

— XTRA-TEC® XT – XTENDED TECHNOLOGY

Xtra-tec® XT catalogue

Milling



Powered by
Tiger-tec® Gold
Xtra-tec® XT

Performance and reliability extend your perspective.

THE TOOL

- Xtra-tec® XT M5130 shoulder milling cutter
- Stable cross-section due to modified installation position of the indexable inserts
- Three tooth pitches for different applications
- Approach angle: Exactly 90°
- Oversize milling cutter for machining operations on deep shoulders
- Dia. 10–160 mm (or 0.5–6")
- Interfaces: ScrewFit, cylindrical-modular interface, Weldon or cylindrical shank and bore adaption

THE INDEXABLE INSERTS

- Rhombic, positive indexable inserts
- Two cutting edges with positive basic shape
- Stabilised cross-section due to reduced clearance angle
- Four indexable insert sizes with different corner radii:
 - AC..0602...: $r = 0.2\text{--}1.6\text{ mm}$, $a_{p\text{ max}} = 5\text{ mm}$
 - BC..0903...: $r = 0.2\text{--}2.0\text{ mm}$, $a_{p\text{ max}} = 9\text{ mm}$
 - BC..1204...: $r = 0.4\text{--}4.0\text{ mm}$, $a_{p\text{ max}} = 12\text{ mm}$
 - BC..1605...: $r = 0.8\text{--}6.0\text{ mm}$, $a_{p\text{ max}} = 15\text{ mm}$
- Variants:
 - Fully sintered circumference (ACMT..., BCMT...)
 - Fully ground circumference (ACGT..., BCGT... and ACHT..., BCHT...)

THE APPLICATION

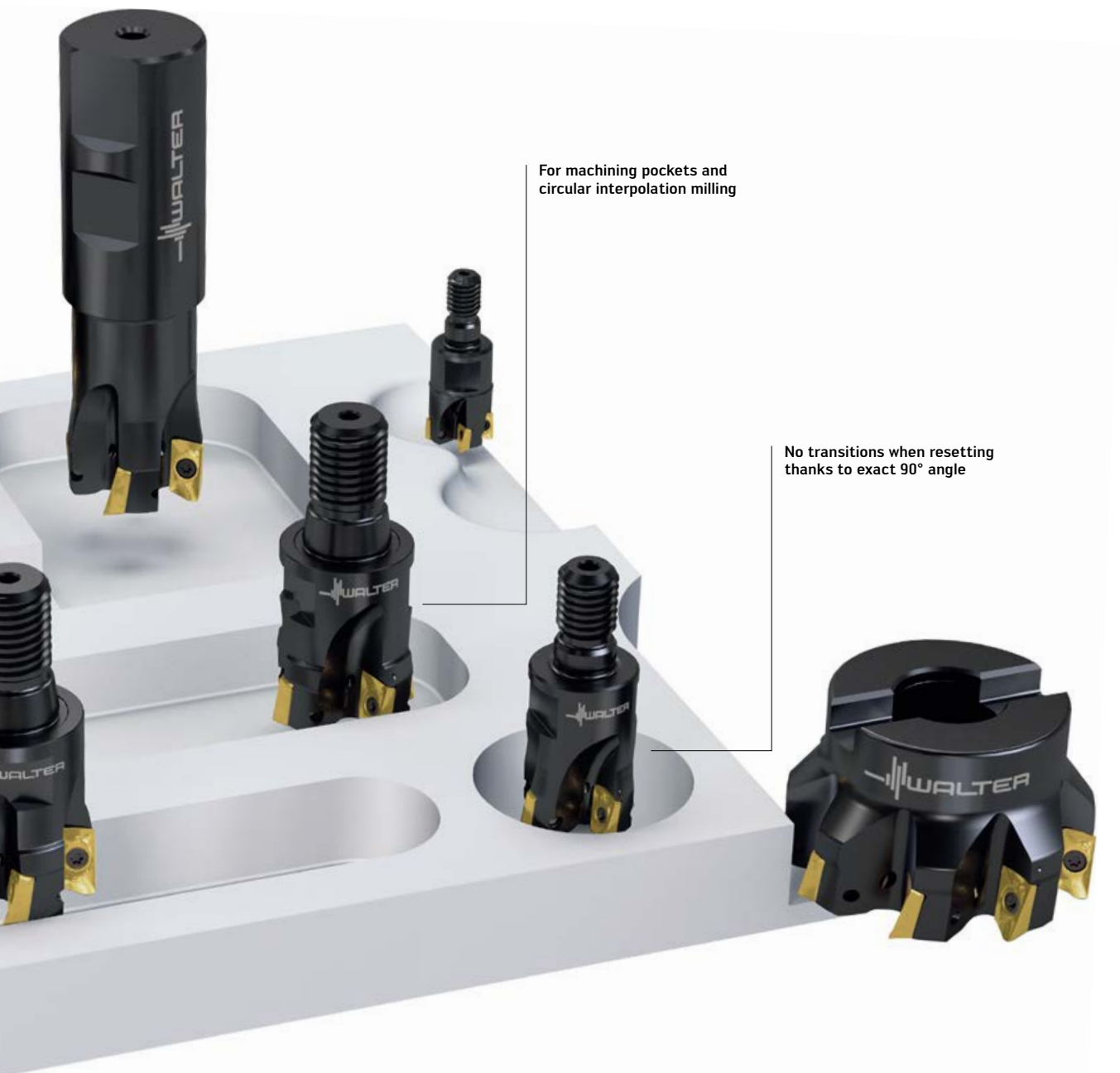
- Face milling, shoulder milling, ramping, pocket milling and circular interpolation milling
- Small indexable inserts combined with a high number of teeth: Ideal for low material removal rates
- For steel, stainless steels, cast iron, non-ferrous metals and materials with difficult cutting properties
- Areas of use: Energy industry, mould and die making, general mechanical engineering, etc.

Stable cross-section due to modified installation position of the indexable inserts



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BENEFITS FOR YOU

- Optimum cutting data and tool life for maximum productivity
- Process reliability thanks to high level of stability
- Indexable insert sizes, corner radii and geometries perfectly adapted to the machining operation
- Lower tool costs and minimised effort due to universal application
- No additional finishing operations thanks to exact 90° angle
- Excellent handling thanks to improved access to screws
- Maximum cost-efficiency thanks to Tiger-tec® cutting tool materials, high number of teeth and adapted indexable insert sizes

Six times as cost-efficient, 90° approach angle.

EXPANSION OF THE RANGE

NEW ADDITION TO THE PRODUCT RANGE

G27 geometry for universal applications

- Sintered version
- Insert sizes: TNMU11T3... and TNMU1604...

Tools with diameters in inches

- Dia. 1–4"
- With bore adaption and Weldon shank
- Depths of cut $a_{p\max} = 5$ or 8 mm

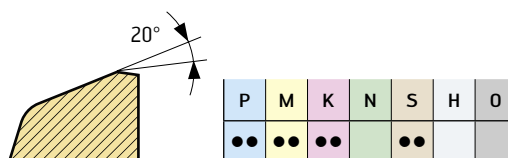
THE TOOL

- Shoulder milling cutter with triangular, double-sided indexable inserts
- Two tooth pitches for different applications
- 90° approach angle
- Interfaces: Weldon shank and bore adaption
- Dia. 25–100 mm or 1–4"
- Two depths of cut $a_{p\max} = 5$ or 8 mm

THE INDEXABLE INSERTS

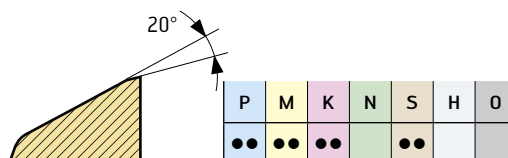
- Two indexable insert sizes:
 - TNMU11T304R for a 5 mm depth of cut
 - TNMU160508R for an 8 mm depth of cut
- Design with secondary cutting edge
- G57 – The easy-cutting one
- G27 – The universal one
- Sintered: For maximum cost-efficiency

G27 – The universal one

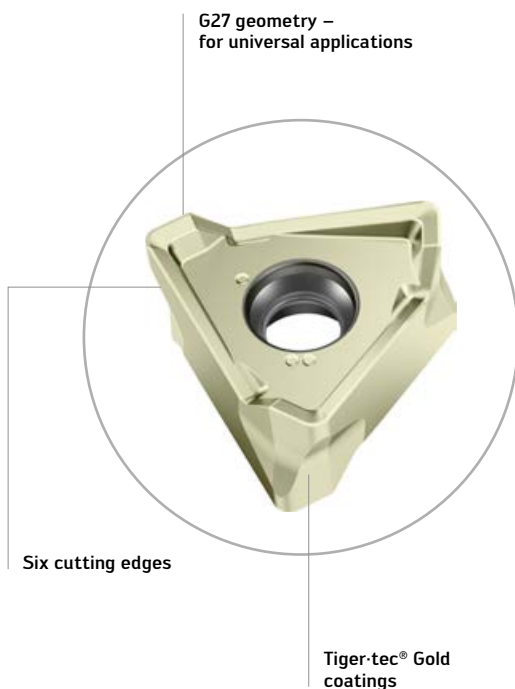


- For medium machining conditions
- Can be used universally for most materials

G57 – The easy-cutting one



- For good machining conditions
- Low cutting forces
- Moderate feeds



THE APPLICATION

- Can be used universally for steel, stainless steels, cast iron and materials with difficult cutting properties
- Face milling, shoulder milling, ramping, pocket milling and circular interpolation milling
- Areas of use: Energy industry, mould and die making, general mechanical engineering, among others



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Xtra-tec[®] XT M5137 shoulder milling cutter

Fig.: M5137-063-B22-09-05
Fig.: TNMU11T304R-G27 WSP45G

BENEFITS FOR YOU

- High process reliability due to strong, double-sided indexable inserts
- High level of cost-efficiency due to Tiger-tec[®] cutting tool materials and six cutting edges per indexable insert
- Simple tool selection and low cutting tool material costs

High machining volume thanks to maximum number of teeth.

THE TOOL

- Xtra-tec® XT M5008 high-feed milling cutter
- 0–15° approach angle
- Depth of cut 1 mm
- Extremely close pitch
- Oversize milling cutter for machining operations on deep shoulders
- Two tooth pitches for different applications
- Dia. 16–66 mm (or 5/8–2½")
- Interfaces: ScrewFit, cylindrical-modular, cylindrical shank and bore adaption

THE INDEXABLE INSERTS

- Double-sided indexable inserts with four cutting edges
- Rhombic basic shape for small tool diameters and high number of teeth
- Curved cutting edges for maximum stability
- Combines stability with easy-cutting geometries
- Tiger-tec® cutting tool materials for optimum cutting data and tool life



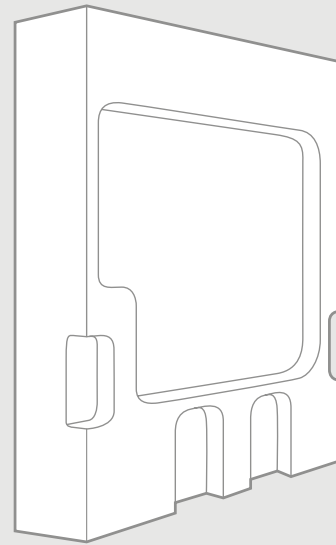
THE APPLICATION

- For steel, stainless steels, cast iron and materials with difficult cutting properties
- Face milling at high feed rates, for plunging, inclined plunging and circular interpolation milling
- Areas of use: Energy industry, mould and die making, among others



APPLICATION EXAMPLE

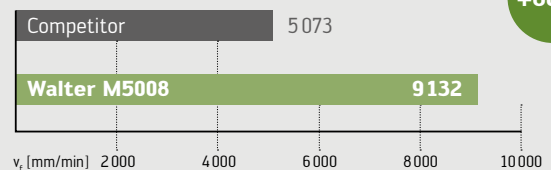
Base plate:
Roughing of grooves



Material: 40CrMnMoS8-6 (1.2312), ISO P
Tool: M5008/dia. 32 mm
Indexable insert: ENMX08T316R-D27
Cutting tool material: WKP35G

	Competitor	Walter
Number of teeth	3	6
v_c (m/min)	170	170
f_z (mm)	1.0	0.9
v_f (mm/min)	5073	9132
a_p (mm)	0.5	0.7
a_e (mm)	20	20

Comparison: Feed rate



BENEFITS FOR YOU

- Universal application
- Optimum productivity thanks to extremely closely pitched tools
- High machining volume thanks to the combination of low depths of cut and high feed per tooth rates
- High process reliability due to stable indexable insert
- Low vibration tendency in long tools
- Reduced process costs thanks to Tiger-tec® cutting tool materials and four cutting edges



Watch the product video:
www.youtube.com/waltertools

Face milling – cost-effective and universal.

THE TOOL

- Xtra-tec® XT M5009 face milling cutter with 45° approach angle
- Xtra-tec® XT M5011 face milling cutter with 75° approach angle
- Xtra-tec® XT M5012 face milling cutter with 88° approach angle

THE APPLICATION

- Steel and cast iron materials, stainless steels and materials with difficult cutting properties
- Face milling: Rough and finishing with wiper insert
- Face milling with larger depth of cut
- Can also be used on less powerful machines thanks to the positive, soft cutting action

System insert –
for various approach angles



Xtra-tec® XT
M5011 face milling cutter

Fig.: M5011-063-
B22-05-08-AP



Xtra-tec® XT
M5009 face milling cutter

Fig.: M5009-
100-B32-09-05

THE INDEXABLE INSERTS

System insert can be used in:

- SN.X0904... can be used in the Xtra-tec® XT M5009 and M5012 face milling cutters
- SN.X1205... can be used in the Xtra-tec® XT M5009, M5011 and M5012 face milling cutters

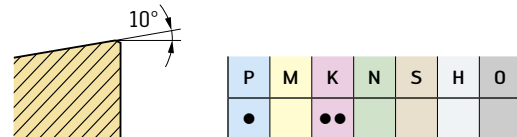
Roughing insert:

- Double-sided indexable inserts with eight cutting edges
- Easy-cutting geometries
- Version with fully ground circumference (SNGX..., SNHX...) for maximum precision
- Sintered version (SNMX...) for maximum cost-efficiency

Wiper insert:

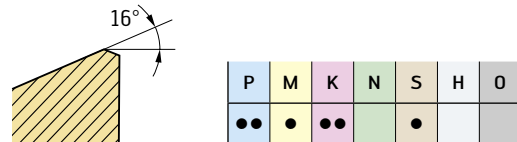
- Double-sided indexable inserts with two cutting edges (XNGX0904... and XNGX1205...)
- System-specific indexable inserts with secondary cutting edge

D27 – The special one



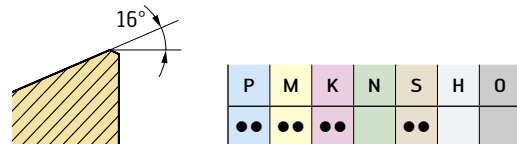
- For machining cast iron materials
- For sand inclusions or cast skin
- Maximum process reliability

F27 – The stable one



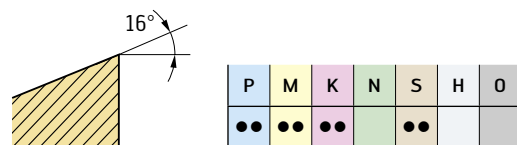
- For unfavourable machining conditions
- Maximum cutting edge stability
- High feeds

F57 – The universal one



- For medium machining conditions
- Can be used universally for most materials

F67 – The easy-cutting one



- For good machining conditions
- Low cutting forces
- Moderate feeds



Xtra-tec® XT
M5012 face milling cutter

Fig.: M5012-063-
B22-05-10-AP

BENEFITS FOR YOU

- High level of stability in variable conditions
- Highly reliable due to strong, double-sided indexable inserts and carbide shim
- Very good handling due to easily accessible clamping screw (prevents typical installation mistakes)
- Cost-effective thanks to low cutting tool material costs

Milling with eight times the flexibility.

THE TOOL

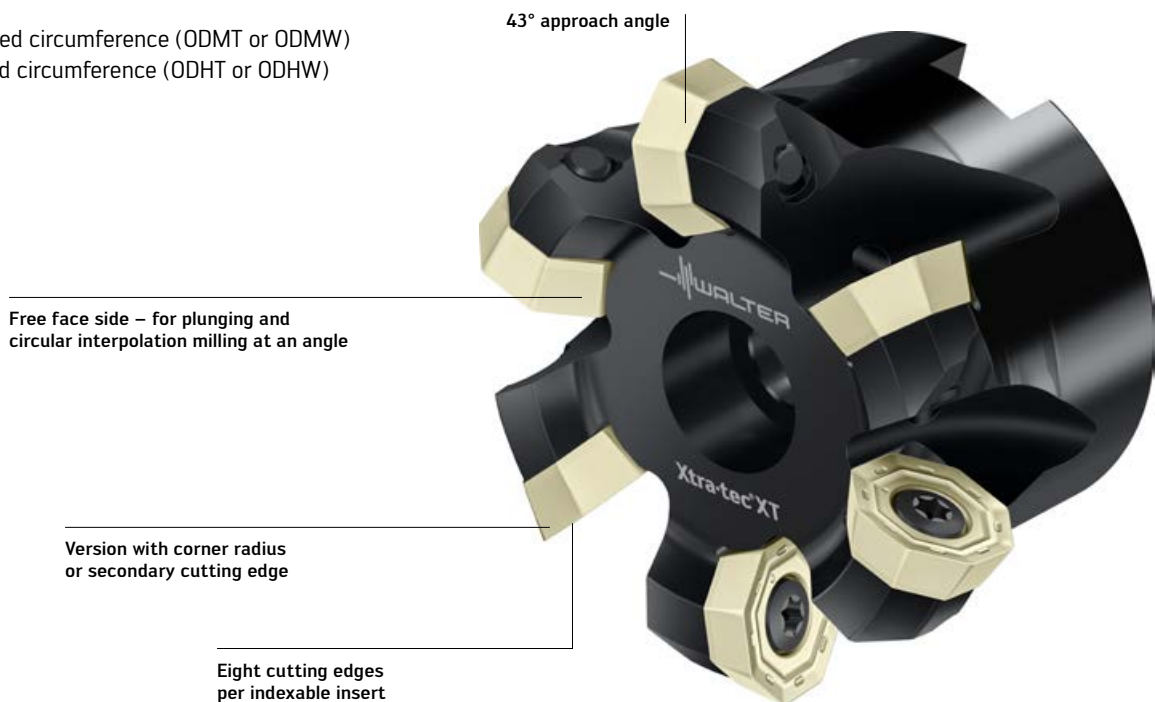
- Xtra-tec® XT M5004 octagon milling cutter
- 43° approach angle
- Depth of cut 3 or 4 mm
- Three tooth pitches for different applications
- Dia. 32–170 mm (or 1.25–3.315")
- Interfaces: ScrewFit, cylindrical-modular, cylindrical shank and bore adaption

THE INDEXABLE INSERT

- Eight-cornered, positive indexable inserts with eight cutting edges
- Two indexable insert sizes with corner radius or facet
- Variants:
 - Fully sintered circumference (ODMT or ODMW)
 - Fully ground circumference (ODHT or ODHW)

THE APPLICATION

- Face milling (roughing and finishing), ramping, pocket milling and circular interpolation milling, as well as chamfering and back chamfering
- For steel, stainless steels, cast iron, non-ferrous metals and materials with difficult cutting properties
- Areas of use: Energy industry, mould and die making, general mechanical engineering, among others



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Xtra-tec® XT M5004 octagon milling cutter

Fig.: M5004-073-B22-06-04

BENEFITS FOR YOU

- Optimum cutting data and tool life for maximum productivity
- Maximum process reliability due to high stability
- Perfectly adapted to the machining operation due to different indexable insert sizes, corner designs and geometries
- Lower tool costs and minimised effort due to universal application
- Maximum cost-efficiency due to Tiger-tec® cutting tool materials, high number of teeth and low cutting tool material costs





Maximum security against inadvertent rotation

THE TOOL

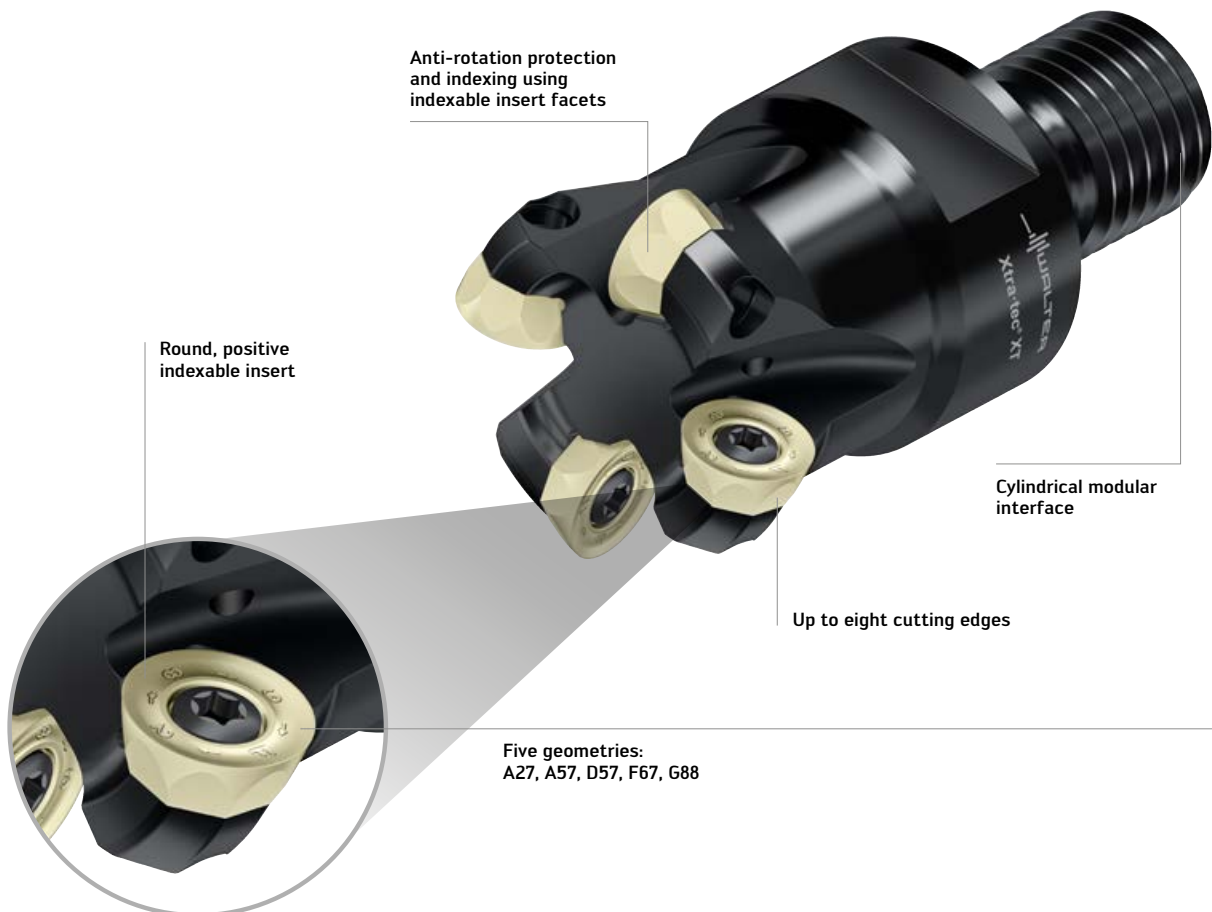
- Xtra-tec® XT M5468 button insert milling cutter
- Protection against inadvertent insert rotation and accurate cutting edge indexing due to up to eight facets on the indexable insert
- Oversize milling cutter for machining operations on deep shoulders
- Dia. 10–125 mm (or 1.0–5.0")
- Two tooth pitches for different applications
- Interfaces: ScrewFit, cylindrical-modular, Weldon shank and bore adaption
- No assembly parts obstructing chip flow
- Good chip removal when machining deep pockets

THE INDEXABLE INSERT

- Up to eight cutting edges with positive basic shape
- Seven indexable insert sizes: RD.X0501M0; RD.X07T1M0; RO.X0803M04; RO.X10T3M08; RO.X1204M08; RO.X1605M08; RO.X2006M08

Variants:

- Fully sintered circumference (RDM.../ROM...)
- Fully ground circumference (ROG.../ROH...)



Xtra-tec® XT M5468 button insert milling cutter
Indexable insert for Xtra-tec® XT M5468 button insert milling cutter

Fig.: M5468-032-TC16-04-05
Fig.: ROMX10T3M08-F67 WSP45G

THE APPLICATION

- Universal system for copy milling, face milling, ramping, pocket milling and circular interpolation milling
- Ideal for copy milling with minimal material removal
- For steel, stainless steels, cast iron, non-ferrous metals, materials with difficult cutting properties and for hard machining
- Areas of use: Mould and die making, general mechanical engineering, energy industry, among others

Overview of geometries:



A27 – The stable one



A57 – The special one



D57 – The universal one



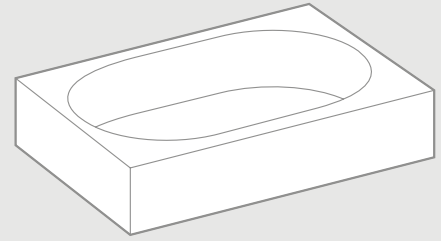
F67 – The easy-cutting one



G88 – The sharp one

APPLICATION EXAMPLE

Pocket milling



Material: 42CrMo4, 900 N/mm², ISO P

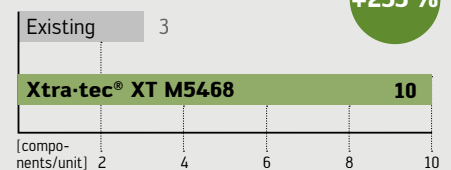
Tool: M5468 / Ø24 / Z2

Indexable insert: ROMX1204M08-F67

Cutting tool material: WSP45G

Cutting data:	Existing	Walter
		Xtra-tec® XT M5468
v_c (m/min)	200	200
f_z (mm)	0,18	0,18
a_e (mm)	14,0–24,0	14,0–24,0
a_p (mm)	max. 4,00	max. 4,00
Cooling	Dry	Dry

Comparison: Tool life quantity



BENEFITS FOR YOU

- Maximum productivity due to optimum cutting data and tool life
- Maximum process reliability due to indexing of the indexable inserts using facets
- Perfectly adapted to the machining operation due to different indexable insert sizes and geometries
- High level of flexibility for use in existing adaption systems due to cylindrical-modular interface
- Lower tool costs and minimised effort due to universal application
- High level of cost-efficiency due to Tiger-tec® cutting tool materials, higher number of teeth

Copying and finishing with maximum tool life and precision.

THE TOOL

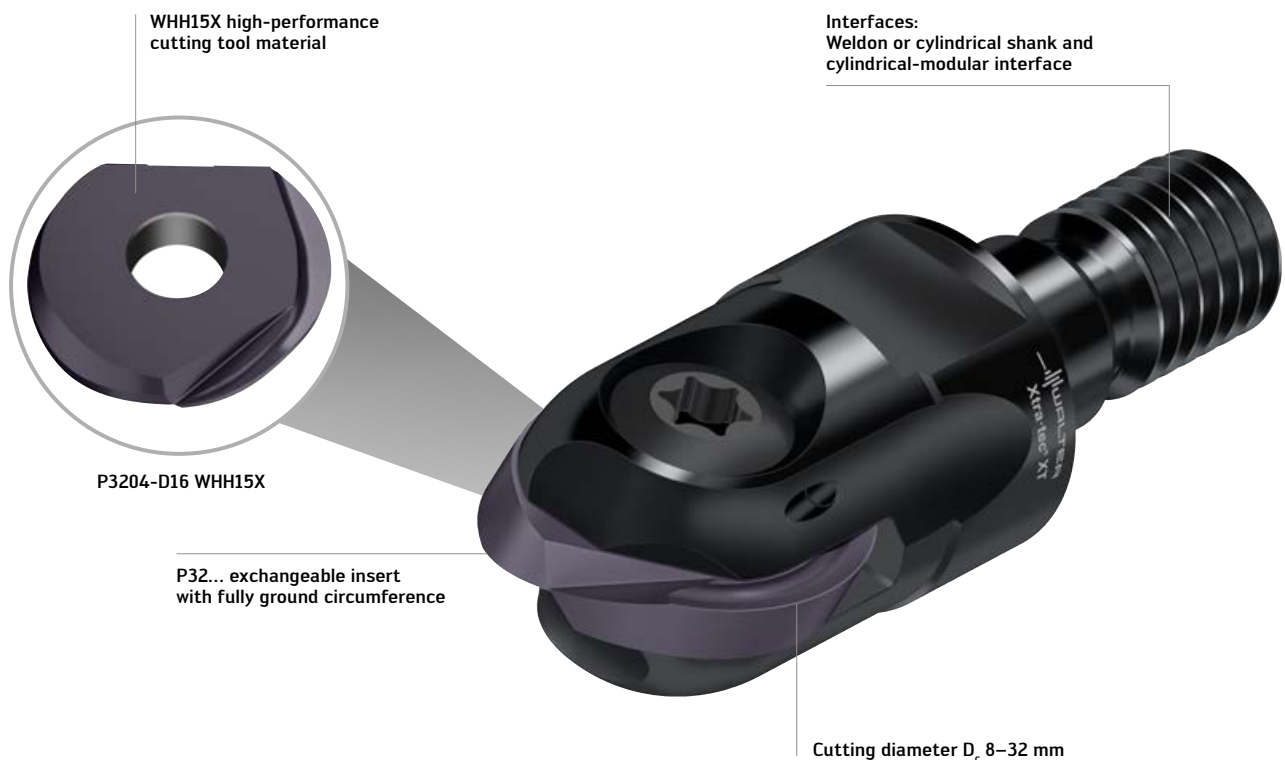
- Xtra-tec® XT M5460 copy finishing cutter
- Compressed air supply or minimum quantity lubrication through an internal coolant channel
- Dia. 8–32 mm (3/8–1")
- Interfaces: Cylindrical-modular, ScrewFit, Weldon and cylindrical shank made of steel and solid carbide cylindrical shank

THE INDEXABLE INSERT

- Double-edged, precision-ground exchangeable inserts with positive basic shape
- WHH15X high-performance cutting tool material with ultra-wear-resistant carbide substrate
- AlTiN coating (optimised for hard machining)

Geometries:

- P3201 (e.g. for semi-finishing and hard milling); P3204 (e.g. for fine finishing and finish machining)
- Correction in the thinner web area for maximum workpiece accuracy
- Precise cutting edge geometry for the best surface quality



Xtra-tec® XT M5460 copy finishing cutter with milling grade WHH15X

THE APPLICATION

- High-precision copying and finishing of freeform surfaces and deep cavities
- For steel, stainless steels, cast iron and materials with difficult cutting properties
- Specialist for hard machining of steels up to 63 HRC
- Areas of application: Mould and die making, aerospace and energy industries

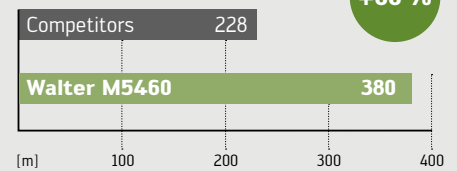
APPLICATION EXAMPLE

Copy forming

Material:	X155CrMo12-1 (1.2379) ISO H (60 HRC)
Tool:	M5460 / z2 / Ø 16 mm
Indexable insert:	P3204-D16 WHH15X

	Competitors	Walter Xtra-tec® XT M5460
v_c (m/min)	120	120
f_z (mm)	0,1	0,1
a_e (mm)	0,5	0,5
a_p (mm)	0,5	0,5
Cooling	Dry	Dry

Milling travel comparison



Xtra-tec® XT M5460 copy finishing cutter
with cylindrical-modular interface

Fig.: M5460-016-TC08-02-08

BENEFITS FOR YOU

- Universal application due to various different shank designs and extensive range of cutting tool materials
- High level of cost-efficiency due to higher cutting speeds and less manual rework
- Maximum precision and tool edge life due to extreme cutting edge stability and wear resistance (especially with hardness > 58 HRC)
- Maximum process reliability and best surfaces due to optimised chip removal

Shoulder milling cutters

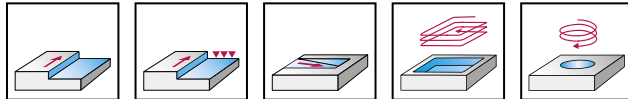
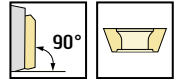
M5130 mm

AC .. 0602 .. R

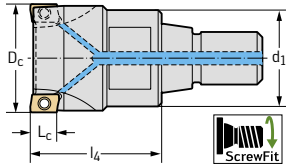
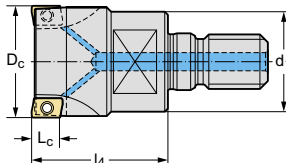
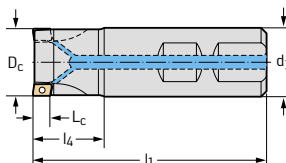
Xtra-tec® XT



– 2 cutting edges per indexable insert



	P	M	K	N	S	H	O
M5130	●	●	●	●	●	●	●

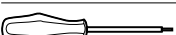
Tool	Designation	D _c mm	d ₁ mm	l ₄ mm	l ₁ mm	L _c mm	Z	kg	No. of indexable inserts	Type
 ScrewFit	M5130-010-T09-02-05	10	T09	20		5	2	0,02	2	AC .. 0602 .. R
	M5130-012-T09-03-05	12	T09	20		5	3	0,02	3	
	M5130-016-T14-03-05	16	T14	25		5	3	0,04	3	
	M5130-016-T14-04-05	16	T14	25		5	4	0,03	4	
	M5130-020-T18-04-05	20	T18	25		5	4	0,05	4	
	M5130-020-T18-05-05	20	T18	25		5	5	0,05	5	
	M5130-025-T22-05-05	25	T22	30		5	5	0,1	5	
	M5130-025-T22-07-05	25	T22	30		5	7	0,1	7	
	M5130-032-T28-06-05	32	T28	35		5	6	0,19	6	
	M5130-032-T28-08-05	32	T28	35		5	8	0,2	8	
	M5130-040-T36-07-05	40	T36	35		5	7	0,34	7	
 Cylindrical modular	M5130-010-TC06-02-05	10	M6	20		5	2	0,01	2	AC .. 0602 .. R
	M5130-012-TC06-03-05	12	M6	20		5	3	0,01	3	
	M5130-016-TC08-03-05	16	M8	25		5	3	0,03	3	
	M5130-016-TC08-04-05	16	M8	25		5	4	0,03	4	
	M5130-020-TC10-04-05	20	M10	25		5	4	0,05	4	
	M5130-020-TC10-05-05	20	M10	25		5	5	0,05	5	
	M5130-025-TC12-05-05	25	M12	30		5	5	0,1	5	
	M5130-025-TC12-07-05	25	M12	30		5	7	0,1	7	
	M5130-032-TC16-06-05	32	M16	35		5	6	0,19	6	
	M5130-032-TC16-08-05	32	M16	35		5	8	0,2	8	
	M5130-040-TC16-07-05	40	M16	35		5	7	0,24	7	
 DIN 1835 B	M5130-010-W10-02-05	10	10	16	60	5	2	0,03	2	AC .. 0602 .. R
	M5130-010-W16-02-05	10	16	30	80	5	2	0,09	2	
	M5130-012-W12-03-05	12	12	19	65	5	3	0,05	3	
	M5130-012-W16-03-05	12	16	30	80	5	3	0,09	3	
	M5130-016-W16-03-05	16	16	21	70	5	3	0,09	3	
	M5130-016-W16-04-05	16	16	21	70	5	4	0,11	4	
	M5130-020-W20-04-05	20	20	24	75	5	4	0,16	4	
	M5130-020-W20-05-05	20	20	24	75	5	5	0,16	5	
	M5130-025-W25-05-05	25	25	26	85	5	5	0,29	5	
	M5130-025-W25-07-05	25	25	26	85	5	7	0,29	7	

Bodies and assembly parts are included in the scope of delivery

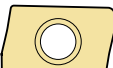
Assembly parts

	D _c [mm]	10-63
	Clamping screw for indexable insert Tightening torque	FS2560 (T6IP) 0,5 Nm

Accessories

	D _c [mm]	10-63
	Torque screwdriver, analogue	FS2001
	Interchangeable blade	SD2001-6IP (T6IP)
	Screwdriver	SD1001-6IP (T6IP)

Indexable inserts

	Designation	Tolerance class	Number of cutting edges	r mm	b mm	P				M				K					N		S		
						HC				HC				HC					HC HW		HC		
						WKP25S	WKP35G	WKP35S	WSP45G	WSM35G	WSM35S	WSP45G	WAK15	WKK25G	WKK25S	WKP25S	WKP35G	WKP35S	WXN15	WK10	WSM35G	WSM35S	WSP45G
	ACGT060204R-G65	G	2	0,4	0,9	⊕	⊕	⊕	⊕	⊕	⊕	⊕				⊕	⊕	⊕	⊕	⊕	⊕		
	ACGT060204R-M85	G	2	0,4	0,9											⊕	⊕						
	ACMT060202R-G55	M	2	0,2	1		⊕	⊕	⊕			⊕				⊕	⊕	⊕	⊕		⊕		
	ACMT060204R-G55	M	2	0,4	0,9	⊕	⊕	⊕	⊕	⊕	⊕	⊕	⊕	⊕	⊕	⊕	⊕	⊕	⊕		⊕		
	ACMT060208R-G55	M	2	0,8	0,8		⊕	⊕	⊕			⊕				⊕	⊕	⊕	⊕		⊕		
	ACMT060212R-G55	M	2	1,2	0,6		⊕	⊕	⊕			⊕				⊕	⊕	⊕	⊕		⊕		
	ACMT060216R-G55	M	2	1,6	0,1		⊕	⊕	⊕			⊕				⊕	⊕	⊕	⊕		⊕		
	ACMT060204R-K55	M	2	0,4	0,9		⊕	⊕	⊕	⊕	⊕	⊕				⊕	⊕	⊕	⊕	⊕	⊕		

HC = Coated carbide
HW = Uncoated carbide

Shoulder milling cutters

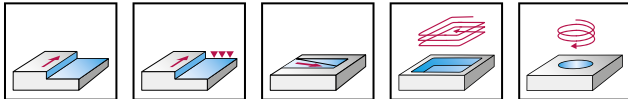
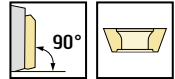
M5130

AC .. 0602 .. R

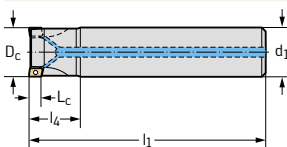
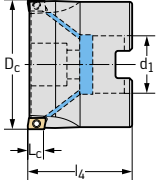
Xtra-tec® XT



– 2 cutting edges per indexable insert



	P	M	K	N	S	H	O
M5130	●	●	●	●	●	●	●

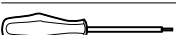
Tool	Designation	D _c mm	d ₁ mm	l ₄ mm	l ₁ mm	L _c mm	Z	kg	No. of indexable inserts	Type
 Cylindrical shank	M5130-010-A10-02-05	10	10	16	60	5	2	0,04	2	AC .. 0602 .. R
	M5130-010-A16-02-05	10	16	30	80	5	2	0,1	2	
	M5130-012-A12-03-05	12	12	19	70	5	3	0,05	3	
	M5130-012-A16-03-05	12	16	30	80	5	3	0,09	3	
	M5130-014-A16-03-05	14	16	30	80	5	3	0,06	3	
	M5130-016-A16-03-05	16	16	21	90	5	3	0,12	3	
	M5130-016-A16-04-05	16	16	21	90	5	4	0,13	4	
	M5130-018-A16-03-05	18	16	21	90	5	3	0,13	3	
	M5130-020-A20-04-05	20	20	24	110	5	4	0,24	4	
	M5130-020-A20-05-05	20	20	24	110	5	5	0,24	5	
	M5130-022-A20-04-05	22	20	24	110	5	4	0,25	4	
	M5130-025-A25-05-05	25	25	26	120	5	5	0,42	5	
	M5130-025-A25-07-05	25	25	26	120	5	7	0,42	7	
 Shell mill mount DIN 138 transverse keyway	M5130-032-B16-06-05	32	16	40		5	6	0,14	6	AC .. 0602 .. R
	M5130-032-B16-08-05	32	16	40		5	8	0,14	8	
	M5130-040-B16-07-05	40	16	40		5	7	0,27	7	
	M5130-040-B16-10-05	40	16	40		5	10	0,27	10	
	M5130-050-B22-09-05	50	22	40		5	9	0,42	9	
	M5130-050-B22-12-05	50	22	40		5	12	0,42	12	
	M5130-063-B22-11-05	63	22	40		5	11	0,54	11	
	M5130-063-B22-14-05	63	22	40		5	14	0,54	14	

Bodies and assembly parts are included in the scope of delivery

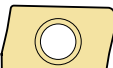
Assembly parts

	D _c [mm]	10-63
	Clamping screw for indexable insert Tightening torque	FS2560 (T6IP) 0,5 Nm

Accessories

	D _c [mm]	10-63
	Torque screwdriver, analogue	FS2001
	Interchangeable blade	SD2001-6IP (T6IP)
	Screwdriver	SD1001-6IP (T6IP)

Indexable inserts

	Designation	Tolerance class	Number of cutting edges	r mm	b mm	P				M				K					N		S		
						HC				HC				HC					HC	HW	HC		
						WKP25S	WKP35G	WKP35S	WSP45G	WSM35G	WSM35S	WSP45G	WAK15	WKK25G	WKK25S	WKP25S	WKP35G	WKP35S	WXN15	WK10	WSM35G	WSM35S	WSP45G
	ACGT060204R-G65	G	2	0,4	0,9	☺	☺	☺	☺	☺	☺	☺				☺	☺	☺	☺	☺	☺	☺	☺
	ACGT060204R-M85	G	2	0,4	0,9															☺	☺		☺
	ACMT060202R-G55	M	2	0,2	1		☺	☺	☺	☺			☺				☺	☺	☺				☺
	ACMT060204R-G55	M	2	0,4	0,9	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺	☺		☺	☺	☺
	ACMT060208R-G55	M	2	0,8	0,8		☺	☺	☺			☺				☺	☺	☺	☺				☺
	ACMT060212R-G55	M	2	1,2	0,6		☺	☺	☺			☺				☺	☺	☺	☺				☺
	ACMT060216R-G55	M	2	1,6	0,1		☺	☺	☺			☺				☺	☺	☺	☺				☺
	ACMT060204R-K55	M	2	0,4	0,9		☺	☺	☺	☺	☺	☺				☺	☺	☺	☺		☺	☺	☺

HC = Coated carbide
HW = Uncoated carbide

Shoulder milling cutters

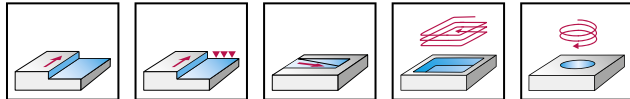
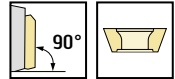
M5130 inch

AC .. 0602 .. R

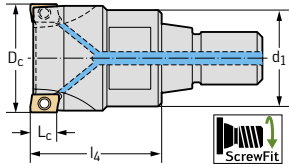
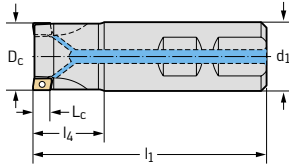
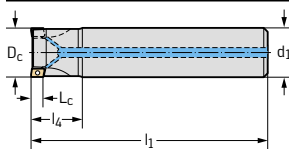
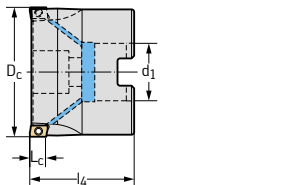
Xtra-tec® XT



