

# LINEPro

70090 | XDKT 100308

Square shoulder milling



## Cutters

- Designed to generate a 90° square shoulder, minimizing secondary operations;
- Large chip gullets ensure efficient chip evacuation;

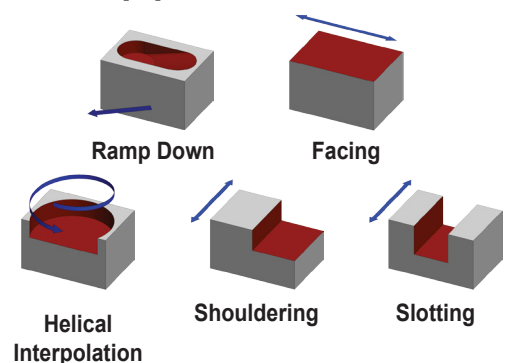
## Specifications

- Geometry: 90° shoulder milling;
- Cutter diameters:
  - Cylindrical Shank (E): Ø17, Ø22 & Ø27
- Workpiece materials: Steel, stainless steel, cast iron & high-temp alloys;

## Inserts

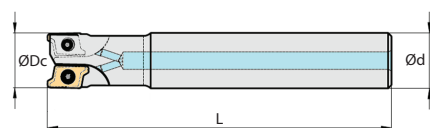
- Positive top-form geometry inserts create lower cutting forces at higher feed rates;
- Insert design makes these cutters ideal for ramping and helical interpolation;

## Applications

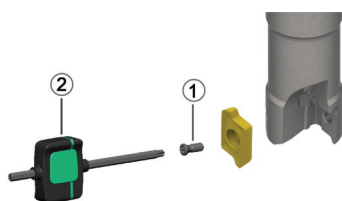


## E700

Order Code	Reference		Dimensions (mm)			Arbor Style	a <sub>p</sub> Max.	Stock
			Ø Dc	Ø d	L			
181046100	017E70090-02-03-016150	02	17	16	150	Cylindrical	9,0	
181046400	017E70090-02-03-016250	02	17	16	250		9,0	
181046200	022E70090-03-05-020150	03	22	20	150		9,0	
181046500	022E70090-03-05-U020250	03	22	20	250		9,0	
181046300	027E70090-04-06-025150	04	27	25	150		9,0	
181046600	027E70090-04-06-U025250	04	27	25	250		9,0	



## Screws & Keys



Item	1	2	
Milling Holder Type	Insert Screw	Key (Torx)	Torque Value
E70090 - Ø17 - Ø27	P0250601	XT08	3,0

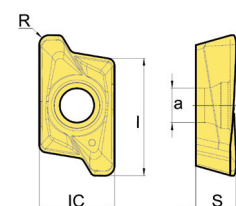
## XDKT

(1) Geometry	ISO	P					M					K					S			Dimensions (mm)				
		54	68	B9	78	86	68	C2	78	53	86	54	68	58	B9	C2	68	66	78	iC	S	I	R	a
1111224	XDKT 100308 PDSR																			6,35	3,4	10,00	0,8	1,3

Insert order code = (1) Geometry Code + (2) Grade Code

## Chip Breaker

Chip Breaker	Features
Geometry <b>MP</b> General machining of steels	Chip-breaker with a reinforced chamfer for general applications on steels.



## Rec. Cutting Conditions

ISO	Grades	Vc (m/min)	fz (mm/t)
P	PH6910	150 - 220	0,10 - 0,30
	PH6920	140 - 200	0,10 - 0,30
	PH6125	130 - 190	0,10 - 0,30
	PH6135	120 - 180	0,10 - 0,30
M	PH6920	100 - 180	0,10 - 0,30
	PH6125	100 - 180	0,10 - 0,30
	PH6135	90 - 180	0,10 - 0,30
K	PH6910	90 - 250	0,10 - 0,30
	PH6920	80 - 240	0,10 - 0,30
S	PH6910	20 - 80	0,10 - 0,30
	PH6920	20 - 70	0,10 - 0,30
	PH6125	20 - 80	0,10 - 0,30

## Grades

Grades	Information
PH6910	PVD coated carbide with micro-grain substrate for light milling of steels or for hardened steels. Excellent for cast iron and high temperature alloys.
PH6920	Coated carbide grade for high cutting speed applications, excellent solution to massive production with stable conditions.
PH6125	PVD coted carbide grade for light to heavy milling (wet and dry) in steel at elevated temperature. Excellent grade for milling mould steels at high productivity.
PH6135	PVD coated carbide for toughness demanding milling operations. Excellent solution for instable applications and can be apply in wet or dry.