀ Make sure to clean the insert and insert seat.
Wechselplatte und Plattensitz sorgfältig reinigen.



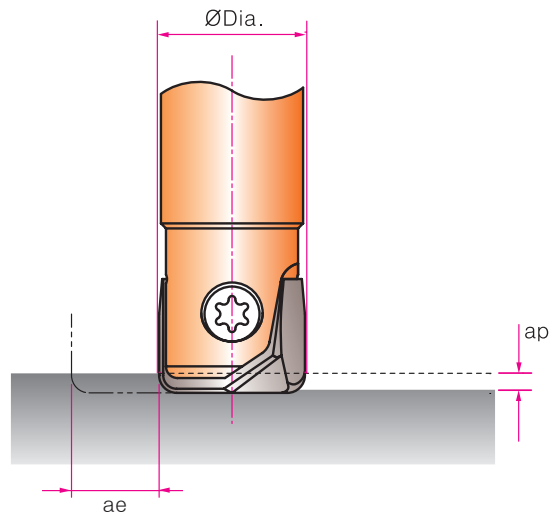
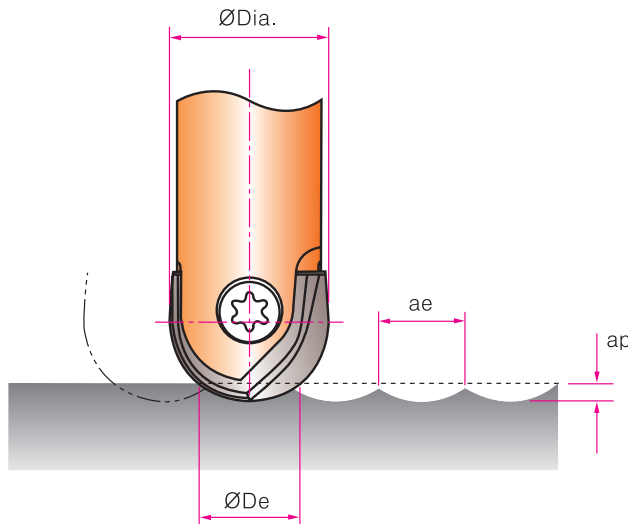
◀ Slide the insert into the slot of the holder.
Tighten the screw using anti-seize compound.
Wechselplatte in den Sitz des Halters einführen.
Die Schraube fest anziehen und dabei Spezialfett verwenden

SIZE (ØD)	CLAMPING TORQUE [N · m]
Ø8	1.0
Ø10	1.5
Ø12, Ø13	2.5
Ø16, Ø17	3.5
Ø20, Ø21	5.0
Ø25, Ø26	6.0
Ø30, Ø32	6.5

- * When the screw is worn out, please change the new screw.
- * Wenn das Schraubengewinde verschlissen ist, bitte neue Schraube verwenden.
- * Please tighten up the screw with recommended torque. (Please refer to the table)
- * Die Feststellschraube mit dem empfohlenen Anzugsmoment anziehen (siehe Tabelle).
- * Don't press down the insert, when the screw is tightened.
- * Die Wechselplatte nicht nach unten drücken, wenn die Schraube angezogen ist.



CUTTING CONDITION



RPM = revolution per minute (rev/min)
Vc = surface meter per minute (M/min)
Dia. = diameter of insert (mm)
Vf = feed speed (mm/min)
f = feed per revolution (mm/rev)
De = effective tool diameter (mm)
ap = axial depth of cut (mm)
ae = radial depth of cut (mm)

$$Vc [M/min] = \frac{(RPM) \cdot (\pi) \cdot (Dia.)}{1000}$$

$$Vf [mm/min] = (RPM) \cdot (f)$$

$$RPM [rev/min] = \frac{(Vc) \cdot (1000)}{(\pi) \cdot (Dia.)}$$

$$De [mm] = 2 \sqrt{(ap) \cdot (Dia. - ap)}$$