– 2 cutting edges per indexable insert

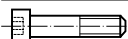


	P	M	K	N	S	H	O
M5130	●	●	●	●	●	●	●

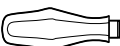
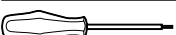
Tool	Designation	D _c inch	d ₁ inch	l ₄ inch	l ₁ inch	L _c inch	Z	lbs	No. of indexable inserts	Type
 ScrewFit	M5130.013-T09-03-05	0,500	T09	0,787		0,197	3	0,044	3	AC .. 0602 .. R
	M5130.015-T14-03-05	0,625	T14	0,984		0,197	3	0,071	3	
	M5130.015-T14-04-05	0,625	T14	0,984		0,197	4	0,099	4	
	M5130.019-T18-04-05	0,750	T18	0,984		0,197	4	0,11	4	
	M5130.019-T18-05-05	0,750	T18	0,984		0,197	5	0,132	5	
	M5130.026-T22-05-05	1,000	T22	1,181		0,197	5	0,212	5	
	M5130.026-T22-07-05	1,000	T22	1,181		0,197	7	0,243	7	
	M5130.031-T28-06-05	1,250	T28	1,378		0,197	6	0,421	6	
	M5130.031-T28-08-05	1,250	T28	1,378		0,197	8	0,443	8	
	M5130.038-T36-07-05	1,500	T36	1,378		0,197	7	0,765	7	
 DIN 1835 B	M5130.038-T36-10-05	1,500	T36	1,378		0,197	10	0,789	10	
	M5130.013-W13-03-05	0,500	0,500	0,700	2,281	0,197	3	0,108	3	AC .. 0602 .. R
	M5130.015-W15-03-05	0,625	0,625	0,750	2,656	0,197	3	0,225	3	
	M5130.015-W15-04-05	0,625	0,625	0,750	2,656	0,197	4	0,198	4	
	M5130.019-W19-04-05	0,750	0,750	0,945	2,781	0,197	4	0,300	4	
	M5130.019-W19-05-05	0,750	0,750	0,945	2,781	0,197	5	0,302	5	
	M5130.026-W26-05-05	1,000	1,000	1,000	3,281	0,197	5	0,626	5	
 Cylindrical shank	M5130.026-W26-07-05	1,000	1,000	1,000	3,281	0,197	7	0,642	7	
	M5130.013-A13-03-05	0,500	0,500	0,750	2,531	0,197	3	0,119	3	AC .. 0602 .. R
	M5130.015-A15-03-05	0,625	0,625	0,750	3,566	0,197	3	0,315	3	
	M5130.015-A15-04-05	0,625	0,625	0,750	3,566	0,197	4	0,278	4	
	M5130.019-A19-04-05	0,750	0,750	1,000	4,250	0,197	4	0,461	4	
	M5130.019-A19-05-05	0,750	0,750	1,000	4,250	0,197	5	0,463	5	
	M5130.026-A26-05-05	1,000	1,000	1,000	4,750	0,197	5	0,963	5	
 Shell mill mount DIN 138 transverse keyway	M5130.026-A26-07-05	1,000	1,000	1,000	4,750	0,197	7	0,963	7	
	M5130.051-B19-09-05	2,000	0,750	1,575		0,197	9	0,891	9	AC .. 0602 .. R
	M5130.051-B19-12-05	2,000	0,750	1,575		0,197	12	0,911	12	
	M5130.064-B26-11-05	2,500	1,000	1,575		0,197	11	1,444	11	
	M5130.064-B26-14-05	2,500	1,000	1,575		0,197	14	1,457	14	

Bodies and assembly parts are included in the scope of delivery

Assembly parts

	D _c [inch]	0,5–1,5	2	2,5
	Clamping screw for indexable insert Tightening torque	FS2560 (T6IP) 0,369 lbs	FS2560 (T6IP) 0,369 lbs	FS2560 (T6IP) 0,369 lbs
	Clamping screw for arbour-mounted tools		FS1518	FS1519

Accessories

	D _c [inch]	0,5–2,5
	Torque screwdriver, analogue	FS2002
	Interchangeable blade	SD2001-6IP (T6IP)
	Screwdriver	SD1001-6IP (T6IP)

Indexable inserts

	Designation	Tolerance class	Number of cutting edges	r inch	b inch	P			M			K					N		S				
						HC			HC			HC					HC		HC		HC		
						WKP25S	WKP35G	WKP35S	WSP45G	WSM35G	WSM35S	WSP45G	WAK15	WKK25G	WKK25S	WKP25S	WKP35G	WKP35S	WXN15	WK10	WSM35G	WSM35S	WSP45G
	ACGT060204R-G65	G	2	0,016	0,035	☑	☑	☑	☑	☑	☑	☑				☑	☑	☑			☑	☑	☑
	ACGT060204R-M85	G	2	0,016	0,035														☑	☑			
	ACMT060202R-G55	M	2	0,008	0,039		☑	☑	☑	☑		☑					☑	☑					☑
	ACMT060204R-G55	M	2	0,016	0,035	☑	☑	☑	☑	☑	☑	☑	☑	☑	☑	☑	☑	☑			☑	☑	☑
	ACMT060208R-G55	M	2	0,031	0,031		☑	☑	☑		☑						☑	☑					☑
	ACMT060212R-G55	M	2	0,047	0,022		☑	☑	☑		☑						☑	☑					☑
	ACMT060216R-G55	M	2	0,063	0,002		☑	☑	☑		☑						☑	☑					☑
	ACMT060204R-K55	M	2	0,016	0,035		☑	☑	☑	☑	☑	☑				☑	☑	☑			☑	☑	☑

HC = Coated carbide
HW = Uncoated carbide

Shoulder milling cutters

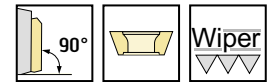
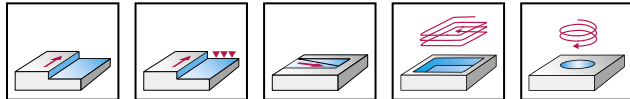
M5130 mm

BC .. 0903 .. R

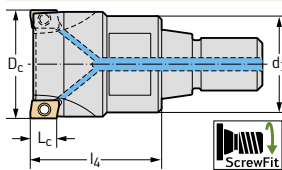
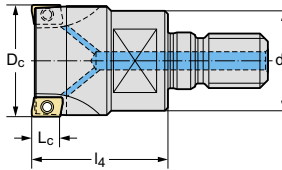
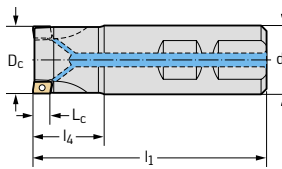
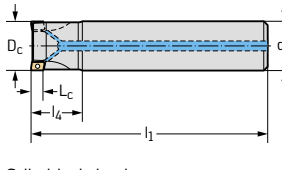
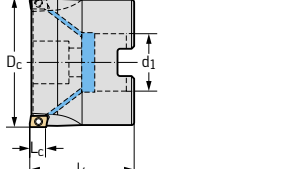
Xtra-tec® XT



– 2 cutting edges per indexable insert



	P	M	K	N	S	H	O
M5130	●	●	●	●	●	●	●

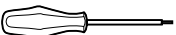
Tool	Designation	D _c mm	d ₁ mm	l ₄ mm	l ₁ mm	L _c mm	Z	kg	No. of indexable inserts	Type
 ScrewFit	M5130-016-T14-02-09	16	T14	25		9	2	0,03	2	BC .. 0903 .. R
	M5130-020-T18-02-09	20	T18	30		9	2	0,05	2	
	M5130-020-T18-03-09	20	T18	30		9	3	0,05	3	
	M5130-025-T22-03-09	25	T22	35		9	3	0,09	3	
	M5130-025-T22-04-09	25	T22	35		9	4	0,09	4	
	M5130-032-T28-04-09	32	T28	40		9	4	0,18	4	
	M5130-032-T28-05-09	32	T28	40		9	5	0,19	5	
 Cylindrical modular	M5130-016-TC08-02-09	16	M8	25		9	2	0,03	2	BC .. 0903 .. R
	M5130-020-TC10-02-09	20	M10	30		9	2	0,05	2	
	M5130-020-TC10-03-09	20	M10	30		9	3	0,05	3	
	M5130-025-TC12-03-09	25	M12	35		9	3	0,1	3	
	M5130-025-TC12-04-09	25	M12	35		9	4	0,09	4	
	M5130-032-TC16-04-09	32	M16	40		9	4	0,17	4	
	M5130-032-TC16-05-09	32	M16	40		9	5	0,18	5	
 DIN 1835 B	M5130-016-W16-02-09	16	16	41	90	9	2	0,12	2	BC .. 0903 .. R
	M5130-020-W20-02-09	20	20	39	90	9	3	0,18	3	
	M5130-020-W20-03-09	20	20	39	90	9	3	0,18	3	
	M5130-025-W25-04-09	25	25	43	100	9	4	0,31	4	
	M5130-032-W32-05-09	32	32	49	110	9	5	0,57	5	
 Cylindrical shank	M5130-016-A16-02-09	16	16	41	180	9	2	0,25	2	BC .. 0903 .. R
	M5130-018-A16-02-09	18	16	41	180	9	2	0,26	2	
	M5130-020-A20-02-09	20	20	39	200	9	2	0,44	2	
	M5130-020-A20-03-09	20	20	39	200	9	3	0,44	3	
	M5130-022-A20-03-09	22	20	39	200	9	3	0,44	3	
	M5130-025-A25-03-09	25	25	43	200	9	3	0,68	3	
	M5130-025-A25-04-09	25	25	43	200	9	4	0,68	4	
 Shell mill mount DIN 138 transverse keyway	M5130-032-B16-03-09	32	16	40		9	3	0,12	3	BC .. 0903 .. R
	M5130-032-B16-06-09	32	16	40		9	6	0,12	6	
	M5130-040-B16-04-09	40	16	40		9	4	0,19	4	
	M5130-040-B16-06-09	40	16	40		9	6	0,21	6	
	M5130-040-B16-07-09	40	16	40		9	7	0,21	7	
	M5130-050-B22-05-09	50	22	40		9	5	0,32	5	
	M5130-050-B22-07-09	50	22	40		9	7	0,49	7	

Bodies and assembly parts are included in the scope of delivery

Assembly parts

	D _c [mm]	16-63
	Clamping screw for indexable insert Tightening torque	FS2576 (T8IP) 1,2 Nm

Accessories

	D _c [mm]	16-63
	Torque screwdriver, analogue	FS2001
	Torque screwdriver, digital	FS2248
	Interchangeable blade	FS2012 (T8IP)
	Screwdriver	FS1483 (T8IP)

Indexable inserts

	Designation	Tolerance class	Number of cutting edges	P					M					K					N			S				H			
				HC					HC					HC					DP	HC	HW	HC							
				WHH15X	WKP25S	WKP35G	WKP35S	WSP45G	WXM15	WSM35G	WSM35S	WSM45X	WSP45G	WXM15	WAK15	WHH15X	WKK25G	WKK25S				WKP25S	WKP35G	WKP35S	WXM15		WDN20	WXN15	WK10
	BCGT090304R-B85	G	1																										
	BCGT090304R-G55	G	2		☺	☺	☺	☺		☺	☺		☺					☺	☺						☺	☺		☺	
	BCGT090304R-K85	G	2																										
	BCMT090302R-G55	M	2			☺	☺	☺	☺				☺															☺	
	BCMT090304R-G55	M	2		☺	☺	☺	☺	☺		☺	☺	☺	☺		☺			☺	☺	☺	☺			☺	☺	☺	☺	
	BCMT090308R-G55	M	2			☺	☺	☺	☺				☺	☺					☺	☺	☺	☺				☺	☺	☺	
	BCMT090312R-G55	M	2			☺	☺	☺	☺				☺	☺					☺	☺	☺	☺				☺	☺	☺	
	BCMT090316R-G55	M	2			☺	☺	☺	☺				☺	☺					☺	☺	☺	☺				☺	☺	☺	
	BCMT090320R-G55	M	2			☺	☺	☺	☺				☺	☺					☺	☺	☺	☺				☺	☺	☺	
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BCMT090304R-K55	M	2			☺	☺	☺	☺		☺	☺		☺					☺	☺	☺	☺			☺	☺	☺	☺		
	BCGX0903PDR-G55	G	2	☺					☺					☺	☺	☺						☺							☺

If the corner radius (r) is greater than 1.6 mm, the corner area of the body must be reworked

R (body) = r (indexable insert) - 1 mm

BCGX0903PDR-G55 wiper insert only in combination with BCGT090304R-G55

HC = Coated carbide

DP = Polycrystalline diamond

HW = Uncoated carbide

Shoulder milling cutters

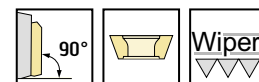
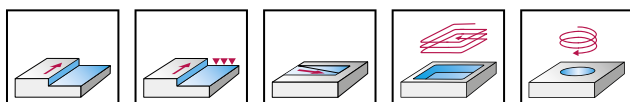
M5130 mm

BC .. 0903 .. R

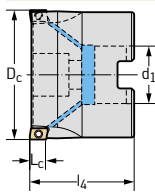
Xtra-tec® XT



– 2 cutting edges per indexable insert



	P	M	K	N	S	H	O
M5130	●	●	●	●	●	●	●

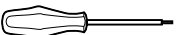
Tool	Designation	D _c mm	d ₁ mm	l ₄ mm	l ₁ mm	L _c mm	Z	kg	No. of indexable inserts	Type
 Shell mill mount DIN 138 transverse keyway	M5130-050-B22-08-09	50	22	40		9	8	0,34	8	BC .. 0903 .. R
	M5130-063-B22-07-09	63	22	40		9	7	0,5	7	
	M5130-063-B22-11-09	63	22	40		9	11	0,51	11	

Bodies and assembly parts are included in the scope of delivery

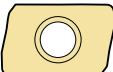
Assembly parts

	D _c [mm]	16-63
	Clamping screw for indexable insert Tightening torque	FS2576 (T8IP) 1,2 Nm

Accessories

	D _c [mm]	16-63
	Torque screwdriver, analogue	FS2001
	Torque screwdriver, digital	FS2248
	Interchangeable blade	FS2012 (T8IP)
	Screwdriver	FS1483 (T8IP)

Indexable inserts

	Designation	Tolerance class	Number of cutting edges	P					M					K					N			S			H			
				HC					HC					HC					DP	HC	HW	HC			H			
				WHH15X	WKP25S	WKP35G	WKP35S	WSP45G	WXM15	WSM35G	WSM35S	WSM45X	WSP45G	WXM15	WAK15	WHH15X	WKK25G	WKK25S	WKP25S	WKP35G	WKP35S	WXM15	WDN20	WXN15	WK10	WSM35G	WSM35S	WSM45X
	BCGT090304R-B85	G	1																									
	BCGT090304R-G55	G	2		☺	☹	☹	☹		☹	☹		☹				☹	☹	☹		☹				☹	☹	☹	
	BCGT090304R-K85	G	2																									
	BCMT090302R-G55	M	2			☹	☹	☹					☹					☹	☹								☹	
	BCMT090304R-G55	M	2		☺	☹	☹	☹		☹	☹	☹	☹		☹			☹	☹					☹	☹	☹	☹	
	BCMT090308R-G55	M	2			☹	☹	☹	☹				☹	☹				☹	☹					☹	☹	☹	☹	
	BCMT090312R-G55	M	2			☹	☹	☹	☹				☹	☹				☹	☹						☹	☹	☹	
	BCMT090316R-G55	M	2			☹	☹	☹	☹				☹	☹				☹	☹						☹	☹	☹	
	BCMT090320R-G55	M	2			☹	☹	☹	☹				☹	☹				☹	☹						☹	☹	☹	
	BCMT090304R-F55	M	2		☺	☹	☹						☹			☹	☹	☹	☹						☹	☹		
BCMT090304R-K55	M	2			☺	☹	☹	☹		☺	☹		☹				☹	☹					☺	☹		☹		
	BCGX0903PDR-G55	G	2	☺					☺				☺	☺	☺					☺								☺

If the corner radius (r) is greater than 1.6 mm, the corner area of the body must be reworked

R (body) = r (indexable insert) - 1 mm

BCGX0903PDR-G55 wiper insert only in combination with BCGT090304R-G55

HC = Coated carbide

DP = Polycrystalline diamond

HW = Uncoated carbide

Shoulder milling cutters

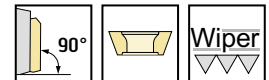
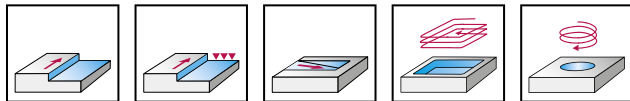
M5130 inch

BC .. 0903 .. R

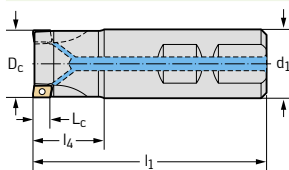
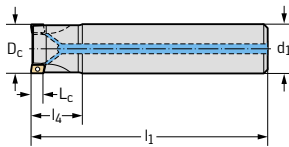
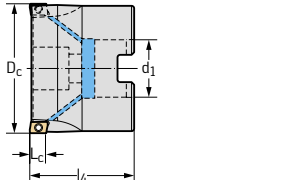
Xtra-tec® XT



– 2 cutting edges per indexable insert

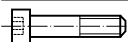


	P	M	K	N	S	H	O
M5130	●	●	●	●	●	●	●

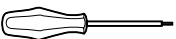
Tool	Designation	D _c inch	d ₁ inch	l ₄ inch	l ₁ inch	L _c inch	Z	lbs	No. of indexable inserts	Type
 DIN 1835 B	M5130.015-W15-02-09	0,625	0,625	0,945	2,851	0,354	2	0,198	2	BC .. 0903 .. R
	M5130.019-W19-03-09	0,750	0,750	1,535	3,567	0,354	3	0,351	3	
	M5130.026-W26-03-09	1,000	1,000	1,181	3,462	0,354	3	0,624	3	
	M5130.026-W26-04-09	1,000	1,000	1,181	3,462	0,354	4	0,626	4	
 Cylindrical shank	M5130.015-A15-02-09	0,625	0,625	1,630	7,000	0,354	2	0,54	2	BC .. 0903 .. R
	M5130.019-A19-02-09	0,750	0,750	1,630	8,000	0,354	2	0,866	2	
	M5130.019-A19-03-09	0,750	0,750	1,630	8,000	0,354	3	0,869	3	
	M5130.026-A26-03-09	1,000	1,000	1,750	8,000	0,354	3	1,583	3	
 Shell mill mount DIN 138 transverse keyway	M5130.051-B19-05-09	2,000	0,750	1,575		0,354	5	0,756	5	BC .. 0903 .. R
	M5130.051-B19-08-09	2,000	0,750	1,575		0,354	8	0,809	8	

Bodies and assembly parts are included in the scope of delivery

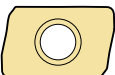
Assembly parts

	D _c [inch]	0,625–1	2
	Clamping screw for indexable insert Tightening torque	FS2576 (T8IP) 0,885 lbs	FS2576 (T8IP) 0,885 lbs
	Clamping screw for arbour-mounted tools		FS1523

Accessories

	D _c [inch]	0,625–2
	Torque screwdriver, analogue	FS2002
	Torque screwdriver, digital	FS2248
	Interchangeable blade	FS2012 (T8IP)
	Screwdriver	FS1483 (T8IP)

Indexable inserts

	Designation	Tolerance class	Number of cutting edges	P						M					K						N			S			H	
				HC						HC					HC						DP	HC	HW	HC			HC	
				WHH15X	WKP25S	WKP35G	WKP35S	WSP45G	WXM15	WSM35G	WSM35S	WSM45X	WSP45G	WXM15	WAK15	WHH15X	WKK25G	WKK25S	WKP25S	WKP35G	WKP35S	WXM15	WDN20	WXN15	WK10	WSM35G	WSM35S	WSM45X
	BCGT090304R-B85	G	1																									
	BCGT090304R-G55	G	2		⊕	⊕	⊕	⊕		⊕	⊕		⊕				⊕	⊕	⊕					⊕	⊕		⊕	
	BCGT090304R-K85	G	2																									
	BCMT090302R-G55	M	2			⊕	⊕	⊕	⊕									⊕	⊕	⊕					⊕	⊕		⊕
	BCMT090304R-G55	M	2		⊕	⊕	⊕	⊕	⊕		⊕	⊕	⊕	⊕										⊕	⊕		⊕	
	BCMT090308R-G55	M	2			⊕	⊕	⊕	⊕				⊕	⊕	⊕									⊕	⊕	⊕	⊕	
	BCMT090312R-G55	M	2			⊕	⊕	⊕	⊕				⊕	⊕	⊕										⊕	⊕		
	BCMT090316R-G55	M	2			⊕	⊕	⊕	⊕				⊕	⊕	⊕										⊕	⊕		
	BCMT090320R-G55	M	2			⊕	⊕	⊕	⊕				⊕	⊕	⊕										⊕	⊕		
	BCMT090304R-F55	M	2		⊕	⊕	⊕						⊕			⊕	⊕	⊕	⊕						⊕	⊕		
	BCMT090304R-K55	M	2		⊕	⊕	⊕					⊕					⊕	⊕	⊕					⊕	⊕		⊕	
	BCGX0903PDR-G55	G	2	⊕					⊕				⊕	⊕	⊕					⊕								⊕

If the corner radius r is greater than 1.6 mm, the corner area of the body must be reworked.
 If the corner radius (r) is greater than 1.6 mm, the corner area of the body must be reworked
 $R(\text{body}) = r(\text{indexable insert}) - 1 \text{ mm}$
 BCGX0903PDR-G55 wiper insert only in combination with BCGT090304R-G55

HC = Coated carbide
 DP = Polycrystalline diamond
 HW = Uncoated carbide

Shoulder milling cutters

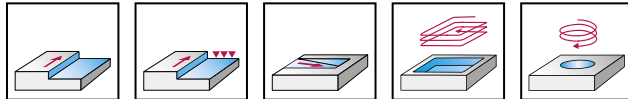
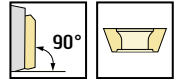
M5130 mm

BC .. 1204 .. R

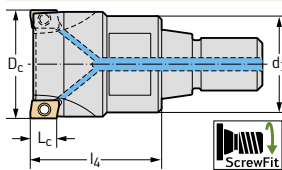
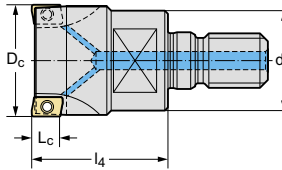
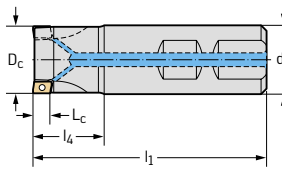
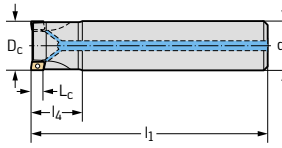
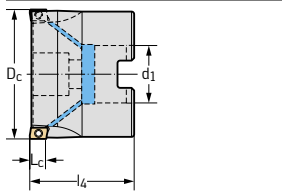
Xtra-tec® XT



– 2 cutting edges per indexable insert



	P	M	K	N	S	H	O
M5130	●	●	●	●	●	●	●

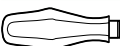
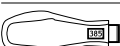
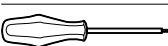
Tool	Designation	D _c mm	d ₁ mm	l ₄ mm	l ₁ mm	L _c mm	Z	kg	No. of indexable inserts	Type
 ScrewFit	M5130-025-T22-03-12	25	T22	35		12	3	0,09	3	BC .. 1204 .. R
	M5130-032-T28-03-12	32	T28	40		12	3	0,17	3	
	M5130-032-T28-04-12	32	T28	40		12	4	0,18	4	
	M5130-040-T36-03-12	40	T36	40		12	3	0,31	3	
	M5130-040-T36-05-12	40	T36	40		12	5	0,32	5	
	M5130-040-T36-06-12	40	T36	40		12	6	0,32	6	
 Cylindrical modular	M5130-025-TC12-03-12	25	M12	35		12	3	0,08	3	BC .. 1204 .. R
	M5130-032-TC16-03-12	32	M16	40		12	3	0,16	3	
	M5130-032-TC16-04-12	32	M16	40		12	4	0,17	4	
	M5130-040-TC16-03-12	40	M16	40		12	3	0,21	3	
	M5130-040-TC16-06-12	40	M16	40		12	6	0,22	6	
 DIN 1835 B	M5130-025-W25-03-12	25	25	43	100	12	3	0,3	3	BC .. 1204 .. R
	M5130-032-W32-03-12	32	32	49	110	12	3	0,53	3	
	M5130-032-W32-04-12	32	32	49	110	12	4	0,54	4	
	M5130-040-W32-05-12	40	32	49	110	12	5	0,68	5	
	M5130-040-W32-06-12	40	32	49	110	12	6	0,65	6	
 Cylindrical shank	M5130-022-A20-02-12	22	20	38	200	12	2	0,45	2	BC .. 1204 .. R
	M5130-025-A25-02-12	25	25	38	200	12	2	0,71	2	
	M5130-025-A25-03-12	25	25	38	200	12	3	0,68	3	
	M5130-032-A32-03-12	32	32	39	250	12	3	1,4	3	
	M5130-032-A32-04-12	32	32	39	250	12	4	1,42	4	
	M5130-040-A32-05-12	40	32	44	250	12	5	1,51	5	
	M5130-040-A40-04-12	40	40	44	250	12	4	2,25	4	
 Shell mill mount DIN 138 transverse keyway	M5130-040-B16-03-12	40	16	40		12	3	0,17	3	BC .. 1204 .. R
	M5130-040-B16-04-12	40	16	40		12	4	0,18	4	
	M5130-040-B16-05-12	40	16	40		12	5	0,19	5	
	M5130-040-B16-06-12	40	16	40		12	6	0,19	6	
	M5130-050-B22-03-12	50	22	40		12	3	0,32	3	
	M5130-050-B22-04-12	50	22	40		12	4	0,29	4	
	M5130-050-B22-06-12	50	22	40		12	6	0,46	6	

Bodies and assembly parts are included in the scope of delivery

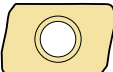
Assembly parts

	D _c [mm]	22–80
	Clamping screw for indexable insert Tightening torque	FS2573 (T9IP) 2 Nm

Accessories

	D _c [mm]	22–80
	Torque screwdriver, analogue	FS2003
	Torque screwdriver, digital	FS2248
	Interchangeable blade	FS2013 (T9IP)
	Screwdriver	FS1484 (T9IP)

Indexable inserts

	Designation	Tolerance class	Number of cutting edges	P				M				K				N			S				
				HC				HC				HC				DP	HC	HW	HC				
				WKP25S	WKP35G	WKP35S	WSP45G	WSM35G	WSM35S	WSM45X	WSP45G	WAK15	WKK25G	WKK25S	WKP25S	WKP35G	WKP35S	WDN20	WXN15	WK10	WSM35G	WSM35S	WSM45X
	BCGT120408R-B85	G	1																				
	BCGT120408R-G55	G	2	⊕	⊕	⊕	⊗	⊕	⊕		⊗	⊕		⊕	⊕	⊕				⊕	⊕		⊗
	BCHT120404R-K85	H	2															⊕	⊕				
	BCHT120408R-K85	H	2															⊕	⊕				
	BCHT120412R-K85	H	2															⊕	⊕				
	BCHT120416R-K85	H	2															⊕	⊕				
	BCHT120420R-K85	H	2															⊕	⊕				
	BCHT120425R-K85	H	2															⊕	⊕				
	BCHT120430R-K85	H	2															⊕	⊕				
	BCHT120440R-K85	H	2															⊕	⊕				
	BCMT120404R-G55	M	2		⊕	⊕	⊗					⊗				⊕	⊕						⊗
	BCMT120408R-G55	M	2	⊕	⊕	⊕	⊗	⊕	⊕	⊗	⊗	⊕	⊕	⊕	⊕	⊕				⊕	⊕	⊗	⊗
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	BCMT120420R-G55	M	2		⊕	⊕	⊗				⊗	⊗				⊕	⊕					⊗	⊗
	BCMT120425R-G55	M	2		⊕	⊕	⊗									⊕	⊕					⊗	⊗
	BCMT120430R-G55	M	2		⊕	⊕	⊗				⊗					⊕	⊕					⊗	⊗
	BCMT120432R-G55	M	2		⊕	⊕	⊗				⊗					⊕	⊕						⊗
	BCMT120440R-G55	M	2		⊕	⊕	⊗				⊗	⊗				⊕	⊕					⊗	⊗
	BCMT120408R-F55	M	2	⊕	⊕	⊕	⊗				⊗	⊕	⊕	⊕	⊕	⊕							⊗
	BCMT120408R-K55	M	2		⊕	⊕	⊕	⊕	⊕	⊕		⊕		⊕		⊕	⊕			⊕	⊕		

If the corner radius r is greater than 2.5 mm, the corner area of the body must be reworked.

$R(\text{body}) = r(\text{indexable insert}) - 1 \text{ mm}$

HC = Coated carbide
DP = Polycrystalline diamond
HW = Uncoated carbide

Shoulder milling cutters

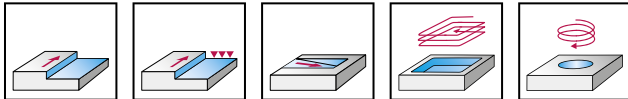
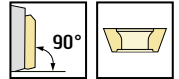
M5130 mm

BC .. 1204 .. R

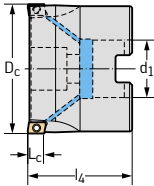
Xtra-tec® XT



– 2 cutting edges per indexable insert



	P	M	K	N	S	H	O
M5130	●	●	●	●	●	●	●

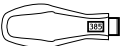
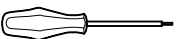
Tool	Designation	D _c mm	d ₁ mm	l ₄ mm	l ₁ mm	L _c mm	Z	kg	No. of indexable inserts	Type
 Shell mill mount DIN 138 transverse keyway	M5130-050-B22-07-12	50	22	40		12	7	0,31	7	BC .. 1204 .. R
	M5130-063-B22-04-12	63	22	40		12	4	0,45	4	
	M5130-063-B22-05-12	63	22	40		12	5	0,47	5	
	M5130-063-B22-07-12	63	22	40		12	7	0,72	7	
	M5130-063-B22-08-12	63	22	40		12	8	0,5	8	
	M5130-063-B27-04-12	63	27	50		12	4	0,66	4	
	M5130-063-B27-05-12	63	27	50		12	5	0,67	5	
	M5130-063-B27-07-12	63	27	50		12	7	0,94	7	
	M5130-063-B27-08-12	63	27	50		12	8	0,71	8	
	M5130-080-B27-05-12	80	27	50		12	5	0,91	5	
	M5130-080-B27-06-12	80	27	50		12	6	0,94	6	
	M5130-080-B27-08-12	80	27	50		12	8	1,02	8	
	M5130-080-B27-09-12	80	27	50		12	9	1	9	

Bodies and assembly parts are included in the scope of delivery

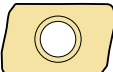
Assembly parts

	D _c [mm]	22–80
	Clamping screw for indexable insert Tightening torque	FS2573 (T9IP) 2 Nm

Accessories

	D _c [mm]	22–80
	Torque screwdriver, analogue	FS2003
	Torque screwdriver, digital	FS2248
	Interchangeable blade	FS2013 (T9IP)
	Screwdriver	FS1484 (T9IP)

Indexable inserts

Designation	Tolerance class	Number of cutting edges	P				M				K				N			S					
			HC				HC				HC				DP	HC	HW	HC					
			WKP25S	WKP35G	WKP35S	WSP45G	WSM35G	WSM35S	WSM45X	WSP45G	WAK15	WKK25G	WKK25S	WKP25S	WKP35G	WKP35S	WDN20	WXN15	WK10	WSM35G	WSM35S	WSM45X	WSP45G
	BCGT120408R-B85	G	1																				
	BCGT120408R-G55	G	2	⊕	⊕	⊕	⊗	⊕	⊕		⊗	⊕		⊕	⊕	⊕				⊕	⊕		⊗
	BCHT120404R-K85	H	2															⊕	⊕				
	BCHT120408R-K85	H	2															⊕	⊕				
	BCHT120412R-K85	H	2															⊕	⊕				
	BCHT120416R-K85	H	2															⊕	⊕				
	BCHT120420R-K85	H	2															⊕	⊕				
	BCHT120425R-K85	H	2															⊕	⊕				
	BCHT120430R-K85	H	2															⊕	⊕				
	BCHT120440R-K85	H	2															⊕	⊕				
	BCMT120404R-G55	M	2		⊕	⊕	⊗					⊗				⊕	⊕						⊗
	BCMT120408R-G55	M	2	⊕	⊕	⊕	⊗	⊕	⊕	⊗	⊗	⊕	⊕	⊕	⊕	⊕				⊕	⊕	⊗	⊗
	BCMT120412R-G55	M	2		⊕	⊕	⊗				⊗	⊗				⊕	⊕					⊗	⊗
	BCMT120416R-G55	M	2		⊕	⊕	⊗				⊗	⊗				⊕	⊕					⊗	⊗
	BCMT120420R-G55	M	2		⊕	⊕	⊗				⊗	⊗				⊕	⊕					⊗	⊗
	BCMT120425R-G55	M	2		⊕	⊕	⊗									⊕	⊕					⊗	⊗
	BCMT120430R-G55	M	2		⊕	⊕	⊗				⊗					⊕	⊕					⊗	⊗
	BCMT120432R-G55	M	2		⊕	⊕	⊗									⊕	⊕						⊗
	BCMT120440R-G55	M	2		⊕	⊕	⊗				⊗	⊗				⊕	⊕					⊗	⊗
	BCMT120408R-F55	M	2	⊕	⊕	⊕	⊗				⊗	⊕	⊕	⊕	⊕	⊕							⊗
BCMT120408R-K55	M	2		⊕	⊕	⊗	⊕	⊕		⊕	⊕	⊕			⊕	⊕			⊕	⊕			

If the corner radius r is greater than 2.5 mm, the corner area of the body must be reworked.

$R(\text{body}) = r(\text{indexable insert}) - 1 \text{ mm}$

HC = Coated carbide
DP = Polycrystalline diamond
HW = Uncoated carbide

Shoulder milling cutters

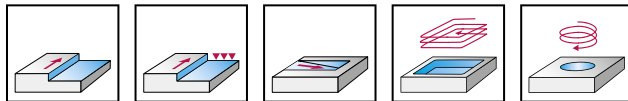
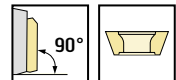
M5130 inch

BC .. 1204 .. R

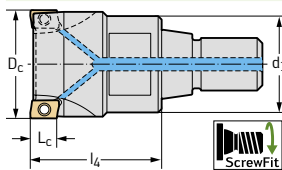
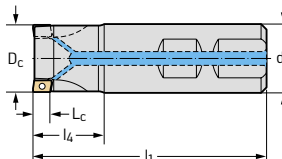
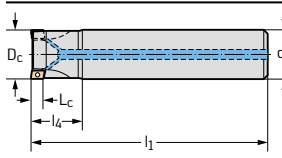
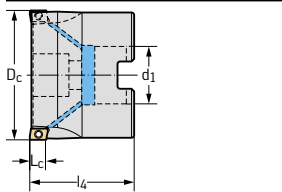
Xtra-tec® XT



– 2 cutting edges per indexable insert

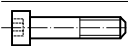


	P	M	K	N	S	H	O
M5130	●	●	●	●	●	●	●

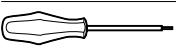
Tool	Designation	D _c inch	d ₁ inch	l ₄ inch	l ₁ inch	L _c inch	Z	lbs	No. of indexable inserts	Type
 ScrewFit	M5130.026-T22-03-12	1,000	T22	1,378		0,472	3	0,187	3	BC .. 1204 .. R
	M5130.031-T28-03-12	1,250	T28	1,575		0,472	3	0,351	3	
	M5130.031-T28-04-12	1,250	T28	1,575		0,472	4	0,375	4	
	M5130.038-T36-06-12	1,500	T36	1,575		0,472	6	0,710	6	
	M5130.051-T45-06-12	2,000	T45	1,575		0,472	6	1,074	6	
	M5130.051-T45-07-12	2,000	T45	1,575		0,472	7	1,076	7	
 DIN 1835 B	M5130.019-W19-02-12	0,750	0,750	1,024	3,059	0,472	2	0,291	2	BC .. 1204 .. R
	M5130.026-W26-03-12	1,000	1,000	1,339	3,280	0,472	3	0,558	3	
	M5130.031-W31-04-12	1,250	1,250	1,417	3,697	0,472	4	1,030	4	
 Cylindrical shank	M5130.019-A19-02-12	0,750	0,750	1,030	7,530	0,472	2	0,816	2	BC .. 1204 .. R
	M5130.026-A26-03-12	1,000	1,000	1,500	8,000	0,472	3	1,572	3	
	M5130.031-A31-04-12	1,250	1,250	1,630	10,000	0,472	4	3,142	4	
 Shell mill mount DIN 138 transverse keyway	M5130.038-B19-05-12	1,500	0,750	1,500		0,472	5	0,340	5	BC .. 1204 .. R
	M5130.038-B19-06-12	1,500	0,750	1,500		0,472	6	0,326	6	
	M5130.051-B19-04-12	2,000	0,750	1,575		0,472	4	0,644	4	
	M5130.051-B19-06-12	2,000	0,750	1,575		0,472	6	1,131	6	
	M5130.051-B19-07-12	2,000	0,750	1,575		0,472	7	0,758	7	
	M5130.064-B26-05-12	2,500	1,000	1,575		0,472	5	1,208	5	
	M5130.064-B26-08-12	2,500	1,000	1,575		0,472	8	1,202	8	
	M5130.076-B26-06-12	3,000	1,000	2,000		0,472	6	2,028	6	
	M5130.076-B26-08-12	3,000	1,000	2,000		0,472	8	2,205	8	
	M5130.076-B26-09-12	3,000	1,000	2,000		0,472	9	2,125	9	

Bodies and assembly parts are included in the scope of delivery

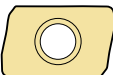
Assembly parts

	D _c [inch]	0,75–1,25	1,5	2	2,5	3
	Clamping screw for indexable insert Tightening torque	FS2573 (T9IP) 1,475 lbs	FS2573 (T9IP) 1,475 lbs	FS2573 (T9IP) 1,475 lbs	FS2573 (T9IP) 1,475 lbs	FS2573 (T9IP) 1,475 lbs
	Clamping screw for arbour-mounted tools		FS1523	FS1523	FS1519	FS1519

Accessories

	D _c [inch]	0,75–3
	Torque screwdriver, analogue	FS2004
	Torque screwdriver, digital	FS2248
	Interchangeable blade	FS2013 (T9IP)
	Screwdriver	FS1484 (T9IP)

Indexable inserts

	Designation	Tolerance class	Number of cutting edges	P				M				K					N			S		
				HC				HC				HC					DP	HC	HW	HC		
				WKP25S	WKP35G	WKP35S	WSP45G	WSM35G	WSM35S	WSM45X	WSP45G	WAK15	WK25G	WK25S	WKP25S	WKP35G	WKP35S	WDN20	WXN15	WK10	WSM35G	WSM35S
	BCGT120408R-B85	G	1																			
	BCGT120408R-G55	G	2	⊕	⊕	⊕	⊗	⊕	⊕		⊗	⊕		⊕	⊕	⊕				⊕	⊕	
	BCHT120404R-K85	H	2															⊕				
	BCHT120408R-K85	H	2															⊕				
	BCHT120412R-K85	H	2															⊕				
	BCHT120416R-K85	H	2															⊕	⊕			
	BCHT120420R-K85	H	2															⊕	⊕			
	BCHT120425R-K85	H	2															⊕	⊕			
	BCHT120430R-K85	H	2															⊕	⊕			
	BCHT120440R-K85	H	2															⊕	⊕			
	BCMT120404R-G55	M	2		⊕	⊕	⊗					⊗				⊕	⊕					⊗
	BCMT120408R-G55	M	2	⊕	⊕	⊕	⊗	⊕	⊕	⊗	⊗	⊕		⊕	⊕	⊕	⊕			⊕	⊕	⊗
	BCMT120412R-G55	M	2		⊕	⊕	⊗				⊗	⊗				⊕	⊕				⊗	⊗
	BCMT120416R-G55	M	2		⊕	⊕	⊗				⊗	⊗				⊕	⊕				⊗	⊗
	BCMT120420R-G55	M	2		⊕	⊕	⊗				⊗	⊗				⊕	⊕				⊗	⊗
	BCMT120425R-G55	M	2		⊕	⊕	⊗									⊕	⊕					⊗
	BCMT120430R-G55	M	2		⊕	⊕	⊗				⊗					⊕	⊕				⊗	⊗
	BCMT120432R-G55	M	2		⊕	⊕	⊗				⊗					⊕	⊕					⊗
	BCMT120440R-G55	M	2		⊕	⊕	⊗				⊗					⊕	⊕					⊗
	BCMT120408R-F55	M	2	⊕	⊕	⊕	⊗				⊗	⊕		⊕	⊕	⊕	⊕					⊗
	BCMT120408R-K55	M	2		⊕	⊕	⊗	⊕	⊕		⊗					⊕	⊕		⊕	⊕		⊗

If the corner radius r is greater than 2.5 mm, the corner area of the body must be reworked.
 $R(\text{body}) = r(\text{indexable insert}) - 1 \text{ mm}$

HC = Coated carbide
 DP = Polycrystalline diamond
 HW = Uncoated carbide

Shoulder milling cutters

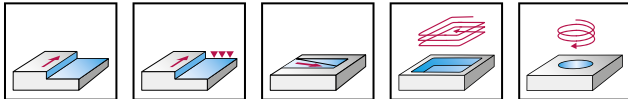
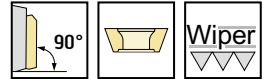
M5130 mm

BC .. 1605 .. R

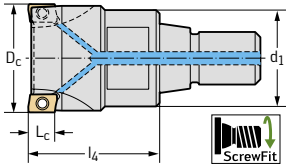
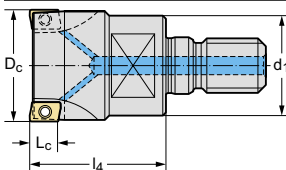
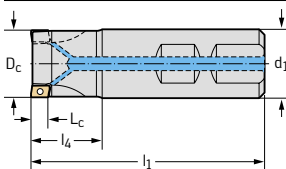
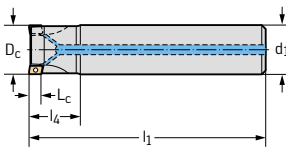
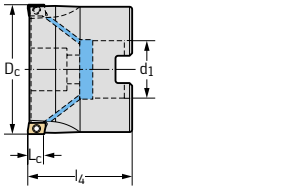
Xtra-tec® XT



– 2 cutting edges per indexable insert



	P	M	K	N	S	H	O
M5130	●	●	●	●	●	●	●

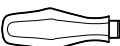
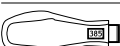
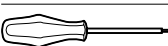
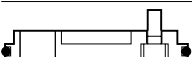
Tool	Designation	D _c mm	d ₁ mm	l ₄ mm	l ₁ mm	L _c mm	Z	kg	No. of indexable inserts	Type
 ScrewFit	M5130-032-T28-03-15	32	T28	40		15	3	0,16	3	BC .. 1605 .. R
	M5130-040-T36-03-15	40	T36	40		15	3	0,31	3	
	M5130-040-T36-04-15	40	T36	40		15	4	0,31	4	
	M5130-050-T45-03-15	50	T45	40		15	3	0,45	3	
	M5130-050-T45-05-15	50	T45	40		15	5	0,43	5	
	M5130-050-T45-06-15	50	T45	40		15	6	0,45	6	
 Cylindrical modular	M5130-032-TC16-03-15	32	M16	40		15	3	0,15	3	BC .. 1605 .. R
	M5130-040-TC16-03-15	40	M16	40		15	3	0,21	3	
	M5130-040-TC16-04-15	40	M16	40		15	4	0,2	4	
 DIN 1835 B	M5130-025-W25-02-15	25	25	43	100	15	2	0,3	2	BC .. 1605 .. R
	M5130-032-W32-03-15	32	32	49	110	15	3	0,57	3	
 Cylindrical shank	M5130-025-A25-02-15	25	25	38	200	15	2	0,68	2	BC .. 1605 .. R
	M5130-028-A25-02-15	28	25	38	200	15	2	0,7	2	
	M5130-032-A32-03-15	32	32	39	250	15	3	1,43	3	
	M5130-035-A32-03-15	35	32	39	250	15	3	1,46	3	
 Shell mill mount DIN 138 transverse keyway	M5130-040-B16-03-15	40	16	40		15	3	0,15	3	BC .. 1605 .. R
	M5130-040-B16-04-15	40	16	40		15	4	0,14	4	
	M5130-042-B16-03-15	42	16	40		15	3	0,17	3	
	M5130-050-B22-03-15	50	22	40		15	3	0,31	3	
	M5130-050-B22-05-15	50	22	40		15	5	0,41	5	
	M5130-050-B22-06-15	50	22	40		15	6	0,44	6	
	M5130-054-B22-03-15	54	22	40		15	3	0,34	3	
	M5130-063-B22-04-15	63	22	40		15	4	0,43	4	

Bodies and assembly parts are included in the scope of delivery

Assembly parts

	D _c [mm]	25	28–160
	Clamping screw for indexable insert Tightening torque	FS1461 (T15IP) 2.5 Nm	FS2300 (T15IP) 3.5 Nm

Accessories

	D _c [mm]	25–125	160
	Torque screwdriver, analogue	FS2003	FS2003
	Torque screwdriver, digital	FS2248	FS2248
	Interchangeable blade	FS2014 (T15IP)	FS2014 (T15IP)
	Screwdriver	FS1485 (T15IP)	FS1485 (T15IP)
	Sealing disc set (incl. gasket and screws)		FS936 COMPLETE SET
	Gasket		O-R 96X4

Indexable inserts

	Designation	Tolerance class	Number of cutting edges	r mm	b mm	P					M					K					N		S				H				
						HC					HC					HC					HC	HW	HC								
						WHH15X	WKP25S	WKP35G	WKP35S	WSP45G	WXM15	WSM35G	WSM35S	WSM45X	WSP45G	WXM15	WAK15	WHH15X	WKK25G	WKK25S			WKP25S	WKP35G	WKP35S	WXM15		WCN15	WK10	WSM35G	WSM35S
	BCGT160508R-G55	G	2	0,8	2	☞	☞	☞	☞		☞	☞				☞				☞	☞				☞	☞					
	BCHT160508R-K85	H	2	0,8	2																				☞	☞					
	BCHT160512R-K85	H	2	1,2	1,7																				☞	☞					
	BCHT160516R-K85	H	2	1,6	1,7																				☞	☞					
	BCHT160520R-K85	H	2	2	1,5																				☞	☞					
	BCHT160525R-K85	H	2	2,5	1,4																				☞	☞					
	BCHT160530R-K85	H	2	3	1,2																				☞	☞					
	BCHT160540R-K85	H	2	4	1,1																				☞	☞					
	BCMT160508R-F55	M	2	0,8	2		☞	☞	☞	☞				☞	☞		☞		☞	☞	☞	☞	☞						☞	☞	
	BCMT160508R-G55	M	2	0,8	2		☞	☞	☞	☞		☞	☞	☞	☞		☞		☞	☞	☞	☞	☞				☞	☞	☞	☞	☞
	BCMT160512R-G55	M	2	1,2	1,7			☞	☞	☞	☞			☞	☞							☞	☞						☞	☞	☞
	BCMT160516R-G55	M	2	1,6	1,5			☞	☞	☞	☞			☞	☞							☞	☞						☞	☞	☞
	BCMT160520R-G55	M	2	2	1,5			☞	☞	☞	☞			☞	☞							☞	☞						☞	☞	☞
	BCMT160525R-G55	M	2	2,5	1,4			☞	☞	☞	☞			☞	☞							☞	☞						☞	☞	☞
	BCMT160530R-G55	M	2	3	1,2			☞	☞	☞	☞			☞	☞							☞	☞						☞	☞	☞
	BCMT160532R-G55	M	2	3,2	1,1			☞	☞	☞	☞				☞	☞						☞	☞						☞	☞	☞
	BCMT160540R-G55	M	2	4	1,1			☞	☞	☞	☞			☞	☞							☞	☞						☞	☞	☞
	BCMT160550R-G55	M	2	5	0,7			☞	☞	☞	☞				☞	☞						☞	☞						☞	☞	☞
	BCMT160560R-G55	M	2	6	0,1			☞	☞	☞	☞			☞	☞							☞	☞						☞	☞	☞
	BCMT160508R-K55	M	2	0,8	2		☞	☞	☞			☞	☞	☞	☞		☞	☞	☞	☞	☞	☞	☞			☞	☞	☞	☞	☞	
	BCGX1605PDR-G55	G	2	0,8	8	☞					☞					☞	☞	☞						☞							☞

If the corner radius r is greater than 2.5 mm, the corner area of the body must be reworked.

R (body) = r (indexable insert) - 1 mm

BCGX1605PDR-G55 wiper insert only in combination with BCGT160508-G55

HC = Coated carbide

HW = Uncoated carbide

Shoulder milling cutters

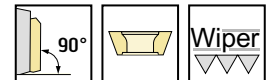
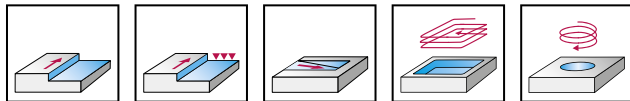
M5130 mm

BC .. 1605 .. R

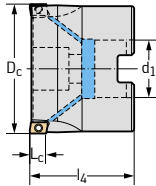
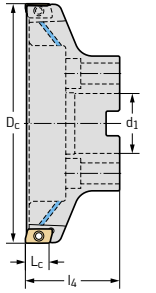
Xtra-tec® XT



– 2 cutting edges per indexable insert



	P	M	K	N	S	H	O
M5130	●	●	●	●	●	●	●

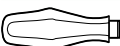
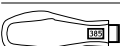
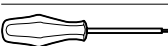
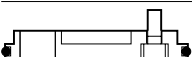
Tool	Designation	D _c mm	d ₁ mm	l ₄ mm	l ₁ mm	L _c mm	Z	kg	No. of indexable inserts	Type
 Shell mill mount DIN 138 transverse keyway	M5130-063-B22-06-15	63	22	40		15	6	0,44	6	BC .. 1605 .. R
	M5130-063-B22-07-15	63	22	40		15	7	0,45	7	
	M5130-063-B27-04-15	63	27	50		15	4	0,66	4	
	M5130-063-B27-06-15	63	27	50		15	6	0,86	6	
	M5130-063-B27-07-15	63	27	50		15	7	0,68	7	
	M5130-066-B27-04-15	66	27	50		15	4	0,72	4	
	M5130-080-B27-05-15	80	27	50		15	5	0,92	5	
	M5130-080-B27-07-15	80	27	50		15	7	0,95	7	
	M5130-080-B27-08-15	80	27	50		15	8	0,97	8	
	M5130-085-B27-05-15	85	27	50		15	5	1,03	5	
	M5130-100-B32-05-15	100	32	50		15	5	1,55	5	
	M5130-100-B32-08-15	100	32	50		15	8	1,62	8	
 Shell mill mount DIN 138 transverse keyway	M5130-125-B40-07-15	125	40	63		15	7	4,06	7	
	M5130-125-B40-10-15	125	40	63		15	10	2,67	10	
	M5130-160-B40-08-15	160	40	63		15	8	2,88	8	BC .. 1605 .. R
	M5130-160-B40-12-15	160	40	63		15	12	3,02	12	

Bodies and assembly parts are included in the scope of delivery

Assembly parts

	D _c [mm]	25	28–160
	Clamping screw for indexable insert Tightening torque	FS1461 (T15IP) 2.5 Nm	FS2300 (T15IP) 3.5 Nm

Accessories

	D _c [mm]	25–125	160
	Torque screwdriver, analogue	FS2003	FS2003
	Torque screwdriver, digital	FS2248	FS2248
	Interchangeable blade	FS2014 (T15IP)	FS2014 (T15IP)
	Screwdriver	FS1485 (T15IP)	FS1485 (T15IP)
	Sealing disc set (incl. gasket and screws)		FS936 COMPLETE SET
	Gasket		O-R 96X4

Indexable inserts

	Designation	Tolerance class	Number of cutting edges	r mm	b mm	P					M					K							N		S				H				
						HC					HC					HC							HC	HW	HC								
						WHH15X	WKP25S	WKP35G	WKP35S	WSP45G	WXM15	WSM35G	WSM35S	WSM45X	WSP45G	WXM15	WAK15	WHH15X	WKK25G	WKK25S	WKP25S	WKP35G	WKP35S	WXM15	WXM15	WXN15	WK10	WSM35G	WSM35S	WSM45X	WSP45G	WHH15X	
	BCGT160508R-G55	G	2	0,8	2	☉	☉	☉	☉						☉		☉			☉						☉	☉						
	BCHT160508R-K85	H	2	0,8	2																						☉	☉					
	BCHT160512R-K85	H	2	1,2	1,7																						☉	☉					
	BCHT160516R-K85	H	2	1,6	1,7																						☉	☉					
	BCHT160520R-K85	H	2	2	1,5																						☉	☉					
	BCHT160525R-K85	H	2	2,5	1,4																						☉	☉					
	BCHT160530R-K85	H	2	3	1,2																						☉	☉					
	BCHT160540R-K85	H	2	4	1,1																						☉	☉					
	BCMT160508R-F55	M	2	0,8	2		☉	☉	☉	☉					☉	☉		☉			☉	☉	☉	☉						☉	☉	☉	☉
	BCMT160508R-G55	M	2	0,8	2		☉	☉	☉	☉					☉	☉		☉			☉	☉	☉	☉						☉	☉	☉	☉
	BCMT160512R-G55	M	2	1,2	1,7			☉	☉	☉					☉	☉							☉	☉							☉	☉	☉
	BCMT160516R-G55	M	2	1,6	1,5			☉	☉	☉					☉	☉							☉	☉							☉	☉	☉
	BCMT160520R-G55	M	2	2	1,5			☉	☉	☉					☉	☉							☉	☉							☉	☉	☉
	BCMT160525R-G55	M	2	2,5	1,4			☉	☉	☉					☉	☉							☉	☉							☉	☉	☉
	BCMT160530R-G55	M	2	3	1,2			☉	☉	☉					☉	☉							☉	☉							☉	☉	☉
	BCMT160532R-G55	M	2	3,2	1,1			☉	☉	☉					☉	☉							☉	☉							☉	☉	☉
	BCMT160540R-G55	M	2	4	1,1			☉	☉	☉					☉	☉							☉	☉							☉	☉	☉
	BCMT160550R-G55	M	2	5	0,7			☉	☉	☉					☉	☉							☉	☉							☉	☉	☉
	BCMT160560R-G55	M	2	6	0,1			☉	☉	☉					☉	☉							☉	☉							☉	☉	☉
	BCMT160508R-K55	M	2	0,8	2			☉	☉	☉					☉								☉	☉							☉	☉	☉
	BCGX1605PDR-G55	G	2	0,8	8	☉					☉					☉	☉	☉														☉	

If the corner radius r is greater than 2.5 mm, the corner area of the body must be reworked.

R (body) = r (indexable insert) - 1 mm

BCGX1605PDR-G55 wiper insert only in combination with BCGT160508-G55

HC = Coated carbide

HW = Uncoated carbide

Shoulder milling cutters

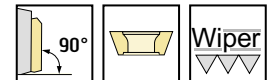
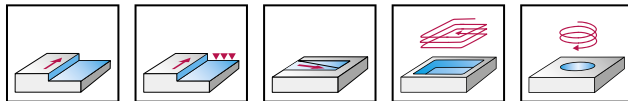
M5130 inch

BC .. 1605 .. R

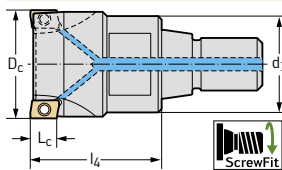
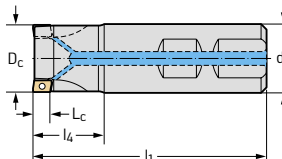
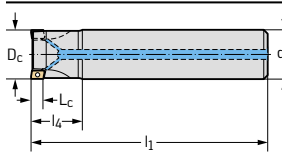
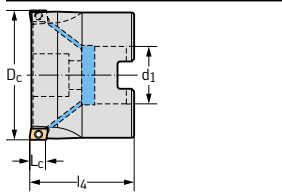
Xtra-tec® XT



– 2 cutting edges per indexable insert

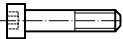


	P	M	K	N	S	H	O
M5130	●	●	●	●	●	●	●

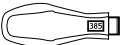
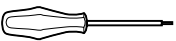
Tool	Designation	D _c inch	d ₁ inch	l ₄ inch	l ₁ inch	L _c inch	Z	lbs	No. of indexable inserts	Type
 ScrewFit	M5130.038-T36-03-15	1,500	T36	1,500		0,591	3	0,661	3	BC .. 1605 .. R
	M5130.038-T36-04-15	1,500	T36	1,500		0,591	4	0,701	4	
	M5130.051-T45-06-15	2,000	T45	1,575		0,591	6	1,016	6	
 DIN 1835 B	M5130.026-W26-02-15	1,000	1,000	1,850	4,131	0,591	2	0,719	2	BC .. 1605 .. R
	M5130.031-W31-03-15	1,250	1,250	1,500	3,781	0,591	3	1,012	3	
	M5130.038-W31-04-15	1,500	1,250	1,730	4,008	0,591	4	1,261	3	
 Cylindrical shank	M5130.026-A26-02-15	1,000	1,000	1,850	8,350	0,591	2	1,607	2	BC .. 1605 .. R
	M5130.031-A31-03-15	1,250	1,250	1,500	9,87	0,591	3	3,201	3	
 Shell mill mount DIN 138 transverse keyway	M5130.051-B19-03-15	2,000	0,750	1,575		0,591	3	0,710	3	BC .. 1605 .. R
	M5130.051-B19-05-15	2,000	0,750	1,575		0,591	5	0,661	5	
	M5130.051-B19-06-15	2,000	0,750	1,575		0,591	6	0,694	6	
	M5130.064-B26-04-15	2,500	1,000	1,575		0,591	4	1,096	4	
	M5130.064-B26-06-15	2,500	1,000	1,575		0,591	6	1,146	6	
	M5130.064-B26-07-15	2,500	1,000	1,575		0,591	7	1,131	7	
	M5130.076-B26-05-15	3,000	1,000	2,000		0,591	5	2,502	5	
	M5130.076-B26-07-15	3,000	1,000	2,000		0,591	7	2,008	7	
	M5130.076-B26-08-15	3,000	1,000	2,000		0,591	8	2,297	8	
	M5130.102-B38-05-15	4,000	1,500	2,500		0,591	5	5,269	5	
	M5130.102-B38-08-15	4,000	1,500	2,500		0,591	8	6,041	8	
	M5130.127-B38-07-15	5,000	1,500	2,500		0,591	7	7,542	7	
	M5130.127-B38-10-15	5,000	1,500	2,500		0,591	10	8,201	10	
	M5130.152-B38-08-15	6,000	1,500	2,500		0,591	8	10,437	8	
	M5130.152-B38-12-15	6,000	1,500	2,500		0,591	12	10,229	12	

Bodies and assembly parts are included in the scope of delivery

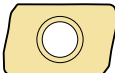
Assembly parts

	D _c [inch]	1	1,25–1,5	2	2,5–3	4–6
	Clamping screw for indexable insert Tightening torque	FS1461 (T15IP) 1,844 lbs	FS2300 (T15IP) 2,581 lbs	FS2300 (T15IP) 2,581 lbs	FS2300 (T15IP) 2,581 lbs	FS2300 (T15IP) 2,581 lbs
	Clamping screw for arbour-mounted tools			FS1523	FS1519	FS1583

Accessories

	D _c [inch]	1–6
	Torque screwdriver, analogue	FS2004
	Torque screwdriver, digital	FS2248
	Interchangeable blade	FS2014 (T15IP)
	Screwdriver	FS1485 (T15IP)

Indexable inserts

	Designation	Tolerance class	Number of cutting edges	r inch	b inch	P					M					K					N		S			H			
						HC					HC					HC					HC	HW	HC						
						WHH15X	WKP25S	WKP35G	WKP35S	WSP45G	WXM15	WSM35G	WSM35S	WSM45X	WSP45G	WXM15	WAK15	WHH15X	WKK25G	WKK25S	WKP25S	WKP35G	WKP35S	WXM15	WXN15		WK10	WSM35G	WSM35S
	BCGT160508R-G55	G	2	0,031	0,079																								
	BCHT160508R-K85	H	2	0,031	0,079																								
	BCHT160512R-K85	H	2	0,047	0,067																								
	BCHT160516R-K85	H	2	0,063	0,067																								
	BCHT160520R-K85	H	2	0,079	0,059																								
	BCHT160525R-K85	H	2	0,098	0,055																								
	BCHT160530R-K85	H	2	0,118	0,047																								
	BCHT160540R-K85	H	2	0,157	0,043																								
	BCMT160508R-F55	M	2	0,031	0,079																								
	BCMT160508R-G55	M	2	0,031	0,079																								
	BCMT160512R-G55	M	2	0,047	0,067																								
	BCMT160516R-G55	M	2	0,063	0,059																								
	BCMT160520R-G55	M	2	0,079	0,059																								
	BCMT160525R-G55	M	2	0,098	0,055																								
	BCMT160530R-G55	M	2	0,118	0,047																								
	BCMT160532R-G55	M	2	0,126	0,043																								
	BCMT160540R-G55	M	2	0,157	0,043																								
	BCMT160550R-G55	M	2	0,197	0,028																								
	BCMT160560R-G55	M	2	0,236	0,004																								
	BCMT160508R-K55	M	2	0,031	0,079																								
	BCGX1605PDR-G55	G	2	0,031	0,315																								

If the corner radius r is greater than 2.5 mm, the corner area of the body must be reworked.

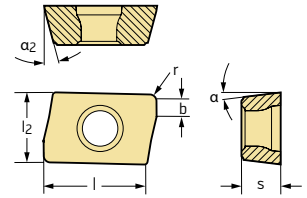
R (body) = r (indexable insert) - 1 mm

BCGX1605PDR-G55 wiper insert only in combination with BCGT160508-G55

HC = Coated carbide

HW = Uncoated carbide

Positive rhombic
ACGT / ACMT
Tiger-tec® Gold

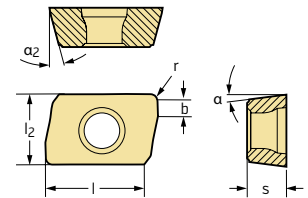


Indexable inserts

	Designation	Tolerance class	Number of cutting edges	l mm	l ₂ mm	s mm	r mm	α	α ₂	b mm	P HC					M HC			K HC					N HC HW		S HC		
											WKP25S	WKP35G	WKP35S	WSP45G	WSP45S	WSM35S	WSP45G	WSP45S	WAK15	WKK25S	WKP25S	WKP35G	WKP35S	WKN15	WK10	WSM35S	WSP45G	WSP45S
	ACGT060204R-G65	G	2	6,7	4,4	2,38	0,4	7°	15°	0,9	⊕	⊕	⊕	⊕	⊕	⊕	⊕			⊕	⊕	⊕			⊕	⊕	⊕	
	ACGT060204R-M85	G	2	6,7	4,4	2,38	0,4	7°	15°	0,9													⊕	⊕				
	ACMT060202R-G55	M	2	6,7	4,4	2,38	0,2	7°	15°	1		⊕	⊕	⊕	⊕		⊕				⊕	⊕				⊕	⊕	
	ACMT060204R-G55	M	2	6,7	4,4	2,38	0,4	7°	15°	0,9	⊕	⊕	⊕	⊕	⊕	⊕	⊕	⊕	⊕	⊕	⊕	⊕			⊕	⊕	⊕	
	ACMT060208R-G55	M	2	6,7	4,4	2,38	0,8	7°	15°	0,8		⊕	⊕	⊕	⊕		⊕				⊕	⊕				⊕	⊕	
	ACMT060212R-G55	M	2	6,7	4,4	2,38	1,2	7°	15°	0,6		⊕	⊕	⊕	⊕		⊕				⊕	⊕				⊕	⊕	
	ACMT060216R-G55	M	2	6,7	4,4	2,38	1,6	7°	15°	0,1		⊕	⊕	⊕	⊕		⊕				⊕	⊕				⊕	⊕	
	ACMT060204R-K55	M	2	6,7	4,4	2,38	0,4	7°	15°	0,9		⊕	⊕	⊕	⊕	⊕	⊕			⊕	⊕			⊕	⊕	⊕		

HC = Coated carbide
HW = Uncoated carbide

Positive rhombic BCGT / BCHT / BCMT Tiger-tec® Gold

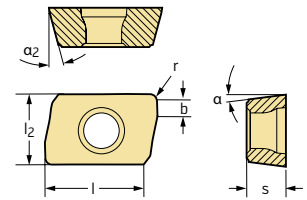


Indexable inserts

Designation		Tolerance class	Number of cutting edges	l mm	l ₂ mm	s mm	r mm	α	α ₂	b mm	P					M				K					N		S																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																					
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	BCGT090304R-G55	G	2	10,3	6,3	3,21	0,4	7°	15°	1,2																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																						
	BCGT120408R-G55	G	2	13,8	7,6	4,8	0,8	7°	15°	1,3																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																						
	BCGT160508R-G55	G	2	17,3	9,9	5,75	0,8	7°	15°	2																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																						
	BCGT090304R-K85	G	2	10,3	6,3	3,21	0,4	7°	15°	1,2																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																						

HC = Coated carbide
HW = Uncoated carbide

Positive rhombic
BCGT / BCHT / BCMT
Tiger-tec® Gold



Indexable inserts

	Designation	Tolerance class	Number of cutting edges	l mm	l ₂ mm	s mm	r mm	α	α ₂	b mm	P					M				K			N		S						
											HC					HC				HC			HC	HW	HC						
											WKP25S	WKP35G	WKP35S	WSP45G	WSP45S	WSM35S	WSM45X	WSP45G	WSP45S	WAK15	WKK25S	WKP25S	WKP35G	WKP35S	WXN15	WK10	WSM35S	WSM45X	WSP45G	WSP45S	
	BCMT160530R-G55	M	2	17,3	9,9	5,75	3	7°	15°	1,2	⊗	⊗	⊗	⊗	⊗		⊗	⊗	⊗				⊗	⊗				⊗	⊗	⊗	
	BCMT160532R-G55	M	2	17,3	9,9	5,75	3,2	7°	15°	1,1	⊗	⊗	⊗	⊗	⊗			⊗	⊗	⊗				⊗	⊗				⊗	⊗	⊗
	BCMT160540R-G55	M	2	17,3	9,9	5,75	4	7°	15°	1,1	⊗	⊗	⊗	⊗	⊗			⊗	⊗	⊗				⊗	⊗				⊗	⊗	⊗
	BCMT160550R-G55	M	2	17,3	9,9	5,75	5	7°	15°	0,7	⊗	⊗	⊗	⊗	⊗			⊗	⊗	⊗				⊗	⊗				⊗	⊗	⊗
	BCMT160560R-G55	M	2	17,3	9,9	5,75	6	7°	15°	0,1	⊗	⊗	⊗	⊗	⊗		⊗	⊗	⊗	⊗				⊗	⊗				⊗	⊗	⊗
	BCMT090304R-K55	M	2	10,3	6,3	3,21	0,4	7°	15°	1,2	⊗	⊗	⊗	⊗	⊗	⊗		⊗	⊗				⊗	⊗				⊗	⊗	⊗	
	BCMT120408R-K55	M	2	13,8	7,3	4,8	0,8	7°	15°	1,3	⊗	⊗	⊗	⊗	⊗	⊗		⊗	⊗				⊗	⊗				⊗	⊗	⊗	
	BCMT160508R-K55	M	2	17,3	9,9	5,75	0,8	7°	15°	2	⊗	⊗	⊗	⊗	⊗	⊗	⊗	⊗	⊗				⊗	⊗				⊗	⊗	⊗	

HC = Coated carbide
 HW = Uncoated carbide

Shoulder milling cutters

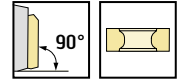
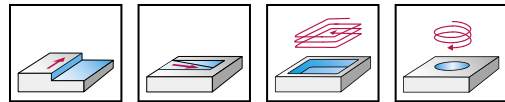
M5137

TNMU11T304R

Xtra-tec® XT



– 6 cutting edges per indexable insert



	P	M	K	N	S	H	O
M5137	●	●	●	●	●		

Tool	Designation	D _c mm	d ₁ mm	l ₄ mm	l ₁ mm	L _c mm	Z	kg	No. of indexable inserts	Type
 DIN 1835 B	M5137-025-W25-03-05	25	25	40	96	5	3	0,3	3	TNMU11T304R
	M5137-032-W32-04-05	32	32	40	101	5	4	0,53	4	
	M5137-032-W32-05-05	32	32	40	101	5	5	0,53	5	
 Shell mill mount DIN 138 transverse keyway	M5137-040-B16-05-05	40	16	40		5	5	0,19	5	TNMU11T304R
	M5137-040-B16-06-05	40	16	40		5	6	0,19	6	
	M5137-050-B22-06-05	50	22	40		5	6	0,29	6	
	M5137-050-B22-08-05	50	22	40		5	8	0,29	8	
	M5137-063-B22-07-05	63	22	40		5	7	0,48	7	
	M5137-063-B22-09-05	63	22	40		5	9	0,48	9	

Bodies and assembly parts are included in the scope of delivery

Assembly parts		D _c [mm]	25–63
	Clamping screw for indexable insert		FS2061 (T7IP)
	Tightening torque		0,9 Nm

Accessories		D _c [mm]	25–63
	Torque screwdriver, analogue		FS2001
	Interchangeable blade		FS2011 (T7IP)
	Screwdriver		FS2088 (T7IP)

Indexable inserts						P	M	K	S
		Tolerance class	Number of cutting edges	r mm	b mm	HC	HC	HC	HC
Designation						WKP25S	WKP35G	WKP35S	WSP45G
	TNMU11T304R-G27	M	6	0,4	1	●	●	●	●
	TNMU11T304R-G57	M	6	0,4	1	●	●	●	●

HC = Coated carbide

Shoulder milling cutters

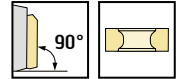
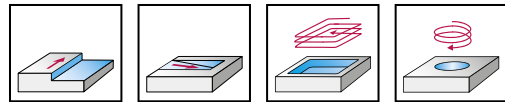
M5137 inch

TNMU11T304R

Xtra-tec® XT



– 6 cutting edges per indexable insert



	P	M	K	N	S	H	O
M5137	●	●	●	●	●		

Tool	Designation	D _c inch	d ₁ inch	l ₄ inch	l ₁ inch	L _c inch	Z	lbs	No. of indexable inserts	Type
 DIN 1835 B	M5137.026-W26-03-05	1,000	1,000	1,181	3,462	0,197	3	0,639	3	TNMU11T304R
	M5137.031-W31-04-05	1,250	1,250	1,181	3,462	0,197	4	1,014	4	
	M5137.031-W31-05-05	1,250	1,250	1,181	3,462	0,197	5	0,992	5	
 Shell mill mount DIN 138 transverse keyway	M5137.038-B19-05-05	1,500	0,750	1,500		0,197	5	0,331	5	TNMU11T304R
	M5137.038-B19-06-05	1,500	0,750	1,500		0,197	6	0,617	6	
	M5137.051-B19-06-05	2,000	0,750	1,500		0,197	6	0,728	6	
	M5137.051-B19-08-05	2,000	0,750	1,500		0,197	8	0,728	8	
	M5137.064-B26-07-05	2,500	1,000	1,500		0,197	7	1,786	7	
	M5137.064-B26-09-05	2,500	1,000	1,500		0,197	9	1,146	9	

Bodies and assembly parts are included in the scope of delivery

Assembly parts		D _c [inch]	1–1,25	1,5–2	2,5
 	Clamping screw for indexable insert Tightening torque		FS2061 (T7IP) 0,664 lbs	FS2061 (T7IP) 0,664 lbs	FS2061 (T7IP) 0,664 lbs
	Clamping screw for arbour-mounted tools			FS1518	FS1519

Accessories		D _c [inch]	1–2,5
 	Torque screwdriver, analogue		FS2002
	Interchangeable blade		FS2011 (T7IP)
	Screwdriver		FS2088 (T7IP)

Indexable inserts						P	M	K	S
		Tolerance class	Number of cutting edges	r inch	b inch	HC	HC	HC	HC
Designation						WKP25S	WKP35G	WKP35S	WSP45G
	TNMU11T304R-G27	M	6	0,016	0,039	●	●	●	●
	TNMU11T304R-G57	M	6	0,016	0,039	●	●	●	●

Shoulder milling cutters

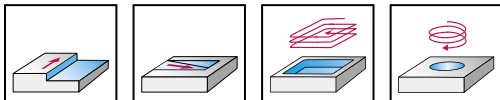
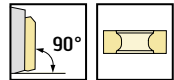
M5137

TNMU160508R

Xtra-tec® XT

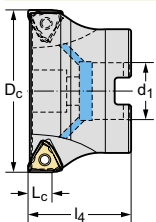


– 6 cutting edges per indexable insert



	P	M	K	N	S	H	O
M5137	●	●	●	●	●		

Tool



Shell mill mount DIN 138 transverse keyway

Designation

Designation	D _c mm	d ₁ mm	l ₄ mm	L _c mm	Z	kg	No. of indexable inserts	Type
M5137-050-B22-04-08	50	22	40	8	4	0,26	4	TNMU160508R
M5137-050-B22-05-08	50	22	40	8	5	0,25	5	
M5137-063-B22-05-08	63	22	40	8	5	0,45	5	
M5137-063-B22-07-08	63	22	40	8	7	0,42	7	
M5137-080-B27-07-08	80	27	50	8	7	1,13	7	
M5137-080-B27-09-08	80	27	50	8	9	0,94	9	
M5137-100-B32-08-08	100	32	50	8	8	1,63	8	
M5137-100-B32-11-08	100	32	50	8	11	1,62	11	

Bodies and assembly parts are included in the scope of delivery

Assembly parts

	D _c [mm]	50–100
	Clamping screw for indexable insert Tightening torque	FS2079 (T9IP) 2 Nm

Accessories

	D _c [mm]	50–100
	Torque screwdriver, analogue	FS2003
	Torque screwdriver, digital	FS2248
	Interchangeable blade	FS2013 (T9IP)
	Screwdriver	FS1484 (T9IP)

Indexable inserts

Designation	Tolerance class	Number of cutting edges	r mm	b mm	P	M	K	S
					HC	HC	HC	HC
	M	6	0,8	1,6	WKP25S	WKP35G	WKP35S	WSP45G
					WSP45G	WSP45G	WKP25S	WKP35G
TNMU160508R-G27	M	6	0,8	1,6	WKP25S	WKP35G	WKP35S	WSP45G
TNMU160508R-G57	M	6	0,8	1,6	WKP25S	WKP35G	WKP35S	WSP45G

HC = Coated carbide

Shoulder milling cutters

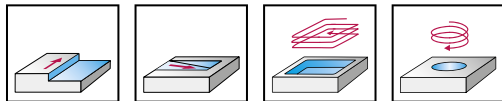
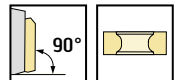
M5137 inch

TNMU160508R

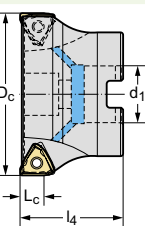
Xtra-tec® XT



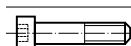
– 6 cutting edges per indexable insert

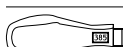


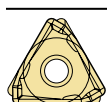
	P	M	K	N	S	H	O
M5137	●●	●●	●●	●●	●●	●●	●●

Tool	Designation	D _c inch	d ₁ inch	l ₄ inch	L _c inch	Z	 lbs	No. of indexable inserts	Type
	M5137.051-B19-04-08	2,000	0,750	1,500	0,315	4	0,639	4	TNMU160508R
	M5137.051-B19-05-08	2,000	0,750	1,500	0,315	5	0,617	5	
	M5137.064-B26-05-08	2,500	1,000	1,500	0,315	5	1,065	5	
	M5137.064-B26-07-08	2,500	1,000	1,500	0,315	7	1,014	7	
	M5137.076-B26-07-08	3,000	1,000	2,000	0,315	7	1,814	7	
	M5137.076-B26-09-08	3,000	1,000	2,000	0,315	9	1,764	9	
	M5137.102-B38-08-08	4,000	1,500	2,500	0,315	8	5,470	8	
	M5137.102-B38-11-08	4,000	1,500	2,500	0,315	11	5,445	11	
Shell mill mount DIN 138 transverse keyway									

Bodies and assembly parts are included in the scope of delivery

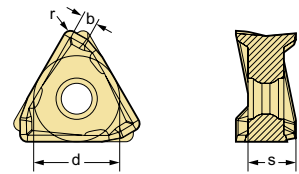
Assembly parts		D _c [inch]	2	2,5–3	4
	Clamping screw for indexable insert		FS2079 (T9IP)	FS2079 (T9IP)	FS2079 (T9IP)
	Tightening torque		1,475 lbs	1,475 lbs	1,475 lbs
	Clamping screw for arbour-mounted tools		FS1518	FS1519	FS1583

Accessories		D _c [inch]	2–4
	Torque screwdriver, analogue		FS2004
	Torque screwdriver, digital		FS2248
	Interchangeable blade		FS2013 (T9IP)
	Screwdriver		FS1484 (T9IP)

Indexable inserts						P	M	K	S
						HC	HC	HC	HC
						WKP25S	WKP35G	WKP35S	WSP45G
						WSP45G	WSP45G	WKP25S	WKP35G
						WKP35S	WKP35S	WKP35S	WSP45G
Designation	Tolerance class	Number of cutting edges	r inch	b inch					
	TNMU160508R-G27	M	6	0,031	0,063	⊗	⊗	⊗	⊗
	TNMU160508R-G57	M	6	0,031	0,063	⊗	⊗	⊗	⊗

HC = Coated carbide

Negative triangular TNMU Tiger-tec® Gold



Indexable inserts

Designation	Tolerance class	Number of cutting edges	s mm	d mm	r mm	b mm	P				M	K			S
							HC				HC	HC			HC
							WKP25S	WKP35G	WKP35S	WSP45G	WSP45G	WKP25S	WKP35G	WKP35S	WSP45G
	TNMU11T304R-G57	M	6	3,75	6,72	0,4	1								
	TNMU160508R-G57	M	6	5,35	9,6	0,8	1,6								
	TNMU11T304R-G27	M	6	3,75	6,72	0,4	1								
	TNMU160508R-G27	M	6	5,35	9,6	0,8	1,6								

Ordering example for the WKP35G grade: TNMU11T304R-G57 WKP35G

HC = Coated carbide

High-feed milling cutters

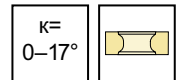
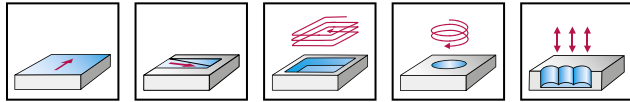
M5008 mm

ENMX08T316R

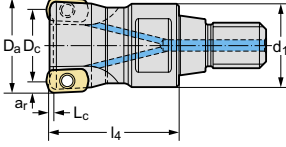
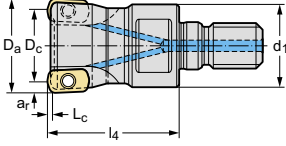
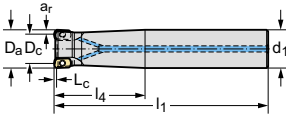
Xtra-tec® XT



– 4 cutting edges per indexable insert



	P	M	K	N	S	H	O
M5008	●	●	●	●	●	●	●

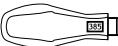
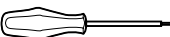
Tool	Designation	D _c mm	D _a mm	d ₁ mm	l ₄ mm	l ₁ mm	L _c mm	a _r mm	Z	 kg	No. of indexable inserts	Type
 ScrewFit	M5008-016-T14-02-01	10,1	16	T14	25		1	2,9	2	0,03	2	ENMX08T316R
	M5008-020-T18-03-01	14,1	20	T18	30		1	2,9	3	0,05	3	
	M5008-020-T18-04-01	14,1	20	T18	30		1	2,9	4	0,05	4	
	M5008-025-T22-04-01	19,1	25	T22	35		1	2,9	4	0,09	4	
	M5008-025-T22-05-01	19,1	25	T22	35		1	2,9	5	0,09	5	
	M5008-030-T28-04-01	24,1	30	T28	40		1	2,9	4	0,17	4	
	M5008-030-T28-05-01	24,1	30	T28	40		1	2,9	5	0,17	5	
	M5008-032-T28-05-01	26,1	32	T28	40		1	2,9	5	0,18	5	
	M5008-032-T28-06-01	26,1	32	T28	40		1	2,9	6	0,18	6	
	M5008-035-T28-05-01	29,1	35	T28	40		1	2,9	5	0,2	5	
	M5008-035-T28-06-01	29,1	35	T28	40		1	2,9	6	0,2	6	
	M5008-040-T36-06-01	34,1	40	T36	40		1	2,9	6	0,33	6	
	M5008-040-T36-08-01	34,1	40	T36	40		1	2,9	8	0,32	8	
	M5008-042-T36-06-01	36,1	42	T36	40		1	2,9	6	0,34	6	
	M5008-042-T36-08-01	36,1	42	T36	40		1	2,9	8	0,33	8	
 Cylindrical modular	M5008-016-TC08-02-01	10,1	16	M8	25		1	2,9	2	0,03	2	ENMX08T316R
	M5008-020-TC10-03-01	14,1	20	M10	30		1	2,9	3	0,04	3	
	M5008-020-TC10-04-01	14,1	20	M10	30		1	2,9	4	0,04	4	
	M5008-025-TC12-04-01	19,1	25	M12	35		1	2,9	4	0,08	4	
	M5008-025-TC12-05-01	19,1	25	M12	35		1	2,9	5	0,08	5	
	M5008-030-TC16-04-01	24,1	30	M16	40		1	2,9	4	0,16	4	
	M5008-030-TC16-05-01	24,1	30	M16	40		1	2,9	5	0,16	5	
	M5008-032-TC16-05-01	26,1	32	M16	40		1	2,9	5	0,17	5	
	M5008-032-TC16-06-01	26,1	32	M16	40		1	2,9	6	0,17	6	
	M5008-035-TC16-05-01	29,1	35	M16	40		1	2,9	5	0,19	5	
	M5008-035-TC16-06-01	29,1	35	M16	40		1	2,9	6	0,2	6	
	M5008-040-TC16-06-01	34,1	40	M16	40		1	2,9	6	0,22	6	
	M5008-040-TC16-08-01	34,1	40	M16	40		1	2,9	8	0,23	8	
	M5008-042-TC16-06-01	36,1	42	M16	40		1	2,9	6	0,24	6	
	M5008-042-TC16-08-01	36,1	42	M16	40		1	2,9	8	0,25	8	
 Cylindrical shank	M5008-016-A16-02-01	10	16	16	30	100	1	2,9	2	0,13	2	ENMX08T316R
	M5008-020-A20-03-01	14,1	20	20	50	130	1	2,9	3	0,27	3	
	M5008-020-A20-04-01	14,1	20	20	50	130	1	2,9	4	0,27	4	
	M5008-025-A25-04-01	19,1	25	25	60	140	1	2,9	4	0,47	4	
	M5008-025-A25-05-01	19,1	25	25	60	140	1	2,9	5	0,46	5	
	M5008-032-A32-05-01	26,1	32	32	70	150	1	2,9	5	0,84	5	
	M5008-032-A32-06-01	26,1	32	32	70	150	1	2,9	6	0,83	6	

Bodies and assembly parts are included in the scope of delivery

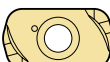
Assembly parts

	D _a [mm]	16–66
	Clamping screw for indexable insert Tightening torque	FS1454 (T8IP) 1.2 Nm

Accessories

	D _a [mm]	16–66
	Torque screwdriver, analogue	FS2001
	Torque screwdriver, digital	FS2248
	Interchangeable blade	FS2012 (T8IP)
	Screwdriver	FS1483 (T8IP)

Indexable inserts

	Designation	Tolerance class	Number of cutting edges	r mm	P					M				K				S				H
					WHH15X	WKP25S	WKP35G	WKP35S	WSP45G	WSM35G	WSM35S	WSM45X	WSP45G	WKK25G	WKP25S	WKP35G	WKP35S	WSM35G	WSM35S	WSM45X	WSP45G	
	ENMX08T316R-D27	M	4	1,6																		
	ENMX08T316R-F47	M	4	1,6																		

HC = Coated carbide

High-feed milling cutters

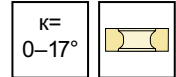
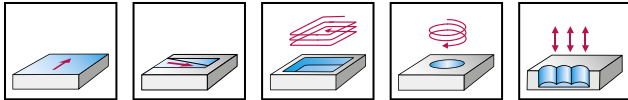
M5008 mm

ENMX08T316R

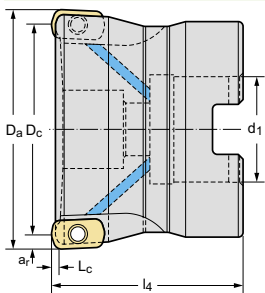
Xtra-tec® XT



– 4 cutting edges per indexable insert



	P	M	K	N	S	H	O
M5008	●	●	●	●	●	●	●

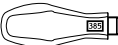
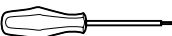
Tool	Designation	D _c mm	D _a mm	d ₁ mm	l ₄ mm	l ₁ mm	L _c mm	a _r mm	Z	kg	No. of indexable inserts	Type
 Shell mill mount DIN 138 transverse keyway	M5008-032-B16-05-01	26,1	32	16	40		1	2,9	5	0,13	5	ENMX08T316R
	M5008-032-B16-06-01	26,1	32	16	40		1	2,9	6	0,13	6	
	M5008-035-B16-05-01	29,1	35	16	40		1	2,9	5	0,14	5	
	M5008-035-B16-06-01	29,1	35	16	40		1	2,9	6	0,15	6	
	M5008-040-B16-06-01	34,1	40	16	40		1	2,9	6	0,2	6	
	M5008-040-B16-08-01	34,1	40	16	40		1	2,9	8	0,21	8	
	M5008-042-B16-06-01	36,1	42	16	40		1	2,9	6	0,23	6	
	M5008-042-B16-08-01	36,1	42	16	40		1	2,9	8	0,23	8	
	M5008-050-B22-07-01	44,1	50	22	40		1	2,9	7	0,36	7	
	M5008-050-B22-09-01	44,1	50	22	40		1	2,9	9	0,36	9	
	M5008-052-B22-07-01	46,1	52	22	40		1	2,9	7	0,38	7	
	M5008-052-B22-09-01	46,1	52	22	40		1	2,9	9	0,38	9	
	M5008-063-B22-08-01	57,1	63	22	40		1	2,9	8	0,52	8	
	M5008-063-B22-10-01	57,1	63	22	40		1	2,9	10	0,51	10	
	M5008-066-B27-08-01	60,1	66	27	50		1	2,9	8	0,82	8	
	M5008-066-B27-10-01	60,1	66	27	50		1	2,9	10	0,81	10	

Bodies and assembly parts are included in the scope of delivery

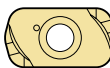
Assembly parts

	D _a [inch]	0,625–1,25	1,5–2	2,5
	Clamping screw for indexable insert Tightening torque	FS1454 (T8IP) 0,885 lbs	FS1454 (T8IP) 0,885 lbs	FS1454 (T8IP) 0,885 lbs
	Clamping screw for arbour-mounted tools		FS1523	FS1519

Accessories

	D _a [inch]	0,625–2,5
	Torque screwdriver, analogue	FS2002
	Torque screwdriver, digital	FS2248
	Interchangeable blade	FS2012 (T8IP)
	Screwdriver	FS1483 (T8IP)

Indexable inserts

	Designation	Tolerance class	Number of cutting edges	r inch	P				M				K				S				H
					HC				HC				HC				HC				HC
					WHH15X	WKP25S	WKP35G	WKP35S	WSP45G	WSM35G	WSM35S	WSM45X	WSP45G	WKK25G	WKP25S	WKP35G	WKP35S	WSM35G	WSM35S	WSM45X	WSP45G
	ENMX08T316R-D27	M	4	0,063																	
	ENMX08T316R-F47	M	4	0,063																	

HC = Coated carbide

High-feed milling cutters

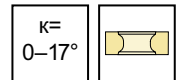
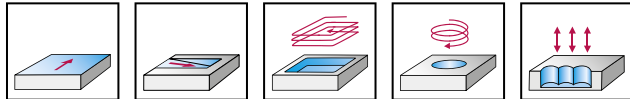
M5008 inch

ENMX08T316R

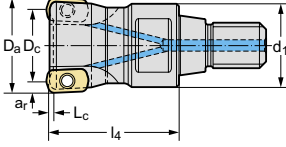
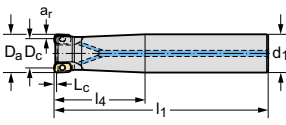
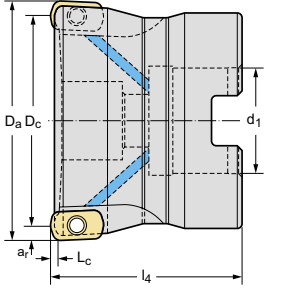
Xtra-tec® XT



– 4 cutting edges per indexable insert

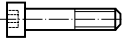


	P	M	K	N	S	H	O
M5008	●	●	●	●	●	●	●

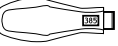
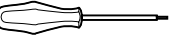
Tool	Designation	D _c inch	D _a inch	d ₁ inch	l ₄ inch	l ₁ inch	L _c inch	a _r inch	Z	 lbs	No. of indexable inserts	Type
 ScrewFit	M5008.015-T14-02-01	0,394	0,625	T14	0,984		0,039	0,114	2	0,064	2	ENMX08T316R
	M5008.019-T18-03-01	0,516	0,750	T18	1,181		0,039	0,114	3	0,099	3	
	M5008.026-T22-04-01	0,768	1,000	T22	1,378		0,039	0,114	4	0,201	4	
	M5008.026-T22-05-01	0,768	1,000	T22	1,378		0,039	0,114	5	0,196	5	
	M5008.031-T28-05-01	1,016	1,250	T28	1,575		0,039	0,114	5	0,408	5	
	M5008.031-T28-06-01	1,016	1,250	T28	1,575		0,039	0,114	6	0,397	6	
	M5008.038-T36-06-01	1,268	1,500	T36	1,575		0,039	0,114	6	0,705	6	
	M5008.038-T36-08-01	1,268	1,500	T36	1,575		0,039	0,114	8	0,69	8	
 Cylindrical shank	M5008.015-A15-02-01	0,394	0,625	0,625	1,000	4,000	0,039	0,114	2	0,295	2	ENMX08T316R
	M5008.019-A19-03-01	0,516	0,750	0,750	1,000	5,000	0,039	0,114	3	0,542	3	
	M5008.026-A26-04-01	0,768	1,000	1,000	1,000	5,500	0,039	0,114	4	1,107	4	
	M5008.026-A26-05-01	0,768	1,000	1,000	1,000	5,500	0,039	0,114	5	1,096	5	
 Shell mill mount DIN 138 transverse keyway	M5008.038-B19-06-01	1,268	1,500	0,750	1,500		0,039	0,114	6	0,397	6	ENMX08T316R
	M5008.038-B19-08-01	1,268	1,500	0,750	1,500		0,039	0,114	8	0,384	8	
	M5008.051-B19-07-01	1,768	2,000	0,750	1,500		0,039	0,114	7	0,591	7	
	M5008.051-B19-09-01	1,768	2,000	0,750	1,500		0,039	0,114	9	0,584	9	
	M5008.064-B26-08-01	2,268	2,500	1,000	1,577		0,039	0,114	8	1,166	8	
	M5008.064-B26-10-01	2,268	2,500	1,000	1,577		0,039	0,114	10	1,146	10	

Bodies and assembly parts are included in the scope of delivery

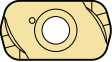
Assembly parts

	D _a [inch]	0,625–1,25	1,5–2	2,5
	Clamping screw for indexable insert Tightening torque	FS1454 (T8IP) 0,885 lbs	FS1454 (T8IP) 0,885 lbs	FS1454 (T8IP) 0,885 lbs
	Clamping screw for arbour-mounted tools		FS1523	FS1519

Accessories

	D _a [inch]	0,625–2,5
	Torque screwdriver, analogue	FS2002
	Torque screwdriver, digital	FS2248
	Interchangeable blade	FS2012 (T8IP)
	Screwdriver	FS1483 (T8IP)

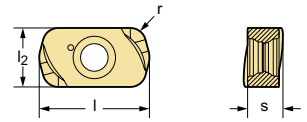
Indexable inserts

	Designation	Tolerance class	Number of cutting edges	r inch	P				M				K				S				H	
					HC				HC				HC				HC				HC	
					WHH15X	WKP25S	WKP35G	WKP35S	WSP45G	WSM35G	WSM35S	WSM45X	WSP45G	WKK25G	WKP25S	WKP35G	WKP35S	WSM35G	WSM35S	WSM45X	WSP45G	WHH15X
	ENMX08T316R-D27	M	4	0,063																		
	ENMX08T316R-F47	M	4	0,063																		

HC = Coated carbide

Negative rhombic ENMX

Tiger-tec® Gold



Indexable inserts

	Designation	Tolerance class	Number of cutting edges	l ₂ mm	l mm	s mm	r mm	P					M				K				N		S				H	
								HC					HC				HC				HW	HC	HC				HC	
								WKP25S	WKP35G	WKP35S	WSP45S	WSP45G	WSM35S	WSP45S	WSP45G	WSM45X	WAK15	WKK25S	WKP25S	WKP35G	WKP35S	WK10	WXN15	WSM35S	WSP45S	WSP45G	WSM45X	WHH15
	ENMX08T316R-D27	M	4	6	11	3,60	1,6	☹	☹	☹	☹	☹	☹	☹	☹	☹	☹	☹	☹	☹			☹	☹			☹	☹
	ENMX08T316R-F47	M	4	6	11	3,60	1,6	☹	☹	☹	☹	☹	☹	☹	☹	☹	☹	☹	☹	☹			☹	☹	☹	☹	☹	☹

HC = Coated carbide
HW = Uncoated carbide



Octagon face milling cutters

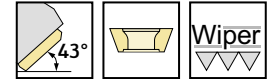
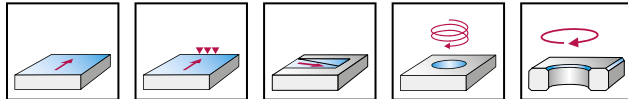
M5004 mm

OD .. 0504 ..; ODHX0504ZZR

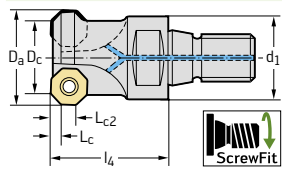
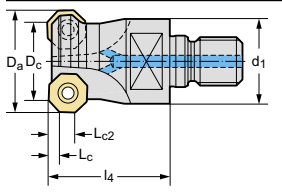
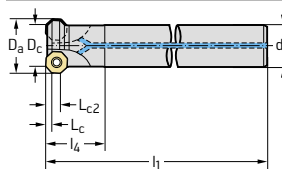
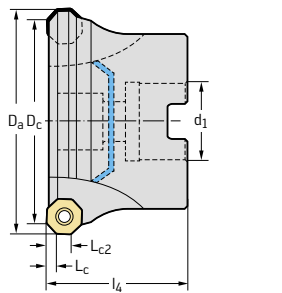
Xtra-tec® XT



– 8 cutting edges per indexable insert



	P	M	K	N	S	H	O
M5004	●	●	●	●	●	●	●

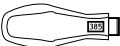
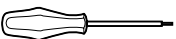
Tool	Designation	D _c mm	D _a mm	d ₁ mm	l ₄ mm	l ₁ mm	L _c mm	L _{c2} mm	Z	kg	No. of indexable inserts	Type
 ScrewFit	M5004-032-T28-02-03	24	32	T28	40		3	8	2	0,16	2	OD .. 0504 .. ODHX0504ZZR
	M5004-040-T36-03-03	32	40	T36	40		3	8	3	0,3	3	
 Cylindrical modular	M5004-032-TC16-02-03	24	32	M16	40		3	8	2	0,15	2	OD .. 0504 .. ODHX0504ZZR
 Cylindrical shank	M5004-032-A20-02-03	24	32	20	35	110	3	8	2	0,25	2	OD .. 0504 .. ODHX0504ZZR
	M5004-032-A25-02-03	24	32	25	35	150	3	8	2	0,51	2	
	M5004-040-A20-03-03	32	40	20	35	110	3	8	3	0,28	3	
	M5004-040-A25-03-03	32	40	25	35	150	3	8	3	0,59	3	
 Shell mill mount DIN 138 transverse keyway	M5004-050-B16-04-03	42	50	16	40		3	8	4	0,38	4	OD .. 0504 .. ODHX0504ZZR
	M5004-050-B16-05-03	42	50	16	40		3	8	5	0,22	5	
	M5004-052-B22-04-03	44	52	22	45		3	8	4	0,42	4	
	M5004-052-B22-05-03	44	52	22	40		3	8	5	0,35	5	
	M5004-058-B16-04-03	50	58	16	40		3	8	4	0,51	4	
	M5004-058-B16-05-03	50	58	16	40		3	8	5	0,3	5	
	M5004-063-B22-05-03	55	63	22	40		3	8	5	0,62	5	
	M5004-063-B22-06-03	55	63	22	40		3	8	6	0,4	6	
	M5004-063-B22-07-03	55	63	22	40		3	8	7	0,39	7	
	M5004-066-B27-06-03	58	66	27	50		3	8	6	0,6	6	
	M5004-066-B27-07-03	58	66	27	50		3	8	7	0,6	7	
	M5004-071-B22-06-03	63	71	22	40		3	8	6	0,72	6	

Bodies and assembly parts are included in the scope of delivery

Assembly parts

	D _c [mm]	24–117
	Clamping screw for indexable insert Tightening torque	FS2119 (T15IP) 3 Nm

Accessories

	D _c [mm]	24–117
	Torque screwdriver, analogue	FS2003
	Torque screwdriver, digital	FS2248
	Interchangeable blade	FS2014 (T15IP)
	Screwdriver	FS1485 (T15IP)

Indexable inserts

	Designation	Tolerance class	Number of cutting edges	r mm	b mm	P				M				K				N		S			H		
						WHH15X	WKP25S	WKP35G	WKP35S	WSP45G	WSM35G	WSM35S	WSM45X	WSP45G	WSN10	WAK15	WHH15X	WKK25G	WKK25S	WKP25S	WKP35G	WKP35S	WXN15	WK10	WSM35G
	ODHT050408-F57	H	8	0,8			⊗	⊗	⊗				⊗				⊗	⊗						⊗	
	ODHW050412-A57	H	8	1,2										⊕											
	ODMT050408-D57	M	8	0,8											⊗	⊗						⊗	⊗		
	ODMW050408-A57	M	8	0,8			⊗	⊗	⊗							⊗	⊗	⊗				⊗	⊗		⊗
	ODMW050408T-A27	M	8	0,8			⊗	⊗	⊗						⊕		⊗	⊗	⊗						
	ODHT0504ZZN-F57	H	8	0,8	1,2		⊕		⊗	⊗	⊗		⊗				⊗	⊗	⊗			⊗	⊗		⊗
	ODHT0504ZZN-G77	H	8	0,8	1,6					⊗				⊗								⊗	⊗		⊗
	ODHT0504ZZN-G88	H	8	0,8	1,2													⊕	⊗						
	ODHW0504ZZN-A57	H	8	0,8	1,2		⊗	⊗	⊗					⊕			⊗	⊗	⊗						
	ODMT0504ZZN-D57	M	8	0,8	1,2		⊕	⊗	⊗	⊗	⊗	⊗	⊗			⊗	⊗	⊗			⊗	⊗	⊗	⊗	
	ODMT0504ZZN-F57	M	8	0,8	1,2		⊕	⊗	⊗	⊗	⊗	⊗	⊗			⊗	⊗	⊗			⊗	⊗		⊗	
 	ODHX0504ZZR-A57	H	1	0,8	7,2	⊕		⊗						⊕	⊕				⊗						⊕

ODHX0504ZZR-A57 wiper insert only in combination with ODH.0504ZZN...

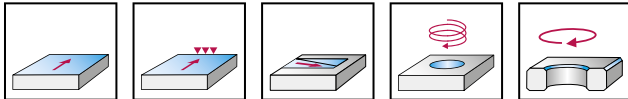
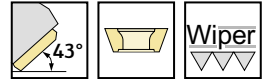
ODHX0504ZZR-A57 wiper insert only in combination with ODH.0504ZZN . .

HC = Coated carbide
CN = Silicon nitride ceramic Si₃N₄
HW = Uncoated carbide

Octagon face milling cutters

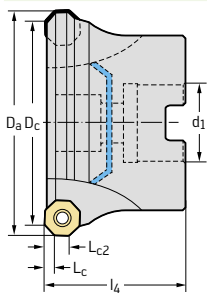
M5004
mm
OD .. 0504 ..; ODHX0504ZZR
Xtra-tec® XT


– 8 cutting edges per indexable insert



	P	M	K	N	S	H	O
M5004	●	●	●	●	●	●	●

Tool



Shell mill mount DIN 138 transverse keyway

Designation

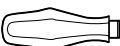
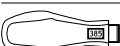
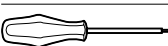
Designation	D _c mm	D _a mm	d ₁ mm	l ₄ mm	l ₁ mm	L _c mm	L _{c2} mm	Z	 kg	No. of indexable inserts	Type
M5004-071-B22-07-03	63	71	22	40		3	8	7	0,48	7	OD .. 0504 .. ODHX0504ZZR
M5004-080-B27-06-03	72	80	27	50		3	8	6	0,88	6	
M5004-080-B27-07-03	72	80	27	50		3	8	7	1,16	7	
M5004-080-B27-08-03	72	80	27	50		3	8	8	0,91	8	
M5004-088-B27-07-03	80	88	27	50		3	8	7	1,05	7	
M5004-088-B27-08-03	80	88	27	50		3	8	8	1,07	8	
M5004-100-B32-08-03	92	100	32	50		3	8	8	1,59	8	
M5004-100-B32-10-03	92	100	32	50		3	8	10	1,57	10	
M5004-108-B32-08-03	100	108	32	50		3	8	8	1,77	8	
M5004-108-B32-10-03	100	108	32	50		3	8	10	1,77	10	
M5004-125-B40-10-03	117	125	40	63		3	8	10	3,07	10	
M5004-125-B40-12-03	117	125	40	63		3	8	12	3	12	

Bodies and assembly parts are included in the scope of delivery

Assembly parts

	D _c [mm]	24–117
	Clamping screw for indexable insert Tightening torque	FS2119 (T15IP) 3 Nm

Accessories

	D _c [mm]	24–117
	Torque screwdriver, analogue	FS2003
	Torque screwdriver, digital	FS2248
	Interchangeable blade	FS2014 (T15IP)
	Screwdriver	FS1485 (T15IP)

Indexable inserts

	Designation	Tolerance class	Number of cutting edges	r mm	b mm	P				M				K				N		S			H			
						WHH15X	WKP25S	WKP35G	WKP35S	WSP45G	WSM35G	WSM35S	WSM45X	WSP45G	WSN10	WAK15	WHH15X	WKK25G	WKK25S	WKP25S	WKP35G	WKP35S	WXN15	WK10	WSM35G	WSM35S
	ODHT050408-F57	H	8	0,8																						
	ODHW050412-A57	H	8	1,2																						
	ODMT050408-D57	M	8	0,8																						
	ODMW050408-A57	M	8	0,8																						
	ODMW050408T-A27	M	8	0,8																						
	ODHT0504ZZN-F57	H	8	0,8	1,2																					
	ODHT0504ZZN-G77	H	8	0,8	1,6																					
	ODHT0504ZZN-G88	H	8	0,8	1,2																					
	ODHW0504ZZN-A57	H	8	0,8	1,2																					
	ODMT0504ZZN-D57	M	8	0,8	1,2																					
	ODMT0504ZZN-F57	M	8	0,8	1,2																					
 	ODHX0504ZZR-A57	H	1	0,8	7,2																					

ODHX0504ZZR-A57 wiper insert only in combination with ODH.0504ZZN...

ODHX0504ZZR-A57 wiper insert only in combination with ODH.0504ZZN . .

HC = Coated carbide
CN = Silicon nitride ceramic Si₃N₄
HW = Uncoated carbide

Octagon face milling cutters

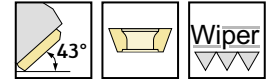
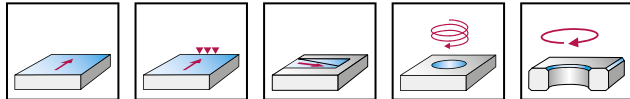
M5004 inch

OD .. 0504 ..; ODHX0504ZZR

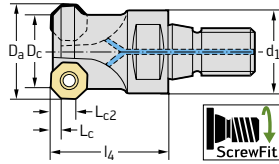
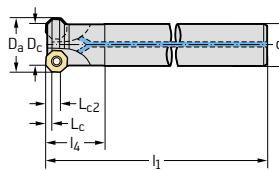
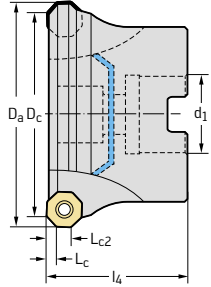
Xtra-tec® XT



– 8 cutting edges per indexable insert

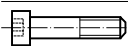


	P	M	K	N	S	H	O
M5004	●	●	●	●	●	●	●

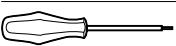
Tool	Designation	D _c inch	D _a inch	d ₁ inch	l ₄ inch	l ₁ inch	L _c inch	L _{c2} inch	Z	lbs	No. of indexable inserts	Type
	M5004.031-T28-02-03	0,935	1,250	T28	1,575		0,118	0,315	2	0,359	2	OD .. 0504 .. ODHX0504ZZR
	M5004.038-T36-03-03	1,185	1,500	T36	1,575		0,118	0,315	3	0,619	3	
ScrewFit												
	M5004.038-A26-03-03	1,185	1,500	1,000	1,500	6,000	0,118	0,315	3	1,219	3	OD .. 0504 .. ODHX0504ZZR
	M5004.046-A31-03-03	1,500	1,815	1,250	1,750	10,000	0,118	0,315	3	3,263	3	
Cylindrical shank												
	M5004.059-B19-04-03	2,000	2,315	0,750	1,575		0,118	0,315	4	0,769	4	OD .. 0504 .. ODHX0504ZZR
	M5004.059-B19-05-03	2,000	2,315	0,750	1,575		0,118	0,315	5	0,778	5	
	M5004.072-B19-06-03	2,500	2,815	0,750	1,575		0,118	0,315	6	1,054	6	
	M5004.072-B19-07-03	2,500	2,815	0,750	1,575		0,118	0,315	7	1,032	7	
	M5004.076-B26-07-03	2,685	3,000	1,000	1,575		0,118	0,315	7	1,400	7	
	M5004.084-B26-07-03	3,000	3,315	1,000	1,575		0,118	0,315	7	1,625	7	
	M5004.084-B26-08-03	3,000	3,315	1,000	1,575		0,118	0,315	8	1,731	8	
Shell mill mount DIN 138 transverse keyway												

Bodies and assembly parts are included in the scope of delivery

Assembly parts

	D _c [inch]	0,935–1,5	2–2,5	2,685–3
	Clamping screw for indexable insert Tightening torque	FS2119 (T15IP) 2,213 lbs	FS2119 (T15IP) 2,213 lbs	FS2119 (T15IP) 2,213 lbs
	Clamping screw for arbour-mounted tools		FS1518	FS1519

Accessories

	D _c [inch]	0,935–3
	Torque screwdriver, analogue	FS2004
	Torque screwdriver, digital	FS2248
	Interchangeable blade	FS2014 (T15IP)
	Screwdriver	FS1485 (T15IP)

Indexable inserts

	Designation	Tolerance class	Number of cutting edges	r inch	b inch	P				M				CN	K				N		S				H
						WHH15X	WKP25S	WKP35G	WKP35S	WSP45G	WSM35G	WSM35S	WSM45X		WSP45G	HC	HC	HC	HC	HC	HW	HC	HC	HC	
	ODHT050408-F57	H	8	0,031			⊕	⊕	⊗				⊗											⊗	
	ODHW050412-A57	H	8	0,047										⊕											
	ODMT050408-D57	M	8	0,031			⊕	⊕	⊗			⊕			⊕	⊕	⊕				⊕	⊕		⊗	
	ODMW050408-A57	M	8	0,031			⊕	⊕	⊗			⊕				⊕	⊕	⊕				⊕	⊕		⊗
	ODMW050408T-A27	M	8	0,031			⊕	⊕	⊗						⊕		⊕	⊕	⊕						
	ODHT0504ZZN-F57	H	8	0,031	0,047		⊕	⊕	⊗	⊗	⊕	⊕		⊗					⊗	⊗	⊗			⊗	
	ODHT0504ZZN-G77	H	8	0,031	0,063					⊕		⊕		⊕										⊕	
	ODHT0504ZZN-G88	H	8	0,031	0,047														⊕	⊕					
	ODHW0504ZZN-A57	H	8	0,031	0,047		⊕	⊕	⊗					⊕				⊕	⊕	⊕					
	ODMT0504ZZN-D57	M	8	0,031	0,047		⊕	⊕	⊗	⊗	⊕	⊕	⊗				⊕	⊕	⊕			⊕	⊕	⊗	
	ODMT0504ZZN-F57	M	8	0,031	0,047		⊕	⊕	⊗	⊗	⊕	⊕		⊗				⊕	⊕	⊕				⊗	
	ODHX0504ZZR-A57	H	1	0,031	0,283	⊕			⊗						⊕	⊕			⊗						⊕

ODHX0504ZZR-A57 wiper insert only in combination with ODH.0504ZZN...
 ODHX0504ZZR-A57 wiper insert only in combination with ODH.0504ZZN . .

HC = Coated carbide
 CN = Silicon nitride ceramic Si₃N₄
 HW = Uncoated carbide

Octagon face milling cutters

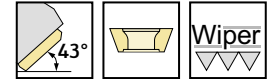
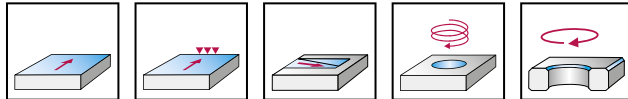
M5004 mm

OD .. 0605 ..; ODHX0605ZZR

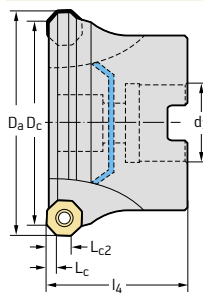
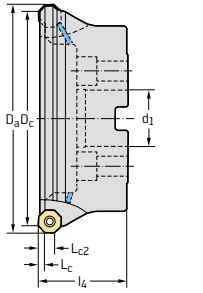
Xtra-tec® XT



– 8 cutting edges per indexable insert



	P	M	K	N	S	H	O
M5004	●	●	●	●	●	●	●

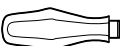
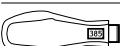
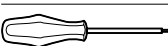
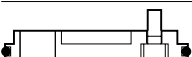
Tool	Designation	D _c mm	D _a mm	d ₁ mm	l ₄ mm	L _c mm	L _{c2} mm	Z	kg	No. of indexable inserts	Type
 Shell mill mount DIN 138 transverse keyway	M5004-050-B16-03-04	40	50	16	40	4	10	3	0,19	3	OD .. 0605 .. ODHX0605ZZR
	M5004-052-B22-03-04	42	52	22	45	4	10	3	0,29	3	
	M5004-060-B16-03-04	50	60	16	40	4	10	3	0,29	3	
	M5004-063-B22-04-04	53	63	22	40	4	10	4	0,38	4	
	M5004-063-B22-05-04	53	63	22	40	4	10	5	0,34	5	
	M5004-063-B22-06-04	53	63	22	40	4	10	6	0,35	6	
	M5004-066-B27-05-04	56	66	27	50	4	10	5	0,63	5	
	M5004-066-B27-06-04	56	66	27	50	4	10	6	0,83	6	
	M5004-073-B22-05-04	63	73	22	40	4	10	5	0,48	5	
	M5004-073-B22-06-04	63	73	22	40	4	10	6	0,45	6	
	M5004-080-B27-05-04	70	80	27	50	4	10	5	0,85	5	
	M5004-080-B27-06-04	70	80	27	50	4	10	6	0,85	6	
	M5004-080-B27-07-04	70	80	27	50	4	10	7	0,82	7	
	M5004-090-B27-06-04	80	90	27	50	4	10	6	1	6	
	M5004-090-B27-07-04	80	90	27	50	4	10	7	0,99	7	
	M5004-100-B32-07-04	90	100	32	50	4	10	7	1,44	7	
	M5004-100-B32-09-04	90	100	32	50	4	10	9	1,4	9	
	M5004-110-B32-07-04	100	110	32	50	4	10	7	1,64	7	
	M5004-110-B32-09-04	100	110	32	50	4	10	9	1,69	9	
	M5004-125-B40-08-04	115	125	40	63	4	10	8	2,79	8	
	M5004-125-B40-10-04	115	125	40	63	4	10	10	2,8	10	
	M5004-135-B40-08-04	125	135	40	63	4	10	8	3,16	8	
	M5004-135-B40-10-04	125	135	40	63	4	10	10	3,1	10	
 Shell mill mount DIN 138 transverse keyway	M5004-160-B40-09-04	150	160	40	63	4	10	9	4,23	9	OD .. 0605 .. ODHX0605ZZR
	M5004-160-B40-11-04	150	160	40	63	4	10	11	4,22	11	
	M5004-170-B40-09-04	160	170	40	63	4	10	9	4,71	9	
	M5004-170-B40-11-04	160	170	40	63	4	10	11	4,66	11	

Bodies and assembly parts are included in the scope of delivery

Assembly parts

	D _c [mm]	40–160
	Clamping screw for indexable insert Tightening torque	FS1495 (T20IP) 5 Nm

Accessories

	D _c [mm]	40–125	150–160
	Torque screwdriver, analogue	FS2003	FS2003
	Torque screwdriver, digital	FS2248	FS2248
	Interchangeable blade	FS2015 (T20IP)	FS2015 (T20IP)
	Screwdriver	FS1486 (T20IP)	FS1486 (T20IP)
	Sealing disc set (incl. gasket and screws)		FS936 COMPLETE SET
	Gasket		O-R 96X4

Indexable inserts

	Designation	Tolerance class	Number of cutting edges	r mm	b mm	P				M				CN	K						N		S				H		
						WHH15X	WKP25S	WKP35G	WKP35S	WSP45G	WSM35G	WSM35S	WSM45X		WSP45G	HC	HC	HC	HC	HC	HC	HC	HC	HC	HC	HC		HC	HC
	ODHT060512-F57	H	8	1.2																									
	ODHW060516-A57	H	8	1.6																									
	ODMT060512-D57	M	8	1.2																									
	ODMW060508-A57	M	8	0.8																									
	ODMW060508T-A27	M	8	0.8																									
	ODHT0605ZZN-F57	H	8	0.8	1.6																								
	ODHT0605ZZN-G77	H	8	0.8	1.6																								
	ODHT0605ZZN-G88	H	8	0.8	1.6																								
	ODHW0605ZZN-A57	H	8	0.8	1.6																								
	ODMT0605ZZN-D57	M	8	0.8	1.6																								
	ODMT0605ZZN-F57	M	8	0.8	1.6																								
	ODHX0605ZZR-A57	H	1	0.8	9.4																								

ODHX0605ZZR-A57 wiper insert only in combination with ODH.0605ZZN . .

HC = Coated carbide
CN = Silicon nitride ceramic Si₃N₄
HW = Uncoated carbide

Octagon face milling cutters

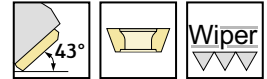
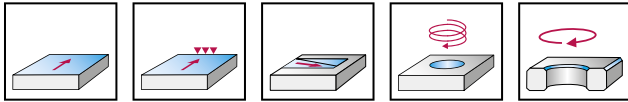
M5004 inch

OD .. 0605 ..; ODHX0605ZZR

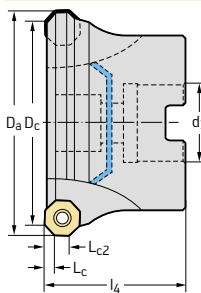
Xtra-tec® XT



– 8 cutting edges per indexable insert



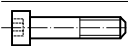
	P	M	K	N	S	H	O
M5004	●	●	●	●	●	●	●

Tool	Designation	D _c inch	D _a inch	d ₁ inch	l ₄ inch	L _c inch	L _{c2} inch	Z	lbs	No. of indexable inserts	Type
	M5004.086-B26-06-04	3,000	3,394	1,000	1,969	0,157	0,394	6	2,088	6	OD .. 0605 .. ODHX0605ZZR
	M5004.086-B26-07-04	3,000	3,394	1,000	1,969	0,157	0,394	7	2,07	7	
	M5004.112-B38-07-04	4,000	4,394	1,500	2,48	0,157	0,394	7	5,955	7	
	M5004.112-B38-09-04	4,000	4,394	1,500	2,48	0,157	0,394	9	5,82	9	
	M5004.137-B38-08-04	5,000	5,394	1,500	2,48	0,157	0,394	8	7,974	8	
	M5004.137-B38-09-04	5,000	5,394	1,500	2,48	0,157	0,394	9	7,848	9	
	M5004.162-B38-09-04	6,000	6,394	1,500	2,48	0,157	0,394	9	9,824	9	
	M5004.162-B38-10-04	6,000	6,394	1,500	2,48	0,157	0,394	10	10,183	10	

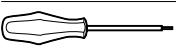
Shell mill mount DIN 138 transverse keyway

Bodies and assembly parts are included in the scope of delivery

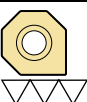
Assembly parts

	D _c [inch]	3	4-6
	Clamping screw for indexable insert Tightening torque	FS1495 (T20IP) 3,688 lbs	FS1495 (T20IP) 3,688 lbs
	Clamping screw for arbour-mounted tools	FS1519	FS1583

Accessories

	D _c [inch]	3-6
	Torque screwdriver, analogue	FS2004
	Torque screwdriver, digital	FS2248
	Interchangeable blade	FS2015 (T20IP)
	Screwdriver	FS1486 (T20IP)

Indexable inserts

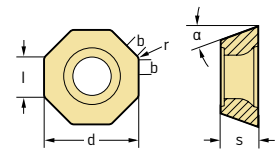
	Designation	Tolerance class	Number of cutting edges	r inch	b inch	P				M				CN	K				N		S				H				
						WHH15X	WKP25S	WKP35G	WKP35S	WSP45G	WSM35G	WSM35S	WSM45X		WSP45G	WSN10	WAK15	WHH15X	WKK25G	WKK25S	WKP25S	WKP35G	WKP35S	WCN15		WK10	WSM35G	WSM35S	WSM45X
	ODHT060512-F57	H	8	0,047																									
	ODHW060516-A57	H	8	0,063																									
	ODMT060512-D57	M	8	0,047																									
	ODMW060508-A57	M	8	0,031																									
	ODMW060508T-A27	M	8	0,031																									
	ODHT0605ZZN-F57	H	8	0,031	0,063																								
	ODHT0605ZZN-G77	H	8	0,031	0,063																								
	ODHT0605ZZN-G88	H	8	0,031	0,063																								
	ODHW0605ZZN-A57	H	8	0,031	0,063																								
	ODMT0605ZZN-D57	M	8	0,031	0,063																								
	ODMT0605ZZN-F57	M	8	0,031	0,063																								
	ODHX0605ZZR-A57	H	1	0,031	0,37																								

ODHX0605ZZR-A57 wiper insert only in combination with ODH.0605ZZN . .

HC = Coated carbide
CN = Silicon nitride ceramic Si₃N₄
HW = Uncoated carbide

Positive octagonal ODHW / ODHT / ODMT / ODMW

Tiger-tec® Gold



Indexable inserts

Designation		Tolerance class	Number of cutting edges	s mm	d mm	l mm	r mm	α	b mm	P HC				M HC				K HC					CN	N		S		
										WKP25S	WKP35G	WKP35S	WSP45G	WSM35G	WSM35S	WSM45X	WSP45G	WAK15	WKK25G	WKK25S	WKP25S	WKP35G		WKP35S	WXN10	WXN15	WK10	WSM35G
	ODHW050412-A57	H	8	4,76	12,7	5,26	1,2	15°													⊕							
	ODHW060516-A57	H	8	5,56	15,88	6,58	1,6	15°													⊕							
	ODHT050408-F57	H	8	4,76	12,7	5,26	0,8	15°			⊗	⊗	⊗				⊗				⊗	⊗					⊗	
	ODHT060512-F57	H	8	5,56	15,88	6,58	1,2	15°				⊗	⊗	⊗			⊗				⊗	⊗					⊗	
	ODHW0504ZZN-A57	H	8	4,76	12,7	5,26	0,8	15°	1,2	⊗	⊗	⊗	⊗					⊕			⊗	⊗	⊗					
	ODHW0605ZZN-A57	H	8	5,56	15,88	6,58	0,8	15°	1,6	⊗	⊗	⊗	⊗					⊕			⊗	⊗	⊗					
	ODHT0504ZZN-F57	H	8	4,76	12,7	5,26	0,8	15°	1,2	⊕	⊗	⊗	⊗	⊗	⊗	⊗	⊗				⊗	⊗	⊗			⊗	⊗	
	ODHT0605ZZN-F57	H	8	5,56	15,88	6,58	0,8	15°	1,6	⊕	⊗	⊗	⊗	⊗	⊗	⊗	⊗				⊗	⊗	⊗			⊗	⊗	
	ODHT0504ZZN-G77	H	8	4,76	12,7	5,26	0,8	15°	1,6				⊗				⊗										⊗	
	ODHT0605ZZN-G77	H	8	5,56	15,88	6,58	0,8	15°	1,6				⊗				⊗										⊗	
	ODHT0504ZZN-G88	H	8	4,76	12,7	5,26	0,8	15°	1,2													⊕	⊗					
	ODHT0605ZZN-G88	H	8	5,56	15,88	6,58	0,8	15°	1,6													⊕	⊗					
	ODMT0504ZZN-F57	M	8	4,76	12,7	5,26	0,8	15°	1,2	⊕	⊗	⊗	⊗	⊗	⊗	⊗	⊗				⊗	⊗	⊗			⊗	⊗	
	ODMT0605ZZN-F57	M	8	5,56	15,88	6,58	0,8	15°	1,6	⊕	⊗	⊗	⊗	⊗	⊗	⊗	⊗				⊗	⊗	⊗			⊗	⊗	
	ODMT050408-D57	M	8	4,76	12,7	5,26	0,8	15°			⊗	⊗	⊗	⊗	⊗	⊗	⊗		⊗	⊗					⊗	⊗	⊗	
	ODMT060512-D57	M	8	5,56	15,88	6,58	1,2	15°			⊗	⊗	⊗	⊗	⊗	⊗	⊗		⊗	⊗					⊗	⊗	⊗	
	ODMT0504ZZN-D57	M	8	4,76	12,7	5,26	0,8	15°	1,2	⊕	⊗	⊗	⊗	⊗	⊗	⊗	⊗		⊗	⊗	⊗	⊗	⊗			⊗	⊗	
	ODMT0605ZZN-D57	M	8	5,56	15,88	6,58	0,8	15°	1,6	⊕	⊗	⊗	⊗	⊗	⊗	⊗	⊗		⊗	⊗	⊗	⊗	⊗			⊗	⊗	
	ODMW050408T-A27	M	8	4,76	12,7	5,26	0,8	15°			⊗	⊗	⊗						⊗	⊗	⊗	⊗	⊗					
	ODMW060508T-A27	M	8	5,56	15,88	6,58	0,8	15°			⊗	⊗	⊗						⊗	⊗	⊗	⊗	⊗					
	ODMW050408-A57	M	8	4,76	12,7	5,26	0,8	15°			⊗	⊗	⊗					⊕	⊗	⊗	⊗	⊗	⊗					
	ODMW060508-A57	M	8	5,56	15,88	6,58	0,8	15°			⊗	⊗	⊗					⊕	⊗	⊗	⊗	⊗	⊗					

Ordering example for the WSN10 grade: ODHW050412-A57 WSN10

HC = Coated carbide
CN = Silicon nitride ceramic Si₃N₄
HW = Uncoated carbide



Face milling cutters

M5009

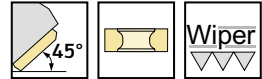
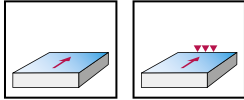
mm

SN . X0904 ..; XNGX0904ANN

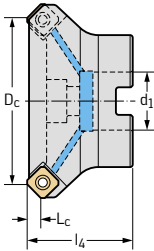
Xtra-tec® XT



– 8 cutting edges per indexable insert



	P	M	K	N	S	H	O
M5009	●	●	●	●	●	●	●

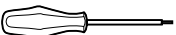
Tool	Designation	D _c mm	d ₁ mm	l ₄ mm	L _c mm	Z	kg	No. of indexable inserts	Type
 Shell mill mount DIN 138 transverse keyway	M5009-040-B16-04-05	40	16	40	5	4	0,3	4	SN . X0904 .. XNGX0904ANN
	M5009-040-B16-06-05	40	16	40	5	6	0,29	6	
	M5009-050-B22-06-05	50	22	40	5	6	0,44	6	
	M5009-050-B22-08-05	50	22	40	5	8	0,43	8	
	M5009-063-B22-07-05	63	22	40	5	7	0,56	7	
	M5009-063-B22-09-05	63	22	40	5	9	0,56	9	
	M5009-080-B27-08-05	80	27	50	5	8	1,36	8	
	M5009-080-B27-11-05	80	27	50	5	11	1,36	11	
	M5009-100-B32-09-05	100	32	50	5	9	1,85	9	
	M5009-100-B32-13-05	100	32	50	5	13	1,83	13	

Bodies and assembly parts are included in the scope of delivery

Assembly parts

	D _c [mm]	40–100
	Clamping screw for indexable insert Tightening torque	FS2579 (T8IP) 1,2 Nm

Accessories

	D _c [mm]	40–100
	Torque screwdriver, analogue	FS2001
	Torque screwdriver, digital	FS2248
	Interchangeable blade	FS2012 (T8IP)
	Screwdriver	FS1483 (T8IP)

Indexable inserts

		Tolerance class	Number of cutting edges	r mm	b mm	P					M				K						N		S			H
						HC					HC				HC						HC	HW	HC			H
						WHH15X	WKP25S	WKP35G	WKP35S	WSP45G	WXM15	WSM35G	WSM35S	WSP45G	WXM15	WAK15	WHH15X	WKK25G	WKK25S	WKP25S	WKP35G	WKP35S	WXM15	WXN15	WK10	WSM35G
Designation		G	8	0,4	1,2	☺	☺	☺	☺	☺	☺			☺	☺	☺	☺	☺	☺		☺	☺		☺	☺	
	SNGX0904ANN-F57	G	8	0,4	1,2		☺	☺	☺	☺				☺	☺	☺		☺	☺				☺	☺	☺	
	SNGX0904ANN-F67	G	8	0,4	1,2			☺	☺	☺	☺						☺	☺	☺				☺	☺	☺	
	SNHX0904ANN-K88	H	8	0,4	1,5																☺	☺				
	SNMX0904ANN-F27	M	8	0,4	1,2		☺	☺	☺								☺	☺	☺	☺						
	SNMX0904ANN-F57	M	8	0,4	1,2		☺	☺	☺	☺					☺	☺		☺	☺	☺	☺			☺	☺	
	SNMX0904ANN-F67	M	8	0,4	1,2			☺	☺	☺	☺							☺	☺	☺				☺	☺	
	SNMX090408-F27	M	8	0,8			☺	☺	☺							☺	☺	☺	☺							
	SNMX090408-F57	M	8	0,8			☺	☺	☺	☺					☺	☺		☺	☺	☺			☺	☺		
	SNMX090408-F67	M	8	0,8			☺	☺	☺	☺							☺	☺	☺				☺	☺		
	XNGX0904ANN-F67	G	2	0,4	5	☺					☺			☺	☺	☺				☺					☺	

XNGX0904ANN-F67 wiper insert only in combination with SNGX0904ANN...

HC = Coated carbide
HW = Uncoated carbide

Face milling cutters

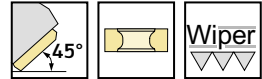
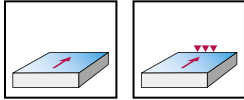
M5009 inch

SN . X0904 ..; XNGX0904ANN

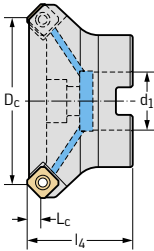
Xtra-tec® XT



– 8 cutting edges per indexable insert

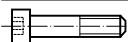


	P	M	K	N	S	H	O
M5009	●	●	●	●	●	●	●

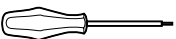
Tool	Designation	D _c inch	d ₁ inch	l ₄ inch	L _c inch	Z	lbs	No. of indexable inserts	Type
 Shell mill mount DIN 138 transverse keyway	M5009.038-B19-04-05	1,500	0,750	1,500	0,197	4	0,573	4	SN . X0904 .. XNGX0904ANN
	M5009.038-B19-06-05	1,500	0,750	1,500	0,197	6	0,551	6	
	M5009.051-B19-06-05	2,000	0,750	1,500	0,197	6	0,882	6	
	M5009.051-B19-08-05	2,000	0,750	1,500	0,197	8	0,882	8	
	M5009.064-B26-07-05	2,500	1,000	2,000	0,197	7	1,874	7	
	M5009.064-B26-09-05	2,500	1,000	2,000	0,197	9	1,830	9	
	M5009.076-B26-08-05	3,000	1,000	2,000	0,197	8	2,381	8	
	M5009.076-B26-11-05	3,000	1,000	2,000	0,197	11	2,906	11	
	M5009.102-B38-09-05	4,000	1,500	2,500	0,197	9	6,526	9	

Bodies and assembly parts are included in the scope of delivery

Assembly parts

	D _c [inch]	1,5–2	2,5–3	4
	Clamping screw for indexable insert Tightening torque	FS2579 (T8IP) 0,885 lbs	FS2579 (T8IP) 0,885 lbs	FS2579 (T8IP) 0,885 lbs
	Clamping screw for arbour-mounted tools	FS1518	FS1519	FS1583

Accessories

	D _c [inch]	1,5–4
	Torque screwdriver, analogue	FS2002
	Torque screwdriver, digital	FS2248
	Interchangeable blade	FS2012 (T8IP)
	Screwdriver	FS1483 (T8IP)

Indexable inserts

		Tolerance class	Number of cutting edges	r inch	b inch	P HC					M HC				K HC						N HC HW		S HC		H HC				
						WHH15X	WKP25S	WKP35G	WKP35S	WSP45G	WXM15	WSM35G	WSM35S	WSP45G	WXM15	WAK15	WHH15X	WKK25G	WKK25S	WKP25S	WKP35G	WKP35S	WXM15	WXN15	WK10	WSM35G	WSM35S	WSP45G	WHH15X
Designation																													
	SNGX0904ANN-F57	G	8	0,016	0,047	☺	☺	☺	☺	☺					☺	☺	☺	☺	☺					☺	☺				
	SNGX0904ANN-F67	G	8	0,016	0,047		☺	☺	☺	☺		☺	☺	☺					☺	☺			☺	☺	☺				
	SNHX0904ANN-K88	H	8	0,016	0,059																☺	☺							
	SNMX0904ANN-F27	M	8	0,016	0,047	☺	☺	☺	☺									☺	☺	☺									
	SNMX0904ANN-F57	M	8	0,016	0,047	☺	☺	☺	☺			☺	☺		☺	☺	☺	☺	☺					☺	☺				
	SNMX0904ANN-F67	M	8	0,016	0,047		☺	☺	☺	☺		☺	☺	☺				☺	☺	☺				☺	☺	☺			
	SNMX090408-F27	M	8	0,031		☺	☺	☺	☺								☺	☺	☺					☺	☺	☺			
	SNMX090408-F57	M	8	0,031		☺	☺	☺	☺			☺	☺	☺		☺	☺	☺	☺					☺	☺	☺			
	SNMX090408-F67	M	8	0,031		☺	☺	☺	☺			☺	☺	☺			☺	☺	☺					☺	☺	☺			
	XNGX0904ANN-F67	G	2	0,016	0,197	☺					☺				☺	☺	☺				☺					☺			

XNGX0904ANN-F67 wiper insert only in combination with SNGX0904ANN...

HC = Coated carbide
HW = Uncoated carbide

Face milling cutters

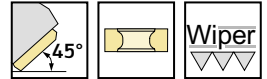
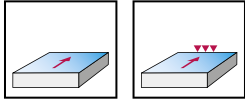
M5009 mm

SN . X1205 ..; XNGX1205ANN

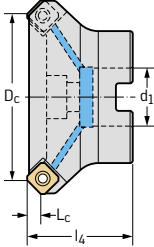
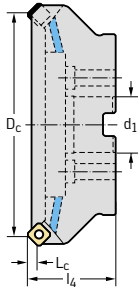
Xtra-tec® XT



– 8 cutting edges per indexable insert



	P	M	K	N	S	H	O
M5009	●	●	●	●	●	●	●

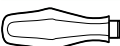
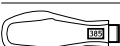
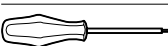
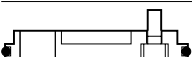
Tool	Designation	D _c mm	d ₁ mm	l ₄ mm	L _c mm	Z	kg	No. of indexable inserts	Type
	M5009-050-B22-06-06	50	22	40	6	6	0,49	6	SN . X1205 .. XNGX1205ANN
	M5009-063-B22-08-06	63	22	40	6	8	0,54	8	
	M5009-063-B27-08-06	63	27	50	6	8	0,8	8	
	M5009-080-B27-10-06	80	27	50	6	10	1,15	10	
	M5009-100-B32-12-06	100	32	50	6	12	1,79	12	
Shell mill mount DIN 138 transverse keyway									
	M5009-125-B40-16-06	125	40	63	6	16	3,34	16	SN . X1205 .. XNGX1205ANN
	M5009-160-B40-20-06	160	40	63	6	20	5,05	20	
Shell mill mount DIN 138 transverse keyway									

Bodies and assembly parts are included in the scope of delivery

Assembly parts

	D _c [mm]	50–160
	Clamping screw for indexable insert Tightening torque	FS1459 (T15IP) 4 Nm

Accessories

	D _c [mm]	50–125	160
	Torque screwdriver, analogue	FS2003	FS2003
	Torque screwdriver, digital	FS2248	FS2248
	Interchangeable blade	FS2014 (T15IP)	FS2014 (T15IP)
	Screwdriver	FS1485 (T15IP)	FS1485 (T15IP)
	Sealing disc set (incl. gasket and screws)		FS936 COMPLETE SET
	Gasket		O-R 96X4

Indexable inserts

	Designation	Tolerance class	Number of cutting edges	r mm	b mm	P					M				K					N		S		H			
						HC					HC				HC					HC	HW	HC	HC				
						WHH15X	WKP25S	WKP35G	WKP35S	WSP45G	WXM15	WSM35G	WSM35S	WSP45G	WXM15	WAK15	WHH15X	WKK25G	WKK25S	WKP25S	WKP35G	WKP35S	WXM15		WXN15	WK10	WSM35G
	SNGX120512-F57	G	8	1,2		☺	☺	☺	☺	☺	☺	☺	☺					☺	☺	☺	☺		☺	☺	☺		
	SNMX120512-D27	M	8	1,2		☺	☺	☺	☺									☺	☺	☺	☺						
	SNMX120520-D27	M	8	2		☺	☺	☺										☺	☺	☺	☺						
	SNMX120512-F27	M	8	1,2		☺		☺												☺		☺					
	SNMX120512-F57	M	8	1,2			☺	☺	☺	☺		☺	☺	☺				☺	☺	☺	☺			☺	☺	☺	
	SNMX120520-F57	M	8	2			☺	☺	☺	☺		☺	☺	☺				☺	☺	☺	☺			☺	☺	☺	
	SNMX120512-F67	M	8	1,2			☺	☺	☺	☺		☺	☺	☺		☺			☺	☺	☺	☺			☺	☺	☺
	SNGX1205ANN-F27	G	8	0,8	1,5		☺	☺	☺			☺	☺	☺					☺	☺	☺	☺					
	SNGX1205ANN-F57	G	8	0,8	1,5		☺	☺	☺	☺		☺	☺	☺				☺	☺	☺	☺			☺	☺	☺	
	SNGX1205ANN-F67	G	8	0,8	1,5		☺	☺	☺	☺		☺	☺	☺		☺				☺	☺	☺			☺	☺	☺
	SNHX1205ANN-K88	H	8	0,8	1,5																			☺	☺		
	SNMX1205ANN-F27	M	8	0,8	1,5		☺	☺	☺											☺	☺	☺					
	SNMX1205ANN-F57	M	8	0,8	1,5		☺	☺	☺									☺	☺	☺	☺						
	SNMX1205ANN-F67	M	8	0,8	1,5		☺	☺	☺									☺	☺	☺	☺						
	XNGX1205ANN-F67	G	2	1,2	4,7	☺					☺				☺	☺	☺						☺				☺

XNGX1205ANN-F67 wiper insert only in combination with SNGX1205ANN . .

HC = Coated carbide
HW = Uncoated carbide

Face milling cutters

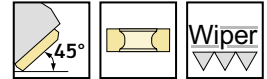
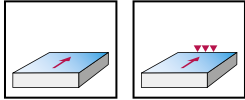
M5009 inch

SN . X1205 ..; XNGX1205ANN

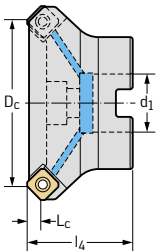
Xtra-tec® XT



– 8 cutting edges per indexable insert

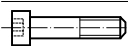


	P	M	K	N	S	H	O
M5009	●	●	●	●	●	●	●

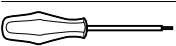
Tool	Designation	D _c inch	d ₁ inch	l ₄ inch	L _c inch	Z	 lbs	No. of indexable inserts	Type
	M5009.051-B19-06-06	2,000	0,750	1,500	0,236	6	0,864	6	SN . X1205 .. XNGX1205ANN
	M5009.064-B26-08-06	2,500	1,000	2,000	0,236	8	1,757	8	
	M5009.076-B26-09-06	3,000	1,000	2,000	0,236	9	2,379	9	
	M5009.102-B38-12-06	4,000	1,500	2,500	0,236	12	6,118	12	
	M5009.127-B38-16-06	5,000	1,500	2,500	0,236	16	8,104	16	
	M5009.152-B38-19-06	6,000	1,500	2,500	0,236	19	10,251	19	
Shell mill mount DIN 138 transverse keyway									

Bodies and assembly parts are included in the scope of delivery

Assembly parts

	D _c [inch]	2	2,5–3	4–6
	Clamping screw for indexable insert Tightening torque	FS1459 (T15IP) 2,95 lbs	FS1459 (T15IP) 2,95 lbs	FS1459 (T15IP) 2,95 lbs
	Clamping screw for arbour-mounted tools	FS1518	FS1519	FS1583

Accessories

	D _c [inch]	2–6
	Torque screwdriver, analogue	FS2003
	Torque screwdriver, digital	FS2248
	Interchangeable blade	FS2014 (T15IP)
	Screwdriver	FS1485 (T15IP)

Indexable inserts

		Tolerance class	Number of cutting edges	r inch	b inch	P					M				K						N		S		H			
						HC					HC				HC						HC	HW	HC	HC				
						WHH15X	WKP25S	WKP35G	WKP35S	WSP45G	WXM15	WSM35G	WSM35S	WSP45G	WXM15	WAK15	WHH15X	WKK25G	WKK25S	WKP25S	WKP35G	WKP35S	WXM15	WXN15		WK10	WSM35G	WSM35S
	Designation	G	8	0,047		☺	☺	☺	☺	☺		☺	☺	☺					☺	☺	☺			☺	☺	☺		
	SNMX120512-D27	M	8	0,047		☺	☺	☺	☺										☺	☺	☺	☺			☺	☺	☺	
	SNMX120520-D27	M	8	0,079		☺	☺	☺											☺	☺	☺	☺				☺	☺	
	SNMX120512-F27	M	8	0,047		☺		☺											☺		☺				☺	☺	☺	
	SNMX120512-F57	M	8	0,047		☺	☺	☺	☺	☺			☺	☺	☺				☺	☺	☺	☺			☺	☺	☺	
	SNMX120520-F57	M	8	0,079		☺	☺	☺	☺	☺			☺	☺	☺				☺	☺	☺	☺			☺	☺	☺	
	SNMX120512-F67	M	8	0,047		☺	☺	☺	☺	☺			☺	☺	☺		☺			☺	☺	☺			☺	☺	☺	
	SNGX1205ANN-F27	G	8	0,031	0,059	☺	☺	☺	☺										☺	☺	☺				☺	☺	☺	
	SNGX1205ANN-F57	G	8	0,031	0,059	☺	☺	☺	☺			☺	☺	☺					☺	☺	☺	☺			☺	☺	☺	
	SNGX1205ANN-F67	G	8	0,031	0,059	☺	☺	☺	☺			☺	☺	☺		☺			☺	☺	☺				☺	☺	☺	
	SNHX1205ANN-K88	H	8	0,031	0,059																	☺	☺					
	SNMX1205ANN-F27	M	8	0,031	0,059	☺	☺	☺	☺										☺	☺	☺	☺				☺	☺	
	SNMX1205ANN-F57	M	8	0,031	0,059	☺	☺	☺	☺										☺	☺	☺	☺				☺	☺	
	SNMX1205ANN-F67	M	8	0,031	0,059	☺	☺	☺	☺								☺			☺	☺	☺				☺	☺	
	XNGX1205ANN-F67	G	2	0,047	0,185	☺					☺				☺	☺	☺					☺					☺	

XNGX1205ANN-F67 wiper insert only in combination with SNGX1205ANN . .

HC = Coated carbide
HW = Uncoated carbide

Face milling cutters

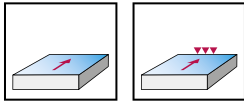
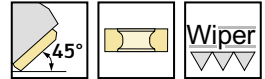
M5009 mm

SN . X1205 ..; XNGX1205ANN

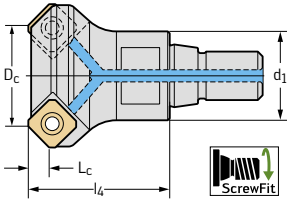
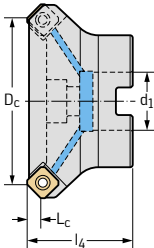
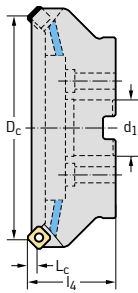
Xtra-tec® XT



– 8 cutting edges per indexable insert



	P	M	K	N	S	H	O
M5009	●	●	●	●	●	●	●

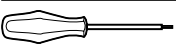
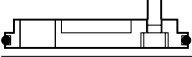
Tool	Designation	D _c mm	d ₁ mm	l ₄ mm	L _c mm	Z	kg	No. of indexable inserts	Type
 ScrewFit	M5009-040-T36-04-06-AP	40	T36	40	6	4	0,37	4	SN . X1205 .. XNGX1205ANN
 Shell mill mount DIN 138 transverse keyway	M5009-050-B22-04-06-AP	50	22	40	6	4	0,61	4	SN . X1205 .. XNGX1205ANN
	M5009-063-B22-06-06-AP	63	22	40	6	6	0,79	6	
	M5009-063-B27-06-06-AP	63	27	50	6	6	0,8	6	
	M5009-080-B27-05-06-AP	80	27	50	6	5	1,22	5	
	M5009-080-B27-07-06-AP	80	27	50	6	7	1,39	7	
	M5009-100-B32-06-06-AP	100	32	50	6	6	1,87	6	
	M5009-100-B32-08-06-AP	100	32	50	6	8	2,69	8	
 Shell mill mount DIN 138 transverse keyway	M5009-125-B40-07-06-AP	125	40	63	6	7	4,68	7	SN . X1205 .. XNGX1205ANN
	M5009-125-B40-10-06-AP	125	40	63	6	10	3,38	10	
	M5009-160-B40-08-06-AP	160	40	63	6	8	5,19	8	
	M5009-160-B40-12-06-AP	160	40	63	6	12	5,1	12	

M5009...-AP with carbide shim | Bodies and assembly parts are included in the scope of delivery

Assembly parts

	D _c [mm]	40–160
	Shim for indexable insert	AP800-SN1205 H81
	Clamping screw for shim	FS2069 (SW 4)
	Clamping screw for indexable insert Tightening torque	FS2617 (T15IP) 4 Nm

Accessories

	D _c [mm]	40–125	160
	Torque screwdriver, analogue	FS2003	FS2003
	Torque screwdriver, digital	FS2248	FS2248
	Interchangeable blade	FS2014 (T15IP)	FS2014 (T15IP)
	Screwdriver	FS1485 (T15IP)	FS1485 (T15IP)
	Key for screw for shim	ISO2936-4 (SW 4)	ISO2936-4 (SW 4)
	Sealing disc set (incl. gasket and screws)		FS936 COMPLETE SET
	Gasket		O-R 96X4

Indexable inserts

	Designation	Tolerance class	Number of cutting edges	r mm	b mm	P					M				K						N			S			H				
						HC					HC				HC						HC			HW	HC			HC			
						WHH15X	WKP25S	WKP35G	WKP35S	WSP45G	WXM15	WSM35G	WSM35S	WSP45G	WXM15	WAK15	WHH15X	WKK25G	WKK25S	WKP25S	WKP35G	WKP35S	WXM15	WXN15	WK10	WSM35G	WSM35S	WSP45G	WHH15X		
	SNGX120512-F57	G	8	1,2		⊗	⊗	⊗	⊗	⊗		⊗	⊗	⊗						⊗	⊗	⊗				⊗	⊗	⊗			
	SNMX120512-D27	M	8	1,2		⊗	⊗	⊗	⊗									⊗	⊗	⊗	⊗	⊗					⊗	⊗			
	SNMX120520-D27	M	8	2		⊗	⊗	⊗											⊗	⊗	⊗	⊗	⊗					⊗			
	SNMX120512-F27	M	8	1,2		⊗	⊗		⊗											⊗	⊗		⊗					⊗	⊗		
	SNMX120512-F57	M	8	1,2		⊗	⊗	⊗	⊗	⊗			⊗	⊗	⊗				⊗		⊗	⊗					⊗	⊗	⊗		
	SNMX120520-F57	M	8	2			⊗	⊗	⊗	⊗	⊗			⊗	⊗				⊗	⊗	⊗	⊗	⊗				⊗	⊗	⊗		
	SNMX120512-F67	M	8	1,2		⊗	⊗	⊗	⊗	⊗			⊗	⊗		⊗				⊗	⊗	⊗				⊗	⊗	⊗			
	SNGX1205ANN-F27	G	8	0,8	1,5	⊗	⊗	⊗	⊗				⊗	⊗	⊗					⊗	⊗	⊗					⊗	⊗	⊗		
	SNGX1205ANN-F57	G	8	0,8	1,5	⊗	⊗	⊗	⊗	⊗			⊗	⊗	⊗			⊗	⊗		⊗	⊗					⊗	⊗	⊗		
	SNGX1205ANN-F67	G	8	0,8	1,5	⊗	⊗		⊗	⊗			⊗	⊗	⊗		⊗			⊗	⊗						⊗	⊗	⊗		
	SNHX1205ANN-K88	H	8	0,8	1,5																			⊗	⊗						
	SNMX1205ANN-F27	M	8	0,8	1,5	⊗	⊗	⊗	⊗												⊗	⊗						⊗	⊗		
	SNMX1205ANN-F57	M	8	0,8	1,5	⊗	⊗	⊗	⊗										⊗	⊗	⊗	⊗	⊗					⊗	⊗		
	SNMX1205ANN-F67	M	8	0,8	1,5	⊗	⊗	⊗	⊗								⊗				⊗	⊗	⊗					⊗	⊗		
	XNGX1205ANN-F67	G	2	1,2	4,7	⊗					⊗				⊗	⊗	⊗						⊗							⊗	

XNGX1205ANN-F67 wiper insert only in combination with SNGX1205ANN . .

HC = Coated carbide
HW = Uncoated carbide

Face milling cutters

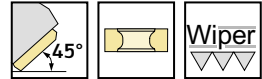
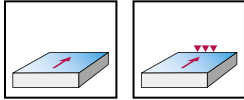
M5009 inch

SN . X1205 ..; XNGX1205ANN

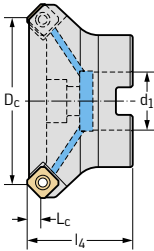
Xtra-tec® XT



– 8 cutting edges per indexable insert

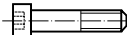


	P	M	K	N	S	H	O
M5009	●	●	●	●	●	●	●

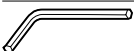
Tool	Designation	D _c inch	d ₁ inch	l ₄ inch	L _c inch	Z	lbs	No. of indexable inserts	Type
 Shell mill mount DIN 138 transverse keyway	M5009.051-B19-04-06-AP	2,000	0,750	1,500	0,236	4	0,888	4	SN . X1205 .. XNGX1205ANN
	M5009.064-B26-06-06-AP	2,500	1,000	2,000	0,236	6	1,75	6	
	M5009.076-B26-07-06-AP	3,000	1,000	2,000	0,236	7	2,35	7	
	M5009.102-B38-08-06-AP	4,000	1,500	2,500	0,236	8	6,074	8	
	M5009.127-B38-10-06-AP	5,000	1,500	2,500	0,236	10	8,157	10	
	M5009.152-B38-12-06-AP	6,000	1,500	2,500	0,236	12	10,313	12	

M5009...-AP with carbide shim | Bodies and assembly parts are included in the scope of delivery

Assembly parts

	D _c [inch]	2	2,5–3	4–6
	Shim for indexable insert	AP800-SN1205 H81	AP800-SN1205 H81	AP800-SN1205 H81
	Clamping screw for shim	FS2069 (SW 4)	FS2069 (SW 4)	FS2069 (SW 4)
	Clamping screw for indexable insert Tightening torque	FS2617 (T15IP) 2,95 lbs	FS2617 (T15IP) 2,95 lbs	FS2617 (T15IP) 2,95 lbs
	Clamping screw for arbour-mounted tools	FS1518	FS1519	FS1583

Accessories

	D _c [inch]	2–6
	Torque screwdriver, analogue	FS2003
	Torque screwdriver, digital	FS2248
	Interchangeable blade	FS2014 (T15IP)
	Screwdriver	FS1485 (T15IP)
	Key for screw for shim	ISO2936-4 (SW 4)

Indexable inserts

	Designation	Tolerance class	Number of cutting edges	r inch	b inch	P					M				K							N		S			H	
						HC					HC				HC							HC	HW	HC				
						WHH15X	WKP25S	WKP35G	WKP35S	WSP45G	WXM15	WSM35G	WSM35S	WSP45G	WXM15	WAK15	WHH15X	WKK25G	WKK25S	WKP25S	WKP35G	WKP35S	WXM15	WXN15	WK10	WSM35G		WSM35S
	SNGX120512-F57	G	8	0,047		⊗	⊗	⊗	⊗	⊗		⊗	⊗	⊗					⊗	⊗	⊗				⊗	⊗	⊗	
	SNMX120512-D27	M	8	0,047		⊗	⊗	⊗	⊗	⊗								⊗	⊗	⊗	⊗	⊗						
	SNMX120520-D27	M	8	0,079		⊗	⊗	⊗	⊗									⊗	⊗	⊗	⊗	⊗						
	SNMX120512-F27	M	8	0,047		⊗	⊗		⊗											⊗		⊗						
	SNMX120512-F57	M	8	0,047		⊗	⊗	⊗	⊗	⊗		⊗	⊗	⊗				⊗	⊗	⊗	⊗	⊗				⊗	⊗	⊗
	SNMX120520-F57	M	8	0,079			⊗	⊗	⊗	⊗		⊗	⊗	⊗				⊗	⊗	⊗	⊗	⊗				⊗	⊗	⊗
	SNMX120512-F67	M	8	0,047			⊗	⊗	⊗	⊗		⊗	⊗	⊗		⊗			⊗	⊗	⊗	⊗				⊗	⊗	⊗
	SNGX1205ANN-F27	G	8	0,031	0,059		⊗	⊗	⊗	⊗		⊗	⊗	⊗						⊗	⊗	⊗				⊗	⊗	⊗
	SNGX1205ANN-F57	G	8	0,031	0,059		⊗	⊗	⊗	⊗		⊗	⊗	⊗				⊗	⊗		⊗	⊗	⊗			⊗	⊗	⊗
	SNGX1205ANN-F67	G	8	0,031	0,059		⊗	⊗	⊗	⊗		⊗	⊗	⊗		⊗				⊗	⊗	⊗				⊗	⊗	⊗
	SNHX1205ANN-K88	H	8	0,031	0,059																⊗	⊗						
	SNMX1205ANN-F27	M	8	0,031	0,059		⊗	⊗	⊗											⊗	⊗	⊗						
	SNMX1205ANN-F57	M	8	0,031	0,059		⊗	⊗	⊗									⊗	⊗	⊗	⊗	⊗						
	SNMX1205ANN-F67	M	8	0,031	0,059		⊗	⊗	⊗							⊗				⊗	⊗	⊗						
	XNGX1205ANN-F67	G	2	0,047	0,185	⊗					⊗				⊗	⊗	⊗					⊗						⊗

XNGX1205ANN-F67 wiper insert only in combination with SNGX1205ANN . .

HC = Coated carbide
HW = Uncoated carbide

Face milling cutters

M5011

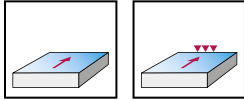
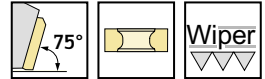
mm

SN . X1205 ..; XNGX1205ZNN

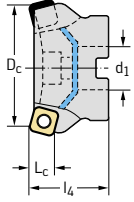
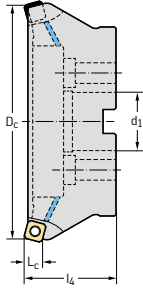
Xtra-tec® XT



– 8 cutting edges per indexable insert



	P	M	K	N	S	H	O
M5011	●	●	●	●	●	●	●

Tool	Designation	D _c mm	d ₁ mm	l ₄ mm	L _c mm	Z	kg	No. of indexable inserts	Type
	M5011-063-B22-07-08	63	22	40	8	7	0,43	7	SN . X1205 .. XNGX1205ZNN
	M5011-063-B27-07-08	63	27	50	8	7	0,75	7	
	M5011-080-B27-09-08	80	27	50	8	9	0,99	9	
	M5011-100-B32-11-08	100	32	50	8	11	1,66	11	
	M5011-125-B40-14-08	125	40	63	8	14	3,13	14	
Shell mill mount DIN 138 transverse keyway									
	M5011-160-B40-18-08	160	40	63	8	18	4,66	18	SN . X1205 .. XNGX1205ZNN
Shell mill mount DIN 138 transverse keyway									

Bodies and assembly parts are included in the scope of delivery

Assembly parts



Type
D_c [mm]

Clamping screw for indexable insert
Tightening torque

SN . X1205 ..
63–160

FS1459 (T15IP)
4 Nm

Accessories



Torque screwdriver, analogue

FS2003

FS2003



Torque screwdriver, digital

FS2248

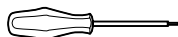
FS2248



Interchangeable blade

FS2014 (T15IP)

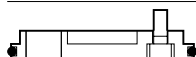
FS2014 (T15IP)



Screwdriver

FS1485 (T15IP)

FS1485 (T15IP)



Sealing disc set

FS936 COMPLETE SET



Gasket

O-R 96X4

Indexable inserts

	Designation	Tolerance class	Number of cutting edges	r mm	b mm	P					M				K						S			H
						HC					HC				HC						HC			HC
						WHH15X	WKP25S	WKP35G	WKP35S	WSP45G	WXM15	WSM35G	WSM35S	WSP45G	WXM15	WAK15	WHH15X	WKK25G	WKK25S	WKP25S	WKP35G	WKP35S	WXM15	WSM35G
	SNGX120512-F57	G	8	1,2		☺	☺	☺	☺	☺	☺	☺	☺				☺	☺	☺	☺	☺	☺		
	SNMX120512-D27	M	8	1,2		☺	☺	☺	☺								☺	☺	☺	☺	☺			
	SNMX120520-D27	M	8	2			☺	☺									☺	☺	☺	☺	☺			
	SNMX120512-F27	M	8	1,2		☺		☺									☺	☺	☺	☺	☺			
	SNMX120512-F57	M	8	1,2		☺	☺	☺	☺			☺	☺	☺			☺	☺	☺	☺	☺	☺	☺	
	SNMX120520-F57	M	8	2		☺	☺	☺	☺	☺			☺	☺	☺			☺	☺	☺	☺	☺	☺	
	SNMX120512-F67	M	8	1,2		☺	☺	☺	☺			☺	☺	☺	☺			☺	☺	☺	☺	☺		
	SNGX1205ENN-F27	G	8	0,3	1,2		☺	☺	☺			☺	☺	☺				☺	☺	☺	☺		☺	☺
	SNGX1205ENN-F57	G	8	0,3	1,2		☺	☺	☺	☺			☺	☺				☺	☺	☺	☺	☺	☺	
	SNGX1205ENN-F67	G	8	0,3	1,2		☺		☺	☺			☺	☺	☺				☺	☺		☺	☺	
	SNMX1205ENN-F57	M	8	0,3	1,2		☺	☺										☺	☺	☺				
	XNGX1205ENN-F67	G	2	0,6	4,5	☺					☺				☺	☺	☺					☺		☺

HC = Coated carbide

Face milling cutters

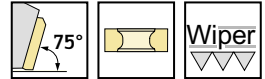
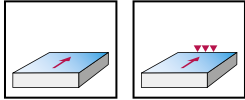
M5011

SN . X1205 ..; XNGX1205ZNN

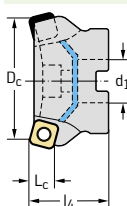
Xtra-tec® XT



– 8 cutting edges per indexable insert

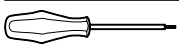


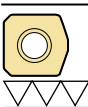
	P	M	K	N	S	H	O
M5011	●	●	●	●	●	●	●

Tool	Designation	D _c mm	d ₁ mm	l ₄ mm	L _c mm	Z		No. of indexable inserts	Type
	M5011-050-B22-04-08-AP	50	22	40	8	4	0,32	4	SN . X1205 .. XNGX1205ZNN
	M5011-063-B22-05-08-AP	63	22	40	8	5	0,67	5	
	M5011-063-B27-05-08-AP	63	27	50	8	5	0,96	5	
	M5011-080-B27-07-08-AP	80	27	50	8	7	0,99	7	
	M5011-100-B32-08-08-AP	100	32	50	8	8	1,67	8	
	M5011-125-B40-10-08-AP	125	40	63	8	10	3,17	10	
Shell mill mount DIN 138 transverse keyway									

M5011...-AP with carbide shim | Bodies and assembly parts are included in the scope of delivery

Assembly parts			Type D _c [mm]	SN . X1205 .. 50-125
	Shim for indexable insert			AP800-SN1205 H81
	Clamping screw for shim			FS2069 (SW 4)
	Clamping screw for indexable insert Tightening torque			FS2617 (T15IP) 4 Nm

Accessories			Type D _c [mm]	SN . X1205 .. 50-125
	Torque screwdriver, analogue			FS2003
	Torque screwdriver, digital			FS2248
	Interchangeable blade			FS2014 (T15IP)
	Screwdriver			FS1485 (T15IP)
	Key for screw for shim			ISO2936-4 (SW 4)

Indexable inserts																													
	Designation	Tolerance class	Number of cutting edges	r mm	b mm	P					M				K					S			H						
						HC					HC				HC					HC			HC						
						WHH15X	WKP25S	WKP35G	WKP35S	WSP45G	WXM15	WSM35G	WSM35S	WSP45G	WXM15	WAK15	WHH15X	WKK25G	WKK25S	WKP25S	WKP35G	WKP35S	WXM15	WSM35G	WSM35S	WSP45G	WHH15X		
	SNGX120512-F57	G	8	1,2																									
	SNMX120512-D27	M	8	1,2																									
	SNMX120520-D27	M	8	2																									
	SNMX120512-F27	M	8	1,2																									
	SNMX120512-F57	M	8	1,2																								H	
	SNMX120520-F57	M	8	2																									
	SNMX120512-F67	M	8	1,2																									
	SNGX1205ENN-F27	G	8	0,3	1,2																								
	SNGX1205ENN-F57	G	8	0,3	1,2																								
	SNGX1205ENN-F67	G	8	0,3	1,2																								
	SNMX1205ENN-F57	M	8	0,3	1,2																								
	XNGX1205ENN-F67	G	2	0,6	4,5																								

HC = Coated carbide

Face milling cutters

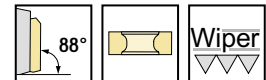
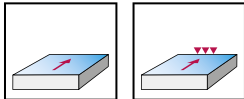
M5012 mm

SN . X0904 ..; XNGX0904ZNN

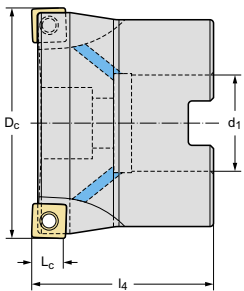
Xtra-tec® XT



– 8 cutting edges per indexable insert



	P	M	K	N	S	H	O
M5012	●	●	●	●	●	●	●

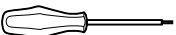
Tool	Designation	D _c mm	d ₁ mm	l ₄ mm	L _c mm	Z	kg	No. of indexable inserts	Type
 Shell mill mount DIN 138 transverse keyway	M5012-040-B16-04-08	40	16	40	8	4	0,24	4	SN . X0904 .. XNGX0904ZNN
	M5012-050-B22-05-08	50	22	40	8	5	0,39	5	
	M5012-050-B22-06-08	50	22	40	8	6	0,39	6	
	M5012-063-B22-06-08	63	22	40	8	6	0,51	6	
	M5012-063-B22-08-08	63	22	40	8	8	0,5	8	
	M5012-063-B27-06-08	63	27	50	8	6	0,61	6	
	M5012-063-B27-08-08	63	27	50	8	8	0,6	8	
	M5012-080-B27-07-08	80	27	50	8	7	1,09	7	
	M5012-080-B27-10-08	80	27	50	8	10	1,07	10	
	M5012-100-B32-08-08	100	32	50	8	8	1,84	8	
	M5012-100-B32-12-08	100	32	50	8	12	1,8	12	

Bodies and assembly parts are included in the scope of delivery

Assembly parts

	D _c [mm]	40–100
	Clamping screw for indexable insert Tightening torque	FS2579 (T8IP) 1,2 Nm

Accessories

	D _c [mm]	40–100
	Torque screwdriver, analogue	FS2001
	Torque screwdriver, digital	FS2248
	Interchangeable blade	FS2012 (T8IP)
	Screwdriver	FS1483 (T8IP)

Indexable inserts

Designation		Tolerance class	Number of cutting edges	r mm	b mm	P					M				K						N		S		H					
						HC					HC				HC						HC	HW	HC	HC						
						WHH15X	WKP25S	WKP35G	WKP35S	WSP45G	WXM15	WSM35G	WSM35S	WSP45G	WXM15	WAK15	WHH15X	WKK25G	WKK25S	WKP25S	WKP35G	WKP35S	WXM15	WXN15	WK10	WSM35G	WSM35S	WSP45G	WHH15X	
	SNGX0904ZNN-F57	G	8	0,6	1	⊗	⊗	⊗	⊗			⊗	⊗	⊗		⊗		⊗	⊗	⊗	⊗								⊗	
	SNGX0904ZNN-F67	G	8	0,6	1	⊗	⊗	⊗	⊗			⊗	⊗	⊗		⊗				⊗	⊗					⊗	⊗	⊗		
	SNHX0904ZNN-K88	H	8	0,6	1																			⊗	⊗					
	SNMX0904ZNN-F27	M	8	0,6	1	⊗	⊗	⊗	⊗												⊗	⊗	⊗							
	SNMX0904ZNN-F57	M	8	0,6	1	⊗	⊗	⊗	⊗	⊗			⊗	⊗	⊗			⊗	⊗	⊗	⊗	⊗	⊗				⊗	⊗	⊗	
	SNMX0904ZNN-F67	M	8	0,6	1					⊗			⊗	⊗	⊗		⊗					⊗	⊗				⊗		⊗	
	SNMX090408-F27	M	8	0,8		⊗	⊗	⊗	⊗				⊗	⊗	⊗					⊗	⊗	⊗					⊗	⊗	⊗	
	SNMX090408-F57	M	8	0,8		⊗	⊗	⊗	⊗	⊗		⊗	⊗	⊗				⊗	⊗	⊗	⊗	⊗	⊗				⊗	⊗	⊗	
	SNMX090408-F67	M	8	0,8		⊗	⊗	⊗	⊗	⊗		⊗	⊗	⊗						⊗	⊗	⊗	⊗				⊗	⊗	⊗	
 	XNGX0904ZNN-F67	G	2	0,8	3,5	⊗					⊗				⊗	⊗	⊗						⊗							⊗

HC = Coated carbide
HW = Uncoated carbide

Face milling cutters

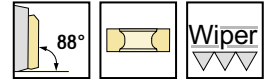
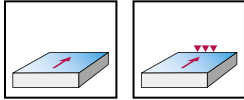
M5012 mm

SN . X1205 ..; XNGX1205ZNN

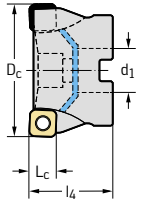
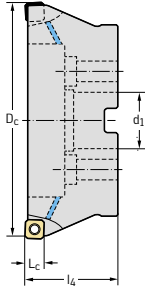
Xtra-tec® XT



– 8 cutting edges per indexable insert



	P	M	K	N	S	H	O
M5012	●	●	●	●	●	●	●

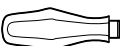
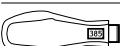
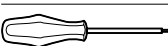
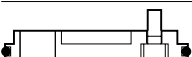
Tool	Designation	D _c mm	d ₁ mm	l ₄ mm	L _c mm	Z	kg	No. of indexable inserts	Type
	M5012-063-B22-07-10	63	22	40	10	7	0,44	7	SN . X1205 .. XNGX1205ZNN
	M5012-063-B27-07-10	63	27	50	10	7	0,66	7	
	M5012-080-B27-09-10	80	27	50	10	9	0,98	9	
	M5012-100-B32-11-10	100	32	50	10	11	1,69	11	
	M5012-125-B40-14-10	125	40	63	10	14	3,23	14	
Shell mill mount DIN 138 transverse keyway									
	M5012-160-B40-18-10	160	40	63	10	18	4,69	18	SN . X1205 .. XNGX1205ZNN
Shell mill mount DIN 138 transverse keyway									

Bodies and assembly parts are included in the scope of delivery

Assembly parts

	D _c [mm]	63–160
	Clamping screw for indexable insert Tightening torque	FS1459 (T15IP) 4 Nm

Accessories

	D _c [mm]	63–125	160
	Torque screwdriver, analogue	FS2003	FS2003
	Torque screwdriver, digital	FS2248	FS2248
	Interchangeable blade	FS2014 (T15IP)	FS2014 (T15IP)
	Screwdriver	FS1485 (T15IP)	FS1485 (T15IP)
	Sealing disc set		FS936 COMPLETE SET
	Gasket		O-R 96X4

Indexable inserts

	Designation	Tolerance Class	Number of cutting edges	r mm	b mm	P					M				K						N		S		H				
						WHH15X	WKP25S	WKP35G	WKP35S	WSP45G	WXM15	WSM35G	WSM35S	WSP45G	WXM15	WAK15	WHH15X	WKK25G	WKK25S	WKP25S	WKP35G	WKP35S	WXM15	HC		HW	WSM35G	WSM35S	WSP45G
	SNGX120512-F57	G	8	1.2		⊗	⊗	⊗	⊗		⊗	⊗	⊗					⊗	⊗	⊗			⊗	⊗	⊗				
	SNMX120512-D27	M	8	1.2		⊗	⊗	⊗	⊗									⊗	⊗	⊗	⊗	⊗							
	SNMX120520-D27	M	8	2			⊗	⊗	⊗									⊗	⊗	⊗	⊗	⊗							
	SNMX120512-F27	M	8	1.2		⊗			⊗										⊗		⊗	⊗							
	SNMX120512-F57	M	8	1.2		⊗	⊗	⊗	⊗		⊗	⊗	⊗	⊗				⊗	⊗	⊗	⊗	⊗				⊗	⊗	⊗	
	SNMX120520-F57	M	8	2		⊗	⊗	⊗	⊗	⊗		⊗	⊗	⊗	⊗				⊗	⊗	⊗	⊗	⊗				⊗	⊗	⊗
	SNMX120512-F67	M	8	1.2		⊗	⊗	⊗	⊗		⊗	⊗	⊗		⊗			⊗	⊗	⊗	⊗	⊗				⊗	⊗	⊗	
	SNGX1205ZNN-F27	G	8	0.8	1.2		⊗	⊗	⊗			⊗	⊗	⊗					⊗	⊗	⊗	⊗				⊗	⊗	⊗	
	SNGX1205ZNN-F57	G	8	0.8	1.2		⊗	⊗	⊗	⊗		⊗	⊗	⊗				⊗	⊗	⊗	⊗	⊗				⊗	⊗	⊗	
	SNGX1205ZNN-F67	G	8	0.8	1.2		⊗	⊗	⊗	⊗		⊗	⊗	⊗		⊗				⊗	⊗	⊗				⊗	⊗	⊗	
	SNHX1205ZNN-K88	H	8	0.8	1.2																			⊗	⊗				
	SNMX1205ZNN-F57	M	8	0.8	1.2		⊗	⊗	⊗									⊗	⊗	⊗	⊗	⊗							
	XNGX1205ZNN-F67	G	2	1	4	⊗					⊗				⊗	⊗	⊗						⊗						⊗

HC = Coated carbide
HW = Uncoated carbide

Face milling cutters

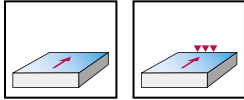
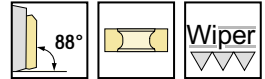
M5012 mm

SN . X1205 ..; XNGX1205ZNN

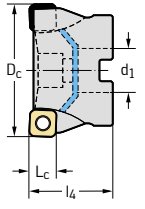
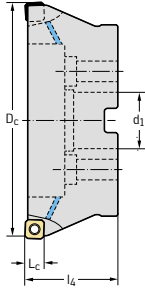
Xtra-tec® XT



– 8 cutting edges per indexable insert

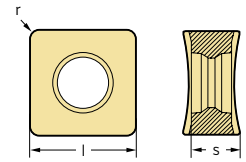


	P	M	K	N	S	H	O
M5012	●	●	●	●	●	●	●

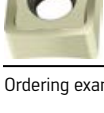
Tool	Designation	D _c mm	d ₁ mm	l ₄ mm	L _c mm	Z	kg	No. of indexable inserts	Type
	M5012-050-B22-04-10-AP	50	22	40	10	4	0,33	4	SN . X1205 .. XNGX1205ZNN
	M5012-063-B22-05-10-AP	63	22	40	10	5	0,45	5	
	M5012-063-B27-05-10-AP	63	27	50	10	5	0,68	5	
	M5012-080-B27-07-10-AP	80	27	50	10	7	0,98	7	
	M5012-100-B32-08-10-AP	100	32	50	10	8	1,71	8	
	M5012-125-B40-10-10-AP	125	40	63	10	10	3,27	10	
Shell mill mount DIN 138 transverse keyway									
	M5012-160-B40-12-10-AP	160	40	63	10	12	4,75	12	SN . X1205 .. XNGX1205ZNN
Shell mill mount DIN 138 transverse keyway									

M5012...-AP with carbide shim | Bodies and assembly parts are included in the scope of delivery

Negative square SNGX / SNMX Tiger-tec® Gold



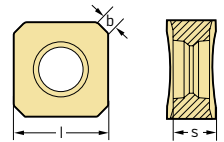
Indexable inserts

Designation	Tolerance class	Number of cutting edges	s mm	l mm	r mm	P				M				K					S		
						HC				HC				HC					HC		
						WKP25S	WKP35G	WKP35S	WSP45G	WSM35G	WSM35S	WSP45G	WAK15	WKK25G	WKK25S	WKP25S	WKP35G	WKP35S	WSM35G	WSM35S	WSP45G
 SNGX120512-F57	G	8	5,6	12,7	1,2	☞	☞	☞	☞	☞	☞	☞				☞	☞	☞	☞	☞	☞
 SNMX120512-D27	M	8	5,55	12,7	1,2	☞	☞	☞						☞	☞	☞	☞	☞			
 SNMX120520-D27	M	8	5,55	12,7	2	☞	☞	☞						☞	☞	☞	☞	☞			
 SNMX090408-F27	M	8	4,87	9,52	0,8	☞	☞	☞								☞	☞	☞			
 SNMX120512-F27	M	8	5,65	12,7	1,2	☞		☞								☞		☞			
 SNMX160620-F27	M	8	6,38	16	2			☞										☞			
 SNMX090408-F57	M	8	4,85	9,52	0,8	☞	☞	☞	☞	☞	☞	☞		☞	☞	☞	☞	☞	☞	☞	☞
 SNMX120512-F57	M	8	5,5	12,7	1,2	☞	☞	☞	☞	☞	☞	☞		☞	☞	☞	☞	☞	☞	☞	☞
 SNMX120520-F57	M	8	5,5	12,7	2	☞	☞	☞	☞	☞	☞	☞		☞	☞	☞	☞	☞	☞	☞	☞
 SNMX160620-F57	M	8	6,38	16	2	☞		☞				☞				☞					☞
 SNMX160640-F57	M	8	6,38	16	4				☞			☞									☞
 SNMX090408-F67	M	8	4,87	9,52	0,8	☞	☞	☞	☞	☞	☞	☞				☞	☞	☞	☞	☞	☞
 SNMX120512-F67	M	8	5,63	12,7	1,2	☞	☞	☞	☞	☞	☞	☞	☞			☞	☞	☞	☞	☞	☞

Ordering example for the WKP35G grade: SNGX120512-F57 WKP35G

HC = Coated carbide

Negative square SNGX / SNHX / SNMX Tiger-tec® Gold



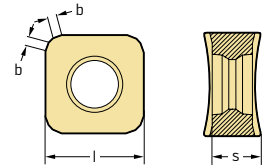
Indexable inserts

	Designation	Tolerance class	Number of cutting edges	s mm	l mm	b mm	P				M			K					N		S			
							HC				HC			HC					HC	HW	HC			
							WKP25S	WKP35G	WKP35S	WSP45G	WSM35G	WSM35S	WSP45G	WAK15	WKK25G	WKK25S	WKP25S	WKP35G	WKP35S	WXN15	WK10	WSM35G	WSM35S	WSP45G
	SNGX1205ANN-F27	G	8	5,59	12,7	1,5	☺	☺	☺							☺	☺	☺						
	SNGX0904ANN-F57	G	8	4,69	9,52	1,2	☺	☺	☺	☺	☺	☺		☺	☺	☺	☺	☺			☺	☺	☺	
	SNGX1205ANN-F57	G	8	5,54	12,7	1,5	☺		☺	☺	☺	☺	☺	☺	☺	☺	☺	☺			☺	☺	☺	
	SNGX1606ANN-F57	G	8	6,3	16	1,8			☺	☺			☺				☺						☺	
	SNGX0904ANN-F67	G	8	4,72	9,52	1,2		☺	☺	☺	☺	☺	☺				☺	☺	☺			☺	☺	☺
	SNGX1205ANN-F67	G	8	5,54	12,7	1,5	☺	☺	☺	☺	☺	☺	☺				☺	☺	☺			☺	☺	☺
	SNHX0904ANN-K88	H	8	4,68	9,52	1,5													☺	☺				
	SNHX1205ANN-K88	H	8	5,54	12,7	1,5													☺					
	SNMX0904ANN-F27	M	8	4,72	9,52	1,2	☺	☺	☺							☺	☺	☺						
	SNMX1205ANN-F27	M	8	5,59	12,7	1,5	☺	☺	☺							☺	☺	☺						
	SNMX0904ANN-F57	M	8	4,69	9,52	1,2	☺	☺	☺	☺	☺	☺		☺	☺	☺	☺	☺			☺	☺	☺	
	SNMX1205ANN-F57	M	8	5,54	12,7	1,5	☺	☺	☺					☺	☺	☺	☺	☺						
	SNMX0904ANN-F67	M	8	4,72	9,52	1,2		☺	☺	☺	☺	☺	☺				☺	☺	☺			☺	☺	☺
	SNMX1205ANN-F67	M	8	5,54	12,7	1,5	☺	☺	☺				☺			☺	☺	☺						

Ordering example for the WKP35G grade: SNGX1205ANN-F27 WKP35G

HC = Coated carbide
HW = Uncoated carbide

Negative square SNGX / SNMX Tiger-tec® Gold



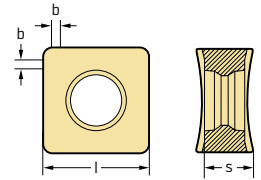
Indexable inserts

Designation	Tolerance class	Number of cutting edges	s mm	l mm	b mm	P HC				M HC				K HC					S HC		
						WKP25S	WKP35G	WKP35S	WSP45G	WSM35G	WSM35S	WSP45G	WAK15	WKK25G	WKK25S	WKP25S	WKP35G	WKP35S	WSM35G	WSM35S	WSP45G
 SNGX1205ENN-F27	G	8	5,65	12,7	1,2	☺	☺	☺								☺	☺	☺			
 SNGX1205ENN-F57	G	8	5,61	12,7	1,2	☺	☺	☺	☺	☺	☺	☺		☺	☺	☺	☺	☺	☺	☺	☺
 SNGX1205ENN-F67	G	8	5,64	12,7	1,2	☺		☺	☺	☺	☺	☺	☺			☺	☺	☺	☺	☺	☺
 SNMX1205ENN-F57	M	8	5,61	12,7	1,2	☺	☺							☺		☺	☺				

Ordering example for the WKP35G grade: SNGX1205ENN-F27 WKP35G

HC = Coated carbide

Negative square SNGX / SNHX / SNMX Tiger-tec® Gold



Indexable inserts

	Designation	Tolerance class	Number of cutting edges	s mm	l mm	b mm	P				M				K				N		S				
							HC				HC				HC				HC		HC		HC		
							WKP25S	WKP35G	WKP35S	WSP45G	WSM35G	WSM35S	WSP45G	WAK15	WKK25G	WKK25S	WKP25S	WKP35G	WKP35S	WXN15	WK10	WSM35G	WSM35S	WSP45G	
	SNGX1205ZNN-F27	G	8	5,77	12,7	1,2	☺	☺	☺							☺	☺	☺							
	SNGX0904ZNN-F57	G	8	4,9	9,52	1	☺	☺		☺				☺	☺	☺	☺					☺			
	SNGX1205ZNN-F57	G	8	5,77	12,7	1,2	☺	☺	☺	☺	☺	☺		☺	☺	☺	☺	☺			☺	☺	☺		
	SNGX0904ZNN-F67	G	8	4,93	9,52	1	☺			☺	☺	☺		☺		☺	☺				☺	☺	☺		
	SNGX1205ZNN-F67	G	8	5,8	12,7	1,2	☺		☺	☺	☺	☺	☺			☺	☺	☺			☺	☺	☺		
	SNHX0904ZNN-K88	H	8	5,01	9,52	1													☺	☺					
	SNHX1205ZNN-K88	H	8	5,89	12,7	1,2													☺	☺					
	SNMX0904ZNN-F27	M	8	4,93	9,52	1	☺	☺	☺							☺	☺	☺							
	SNMX0904ZNN-F57	M	8	4,91	9,52	1	☺	☺	☺	☺	☺	☺		☺	☺	☺	☺	☺			☺	☺	☺		
	SNMX1205ZNN-F57	M	8	5,77	12,7	1,2	☺	☺	☺					☺	☺	☺	☺	☺							
	SNMX0904ZNN-F67	M	8	4,93	9,52	1				☺	☺		☺	☺							☺		☺		

Ordering example for the WKP35G grade: SNGX1205ZNN-F27 WKP35G

HC = Coated carbide
HW = Uncoated carbide

Button insert milling cutters

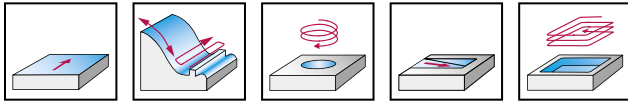
M5468 mm

RD . X0501M0

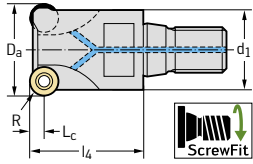
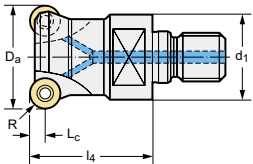
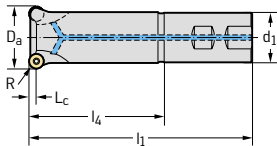
Xtra-tec® XT



– 4 cutting edges per indexable insert



	P	M	K	N	S	H	O
M5468	●	●	●	●	●	●	●

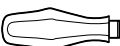
Tool	Designation	R mm	D _a mm	d ₁ mm	l ₄ mm	l ₁ mm	L _c mm	Z	kg	No. of indexable inserts	Type
 ScrewFit	M5468-010-T09-02-02.5	2,5	10	T09	20		2,5	2	0,01	2	RD . X0501M0
	M5468-012-T09-03-02.5	2,5	12	T09	20		2,5	3	0,01	3	
	M5468-016-T14-04-02.5	2,5	16	T14	25		2,5	4	0,03	4	
	M5468-020-T18-05-02.5	2,5	20	T18	30		2,5	5	0,06	5	
 Cylindrical modular	M5468-010-TC06-02-02.5	2,5	10	M6	20		2,5	2	0,01	2	RD . X0501M0
	M5468-012-TC06-03-02.5	2,5	12	M6	20		2,5	3	0,01	3	
	M5468-016-TC08-04-02.5	2,5	16	M8	25		2,5	4	0,03	4	
	M5468-020-TC10-05-02.5	2,5	20	M10	30		2,5	5	0,06	5	
 DIN 1835 B	M5468-010-W10-02-02.5	2,5	10	10	19	60	2,5	2	0,03	2	RD . X0501M0
	M5468-012-W12-03-02.5	2,5	12	12	19	65	2,5	3	0,05	3	

Bodies and assembly parts are included in the scope of delivery

Assembly parts

	D _a [mm]	10–20
	Clamping screw for indexable insert Tightening torque	FS1358 (T6) 0,4 Nm

Accessories

	D _a [mm]	10–20
	Torque screwdriver, analogue	FS2001
	Interchangeable blade	FS2005 (T6)
	Screwdriver	FS1063 (T6)

Indexable inserts

	Designation	Tolerance class	Number of cutting edges	d mm	P					M			K					N	S	H			
					HC					HC			HC					HW	HC	HC			
					WHH15X	WKP25S	WKP35G	WKP35S	WSP45G	WSM35G	WSM35S	WSP45G	WHH15X	WKK25G	WKK25S	WKP25S	WKP35G	WKP35S	WK10	WSM35G	WSM35S	WSP45G	WHH15X
	RDGX0501M0-G88	G	4	5																			
	RDHX0501M0-A57	H	4	5	⊕	⊗	⊗	⊗					⊕	⊗	⊗	⊗				⊕			
	RDMX0501M0-D57	M	4	5	⊕	⊗	⊗	⊗	⊗	⊗	⊗	⊗		⊗	⊗	⊗	⊗	⊗	⊗				

HC = Coated carbide
HW = Uncoated carbide

Button insert milling cutters

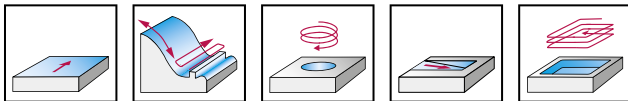
M5468 mm

RD . X07T1M0

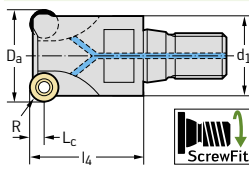
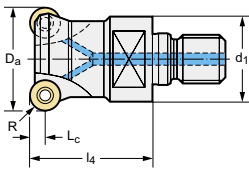
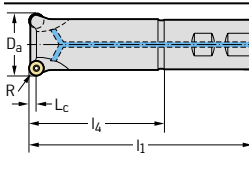
Xtra-tec® XT



– 4 cutting edges per indexable insert



	P	M	K	N	S	H	O
M5468	●	●	●	●	●	●	●

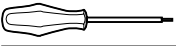
Tool	Designation	R mm	D _a mm	d ₁ mm	l ₄ mm	l ₁ mm	L _c mm	Z	kg	No. of indexable inserts	Type
 ScrewFit	M5468-015-T14-03-03.5	3,5	15	T14	25		3,5	3	0,03	3	RD . X07T1M0
	M5468-020-T18-04-03.5	3,5	20	T18	30		3,5	4	0,05	4	
	M5468-025-T22-05-03.5	3,5	25	T22	35		3,5	5	0,1	5	
	M5468-030-T28-06-03.5	3,5	30	T28	40		3,5	6	0,18	6	
 Cylindrical modular	M5468-015-TC08-03-03.5	3,5	15	M8	25		3,5	3	0,03	3	RD . X07T1M0
	M5468-020-TC10-04-03.5	3,5	20	M10	30		3,5	4	0,05	4	
	M5468-025-TC12-05-03.5	3,5	25	M12	35		3,5	5	0,09	5	
	M5468-030-TC16-06-03.5	3,5	30	M16	40		3,5	6	0,17	6	
 DIN 1835 B	M5468-015-W16-03-03.5	3,5	15	16	51	100	3,5	3	0,12	3	RD . X07T1M0

Bodies and assembly parts are included in the scope of delivery

Assembly parts

	D _a [mm]	15–30
	Clamping screw for indexable insert Tightening torque	FS1455 (T8IP) 1,2 Nm

Accessories

	D _a [mm]	15–30
	Torque screwdriver, analogue	FS2001
	Torque screwdriver, digital	FS2248
	Interchangeable blade	FS2012 (T8IP)
	Screwdriver	FS1483 (T8IP)

Indexable inserts

Designation		Tolerance class	Number of cutting edges	d mm	P				M			K				N	S			H			
					HC				HC			HC				HW	HC			HC			
					WHH15X	WKP25S	WKP35G	WKP35S	WSP45G	WSM35G	WSM35S	WSP45G	WHH15X	WKK25G	WKK25S	WKP25S	WKP35G	WKP35S	WK10	WSM35G	WSM35S	WSP45G	WHH15X
	RDGX07T1M0-G88	G	4	7																			
	RDHX07T1M0-A57	H	4	7	☺	☺	☺	☺					☺	☺	☺	☺	☺	☺					☺
	RDMX07T1M0-D57	M	4	7		☺	☺	☺	☺	☺	☺	☺		☺	☺	☺	☺	☺		☺	☺	☺	

HC = Coated carbide
HW = Uncoated carbide

Button insert milling cutters

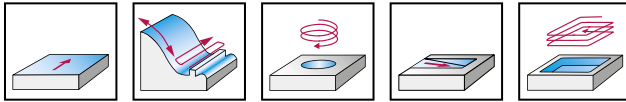
M5468 mm

RO . X0803M0

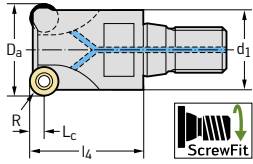
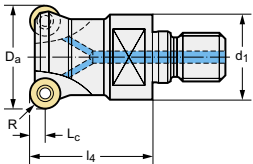
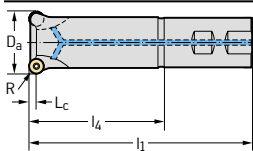
Xtra-tec® XT



- With indexing surfaces
- 4 cutting edges per indexable insert



	P	M	K	N	S	H	O
M5468	●	●	●	●	●	●	●

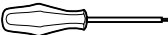
Tool	Designation	R mm	D _a mm	d ₁ mm	l ₄ mm	l ₁ mm	L _c mm	Z	kg	No. of indexable inserts	Type
 ScrewFit	M5468-016-T14-02-04	4	16	T14	25		4	2	0,03	2	RO . X0803M0
	M5468-025-T22-03-04	4	25	T22	35		4	3	0,09	3	
	M5468-032-T28-05-04	4	32	T28	40		4	5	0,18	5	
 Cylindrical modular	M5468-016-TC08-02-04	4	16	M8	25		4	2	0,03	2	RO . X0803M0
	M5468-025-TC12-03-04	4	25	M12	35		4	3	0,09	3	
	M5468-032-TC16-05-04	4	32	M16	40		4	5	0,17	5	
 DIN 1835 B	M5468-016-W16-02-04	4	16	16	51	100	4	2	0,13	2	RO . X0803M0
	M5468-016-W16-02-04-XL	4	16	16	81	130	4	2	0,16	2	
	M5468-025-W25-03-04	4	25	25	93	150	4	3	0,45	3	

Bodies and assembly parts are included in the scope of delivery

Assembly parts

	D _a [mm]	16	25–32
	Clamping screw for indexable insert Tightening torque	FS1456 (T9IP) 2 Nm	FS2078 (T9IP) 1,5 Nm

Accessories

	D _a [mm]	16	25–32
	Torque screwdriver, analogue	FS2003	FS2003
	Torque screwdriver, digital	FS2248	FS2248
	Interchangeable blade	FS2013 (T9IP)	FS2013 (T9IP)
	Screwdriver	FS1484 (T9IP)	FS1484 (T9IP)

Indexable inserts

	Designation	Tolerance class	Number of cutting edges	d mm	P					M			K					N		S			H
					HC					HC			HC					HC	HW	HC			HC
					WHH15X	WKP25S	WKP35G	WKP35S	WSP45G	WSM35G	WSM35S	WSP45G	WHH15X	WKP25S	WKP35G	WKP35S	WSP45G	WSM35G	WSM35S	WSP45G	WHH15X		
	ROGX0803M04-G88	G	4	8																			
	ROHX0803M04-A57	H	4	8																			
	ROHX0803M04-D57	H	4	8																			
	ROHX0803M04-D67	H	4	8																			
	ROMX0803M04-D57	M	4	8																			

HC = Coated carbide
HW = Uncoated carbide

Button insert milling cutters

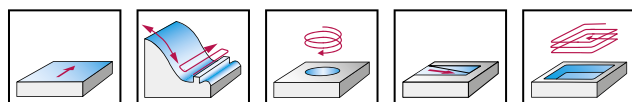
M5468 inch

RO . X0803M0

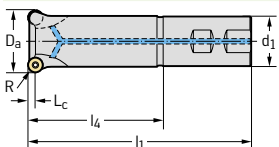
Xtra-tec® XT



- With indexing surfaces
- 4 cutting edges per indexable insert



	P	M	K	N	S	H	O
M5468	●	●	●	●	●	●	●

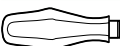
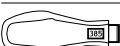
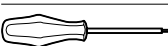
Tool	Designation	R inch	D _a inch	d ₁ inch	l ₄ inch	l ₁ inch	L _c inch	Z	 lbs	No. of indexable inserts	Type
	M5468.026-W26-03-04	0,157	1,000	1,000	2,5	4,781	0,157	3	0,805	3	RO . X0803M0
DIN 1835 B											

Bodies and assembly parts are included in the scope of delivery

Assembly parts

	D _a [inch]	1
	Clamping screw for indexable insert Tightening torque	FS2078 (T9IP) 1,106 lbs

Accessories

	D _a [inch]	1
	Torque screwdriver, analogue	FS2004
	Torque screwdriver, digital	FS2248
	Interchangeable blade	FS2013 (T9IP)
	Screwdriver	FS1484 (T9IP)

Indexable inserts

	Designation	Tolerance class	Number of cutting edges	d inch	P					M			K					N		S		H		
					HC					HC			HC					HC	HW	HC		HC		
					WHH15X	WKP25S	WKP35G	WKP35S	WSP45G	WSM35G	WSM35S	WSP45G	WHH15X	WKP25S	WKP35G	WKP35S	WSP45G	WHH15X	WKP25S	WKP35G	WKP35S	WXN15	WK10	WSM35G
	ROGX0803M04-G88	G	4	0,315																				
	ROHX0803M04-A57	H	4	0,315	☺	☺	☺	☺					☺	☺	☺	☺	☺	☺						☺
	ROHX0803M04-D57	H	4	0,315				☺	☺										☺			☺	☺	
	ROHX0803M04-D67	H	4	0,315					☺													☺	☺	☺
	ROMX0803M04-D57	M	4	0,315		☺		☺	☺	☺	☺	☺	☺			☺	☺	☺				☺	☺	☺

HC = Coated carbide
HW = Uncoated carbide

Button insert milling cutters

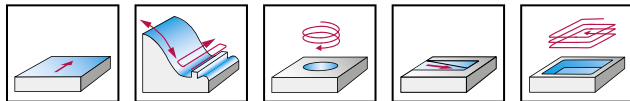
M5468 mm

RO . X10T3M0

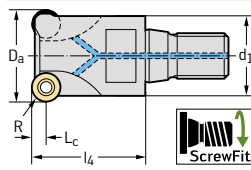
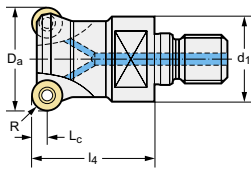
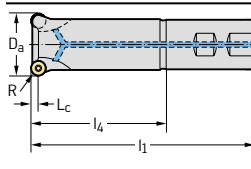
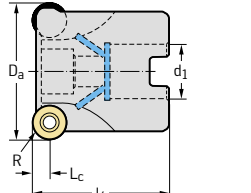
Xtra-tec® XT



- With indexing surfaces
- 8 cutting edges per indexable insert



	P	M	K	N	S	H	O
M5468	●	●	●	●	●	●	●

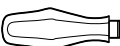
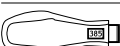
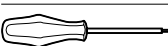
Tool	Designation	R mm	D _a mm	d ₁ mm	l ₄ mm	l ₁ mm	L _c mm	Z	kg	No. of indexable inserts	Type
 ScrewFit	M5468-020-T18-02-05	5	20	T18	30		5	2	0,05	2	RO . X10T3M0
	M5468-025-T22-03-05	5	25	T22	35		5	3	0,09	3	
	M5468-030-T28-04-05	5	30	T28	40		5	4	0,16	4	
	M5468-032-T28-04-05	5	32	T28	40		5	4	0,17	4	
	M5468-035-T28-05-05	5	35	T28	40		5	5	0,19	5	
	M5468-040-T36-05-05	5	40	T36	40		5	5	0,31	5	
 Cylindrical modular	M5468-020-TC10-02-05	5	20	M10	30		5	2	0,05	2	RO . X10T3M0
	M5468-025-TC12-03-05	5	25	M12	35		5	3	0,08	3	
	M5468-030-TC16-04-05	5	30	M16	40		5	4	0,15	4	
	M5468-032-TC16-04-05	5	32	M16	40		5	4	0,16	4	
	M5468-035-TC16-05-05	5	35	M16	40		5	5	0,18	5	
	M5468-040-TC16-05-05	5	40	M16	40		5	5	0,19	5	
 DIN 1835 B	M5468-020-W20-02-05	5	20	20	59	110	5	2	0,21	2	RO . X10T3M0
	M5468-020-W20-02-05-XL	5	20	20	99	150	5	2	0,29	2	
	M5468-032-W32-04-05	5	32	32	114	175	5	4	0,89	4	
 Shell mill mount DIN 138 transverse keyway	M5468-040-B16-05-05	5	40	16	40		5	5	0,14	5	RO . X10T3M0
	M5468-050-B22-06-05	5	50	22	50		5	6	0,33	6	
	M5468-052-B22-06-05	5	52	22	50		5	6	0,38	6	

Bodies and assembly parts are included in the scope of delivery

Assembly parts

	D _a [mm]	20–52
	Clamping screw for indexable insert Tightening torque	FS2181 (T15IP) 3 Nm

Accessories

	D _a [mm]	20–52
	Torque screwdriver, analogue	FS2003
	Torque screwdriver, digital	FS2248
	Interchangeable blade	FS2014 (T15IP)
	Screwdriver	FS1485 (T15IP)

Indexable inserts

	Designation	Tolerance class	Number of cutting edges	d mm	P					M				K					N		S			H
					HC					HC				HC					HC	HW	HC			HC
					WHH15X	WKP25S	WKP35G	WKP35S	WSP45G	WSM35G	WSM35S	WSM45X	WSP45G	WHH15X	WKK25G	WKK25S	WKP25S	WKP35G	WKP35S	WXN15	WK10	WSM35G	WSM35S	WSM45X
	ROGX10T3M08-G88	G	8	10																				
	ROHX10T3M08-A57	H	8	10	⊕	⊕	⊕	⊕										⊕					⊕	
	ROMX10T3M08-D57	M	8	10		⊕	⊕	⊕																
	ROMX10T3M08-F67	M	8	10					⊕	⊕	⊕									⊕	⊕			
	ROMX10T3M08-A27	M	8	10		⊕	⊕	⊕		⊕	⊕	⊕									⊕	⊕		

HC = Coated carbide
HW = Uncoated carbide

Button insert milling cutters

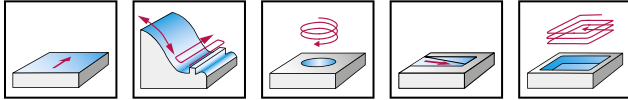
M5468 inch

RO . X10T3M0

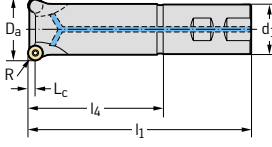
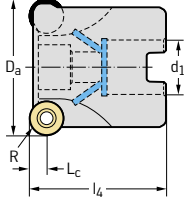
Xtra-tec® XT



- With indexing surfaces
- 8 cutting edges per indexable insert

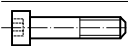


	P	M	K	N	S	H	O
M5468	●	●	●	●	●	●	●

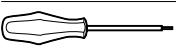
Tool	Designation	R inch	D _a inch	d ₁ inch	l ₄ inch	l ₁ inch	L _c inch	Z	 lbs	No. of indexable inserts	Type
	M5468.026-W26-03-05	0,197	1,000	1,000	2,5	4,781	0,197	3	0,825	3	RO . X10T3M0
	M5468.031-W31-04-05	0,197	1,250	1,250	2,5	4,781	0,197	4	1,294	4	
	M5468.038-W31-05-05	0,197	1,500	1,250	2,5	4,781	0,197	5	1,396	5	
DIN 1835 B											
	M5468.051-B19-06-05	0,197	2,000	0,750	1,750		0,197	6	0,597	6	RO . X10T3M0
Shell mill mount DIN 138 transverse keyway											

Bodies and assembly parts are included in the scope of delivery

Assembly parts

	D _a [inch]	1–1,5	2
	Clamping screw for indexable insert Tightening torque	FS2181 (T15IP) 2,213 lbs	FS2181 (T15IP) 2,213 lbs
	Clamping screw for arbour-mounted tools		FS1518

Accessories

	D _a [inch]	1–2
	Torque screwdriver, analogue	FS2004
	Torque screwdriver, digital	FS2248
	Interchangeable blade	FS2014 (T15IP)
	Screwdriver	FS1485 (T15IP)

Indexable inserts

	Designation	Tolerance class	Number of cutting edges	d inch	P				M				K				N		S				H	
					HC				HC				HC				HC	HW	HC					HC
					WHH15X	WKP25S	WKP35G	WKP35S	WSP45G	WSM35G	WSM35S	WSM45X	WSP45G	WHH15X	WKK25G	WKK25S	WKP25S	WKP35G	WKP35S	WXN15	WK10	WSM35G		WSM35S
	ROGX10T3M08-G88	G	8	0,394																				
	ROHX10T3M08-A57	H	8	0,394	⊕	⊕	⊕	⊕						⊕	⊕	⊕	⊕	⊕	⊕				⊕	
	ROMX10T3M08-D57	M	8	0,394		⊕	⊕	⊕	⊕	⊕	⊕		⊕	⊕	⊕	⊕	⊕	⊕			⊕	⊕		
	ROMX10T3M08-F67	M	8	0,394					⊕	⊕	⊕	⊕	⊕		⊕	⊕	⊕	⊕			⊕	⊕	⊕	
	ROMX10T3M0T8-A27	M	8	0,394		⊕	⊕	⊕						⊕	⊕	⊕	⊕	⊕						

HC = Coated carbide
HW = Uncoated carbide

Button insert milling cutters

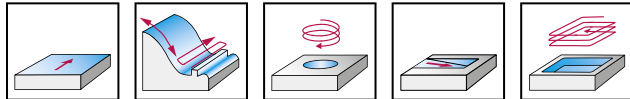
M5468 mm

RO . X1204M0

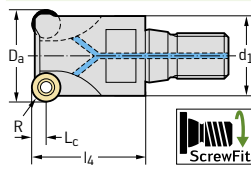
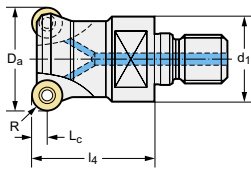
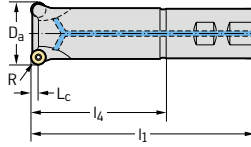
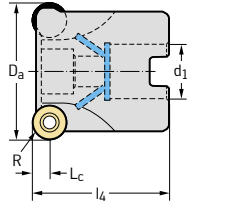
Xtra-tec® XT



- With indexing surfaces
- 8 cutting edges per indexable insert



	P	M	K	N	S	H	O
M5468	●	●	●	●	●	●	●

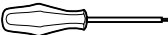
Tool	Designation	R mm	D _a mm	d ₁ mm	l ₄ mm	l ₁ mm	L _c mm	Z	kg	No. of indexable inserts	Type
 ScrewFit	M5468-024-T22-02-06	6	24	T22	35		6	2	0,08	2	RO . X1204M0
	M5468-032-T28-03-06	6	32	T28	40		6	3	0,17	3	
	M5468-040-T36-05-06	6	40	T36	40		6	5	0,3	5	
	M5468-042-T36-05-06	6	42	T36	40		6	5	0,31	5	
 Cylindrical modular	M5468-024-TC12-02-06	6	24	M12	35		6	2	0,07	2	RO . X1204M0
	M5468-032-TC16-03-06	6	32	M16	40		6	3	0,16	3	
	M5468-040-TC16-05-06	6	40	M16	40		6	5	0,18	5	
	M5468-042-TC16-05-06	6	42	M16	40		6	5	0,19	5	
 DIN 1835 B	M5468-024-W25-02-06	6	24	25	73	130	6	2	0,36	2	RO . X1204M0
	M5468-024-W25-02-06-XL	6	24	25	118	175	6	2	0,48	2	
	M5468-040-W40-04-06-XL	6	40	40	149	220	6	4	1,62	4	
 Shell mill mount DIN 138 transverse keyway	M5468-040-B16-04-06	6	40	16	40		6	4	0,13	4	RO . X1204M0
	M5468-040-B16-05-06	6	40	16	40		6	5	0,13	5	
	M5468-042-B16-05-06	6	42	16	40		6	5	0,15	5	
	M5468-050-B22-05-06	6	50	22	50		6	5	0,31	5	
	M5468-050-B22-06-06	6	50	22	50		6	6	0,31	6	
	M5468-052-B22-05-06	6	52	22	50		6	5	0,35	5	
	M5468-052-B22-06-06	6	52	22	50		6	6	0,35	6	
	M5468-063-B22-06-06	6	63	22	50		6	6	0,52	6	
	M5468-063-B22-07-06	6	63	22	50		6	7	0,51	7	
	M5468-066-B27-06-06	6	66	27	50		6	6	0,68	6	
	M5468-066-B27-07-06	6	66	27	50		6	7	0,62	7	
	M5468-080-B27-07-06	6	80	27	50		6	7	1,08	7	

Bodies and assembly parts are included in the scope of delivery

Assembly parts

	D _a [mm]	24	32–100	40
	Clamping screw for indexable insert Tightening torque	FS2080 (T15IP) 2,5 Nm	FS1453 (T15IP) 3,5 Nm	FS2080 (T15IP) 2,5 Nm

Accessories

	D _a [mm]	24–100
	Torque screwdriver, analogue	FS2003
	Torque screwdriver, digital	FS2248
	Interchangeable blade	FS2014 (T15IP)
	Screwdriver	FS1485 (T15IP)

Indexable inserts

	Designation	Tolerance class	Number of cutting edges	d mm	P					M				K					N		S			H	
					HC					HC				HC					HC	HW	HC			HC	
					WHH15X	WKP25S	WKP35G	WKP35S	WSP45G	WSM35G	WSM35S	WSM45X	WSP45G	WHH15X	WKP25S	WKP25S	WKP35G	WKP35S	WXN15	WK10	WSM35G	WSM35S	WSM45X	WSP45G	WHH15X
	ROGX1204M08-G88	G	8	12																					
	ROHX1204M08-A57	H	8	12	⊕	⊕	⊕	⊕							⊕	⊕	⊕					⊕			
	ROMX1204M08-D57	M	8	12		⊕	⊕	⊕							⊕	⊕	⊕	⊕	⊕						
	ROMX1204M08-F67	M	8	12					⊕	⊕	⊕	⊕							⊕	⊕					
	ROMX1204M0T8-A27	M	8	12		⊕	⊕	⊕							⊕	⊕	⊕	⊕	⊕		⊕				

HC = Coated carbide
HW = Uncoated carbide

Button insert milling cutters

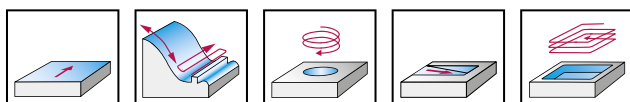
M5468 mm

RO . X1204M0

Xtra-tec® XT

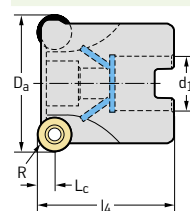


- With indexing surfaces
- 8 cutting edges per indexable insert



	P	M	K	N	S	H	O
M5468	●	●	●	●	●	●	●

Tool



Shell mill mount DIN 138 transverse keyway

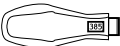
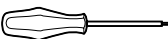
Designation	R mm	D _a mm	d ₁ mm	l ₄ mm	l ₁ mm	L _c mm	Z	kg	No. of indexable inserts	Type
M5468-080-B27-08-06	6	80	27	50		6	8	0,87	8	RO . X1204M0
M5468-100-B32-08-06	6	100	32	50		6	8	1,53	8	

Bodies and assembly parts are included in the scope of delivery

Assembly parts

	D _a [mm]	24	32–100	40
	Clamping screw for indexable insert Tightening torque	FS2080 (T15IP) 2,5 Nm	FS1453 (T15IP) 3,5 Nm	FS2080 (T15IP) 2,5 Nm

Accessories

	D _a [mm]	24–100
	Torque screwdriver, analogue	FS2003
	Torque screwdriver, digital	FS2248
	Interchangeable blade	FS2014 (T15IP)
	Screwdriver	FS1485 (T15IP)

Indexable inserts

	Designation	Tolerance class	Number of cutting edges	d mm	P					M				K					N		S				H
					HC					HC				HC					HC	HW	HC				HC
					WHH15X	WKP25S	WKP35G	WKP35S	WSP45G	WSM35G	WSM35S	WSM45X	WSP45G	WHH15X	WKP25S	WKP25S	WKP35G	WKP35S	WXN15	WK10	WSM35G	WSM35S	WSM45X	WSP45G	WHH15X
	ROGX1204M08-G88	G	8	12																					
	ROHX1204M08-A57	H	8	12	⊕	⊕	⊕	⊕														⊕			
	ROMX1204M08-D57	M	8	12		⊕	⊕	⊕																	
	ROMX1204M08-F67	M	8	12					⊕	⊕	⊕														
	ROMX1204M0T8-A27	M	8	12		⊕	⊕	⊕																	

HC = Coated carbide
HW = Uncoated carbide

Button insert milling cutters

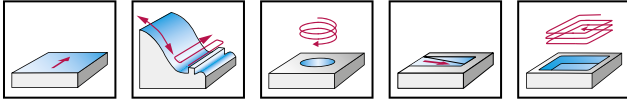
M5468 inch

RO . X1204M0

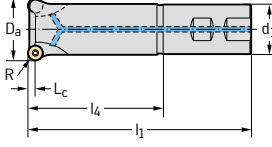
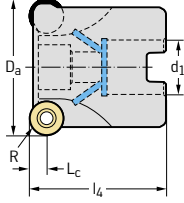
Xtra-tec® XT



- With indexing surfaces
- 8 cutting edges per indexable insert

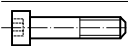


	P	M	K	N	S	H	O
M5468	●	●	●	●	●	●	●

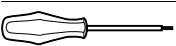
Tool	Designation	R inch	D _a inch	d ₁ inch	l ₄ inch	l ₁ inch	L _c inch	Z	 lbs	No. of indexable inserts	Type
 DIN 1835 B	M5468.038-W31-04-06	0,236	1,500	1,250	2,5	4,781	0,236	4	1,376	4	RO . X1204M0
	M5468.051-B19-06-06	0,236	2,000	0,750	1,750		0,236	6	0,575	6	RO . X1204M0
	M5468.064-B26-07-06	0,236	2,500	1,000	2,000		0,236	7	1,076	7	
	M5468.076-B26-08-06	0,236	3,000	1,000	2,000		0,236	8	1,742	8	
	M5468.102-B38-08-06	0,236	4,000	1,500	2,500		0,236	8	4,242	8	
 Shell mill mount DIN 138 transverse keyway											

Bodies and assembly parts are included in the scope of delivery

Assembly parts

	D _a [inch]	1,5	2	2,5-3	4
	Clamping screw for indexable insert Tightening torque	FS1453 (T15IP) 2,581 lbs	FS1453 (T15IP) 2,581 lbs	FS1453 (T15IP) 2,581 lbs	FS1453 (T15IP) 2,581 lbs
	Clamping screw for arbour-mounted tools		FS1518	FS1519	FS1583

Accessories

	D _a [inch]	1,5-4
	Torque screwdriver, analogue	FS2004
	Torque screwdriver, digital	FS2248
	Interchangeable blade	FS2014 (T15IP)
	Screwdriver	FS1485 (T15IP)

Indexable inserts

	Designation	Tolerance class	Number of cutting edges	d inch	P				M				K				N		S				H	
					HC				HC				HC				HC	HW	HC					HC
					WHH15X	WKP25S	WKP35G	WKP35S	WSP45G	WSM35G	WSM35S	WSM45X	WSP45G	WHH15X	WKK25G	WKK25S	WKP25S	WKP35G	WKP35S	WXN15	WK10	WSM35G		WSM35S
	ROGX1204M08-G88	G	8	0,472																				
	ROHX1204M08-A57	H	8	0,472	⊕	⊕	⊕	⊕						⊕	⊕	⊕	⊕	⊕	⊕	⊕	⊕		⊕	
	ROMX1204M08-D57	M	8	0,472		⊕	⊕	⊕	⊕	⊕	⊕		⊕	⊕	⊕	⊕	⊕	⊕	⊕	⊕		⊕		
	ROMX1204M08-F67	M	8	0,472					⊕	⊕	⊕	⊕	⊕									⊕	⊕	
	ROMX1204M0T8-A27	M	8	0,472		⊕	⊕	⊕						⊕	⊕	⊕	⊕	⊕	⊕					

HC = Coated carbide
HW = Uncoated carbide

Button insert milling cutters

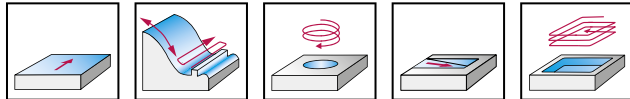
M5468 mm

RO . X1605M0

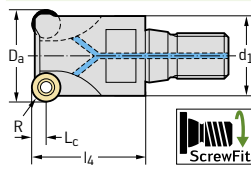
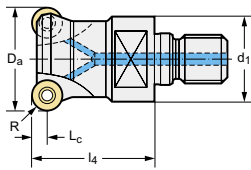
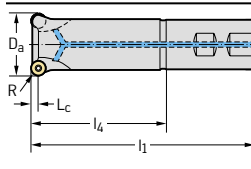
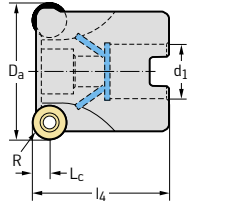
Xtra-tec® XT



- With indexing surfaces
- 8 cutting edges per indexable insert



	P	M	K	N	S	H	O
M5468	●	●	●	●	●	●	●

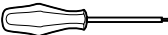
Tool	Designation	R mm	D _a mm	d ₁ mm	l ₄ mm	l ₁ mm	L _c mm	Z	kg	No. of indexable inserts	Type
 ScrewFit	M5468-032-T28-02-08	8	32	T28	40		8	2	0,14	2	RO . X1605M0
 Cylindrical modular	M5468-032-TC16-02-08	8	32	M16	40		8	2	0,14	2	RO . X1605M0
 DIN 1835 B	M5468-032-W32-02-08	8	32	32	99	160	8	2	0,74	2	RO . X1605M0
	M5468-032-W32-02-08-XL	8	32	32	159	220	8	2	1,03	2	
 Shell mill mount DIN 138 transverse keyway	M5468-052-B22-04-08	8	52	22	50		8	4	0,32	4	RO . X1605M0
	M5468-052-B22-05-08	8	52	22	50		8	5	0,38	5	
	M5468-063-B22-05-08	8	63	22	50		8	5	0,49	5	
	M5468-063-B22-06-08	8	63	22	50		8	6	0,49	6	
	M5468-066-B27-05-08	8	66	27	50		8	5	0,57	5	
	M5468-066-B27-06-08	8	66	27	50		8	6	0,66	6	
	M5468-080-B27-06-08	8	80	27	50		8	6	0,82	6	
	M5468-080-B27-07-08	8	80	27	50		8	7	0,82	7	
	M5468-100-B32-07-08	8	100	32	50		8	7	1,43	7	
	M5468-125-B40-08-08	8	125	40	63		8	8	2,79	8	

Bodies and assembly parts are included in the scope of delivery

Assembly parts

	D _a [mm]	32	52–125
	Clamping screw for indexable insert Tightening torque	FS2281 (T20IP) 5 Nm	FS1495 (T20IP) 5 Nm

Accessories

	D _a [mm]	32–125
	Torque screwdriver, analogue	FS2003
	Torque screwdriver, digital	FS2248
	Interchangeable blade	FS2015 (T20IP)
	Screwdriver	FS1486 (T20IP)

Indexable inserts

	Designation	Tolerance class	Number of cutting edges	d mm	P				M				K					N		S			H
					HC				HC				HC					HC	HW	HC			HC
					WHH15X	WKP25S	WKP35G	WKP35S	WSP45G	WSM35G	WSM35S	WSM45X	WSP45G	WHH15X	WKK25G	WKK25S	WKP25S	WKP35G	WKP35S	WXN15	WK10	WSM35G	WSM35S
	ROGX1605M08-G88	G	8	16																			
	ROHX1605M08-A57	H	8	16																			
	ROMX1605M08-D57	M	8	16																			
	ROMX1605M08-F67	M	8	16																			
	ROMX1605M0T8-A27	M	8	16																			

HC = Coated carbide
HW = Uncoated carbide

Button insert milling cutters

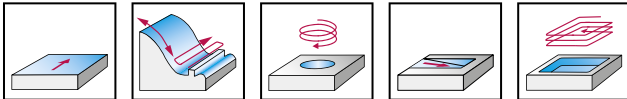
M5468 inch

RO . X1605M0

Xtra-tec® XT

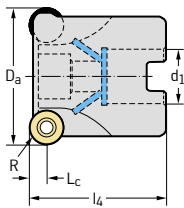


- With indexing surfaces
- 8 cutting edges per indexable insert



	P	M	K	N	S	H	O
M5468	●	●	●	●	●	●	●

Tool

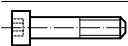


Shell mill mount DIN 138 transverse keyway

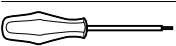
Designation	R inch	D _a inch	d ₁ inch	l ₄ inch	L _c inch	Z	 lbs	No. of indexable inserts	Type
M5468.064-B26-06-08	0,315	2,500	1,000	2,000	0,315	6	1,023	6	RO . X1605M0
M5468.076-B26-07-08	0,315	3,000	1,000	2,000	0,315	7	1,642	7	
M5468.102-B38-07-08	0,315	4,000	1,500	2,500	0,315	7	4,043	7	
M5468.127-B38-08-08	0,315	5,000	1,500	2,500	0,315	8	5,849	8	

Bodies and assembly parts are included in the scope of delivery

Assembly parts

	D _a [inch]	2,5–3	4–5
	Clamping screw for indexable insert Tightening torque	FS1495 (T20IP) 3,688 lbs	FS1495 (T20IP) 3,688 lbs
	Clamping screw for arbour-mounted tools	FS1519	FS1583

Accessories

	D _a [inch]	2,5–5
	Torque screwdriver, analogue	FS2004
	Torque screwdriver, digital	FS2248
	Interchangeable blade	FS2015 (T20IP)
	Screwdriver	FS1486 (T20IP)

Indexable inserts

	Designation	Tolerance class	Number of cutting edges	d inch	P					M				K					N		S				H
					HC					HC				HC					HC	HW	HC				HC
					WHH15X	WKP25S	WKP35G	WKP35S	WSP45G	WSM35G	WSM35S	WSM45X	WSP45G	WHH15X	WKP25G	WKP25S	WKP35G	WKP35S	WXN15	WK10	WSM35G	WSM35S	WSM45X	WSP45G	WHH15X
	ROGX1605M08-G88	G	8	0,630																					
	ROHX1605M08-A57	H	8	0,630	⊕	⊕	⊕	⊕						⊕	⊕	⊕	⊕	⊕	⊕	⊕					⊕
	ROMX1605M08-D57	M	8	0,630		⊕	⊕	⊕	⊕	⊕	⊕	⊕	⊕		⊕	⊕	⊕	⊕			⊕	⊕	⊕	⊕	
	ROMX1605M08-F67	M	8	0,630					⊕	⊕	⊕	⊕	⊕		⊕	⊕	⊕	⊕			⊕	⊕	⊕	⊕	
	ROMX1605M0T8-A27	M	8	0,630		⊕	⊕	⊕						⊕	⊕	⊕	⊕	⊕							

HC = Coated carbide
HW = Uncoated carbide

Button insert milling cutters

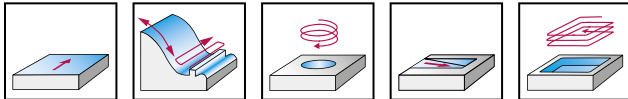
M5468 mm

RO . X2006M0

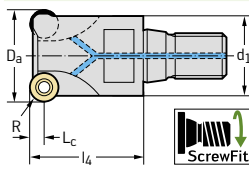
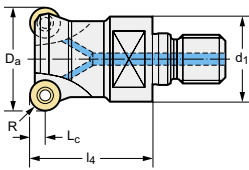
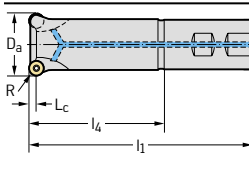
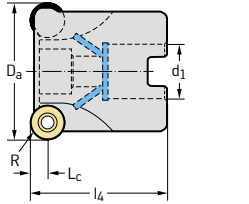
Xtra-tec® XT



- With indexing surfaces
- 8 cutting edges per indexable insert



	P	M	K	N	S	H	O
M5468	●	●	●	●	●	●	●

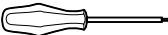
Tool	Designation	R mm	D _a mm	d ₁ mm	l ₄ mm	l ₁ mm	L _c mm	Z	kg	No. of indexable inserts	Type
 ScrewFit	M5468-040-T36-02-10	10	40	T36	40		10	2	0,25	2	RO . X2006M0
 Cylindrical modular	M5468-040-TC16-02-10	10	40	M16	40		10	2	0,15	2	RO . X2006M0
 DIN 1835 B	M5468-040-W40-02-10	10	40	40	119	190	10	2	1,44	2	RO . X2006M0
 Shell mill mount DIN 138 transverse keyway	M5468-063-B22-04-10	10	63	22	50		10	4	0,43	4	RO . X2006M0
	M5468-063-B22-05-10	10	63	22	50		10	5	0,42	5	
	M5468-080-B27-05-10	10	80	27	50		10	5	0,74	5	
	M5468-080-B27-06-10	10	80	27	50		10	6	0,73	6	
	M5468-100-B32-06-10	10	100	32	50		10	6	1,41	6	
	M5468-100-B32-07-10	10	100	32	50		10	7	1,4	7	
	M5468-125-B40-07-10	10	125	40	63		10	7	2,86	7	
	M5468-125-B40-08-10	10	125	40	63		10	8	2,84	8	
	M5468-160-B40-08-10	10	160	40	63		10	8	2,67	8	
	M5468-160-B40-10-10	10	160	40	63		10	10	2,76	10	

Bodies and assembly parts are included in the scope of delivery

Assembly parts

	D _a [mm]	40–160
	Clamping screw for indexable insert Tightening torque	FS2614 (T20IP) 5 Nm

Accessories

	D _a [mm]	40–160
	Torque screwdriver, analogue	FS2003
	Torque screwdriver, digital	FS2248
	Interchangeable blade	FS2015 (T20IP)
	Screwdriver	FS1486 (T20IP)

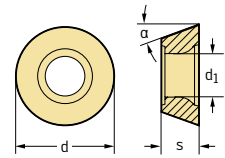
Indexable inserts

	Designation	Tolerance class	Number of cutting edges	d mm	P					M			K					N		S			H
					HC					HC			HC					HC	HW	HC			HC
					WHH15X	WKP25S	WKP35G	WKP35S	WSP45G	WSM35G	WSM35S	WSP45G	WHH15X	WKK25G	WKK25S	WKP25S	WKP35G	WKP35S	WXN15	WK10	WSM35G	WSM35S	WSP45G
	ROGX2006M08-G88	G	8	20																			
	ROHX2006M08-A57	H	8	20	Ⓒ	Ⓒ	Ⓒ	Ⓒ							Ⓒ	Ⓒ	Ⓒ	Ⓒ	Ⓒ			Ⓒ	
	ROHX2006M08-D57	H	8	20																			
	ROHX2006M0T8-A27	H	8	20				Ⓒ															
	ROMX2006M08-D57	M	8	20		Ⓒ	Ⓒ	Ⓒ	Ⓒ	Ⓒ	Ⓒ	Ⓒ			Ⓒ	Ⓒ	Ⓒ	Ⓒ	Ⓒ	Ⓒ			
	ROMX2006M0T8-A27	M	8	20		Ⓒ	Ⓒ	Ⓒ	Ⓒ						Ⓒ			Ⓒ	Ⓒ	Ⓒ			

HC = Coated carbide
HW = Uncoated carbide

Positive round RDHX / RDGX / RDMX

Tiger-tec® Gold



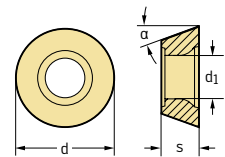
Indexable inserts

	Designation	Tolerance class	d mm	s mm	α	d ₁ mm	P				M		K			N	S	H
							HC				HC		HC			HW	HC	HC
							WKP25S	WKP35G	WKP35S	WSP45G	WSM35S	WSP45G	WKP25S	WKP35G	WKP35S	WK10	WSM35S	WSP45G
	RDHX0501M0-A57	H	5	1,5	15°	2,2												
	RDHX07T1M0-A57	H	7	1,98	15°	2,8												
	RDGX0501M0-G88	G	5	1,5	15°	2,2												
	RDGX07T1M0-G88	G	7	1,98	15°	2,8												
	RDMX0501M0-D57	M	5	1,5	15°	2,2												
	RDMX07T1M0-D57	M	7	1,98	15°	2,8												

HC = Coated carbide
HW = Uncoated carbide

Positive round ROGX / ROHX / ROMX

Tiger-tec® Gold



Indexable inserts

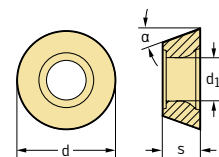
Designation		Tolerance class	Number of cutting edges	d mm	s mm	α	d ₁ mm	P HC				M HC				K HC				N HW		S HC				H HC
								WKP25S	WKP35G	WKP35S	WSP45G	WSP45S	WSM35S	WSM45X	WSP45G	WSP45S	WHH15X	WKK25S	WKP25S	WKP35G	WKP35S	WKN15	WK10	WSM35S	WSM45X	
	ROGX0803M04-G88	G	4	8	3,18	11°	3,4													✗	✗					
	ROGX2006M08-G88	G	8	20	6,35	15°	6,5													✗	✗					
	ROGX10T3M08-G88	G	8	10	3,97	11°	3,9													✗	✗					
	ROGX1204M08-G88	G	8	12	4,76	11°	4,4													✗	✗					
	ROGX1605M08-G88	G	8	16	5,56	15°	5,5													✗	✗					
	ROHX0803M04-A57	H	4	8	3,18	11°	3,4	✗	✗	✗							✗	✗	✗	✗	✗				✗	
	ROHX0803M04-D57	H	4	8	3,18	11°	3,4			✗	✗		✗	✗					✗			✗	✗			
	ROHX0803M04-D67	H	4	8	3,18	11°	3,4			✗			✗										✗			

HW = Uncoated carbide
HC = Coated carbide

Positive round

ROGX / ROHX / ROMX

Tiger-tec® Gold



Indexable inserts

Designation		Tolerance class	Number of cutting edges	d mm	s mm	α	d ₁ mm	P HC					M HC				K HC					N HW	S HC				H HC
								WKP25S	WKP35G	WKP35S	WSP45G	WSP45S	WSM35S	WSM45X	WSP45G	WSP45S	WHH15X	WKK25S	WKP25S	WKP35G	WKP35S	WK10	WSM35S	WSM45X	WSP45G	WSP45S	WHH15X
	ROHX2006M0T8-A27	H	8	20	6,35	15°	6,5																				
	ROHX2006M08-A57	H	8	20	6,35	15°	6,5																				
	ROHX10T3M08-A57	H	8	10	3,97	11°	3,9																				
	ROHX1204M08-A57	H	8	12	4,76	11°	4,4																				
	ROHX1605M08-A57	H	8	16	5,56	15°	5,5																				
	ROHX2006M08-D57	H	8	20	6,35	15°	6,5																				
	ROMX0803M04-D57	M	4	8	3,18	11°	3,4																				
	ROMX2006M0T8-A27	M	8	20	6,35	15°	6,5																				
	ROMX10T3M0T8-A27	M	8	10	3,97	11°	3,9																				
	ROMX1204M0T8-A27	M	8	12	4,76	11°	4,4																				
	ROMX1605M0T8-A27	M	8	16	5,56	15°	5,5																				
	ROMX2006M08-D57	M	8	20	6,35	15°	6,5																				
	ROMX10T3M08-D57	M	8	10	3,97	11°	3,9																				
	ROMX1204M08-D57	M	8	12	4,76	11°	4,4																				
	ROMX1605M08-D57	M	8	16	5,56	15°	5,5																				
	ROMX10T3M08-F67	M	8	10	3,97	11°	3,9																				
	ROMX1204M08-F67	M	8	12	4,76	11°	4,4																				
	ROMX1605M08-F67	M	8	16	5,56	15°	5,5																				

HW = Uncoated carbide
HC = Coated carbide

Copy finishing cutters

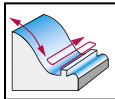
M5460

mm

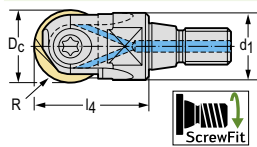
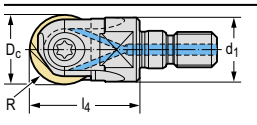
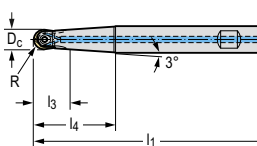
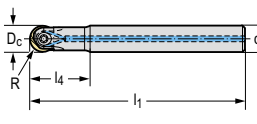
Xtra-tec® XT



- Steel shank
- Linear measurements relative to metric cutting edge diameter

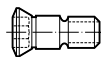


	P	M	K	N	S	H	O
M5460	●	●	●	●	●	●	●

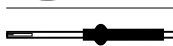
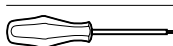
Tool	Designation	D _c mm	R mm	d ₁ mm	l ₄ mm	l ₁ mm	Z	kg	No. of indexable inserts	T Nm	Type
 ScrewFit	M5460-008-T09-02-04	8	4	T09	20		2	0,01	1	6	P320 . -D08
	M5460-010-T09-02-05	10	5	T09	25		2	0,01	1	6	P320 . -D10
	M5460-012-T09-02-06	12	6	T09	25		2	0,01	1	6	P320 . -D12
	M5460-012-T14-02-06	12	6	T14	25		2	0,02	1	25	
	M5460-016-T14-02-08	16	8	T14	25		2	0,03	1	25	P320 . -D16
	M5460-020-T18-02-10	20	10	T18	30		2	0,05	1	50	P320 . -D20
	M5460-025-T22-02-12	25	12,5	T22	35		2	0,08	1	80	P320 . -D25
	M5460-030-T28-02-15	30	15	T28	40		2	0,15	1	150	P320 . -D30
 Cylindrical modular	M5460-032-T28-02-16	32	16	T28	40		2	0,15	1	150	P320 . -D32
	M5460-008-TC06-02-04	8	4	M6	20		2	0,01	1		P320 . -D08
	M5460-010-TC06-02-05	10	5	M6	25		2	0,01	1		P320 . -D10
	M5460-012-TC06-02-06	12	6	M6	25		2	0,01	1		P320 . -D12
	M5460-016-TC08-02-08	16	8	M8	25		2	0,02	1		P320 . -D16
	M5460-020-TC10-02-10	20	10	M10	30		2	0,05	1		P320 . -D20
	M5460-025-TC12-02-12	25	12,5	M12	35		2	0,08	1		P320 . -D25
	M5460-030-TC16-02-15	30	15	M16	40		2	0,14	1		P320 . -D30
 DIN 1835 B	M5460-032-TC16-02-16	32	16	M16	40		2	0,14	1		P320 . -D32
	M5460-008-W12-02-04	8	4	12	50	140	2	0,1	1		P320 . -D08
	M5460-010-W12-02-05	10	5	12	35	150	2	0,11	1		P320 . -D10
	M5460-012-W16-02-06	12	6	16	58,5	160	2	0,2	1		P320 . -D12
	M5460-016-W20-02-08	16	8	20	65	175	2	0,34	1		P320 . -D16
	M5460-020-W25-02-10	20	10	25	76	190	2	0,57	1		P320 . -D20
	M5460-025-W32-02-12	25	12,5	32	98	210	2	1,01	1		P320 . -D25
 Cylindrical shank	M5460-008-A10-02-04	8	4	10	25	110	2	0,05	1		P320 . -D08
	M5460-010-A12-02-05	10	5	12	30	130	2	0,09	1		P320 . -D10
	M5460-012-A12-02-06	12	6	12	32	130	2	0,09	1		P320 . -D12
	M5460-016-A16-02-08	16	8	16	36	140	2	0,18	1		P320 . -D16
	M5460-020-A20-02-10	20	10	20	45	160	2	0,32	1		P320 . -D20
	M5460-025-A25-02-12	25	12,5	25	45	160	2	0,42	1		P320 . -D25
	M5460-030-A32-02-15	30	15	32	56	175	2	0,89	1		P320 . -D30
	M5460-032-A32-02-16	32	16	32	56	175	2	0,9	1		P320 . -D32

Bodies and assembly parts are included in the scope of delivery

Assembly parts

	D _c [mm]	8	10	12	16	20	25	30–32
	Clamping screw for indexable insert Tightening torque	FS2070 (T8IP) 2 Nm	FS2071 (T15IP) 4 Nm	FS2072 (T20IP) 5 Nm	FS2073 (T20IP) 5 Nm	FS2074 (T20IP) 5 Nm	FS2075 (T20IP) 5 Nm	FS2107 (T30IP) 6 Nm

Accessories

	D _c [mm]	8	10	12–25	30–32
	Torque T-handle				FS2041
	Torque screwdriver, analogue	FS2003	FS2003	FS2003	
	Torque screwdriver, digital	FS2248	FS2248	FS2248	FS2248
	Interchangeable blade	FS2012 (T8IP)	FS2014 (T15IP)	FS2015 (T20IP)	FS2108 (T30IP)
	Screwdriver	FS1483 (T8IP)	FS1485 (T15IP)	FS1486 (T20IP)	FS2109 (T30IP)

Indexable inserts

	Designation	D _c ^{-0,03} mm	P				M			K		S			H
			WHH15X	WKP25	WSP46	WSP46G	WSM36	WSP46	WSP46G	WHH15X	WKP25	WSM36	WSP46	WSP46G	WHH15X
	P3201-D08	8	⊗							⊗					⊗
	P3201-D10	10	⊗	⊗						⊗	⊗				⊗
	P3201-D12	12	⊗	⊗						⊗	⊗				⊗
	P3201-D16	16	⊗	⊗						⊗	⊗				⊗
	P3201-D20	20	⊗	⊗						⊗	⊗				⊗
	P3201-D25	25	⊗	⊗						⊗	⊗				⊗
	P3201-D30	30	⊗							⊗					⊗
	P3201-D32	32	⊗							⊗					⊗
	P3204-D08	8		⊗	⊗	⊗	⊗	⊗	⊗	⊗		⊗	⊗	⊗	⊗
	P3204-D10	10		⊗	⊗	⊗	⊗	⊗	⊗	⊗		⊗	⊗	⊗	⊗
	P3204-D12	12		⊗	⊗	⊗	⊗	⊗	⊗	⊗		⊗	⊗	⊗	⊗
	P3204-D16	16		⊗	⊗	⊗	⊗	⊗	⊗	⊗		⊗	⊗	⊗	⊗
	P3204-D20	20		⊗	⊗	⊗	⊗	⊗	⊗	⊗		⊗	⊗	⊗	⊗
	P3204-D25	25		⊗	⊗	⊗	⊗	⊗	⊗	⊗		⊗	⊗	⊗	⊗
	P3204-D30	30		⊗	⊗	⊗	⊗	⊗	⊗	⊗		⊗	⊗	⊗	⊗
	P3204-D32	32		⊗	⊗	⊗	⊗	⊗	⊗	⊗		⊗	⊗	⊗	⊗

HC = Coated carbide

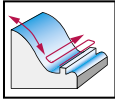
Copy finishing cutters

M5460 mm

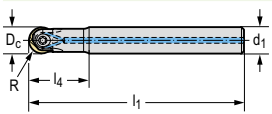
Xtra-tec® XT



- Steel shank
- Linear measurements relative to metric cutting edge diameter

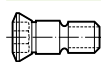


	P	M	K	N	S	H	O
M5460	●	●	●	●	●	●	●

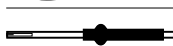
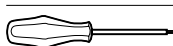
Tool	Designation	D _c mm	R mm	d ₁ mm	l ₄ mm	l ₁ mm	Z	kg	No. of indexable inserts	T Nm	Type
 Cylindrical shank	M5460-008-A08-02-04-C	8	4	8	25	70	2	0,02	1		P320 . -D08
	M5460-008-A08-02-04-C-L	8	4	8	55	100	2	0,03	1		
	M5460-008-A08-02-04-C-XL	8	4	8	105	150	2	0,05	1		
	M5460-010-A10-02-05-C	10	5	10	30	80	2	0,04	1		P320 . -D10
	M5460-010-A10-02-05-C-L	10	5	10	70	120	2	0,06	1		
	M5460-010-A10-02-05-C-XL	10	5	10	100	150	2	0,07	1		
	M5460-012-A12-02-06-C	12	6	12	32	90	2	0,07	1		P320 . -D12
	M5460-012-A12-02-06-C-L	12	6	12	87	145	2	0,1	1		
	M5460-012-A12-02-06-C-XL	12	6	12	142	200	2	0,27	1		
	M5460-016-A16-02-08-C	16	8	16	43	110	2	0,14	1		P320 . -D16
	M5460-016-A16-02-08-C-L	16	8	16	73	140	2	0,18	1		
	M5460-016-A16-02-08-C-XL	16	8	16	128	195	2	0,24	1		
	M5460-020-A20-02-10-C	20	10	20	47	130	2	0,49	1		P320 . -D20
	M5460-020-A20-02-10-C-L	20	10	20	107	190	2	0,39	1		
	M5460-025-A25-02-12-C	25	12,5	25	77	160	2	0,9	1		P320 . -D25
	M5460-025-A25-02-12-C-L	25	12,5	25	167	250	2	1,43	1		

Bodies and assembly parts are included in the scope of delivery

Assembly parts

D _c [mm]	8	10	12	16	20	25	30–32
 Clamping screw for indexable insert Tightening torque	FS2070 (T8IP) 2 Nm	FS2071 (T15IP) 4 Nm	FS2072 (T20IP) 5 Nm	FS2073 (T20IP) 5 Nm	FS2074 (T20IP) 5 Nm	FS2075 (T20IP) 5 Nm	FS2107 (T30IP) 6 Nm

Accessories

D _c [mm]	8	10	12–25	30–32
 Torque T-handle				FS2041
 Torque screwdriver, analogue	FS2003	FS2003	FS2003	
 Torque screwdriver, digital	FS2248	FS2248	FS2248	FS2248
 Interchangeable blade	FS2012 (T8IP)	FS2014 (T15IP)	FS2015 (T20IP)	FS2108 (T30IP)
 Screwdriver	FS1483 (T8IP)	FS1485 (T15IP)	FS1486 (T20IP)	FS2109 (T30IP)

Indexable inserts

Designation	D _c ^{-0,03} mm	P				M			K		S			H
		WHH15X	WKP25	WSP46	WSP46G	WSM36	WSP46	WSP46G	WHH15X	WKP25	WSM36	WSP46	WSP46G	WHH15X
 P3201-D08	8	⊗							⊗					⊗
P3201-D10	10	⊗	⊗						⊗	⊗				⊗
P3201-D12	12	⊗	⊗						⊗	⊗				⊗
P3201-D16	16	⊗	⊗						⊗	⊗				⊗
P3201-D20	20	⊗	⊗						⊗	⊗				⊗
P3201-D25	25	⊗	⊗						⊗	⊗				⊗
P3201-D30	30	⊗							⊗					⊗
P3201-D32	32	⊗							⊗					⊗
 P3204-D08	8		⊗	⊗	⊗	⊗	⊗	⊗	⊗		⊗	⊗	⊗	⊗
P3204-D10	10		⊗	⊗	⊗	⊗	⊗	⊗	⊗		⊗	⊗	⊗	⊗
P3204-D12	12		⊗	⊗	⊗	⊗	⊗	⊗	⊗		⊗	⊗	⊗	⊗
P3204-D16	16		⊗	⊗	⊗	⊗	⊗	⊗	⊗		⊗	⊗	⊗	⊗
P3204-D20	20		⊗	⊗	⊗	⊗	⊗	⊗	⊗		⊗	⊗	⊗	⊗
P3204-D25	25		⊗	⊗	⊗	⊗	⊗	⊗	⊗		⊗	⊗	⊗	⊗
P3204-D30	30		⊗	⊗	⊗	⊗	⊗	⊗	⊗		⊗	⊗	⊗	⊗
P3204-D32	32		⊗	⊗	⊗	⊗	⊗	⊗	⊗		⊗	⊗	⊗	⊗

HC = Coated carbide

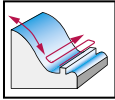
Copy finishing cutters

M5460 inch

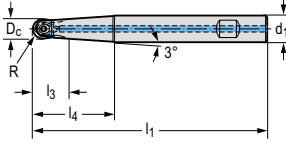
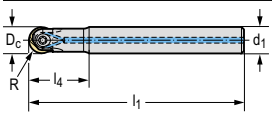
Xtra-tec® XT



- Steel shank
- Linear measurements relative to metric cutting edge diameter



	P	M	K	N	S	H	O
M5460	●	●	●	●	●	●	●

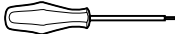
Tool	Designation	D _c inch	R inch	d ₁ inch	l ₄ inch	l ₁ inch	Z		No. of indexable inserts	Type
 DIN 1835 B	M5460.009-W13-02-05	0,375	0,187	0,500	1,378	5,906	2	0,262	1	P320 . -D09.52
	M5460.013-W15-02-06	0,500	0,250	0,625	2,303	6,299	2	0,430	1	P320 . -D12.7
	M5460.015-W19-02-08	0,625	0,312	0,750	2,559	6,890	2	0,688	1	P320 . -D15.87
	M5460.019-W26-02-10	0,750	0,375	1,000	2,992	7,48	2	1,287	1	P320 . -D19.05
	M5460.026-W31-02-13	1,000	0,500	1,250	3,858	8,268	2	2,18	1	P320 . -D25.4
 Cylindrical shank	M5460.009-A13-02-05	0,375	0,187	0,500	1,307	5,118	2	0,216	1	P320 . -D09.52
	M5460.013-A13-02-06	0,500	0,250	0,500	1,331	5,118	2	0,225	1	P320 . -D12.7
	M5460.015-A15-02-08	0,625	0,312	0,625	1,48	5,512	2	0,384	1	P320 . -D15.87
	M5460.019-A19-02-10	0,750	0,375	0,750	1,807	6,299	2	0,648	1	P320 . -D19.05
	M5460.026-A26-02-13	1,000	0,500	1,000	1,854	6,299	2	1,111	1	P320 . -D25.4

Bodies and assembly parts are included in the scope of delivery

Assembly parts

	D _c [inch]	0,375	0,5	0,625	0,75	1
	Clamping screw for indexable insert Tightening torque	FS2071 (T15IP) 2,95 lbs	FS2072 (T20IP) 3,688 lbs	FS2073 (T20IP) 3,688 lbs	FS2074 (T20IP) 3,688 lbs	FS2075 (T20IP) 3,688 lbs

Accessories

	D _c [inch]	0,375	0,5–1
	Torque screwdriver, analogue	FS2004	FS2004
	Torque screwdriver, digital	FS2248	FS2248
	Interchangeable blade	FS2014 (T15IP)	FS2015 (T20IP)
	Screwdriver	FS1485 (T15IP)	FS1486 (T20IP)

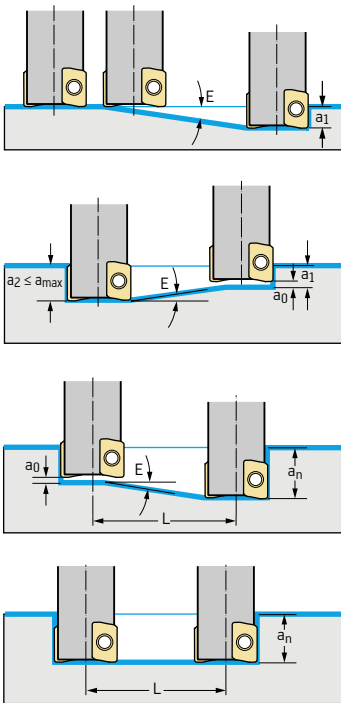
Indexable inserts

	Designation	D _c ^{-0,03} inch	P		M		K		S		H	
			HC	WSP46	HC	WSP46G	HC	WSP46	HC	WSP46G	HC	WSP46
	P3201-D09.52	0,375	⊕	⊗	⊗	⊗	⊗	⊗	⊗	⊗	⊗	⊗
	P3204-D09.52	0,375	⊗	⊗	⊗	⊗	⊗	⊗	⊗	⊗	⊗	⊗
	P3201-D12.7	0,500	⊕	⊗	⊗	⊗	⊗	⊗	⊗	⊗	⊗	⊗
	P3204-D12.7	0,500	⊗	⊗	⊗	⊗	⊗	⊗	⊗	⊗	⊗	⊗
	P3201-D15.87	0,625	⊕	⊗	⊗	⊗	⊗	⊗	⊗	⊗	⊗	⊗
	P3204-D15.87	0,625	⊗	⊗	⊗	⊗	⊗	⊗	⊗	⊗	⊗	⊗
	P3201-D19.05	0,750	⊕	⊗	⊗	⊗	⊗	⊗	⊗	⊗	⊗	⊗
	P3204-D19.05	0,750	⊗	⊗	⊗	⊗	⊗	⊗	⊗	⊗	⊗	⊗
	P3201-D25.4	1,000	⊕	⊗	⊗	⊗	⊗	⊗	⊗	⊗	⊗	⊗
	P3204-D25.4	1,000	⊗	⊗	⊗	⊗	⊗	⊗	⊗	⊗	⊗	⊗

HC = Coated carbide

Application information for M5130 shoulder milling cutter

Ramping and circular plunging into solid material

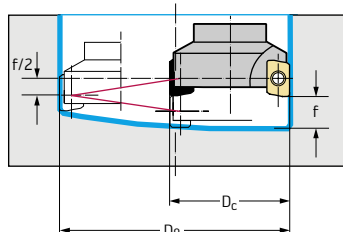


Plunging with M5130 shoulder milling cutter/plunging angle $E_{\max}$ [°]

Milling cutter dia.	AC..0602.. $a_{p \max} = 5 \text{ mm}$				BC..0903.. $a_{p \max} = 9 \text{ mm}$				BC..1204.. $a_{p \max} = 12 \text{ mm}$				BC1605.. $a_{p \max} = 15 \text{ mm}$			
D_c [mm]	$E_{\max}$ [°]	$D_{0 \min}$ [mm]	$D_{0 \max}$ [mm]	a_0 [mm]	$E_{\max}$ [°]	$D_{0 \min}$ [mm]	$D_{0 \max}$ [mm]	a_0 [mm]	$E_{\max}$ [°]	$D_{0 \min}$ [mm]	$D_{0 \max}$ [mm]	a_0 [mm]	$E_{\max}$ [°]	$D_{0 \min}$ [mm]	$D_{0 \max}$ [mm]	a_0 [mm]
10	6,7	15	20	0,58												
12	4,0	18	24	0,57												
14	3,7	21	28	0,57												
16	3,0	25	32	0,56	8,4	20,2	32	1,2								
18	2,5	29	36	0,56	6,7	24,2	36	1,2								
20	2,1	33	40	0,56	5,4	28,2	40	1,1								
22	1,9	37	44	0,56	4,6	32,2	44	1,1	7,1	30	44	1,6				
25	1,6	43	50	0,56	3,8	38,2	50	1,1	5,8	36	50	1,6	8,8	32	50	2
28													7,1	38	56	2
32	1,2	57	64	0,56	2,6	52,2	64	1,1	3,8	50	64	1,5	5,8	46	64	2
35													5,0	52	70	2
40	0,9	73	80	0,56	2,0	68,2	80	1,1	2,8	66	80	1,5	4,1	62	80	2
42													3,8	66	84	2
50	0,7	73	100	0,56	1,6	88,2	100	1,1	2,1	86	100	1,5	3,0	82	100	2
52													2,9	86	104	2
63	0,5	119	126	0,56	1,2	114,2	126	1,1	1,6	112	126	1,5	2,3	108	126	2
66													2,1	114	132	2
80									1,2	146	160	1,5	1,7	142	160	2
85													1,6	152	170	2
100													1,3	182	200	2
125													1,0	232	250	2
160													0,8	302	320	2
D_c [inch]	$E_{\max}$ [°]	$D_{0 \min}$ [inch]	$D_{0 \max}$ [inch]	a_0 [inch]	$E_{\max}$ [°]	$D_{0 \min}$ [inch]	$D_{0 \max}$ [inch]	a_0 [inch]	$E_{\max}$ [°]	$D_{0 \min}$ [inch]	$D_{0 \max}$ [inch]	a_0 [inch]	$E_{\max}$ [°]	$D_{0 \min}$ [inch]	$D_{0 \max}$ [inch]	a_0 [inch]
0,500	4,4	0,709	1,000	0,022												
0,625	3,0	0,974	1,250	0,022	8,5	0,785	1,250	0,047								
0,750	2,3	1,224	1,500	0,022	6,1	1,035	1,500	0,047	9,2	0,949	1,500	0,063				
1,000	1,6	1,724	2,000	0,022	3,7	1,535	2,000	0,043	5,7	1,449	2,000	0,063	8,5	1,291	2,000	0,079
1,250	1,2	2,224	2,500	0,022					3,8	1,949	2,500	0,059	5,8	1,791	2,500	0,079
1,500	1	2,724	3,000	0,022					3	2,449	3,000	0,059	4,4	2,291	3,000	0,079
2,000	0,7	3,724	4,000	0,022	1,5	3,535	4,000	0,043	2,1	3,449	4,000	0,059	3,0	3,291	4,000	0,079
2,500	0,5	4,724	5,000	0,022					1,6	4,449	5,000	0,059	2,2	4,291	5,000	0,079
3,000									1,3	5,449	6,000	0,059	1,8	5,291	6,000	0,079
4,000													1,3	7,291	8,000	0,079
5,000													1,0	9,291	10,000	0,079
6,000													0,8	11,291	12,000	0,079

Application information for M5130 shoulder milling cutter

Circular interpolation of a hole into solid material



Max. axial feed per tool revolution ("thread pitch") f [mm]

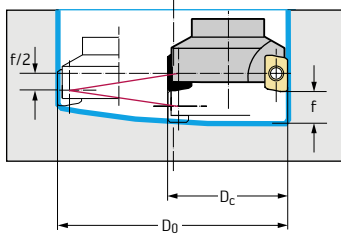
Machined hole diameter D_0 [mm]	AC..0602.. D_c [mm]											
	10	12	14	16	18	20	22	25	32	40	50	63
15	1,8											
20	3,7	2,1										
30	5,0	4,7	3,3	2,3	1,6							
40	5,0	5,0	5,0	4,0	3,0	2,3	1,9					
50	5,0	5,0	5,0	5,0	4,4	3,5	2,9	2,2				
60	5,0	5,0	5,0	5,0	5,0	4,6	4,0	3,1	1,8			
70	5,0	5,0	5,0	5,0	5,0	5,0	5,0	3,9	2,5			
80	5,0	5,0	5,0	5,0	5,0	5,0	5,0	4,8	3,2	2,0		
90	5,0	5,0	5,0	5,0	5,0	5,0	5,0	5,0	3,8	2,5		
100	5,0	5,0	5,0	5,0	5,0	5,0	5,0	5,0	4,5	3,0	1,9	
120	5,0	5,0	5,0	5,0	5,0	5,0	5,0	5,0	5,0	3,9	2,7	1,6
150	5,0	5,0	5,0	5,0	5,0	5,0	5,0	5,0	5,0	5,0	3,8	2,4
180	5,0	5,0	5,0	5,0	5,0	5,0	5,0	5,0	5,0	5,0	5,0	3,2
200	5,0	5,0	5,0	5,0	5,0	5,0	5,0	5,0	5,0	5,0	5,0	3,8
250	5,0	5,0	5,0	5,0	5,0	5,0	5,0	5,0	5,0	5,0	5,0	5,0

Max. axial feed per tool revolution ("thread pitch") f [inch]

Machined hole diameter D_0 [inch]	AC..0602.. D_c [inch]											
	0.500	0.625	0.750	1.000	1.500	2.000	2.500	3.000				
0.591												
0.787	0,069											
1.181	0,165	0,092										
1.575	0,197	0,156	0,104									
1.969	0,197	0,197	0,154	0,085								
2.362	0,197	0,197	0,197	0,120	0,073							
2.756	0,197	0,197	0,197	0,154	0,099	0,069						
3.150	0,197	0,197	0,197	0,189	0,125	0,090						
3.543	0,197	0,197	0,197	0,197	0,151	0,112	0,059					
3.937	0,197	0,197	0,197	0,197	0,177	0,134	0,074					
4.724	0,197	0,197	0,197	0,197	0,197	0,177	0,105	0,061				
5.906	0,197	0,197	0,197	0,197	0,197	0,197	0,150	0,093				
7.087	0,197	0,197	0,197	0,197	0,197	0,197	0,195	0,126				
7.874	0,197	0,197	0,197	0,197	0,197	0,197	0,197	0,147				
9.843	0,197	0,197	0,197	0,197	0,197	0,197	0,197	0,197				

Application information for M5130 shoulder milling cutter

Circular interpolation of a hole into solid material



Max. axial feed per tool revolution ("thread pitch") f [mm]

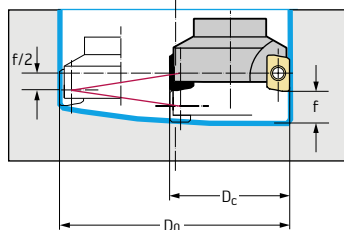
Machined hole diameter D_0 [mm]	BC..0903.. D_c [mm]									
	16	18	20	25	32	40	50	63		
25	3,0	1,5								
30	6,1	4,0	1,5							
40	8,8	8,2	5,5	1,7						
50	8,8	8,8	8,2	5,0						
60	8,8	8,8	8,8	6,5	3,5					
70	8,8	8,8	8,8	8,8	5,5	1,5				
80	8,8	8,8	8,8	8,8	7,5	4,0				
90	8,8	8,8	8,8	8,8	8,8	5,5	1,5			
100	8,8	8,8	8,8	8,8	8,8	6,7	3,8			
120	8,8	8,8	8,8	8,8	8,8	8,8	6,0	3,0		
150	8,8	8,8	8,8	8,8	8,8	8,8	8,8	5,5		
180	8,8	8,8	8,8	8,8	8,8	8,8	8,8	7,5		
200	8,8	8,8	8,8	8,8	8,8	8,8	8,8	8,8		
250	8,8	8,8	8,8	8,8	8,8	8,8	8,8	8,8		

Max. axial feed per tool revolution ("thread pitch") f [inch]

Machined hole diameter D_0 [inch]	BC..0903.. D_c [inch]									
	0,625	0,750	1,000	1,250	1,500	2,000				
0,984	0,110									
1,181	0,240	0,590								
1,575	0,346	0,215	0,066							
1,969	0,346	0,322	0,190							
2,362	0,346	0,346	0,255	0,135						
2,756	0,346	0,346	0,346	0,215	0,055					
3,150	0,346	0,346	0,346	0,295	0,155					
3,543	0,346	0,346	0,346	0,346	0,215	0,055				
3,937	0,346	0,346	0,346	0,346	0,261	0,145				
4,724	0,346	0,346	0,346	0,346	0,346	0,235				
5,906	0,346	0,346	0,346	0,346	0,346	0,346				
7,087	0,346	0,346	0,346	0,346	0,346	0,346				
7,874	0,346	0,346	0,346	0,346	0,346	0,346				
9,843	0,346	0,346	0,346	0,346	0,346	0,346				

Application information for M5130 shoulder milling cutter

Circular interpolation of a hole into solid material



Max. axial feed per tool revolution ("thread pitch") f [mm]

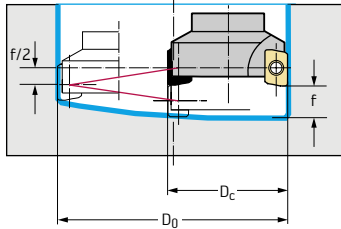
Machined hole diameter D_0 [mm]	BC..1204.. D_c [mm]						
	22	25	32	40	50	63	80
30	3,1						
40	7,0	4,8					
50	11,0	8,0	3,8				
60	12,0	11,2	5,8				
80	12,0	12,0	7,9	4,6			
100	12,0	12,0	10,0	6,1			
120	12,0	12,0	12,0	7,7	4,6		
150	12,0	12,0	12,0	9,2	5,8		
180	12,0	12,0	12,0	12,0	8,1	5,0	
200	12,0	12,0	12,0	12,0	11,5	7,6	4,6
250	12,0	12,0	12,0	12,0	12,0	10,3	6,6
300	12,0	12,0	12,0	12,0	12,0	12,0	7,9
350	12,0	12,0	12,0	12,0	12,0	12,0	11,2
400	12,0	12,0	12,0	12,0	12,0	12,0	12,0
450	12,0	12,0	12,0	12,0	12,0	12,0	12,0
500	12,0	12,0	12,0	12,0	12,0	12,0	12,0

Max. axial feed per tool revolution ("thread pitch") f [inch]

Machined hole diameter D_0 [inch]	BC..1204.. D_c [inch]						
	0,750	1,000	1,250	1,500	2,000	2,500	3,000
0,984							
1,181	0,219						
1,575	0,420	0,180					
1,969	0,472	0,304	0,150				
2,362	0,472	0,427	0,232				
2,756	0,472	0,472	0,314	0,207			
3,150	0,472	0,472	0,396	0,272			
3,543	0,472	0,472	0,472	0,336	0,178		
3,937	0,472	0,472	0,472	0,401	0,223		
4,724	0,472	0,472	0,472	0,472	0,314	0,195	
5,906	0,472	0,472	0,472	0,472	0,450	0,299	0,207
7,087	0,472	0,472	0,472	0,472	0,472	0,403	0,291
7,874	0,472	0,472	0,472	0,472	0,472	0,472	0,347
9,843	0,472	0,472	0,472	0,472	0,472	0,472	0,472
11,8110	0,472	0,472	0,472	0,472	0,472	0,472	0,472
13,7795	0,472	0,472	0,472	0,472	0,472	0,472	0,472
15,7480	0,472	0,472	0,472	0,472	0,472	0,472	0,472
17,7165	0,472	0,472	0,472	0,472	0,472	0,472	0,472
19,6850	0,472	0,472	0,472	0,472	0,472	0,472	0,472

Application information for M5130 shoulder milling cutter

Circular interpolation of a hole into solid material



Max. axial feed per tool revolution ("thread pitch") f [mm]

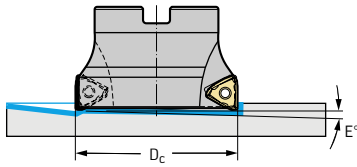
Machined hole diameter D_0 [mm]	BC..1605.. D_c [mm]														
	25	28	32	35	40	42	50	52	63	66	80	85	100	125	160
15															
20															
30															
40	7,3	4,7													
50	12,2	8,6	5,7	4,1											
60	15,0	12,5	8,9	6,9											
70	15,0	15,0	12,1	9,6	6,8	5,8									
80	15,0	15,0	15,0	12,4	9,0	7,9									
90	15,0	15,0	15,0	15,0	11,3	10,0	6,6	6,0							
100	15,0	15,0	15,0	15,0	13,5	12,1	8,2	7,6							
120	15,0	15,0	15,0	15,0	15,0	15,0	11,5	10,8	7,2	6,2					
150	15,0	15,0	15,0	15,0	15,0	15,0	15,0	15,0	11,0	9,7	6,5	5,7			
180	15,0	15,0	15,0	15,0	15,0	15,0	15,0	15,0	14,8	13,1	9,3	8,3			
200	15,0	15,0	15,0	15,0	15,0	15,0	15,0	15,0	15,0	15,0	11,2	10,1	7,1		
250	15,0	15,0	15,0	15,0	15,0	15,0	15,0	15,0	15,0	15,0	15,0	14,5	10,7	6,9	
300	15,0	15,0	15,0	15,0	15,0	15,0	15,0	15,0	15,0	15,0	15,0	15,0	14,3	9,6	
350	15,0	15,0	15,0	15,0	15,0	15,0	15,0	15,0	15,0	15,0	15,0	15,0	15,0	12,3	8,3
400	15,0	15,0	15,0	15,0	15,0	15,0	15,0	15,0	15,0	15,0	15,0	15,0	15,0	15,0	10,5
450	15,0	15,0	15,0	15,0	15,0	15,0	15,0	15,0	15,0	15,0	15,0	15,0	15,0	15,0	12,7
500	15,0	15,0	15,0	15,0	15,0	15,0	15,0	15,0	15,0	15,0	15,0	15,0	15,0	15,0	14,9

Max. axial feed per tool revolution ("thread pitch") f [inch]

Machined hole diameter D_0 [inch]	BC..1605.. D_c [inch]														
	1,000	1,250	1,500	2,000	2,500	3,000	4,000	5,000	6,000						
0.591															
0.787															
1.181	0,085														
1.575	0,270	0,104													
1.969	0,455	0,229	0,113												
2.362	0,591	0,355	0,208												
2.756	0,591	0,481	0,304	0,124											
3.150	0,591	0,591	0,399	0,189											
3.543	0,591	0,591	0,494	0,254	0,126										
3.937	0,591	0,591	0,589	0,319	0,173										
4.724	0,591	0,591	0,591	0,448	0,268	0,170									
5.906	0,591	0,591	0,591	0,591	0,411	0,287	0,136								
7.087	0,591	0,591	0,591	0,591	0,554	0,404	0,220								
7.874	0,591	0,591	0,591	0,591	0,591	0,481	0,276	0,158							
9.843	0,591	0,591	0,591	0,591	0,591	0,591	0,417	0,266	0,169						
11.811	0,591	0,591	0,591	0,591	0,591	0,591	0,557	0,373	0,255						
13.780	0,591	0,591	0,591	0,591	0,591	0,591	0,591	0,481	0,341						
15.748	0,591	0,591	0,591	0,591	0,591	0,591	0,591	0,589	0,428						
17.717	0,591	0,591	0,591	0,591	0,591	0,591	0,591	0,591	0,514						
19.685	0,591	0,591	0,591	0,591	0,591	0,591	0,591	0,591	0,591						

Application information for Xtra-tec® XT M5137 shoulder milling cutter

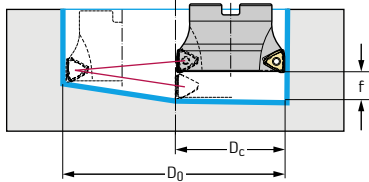
Ramping and circular plunging into solid material



Plunging with the Xtra-tec® XT M5137 shoulder milling cutter/plunging angle E_{max} [°]

Milling cutter dia. D_c [mm]	TNMU11T304R... $a_{pmax} = 5$ mm				TNMU160508R... $a_{pmax} = 8$ mm			
	E_{max} [°]	D_{0min} [mm]	D_{0max} [mm]	a_0 [mm]	E_{max} [°]	D_{0min} [mm]	D_{0max} [mm]	a_0 [mm]
25	3,1	41	50	0,5				
32	2,2	55	64	0,5				
40	1,7	71	80	0,5				
50	1,3	91	100	0,5	1,3	91	100	1,0
63	0,9	117	126	0,5	1,0	117	126	1,0
80					0,8	151	160	1,0
100					0,6	191	200	1,0

Circular interpolation of a hole into solid material

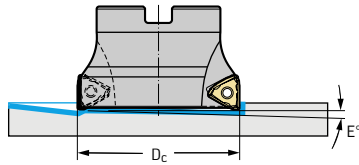


Max. axial feed per tool revolution ("thread pitch") f [mm]

Machined hole diameter D_0 [mm]	TNMU11T304R... D_c [mm]					TNMU160508R... D_c [mm]			
	25	32	40	50	63	50	63	80	100
30	0,9								
40	2,6	1,0							
50	4,3	2,2	0,9						
60	5,0	3,4	1,9	0,7					
70	5,0	4,6	2,8	1,4	0,3				
80	5,0	5,0	3,7	2,1	0,8				
90	5,0	5,0	4,7	2,9	1,3				
100	5,0	5,0	5,0	3,6	1,8	3,6			
120	5,0	5,0	5,0	5,0	2,8	5,0	3,1		
150						7,8	5,3	3,5	
160	5,0	5,0	5,0	5,0	4,8				
180	5,0	5,0	5,0	5,0	5,0	8,0	6,4	4,4	
200	5,0	5,0	5,0	5,0	5,0	8,0	7,5	5,3	3,3
250	5,0	5,0	5,0	5,0	5,0	8,0	8,0	7,5	4,9
300	5,0	5,0	5,0	5,0	5,0	8,0	8,0	8,0	6,6
350	5,0	5,0	5,0	5,0	5,0	8,0	8,0	8,0	8,0
400	5,0	5,0	5,0	5,0	5,0	8,0	8,0	8,0	8,0
450	5,0	5,0	5,0	5,0	5,0				
500	5,0	5,0	5,0	5,0	5,0				

Application information for M5137 shoulder milling cutter

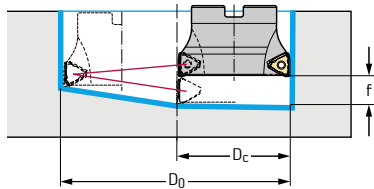
Ramping and circular plunging into solid material



Plunging angle $E_{\max}$ [°]

Milling cutter dia. D_c [in]	TNMU11T304R... $a_{p\max} = 5$ in				TNMU160508R... $a_{p\max} = 8$ in			
	$E_{\max}$ [°]	$D_{0\min}$ [in]	$D_{0\max}$ [in]	a_0 [in]	$E_{\max}$ [°]	$D_{0\min}$ [in]	$D_{0\max}$ [in]	a_0 [in]
0.984	0.122	1.614	1.969	0.020				
1.260	0.087	2.165	2.520	0.020				
1.575	0.067	2.795	3.150	0.020				
1.969	0.051	3.583	3.937	0.020	0.051	3.583	3.937	0.039
2.480	0.035	4.606	4.961	0.020	0.039	4.606	4.961	0.039
3.150					0.031	5.945	6.299	0.039
3.937					0.024	7.520	7.874	0.039

Circular interpolation of a hole into solid material



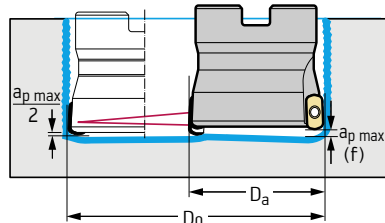
Max. axial feed per tool revolution ("thread pitch") f [inch]

Machined hole diameter D_0 [in]	TNMU11T304R... D_c [in]					TNMU160508R... D_c [in]			
	25	32	40	50	63	50	63	80	100
1.181	0.035								
1.575	0.102	0.039							
1.969	0.169	0.087	0.035						
2.362	0.197	0.134	0.075	0.028					
2.756	0.197	0.181	0.110	0.055	0.012				
3.150	0.197	0.197	0.146	0.083	0.031				
3.543	0.197	0.197	0.185	0.114	0.051				
3.937	0.197	0.197	0.197	0.142	0.071	0.142			
4.724	0.197	0.197	0.197	0.197	0.110	0.197	0.122		
5.906						0.307	0.209	0.138	
6.299	0.197	0.197	0.197	0.197	0.189				
7.087	0.197	0.197	0.197	0.197	0.197	0.315	0.252	0.173	
7.874	0.197	0.197	0.197	0.197	0.197	0.315	0.295	0.209	0.130
9.843	0.197	0.197	0.197	0.197	0.197	0.315	0.315	0.295	0.193
11.811	0.197	0.197	0.197	0.197	0.197	0.315	0.315	0.315	0.260
13.780	0.197	0.197	0.197	0.197	0.197	0.315	0.315	0.315	0.315
15.748	0.197	0.197	0.197	0.197	0.197	0.315	0.315	0.315	0.315
17.717	0.197	0.197	0.197	0.197	0.197				
19.685	0.197	0.197	0.197	0.197	0.197				

Application information for M5008 high-feed milling cutter

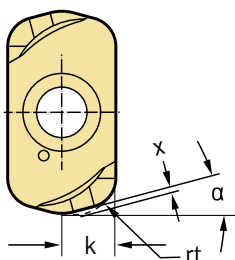
Circular interpolation of a hole into solid material

Diameter range for milling a hole in one pass [mm]



D _a [mm]	ENMX08T316R..				
	D _{0 min} [mm]	D _{0 min} [mm]	D _{0 min} [mm]	D _{0 min} [mm]	D _{0 min} [mm]
16	26,2	32	0.625	1,022	1,250
20	34,2	40	0.750	1,272	1,500
25	44,2	50	1.000	1,772	2,000
30	54,2	60	1.250	2,272	2,500
32	58,2	64	1.500	2,772	3,000
35	64,2	70	2.000	3,772	4,000
40	74,2	80	2.500	4,772	5,000
42	78,2	84			
50	94,2	100			
52	98,2	104			
63	120,2	126			
66	126,2	132			

Programming information

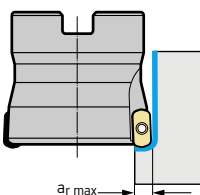


Indexable insert	rt		X		k		α
	[mm]	[inch]	[mm]	[inch]	[mm]	[inch]	
ENMX08T316R..	2	0,079	0,79	0,031	3,0	0,114	17,7

Programming the theoretical tool radius "rt" results in a maximum deviation from the final contour as shown. The minimum difference (only in the corners) is corrected by the subsequent tools for the remaining machining operations.

Plunge milling

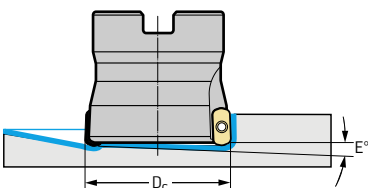
Max. plunging depth a_r



	ENMX08T316R..
a _r [mm]	3,0
a _r [inch]	0,118

Ramping

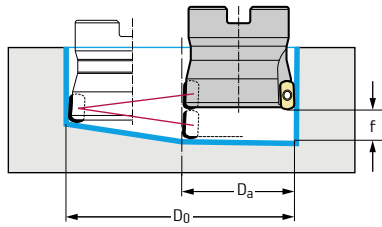
Maximum feed angle E [°]



D _a [mm]	ENMX08T316R..	D _a [inch]	ENMX08T316R..	
16	2,20	0.625	2,3	
20	1,50	0.750	1,6	
25	1,10	1.000	1,1	
30	0,80	1.250	0,8	
32	0,75	1.500	0,6	
35	0,60	2.000	0,4	
40	0,55	2.500	0,3	
42	0,53			
50	0,43			
52	0,40			
63	0,33			
66	0,30			

Application information for M5008 high-feed milling cutter

Circular interpolation of a hole



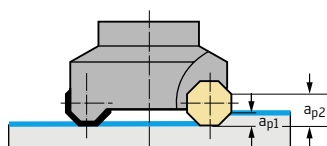
Maximum axial feed per tool revolution ("thread pitch") f [mm]

Premachined hole diameter D_0 [mm]	ENMX08T316R.. D_a [mm]											
	16	20	25	30	32	35	40	42	50	52	63	66
15												
20	0,5											
30	1,0	0,8	0,3									
40	1,0	1,0	0,8	0,4	0,3	0,2						
50	1,0	1,0	1,0	0,9	0,7	0,5	0,3	0,2				
60	1,0	1,0	1,0	1,0	1,0	0,8	0,6	0,5	0,2	0,2		
70	1,0	1,0	1,0	1,0	1,0	1,0	0,9	0,8	0,5	0,4	0,1	0,1
80	1,0	1,0	1,0	1,0	1,0	1,0	1,0	1,0	0,7	0,6	0,3	0,2
90	1,0	1,0	1,0	1,0	1,0	1,0	1,0	1,0	0,9	0,8	0,5	0,4
100	1,0	1,0	1,0	1,0	1,0	1,0	1,0	1,0	1,0	1,0	0,7	0,6
120	1,0	1,0	1,0	1,0	1,0	1,0	1,0	1,0	1,0	1,0	1,0	0,9
150	1,0	1,0	1,0	1,0	1,0	1,0	1,0	1,0	1,0	1,0	1,0	1,0
180	1,0	1,0	1,0	1,0	1,0	1,0	1,0	1,0	1,0	1,0	1,0	1,0
200	1,0	1,0	1,0	1,0	1,0	1,0	1,0	1,0	1,0	1,0	1,0	1,0
250	1,0	1,0	1,0	1,0	1,0	1,0	1,0	1,0	1,0	1,0	1,0	1,0

Application information for Xtra-tec® XT M5004 octagon face milling cutter

Face milling

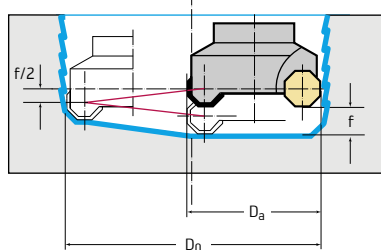
Max. milling depth a_p [mm]



	OD..0504..	OD..0605..
a_{p1}	3	4
a_{p2}	8	10

Circular interpolation of a hole into solid material

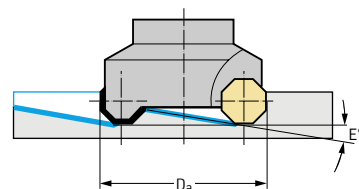
Diameter range for milling a hole in one pass [mm]



D_a [mm]	$D_{0 \min}$ [mm]	Indexable insert			$D_{0 \min}$ [mm]	$D_{0 \max}$ [mm]	$f_{\max}$ [mm]
		OD..0504..	$D_{0 \max}$ [mm]	$f_{\max}$ [mm]			
32	40,4	64	4,5				
40	56,4	80	4,5				
50	76,4	100	4,5	69,5	100	5,8	
52	80,4	104	4,5	73,5	104	5,8	
58	92,4	116	4,5				
60				89,5	120	5,8	
63	102,4	126	4,5	95,5	126	5,8	
66	108,4	132	4,5	101,5	132	5,8	
71	118,4	142	4,5				
73				115,5	146	5,8	
80	136,4	160	4,5	129,5	160	5,8	
88	152,4	176	4,5				
90				149,5	180	5,8	
100	176,4	200	4,5	169,5	200	5,8	
108	192,4	216	4,5				
110				189,5	220	5,8	
125	226,4	250	4,5	219,5	250	5,8	
133	242,4	266	4,5				
135				239,5	270	5,8	
160				289,5	320	5,8	
170				309,5	340	5,8	

Ramping

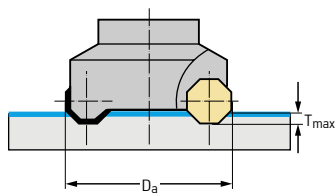
Maximum feed angle E [°]



D_a [mm]	OD..0504..	OD..0605..	D_a [mm]	OD..050408	OD..0605..
32	14,0		90		4,0
36	10,6		100	2,0	3,1
40	8,3		108	2,0	
50	5,5	9,6	110		3,1
52	5,1	8,9	125	1,5	2,3
58	4,6		133	1,5	
60		7,7	135		2,3
63	3,8	6,2	160		1,7
66	3,5	5,8	170		1,7
71	3,2		210		
73		5,4	260		
80	2,7	4,3	325		
88	2,4				

Application information for Xtra-tec® XT M5004 octagon face milling cutter

Vertical plunging

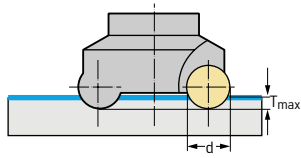


Max. plunging depth T_{max} [mm]

	OD..0504..	OD..0605..
T_{max}	2,8	4,0

Application information for Xtra-tec® XT M5468 copy milling cutter

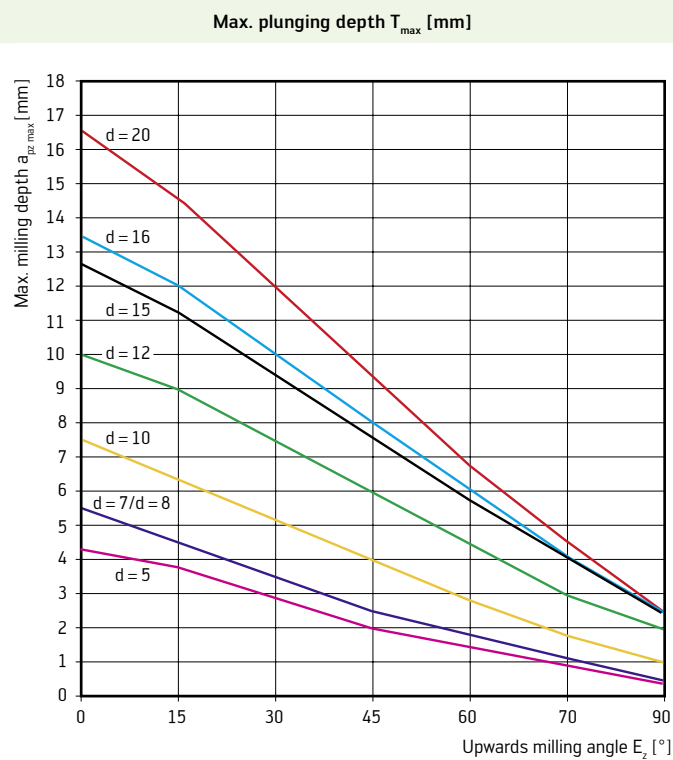
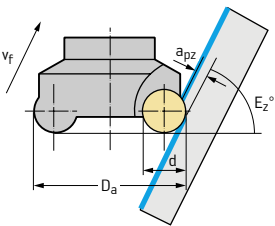
Vertical plunging



Max. plunging depth T_{max} [mm]				
Indexable insert diameter d [mm]				
	RD..0501M0.. d = 5 mm	RD..07T1M0.. d = 7 mm	RO..X0804M04.. d = 8 mm	RO..X10T3M08.. d = 10 mm
T_{max} [mm]	1,1	1,5	2,0	2,5

Max. plunging depth T_{max} [mm]			
Indexable insert diameter d [mm]			
	RO..X1204M08.. d = 12 mm	RO..X1605M08.. d = 16 mm	RO..X2006M08.. d = 20 mm
T_{max} [mm]	$D_a < 40 = 3,5$ $D_a \geq 40 = 4,5$	$D_a < 52 = 6$ $D_a \geq 52 = 7$	$D_a < 100 = 6,5$ $D_a \geq 100 = 3,5$

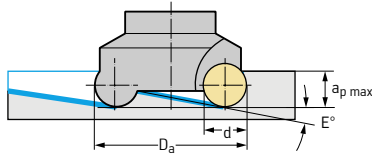
Milling upwards on inclined surfaces



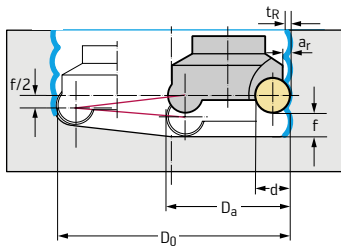
Application information for Xtra-tec® XT M5468 copy milling cutter

Ramping and circular plunging into solid material

Ramping



Circular interpolation of a hole into solid material



Plunging

Milling cutter dia. D_a [mm]	Indexable insert diameter d [mm]								
	RD...0501M0.. $a_{p\max} = 2,5$ mm			RD...07T1M0.. $a_{p\max} = 3,5$ mm			RO.X0804M04.. $a_{p\max} = 4$ mm		
	$E_{\max}$ [°]	$D_{0\min}$ [mm]	$D_{0\max}$ [mm]	$E_{\max}$ [°]	$D_{0\min}$ [mm]	$D_{0\max}$ [mm]	$E_{\max}$ [°]	$D_{0\min}$ [mm]	$D_{0\max}$ [mm]
10	3,5	10	20						
12	14,1	14,6	24						
15				32,5	16,6	30			
16	7,7	22,6	32				8	16	32
20	5,3	30,6	40	8,5	27,2	40			
24									
25				5,7	37,2	50	12,5	34,3	50
30				4,2	47,2	60			
32							8,2	48,3	64

Plunging

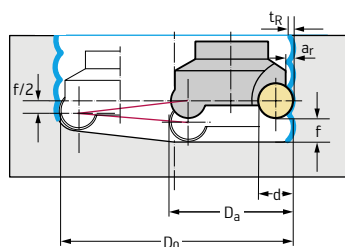
Milling cutter dia. D_a [mm]	Indexable insert diameter d [mm]								
	RO.X10T3M08.. $a_{p\max} = 5$ mm			RO.X1204M08.. $a_{p\max} = 6$ mm			RO.X1605M08.. $a_{p\max} = 8$ mm		
	$E_{\max}$ [°]	$D_{0\min}$ [mm]	$D_{0\max}$ [mm]	$E_{\max}$ [°]	$D_{0\min}$ [mm]	$D_{0\max}$ [mm]	$E_{\max}$ [°]	$D_{0\min}$ [mm]	$D_{0\max}$ [mm]
20	11	20	40						
24				15	24	48			
25	17,3	31	50						
30	11,8	41	60						
32	10,5	45	64	14,4	41	64	15	32	64
35	8,9	51	70						
40	8,3	61	80	14,5	57	80			
42				13,4	61	84			
50	6,0	81	100	10,1	77	100			
52	5,6	85	104	9,5	81	104	13	73	104
63				7,2	103	126	11	95	126
66				6,7	109	132	10	101	132
80				5,2	137	160	8	129	160
100				3,9	177	200	6	169	200
125				3,9	177	200	4	219	250

Plunging

Milling cutter dia. D_a [mm]	Indexable insert diameter d [mm]								
	RO.X2006M08.. $a_{p\max} = 10$ mm								
	$E_{\max}$ [°]	$D_{0\min}$ [mm]	$D_{0\max}$ [mm]						
40	19,0	40,0	80,0						
63	13,0	86,5	126,0						
80	8,7	120,5	160,0						
100	2,8	164,7	200,0						
125	2,7	213,0	250,0						

Application information for Xtra-tec® XT M5468 copy milling cutter

Ramping and circular plunging into solid material



Groove depth on the wall of the bore t_R [mm]

Axial feed per revolution f [mm]	Indexable insert diameter d [mm]			
	RD..0501M0.. $d = 5$ mm	RD..07T1M0.. $d = 7$ mm	RO.X0804M04.. $d = 8$ mm	RO.X10T3M08.. $d = 10$ mm
1	0,051	0,036	0,031	0,025
2	0,209	0,146	0,127	0,100
3	0,500	0,338	0,292	0,230
4			0,536	0,417
5			0,878	0,670
6				(1,000)
7				(1,429)
a_{rmax}	0,5	0,5	1,25	1,5

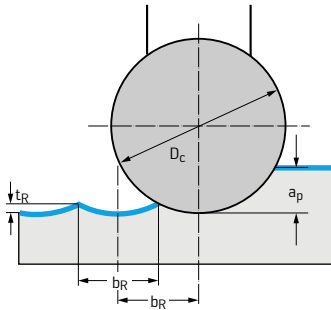
Groove depth on the wall of the bore t_R [mm]

Axial feed per revolution f [mm]	Indexable insert diameter d [mm]			
	RO.X1204M08.. $d = 12$ mm	RO.X1605M08.. $d = 16$ mm	RO.X2006M08.. $d = 20$ mm	
1	0,020	0,015	0,010	
2	0,080	0,060	0,050	
3	0,190	0,140	0,110	
4	0,340	0,250	0,200	
5	0,540	0,400	0,320	
6	0,800	0,580	0,460	
7	(1,120)	0,810	0,630	
8	(1,530)	(1,07)	0,840	
a_{rmax}	2,0	3,0	4,5	

The values in brackets only apply to short holes.

Application information for M5460 copy finishing cutter

Line-by-line milling



Groove depth:

$$t_R = 0,5 \cdot (D_c - \sqrt{D_c^2 - b_R^2})$$

0.3 to 0.5 mm
material removal when finishing
depending on tool diameter

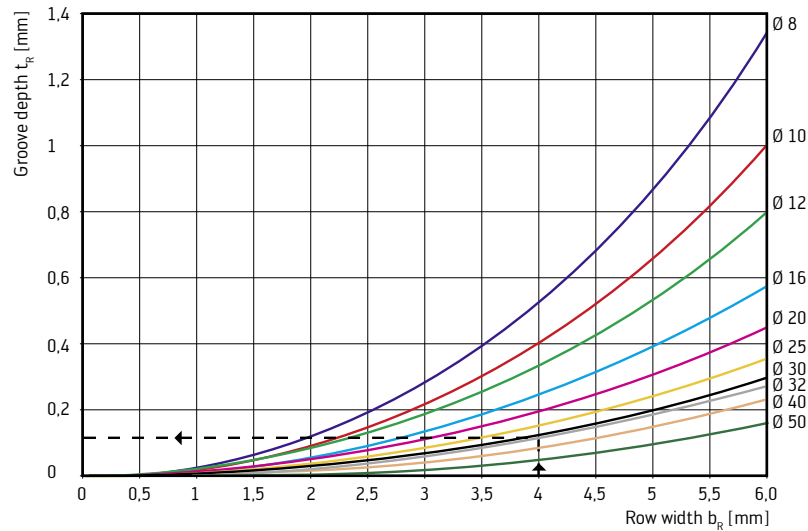
Application recommendations
for M5460 copy and finish milling cutters

Tool diameter D_c [mm]	Line width b_R [mm]	Groove depth t_R [mm]
8	0,5	0,008
10	0,6	0,009
12	0,7	0,010
16	0,8	0,010
20	1,0	0,012
25	1,2	0,014
30	1,3	0,014
32	1,4	0,015

Semi-finishing – Roughing

Example:

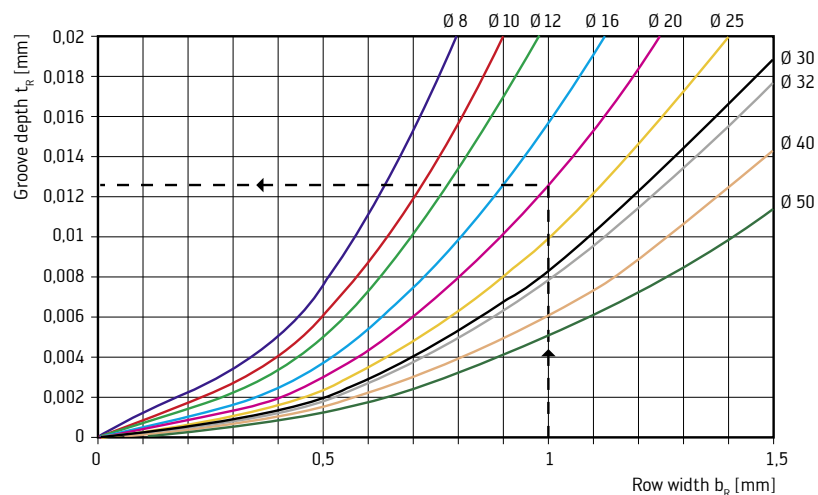
$D_c = 32$ mm
 $b_R = 4$ mm
→ $t_R = 0,125$ mm



Finishing

Example:

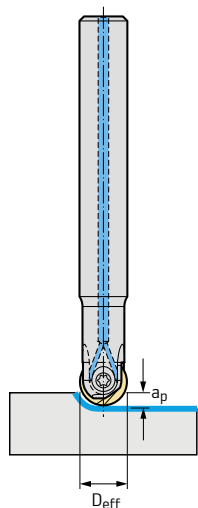
$D_c = 20$ mm
 $b_R = 1,0$ mm
→ $t_R = 0,0125$ mm



Application information for M5460 copy finishing cutter

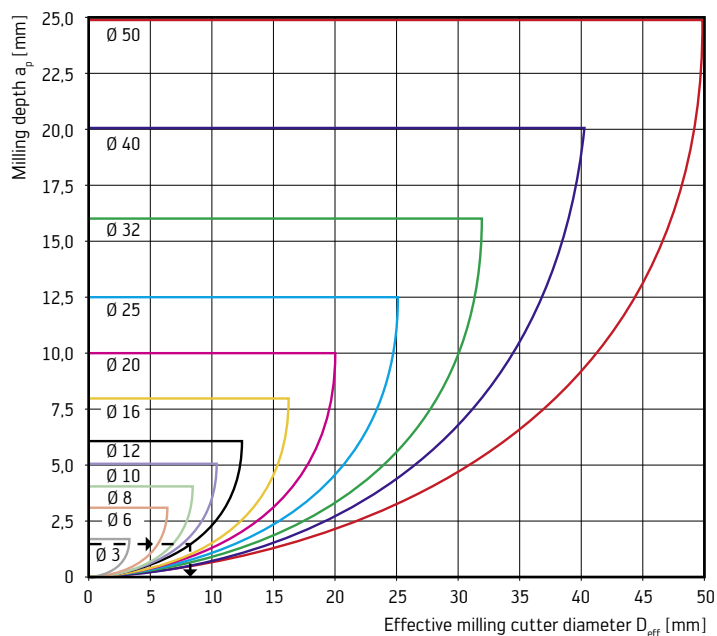
(continued)

Determining the effective cutting diameter



Example:

$$\begin{aligned} D_c &= 12 \text{ mm} \\ a_p &= 1,5 \text{ mm} \\ \rightarrow D_{eff} &= 8 \text{ mm} \end{aligned}$$

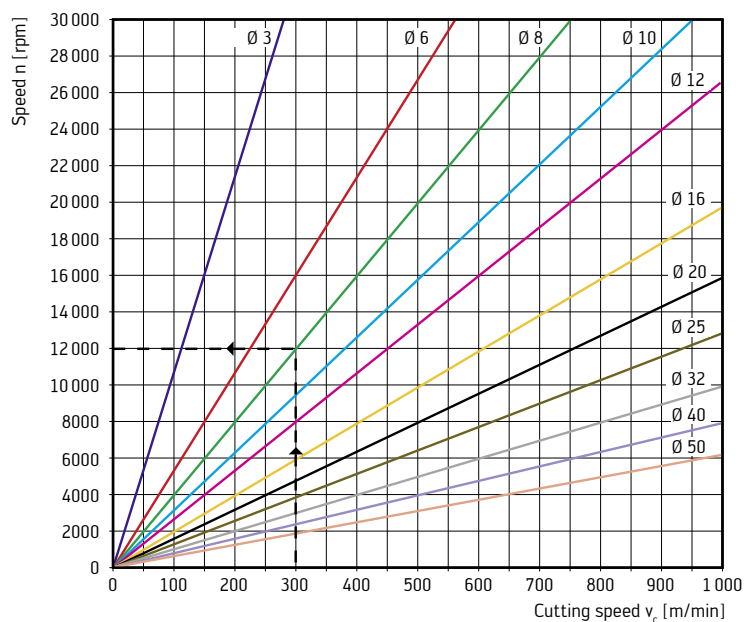


Determining the required speed

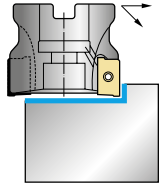
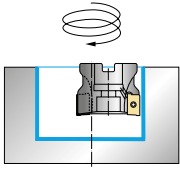
Example:

$$\begin{aligned} D_{eff} &= 8 \text{ mm} \\ v_c &= 300 \text{ m/min} \\ \rightarrow n &= 12\,000 \text{ rpm} \end{aligned}$$

$$n = \frac{v_c \cdot 1\,000}{\pi \cdot D_{eff}} \text{ [rpm]}$$



Feed determination (starting values)

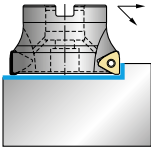
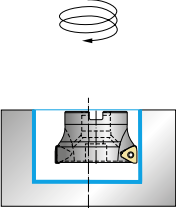
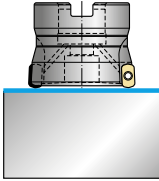
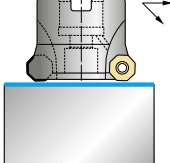
Material group	Cutter type	M5130				M5130				
										
	Feed per tooth f_{z0} for $a_e = D_c$ $a_p = a_{p\max} = L_c$	For shoulder milling operations Xtra-tec® XT 90°				For circular interpolation milling operations Xtra-tec® XT 90°				
	Lead angle κ	f_{z0} [mm]				f_{z0} [mm]				
	Tool diameter or diameter range [mm]	10 - 63	16-50	25 - 80	25 - 160	10-63	16-50	25-80	25-160	
	Maximum depth of cut $a_{p\max} = L_c$ [mm]	5	9	11	15	5	9	11	15	
P	Non-alloyed steel ¹	0,12	0,16	0,21	0,26	0,10	0,14	0,19	0,23	
	Low-alloy steel	0,08	0,11	0,16	0,19	0,07	0,10	0,14	0,17	
	High-alloy steel and tool steel	0,08	0,11	0,16	0,19	0,07	0,10	0,14	0,17	
	Stainless steel	0,06	0,08	0,13	0,16	0,06	0,09	0,12	0,14	
M	Stainless steel ²	0,06	0,08	0,11	0,13	0,06	0,11	0,09	0,11	
K	Malleable cast iron	0,10	0,13	0,21	0,26	0,08	0,12	0,18	0,23	
	Grey cast iron	0,12	0,16	0,26	0,32	0,10	0,14	0,20	0,28	
	Cast iron with spheroidal graphite	0,10	0,13	0,21	0,26	0,08	0,12	0,18	0,23	
	GGV (CGI)	0,08	0,11	0,21	0,19	0,08	0,12	0,18	0,23	
N	Wrought aluminium alloys	0,08	0,11	0,13	0,16	0,08	0,10	0,13	0,16	
	Cast aluminium alloys	0,10	0,13	0,16	0,16	0,08	0,10	0,13	0,16	
	Magnesium-based alloys	0,08	0,11	0,13	0,16	0,07	0,09	0,12	0,15	
	Copper and copper alloys (bronze/brass)	0,06	0,08	0,11	0,13	0,06	0,07	0,09	0,11	
S	Heat-resistant alloys	0,06	0,08	0,13	0,16	0,06	0,08	0,11	0,14	
	Titanium alloys	0,06	0,08	0,13	0,16	0,06	0,08	0,11	0,14	
	Tungsten alloys	0,06	0,08	0,13	0,16	0,06	0,08	0,11	0,14	
	Molybdenum alloys	0,06	0,08	0,13	0,16	0,06	0,08	0,11	0,14	
H	Hardened steel	0,06	0,08	0,11	0,13					
	Hardened cast iron	0,08	0,11	0,13	0,15					
O	Thermoplastics	0,10	0,13	0,18	0,21	0,10	0,13	0,18	0,21	
	Plastic, carbon-fibre-reinforced									
	Graphite (technical)	0,08	0,11	0,16	0,16	0,08	0,10		0,16	
Indexable insert types		AC..0602..	BC..0903..	BC..1204..	BC..1605..	AC..0602..	BC..0903..	BC..1204..	BC..1605..	
Correction factor K_a		$a_e / D_c = 1/1-1/2$								
		1/5								
		1/10								
		1/20								
		1/50								
		$a_p = 1$								
		2								
		3								
		4								
		6								
		8								
$f_z = f_{z0} \cdot K_a \cdot K_p$		$a_{p\max} = L_c$								

¹ and cast steel

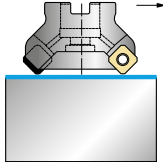
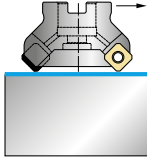
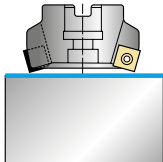
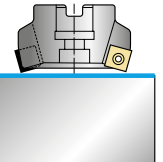
² and austenitic/ferritic

* only possible if $a_e < 0.75 \times D_c$

** only with $a_e/D_c < 1/5$

	M5137		M5137		M5008		M5004	
								
	Shoulder milling cutters Xtra-tec® XT		Xtra-tec® XT		Xtra-tec® XT		Xtra-tec® XT	
	90°		90°		0°-20°	15°	43°	
	f_{20} [mm]		f_{20} [mm]		f_{20} [mm]	f_{20} [mm]	f_{20} [mm]	
	25-63		25-63		16-66	16-66	50-160	
	5	8	5	8	1	1	3	4
	0,15	0,20	0,14	0,19	0,80	0,64	0,45	0,50
	0,11	0,15	0,11	0,14	0,80	0,64	0,40	0,45
	0,11	0,15	0,11	0,14	0,72	0,56	0,30	0,35
	0,09	0,12	0,09	0,12	0,32	0,24	0,20	0,25
	0,08	0,10	0,07	0,09	0,24	0,16	0,15	0,15
	0,15	0,20	0,14	0,18	0,24	0,16	0,40	0,45
	0,19	0,25	0,15	0,20	0,96	0,80	0,50	0,55
	0,15	0,20	0,14	0,18	0,80	0,64	0,40	0,45
	0,11	0,15	0,14	0,18	0,80	0,64	0,25	0,25
							0,25	0,25
							0,20	0,20
							0,15	0,15
							0,15	0,15
	0,09	0,12	0,08	0,11	0,32	0,24	0,15	0,15
	0,09	0,12	0,08	0,11	0,32	0,24	0,15	0,15
	0,09	0,12	0,08	0,11	0,32	0,24	0,15	0,15
	0,09	0,12	0,08	0,11	0,32	0,24	0,15	0,15
					0,24	0,16	0,15	0,15
					0,26	0,24	0,17	0,17
							0,20	0,20
							0,15	0,15
	TN MU 11T304R	TN MU 160408R	TN MU 11T304R...	TN MU160408R	EN MX08T316R..	EN ..08T3..	OD.. 0504..	OD.. 0605..
	1,0	1,0	1,0	1,0	1,0	1,0	1,0	1,0
	1,1	1,1	1,1	1,1	1,1	1,1	1,1	1,1
	1,2	1,2	1,2	1,2	1,2	1,2	1,2	1,2
	1,3	1,3	1,3	1,3	1,3	1,3	1,3	1,3
							1,0	1,0
							1,0	1,0
							1,0	1,0
							0,6	1,0
							0,6	0,6
							0,6	0,6
							0,6	0,6

Feed determination (starting values)

Cutter type		M5009		M5009...-AP	M5011	M5011...-AP	
Material group							
	Feed per tooth f_{20} for $a_e = D_c$ $a_p = a_{p\max} = L_c$	Xtra-tec® XT		Xtra-tec® XT	Xtra-tec® XT	Xtra-tec® XT	
	Lead angle κ	45°		45°	75°	75°	
		f_{20} [mm]		f_{20} [mm]	f_{20} [mm]	f_{20} [mm]	
	Tool diameter or diameter range [mm]	25–100	50–160	40–160	50–160	50–125	
	Maximum depth of cut $a_{p\max} = L_c$ [mm]	5	6	6	8	8	
P	Non-alloyed steel ¹	0,19	0,25	0,30	0,22	0,26	
	Low-alloy steel	0,15	0,20	0,24	0,20	0,24	
	High-alloy steel and tool steel	0,15	0,20	0,24	0,20	0,24	
	Stainless steel	0,11	0,15	0,18	0,15	0,18	
M	Stainless steel ²	0,09	0,12	0,14	0,12	0,14	
K	Malleable cast iron	0,19	0,25	0,30	0,22	0,26	
	Grey cast iron	0,23	0,30	0,36	0,25	0,30	
	Cast iron with spheroidal graphite	0,19	0,25	0,30	0,22	0,26	
	GGV (CGI)	0,15	0,20	0,24	0,20	0,24	
N	Wrought aluminium alloys	0,11	0,15	0,18			
	Cast aluminium alloys	0,11	0,15	0,18			
	Magnesium-based alloys	0,09	0,12	0,14			
	Copper and copper alloys (bronze/brass)	0,09	0,12	0,14			
S	Heat-resistant alloys	0,09	0,12	0,14	0,10	0,12	
	Titanium alloys	0,09	0,12	0,14	0,10	0,12	
	Tungsten alloys	0,09	0,12	0,14	0,10	0,12	
	Molybdenum alloys	0,09	0,12	0,14	0,10	0,12	
H	Hardened steel	0,09	0,12	0,14	0,10	0,12	
	Hardened cast iron	0,11	0,14	0,17	0,12	0,14	
O	Thermoplastics	0,11	0,15	0,18			
	Plastic, carbon-fibre-reinforced						
	Graphite (technical)	0,11	0,15	0,18			
Indexable insert types		SN.X 0904ANN.. SN.X 090408..	SN.X1205ANN SN.X120512.. SN.X120520..	SN.X1205ANN SN.X120512.. SN.X120520..	SN.X120512.. SN.X120520.. SN.X1205ENN	SN.X120512.. SN.X120520.. SN.X1205ENN	
Correction factor K_{a_e}		$a_e / D_c = 1/1-1/2$		1,0	1,0	1,0	
		1/5		1,1	1,1	1,1	
For the feed per tooth depending on the ratio of width of cut a_e to milling cutter diameter D_c		1/10		1,2	1,2	1,2	
		1/20		1,3	1,3	1,3	
		1/50					
Correction factor K_{a_p} for the feed per tooth depending on the depth of cut a_p		$a_p = 1$					
		2					
		3					
		4					
		6					
		8					
$f_z = f_{20} \cdot K_{a_e} \cdot K_{a_p}$		$a_{p\max} = L_c$					

¹ and cast steel

² and austenitic/ferritic

* only possible if $a_p < 0,75 \times D_c$

** only with $a_e/D_c < 1/5$

Notes on high-speed cutting

- Maximum permissible speeds:
The limit values specified in the tables should not be exceeded. Otherwise, correct operation and/or reliability are no longer guaranteed.
- Only use original Walter indexable inserts and assembly parts (screws, etc.). New screws should be used after having replaced the indexable inserts five times at the most.
- Observe the torque specified in the catalogues.
- Balancing:
Balancing in two steps is required when milling at fast speeds (> 6000 rpm) or at circumferential speeds of > 1000 m/min:
a. Basic balancing of the tool body including indexable inserts (can be carried out by Walter if required). In this case, tool adaptors that have been balanced separately beforehand must be used.
b. Fine balancing of the tool when fully mounted on the adaptor. The fine balancing operation is strongly recommended, as even the smallest concentricity fault can seriously affect the balance status.
- Short projection lengths reduce concentricity faults and imbalance, and increase spindle service life. The specified speeds only apply to the use of tools without additional extensions and for tools with a neck length of $\leq 2.2 \times D_c$. For tools with longer necks, the speeds must be reduced upon consultation with Walter.

Tool	Safety-related parts	In relation to	n _{max} [rpm] with D											
			Ø 8	Ø 10	Ø 12	Ø 14	Ø 15	Ø 16	Ø 18	Ø 20	Ø 21	Ø 22	Ø 24	Ø 25
M5468	RD..0501M0..	D _a		40.000	40.000			40.000		40.000				
	RD..07T1M0..	D _a					40.000			40.000				40.000
	RO.X0803M04..	D _a						40.000						40.000
	RO.X10T3M08..	D _a								40.000				40.000
	RO.X1204M08..	D _a											36.400	
	RO.X1605M08..	D _a												
	RO.X2006M08..	D _a												
M5460	P32..	D _c						40.000*		40.000*				40.000*
M5137	TNMU11T304R	D _c												24.400
	TNMU160508R	D _c												
M5130	AC.T0602..	D _c		40.000	40.000	40.000		40.000	40.000	40.000		40.000		40.000
	BC.T0903..	D _c						40.000	40.000	40.000		38.700		36.000
	BC.T1204..	D _c												28.100
	BC.T1605..	D _c												22.300
M5012	SN.X0904..	D _c												
	SN.X1205..	D _c												
M5012...-AP	SN.X1205..	D _c												
M5011	SN.X1205..	D _c												
M5011...-AP	SN.X1205..	D _c												
M5009	SN.X0904..	D _c												34.100
	SN.X1205..	D _c												
M5009...-AP	SN.X1205..	D _c												
M5008	ENMX08T316R..	D _a							32.700	29.200				26.100
M5004	OD..0504..	D _a												
	OD..0504..	D _a												

¹ The specified speed of 40,000 rpm refers to the entire tool diameter range of 8–32 mm.

* Speeds higher than 40,000 rpm are possible under favourable conditions and for short projection lengths upon consultation with Walter.

6. Safety guards:

Appropriate safety guards or machine enclosures must be used to securely collect particles that spin off such as chips or parts of cutting edges that are broken as a result of collisions.

7. Damaged tools:

The operating speed must be specified for the repair of an HSC tool. The table values only apply to tools with a condition equivalent to new condition following repair.

8. Use of standards:

Walter recommends using the balancing standard DIN 69888, which describes the balancing of tools and the requirements in the machining sector. DIN 69888 is tailored to the needs of the machining sector, and describes the tool balancing requirements in a practical way. DIN ISO 1940, which was previously often used, describes balancing for all areas of mechanical engineering.

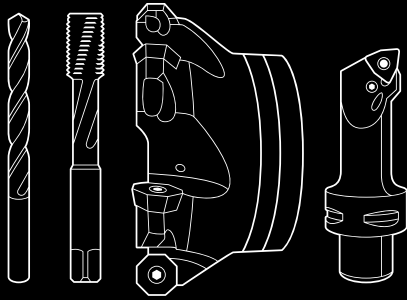
The requirements when working at circumferential speeds of > 1000 m/min are described in DIN ISO 15641.

n _{max} [rpm] with D																	
Ø 28	Ø 30	Ø 32	Ø 35	Ø 40	Ø 42	Ø 50	Ø 52	Ø 63	Ø 66	Ø 80	Ø 85	Ø 100	Ø 125	Ø 160	Ø 200	Ø 250	Ø 315
	36.200																
		36.500															
	38.400	37.100	35.500	33.200		29.700	29.100	26.500									
		31.500		28.200	27.500	25.200	24.700	22.500	21.900	19.900		17.800					
		28.700					22.500	20.500	20.000	18.100		16.200	14.500				
				24.300				19.400		17.200		15.300	13.700				
		40.000*															
		21.600		19.300		17.200		15.400									
						10.700		9.600		8.500		7.600					
		36.600		32.500		28.900		25.700									
		31.300		27.500		24.600		21.800									
		24.400		21.500		19.100		16.900		14.800							
	20.900		19.300	18.300	16.900	16.500	14.900	14.600	13.200	12.800	11.600	11.200	10.300	9.100	8.000		
		27.300		24.400		21.800		19.500		17.300		15.400					
						16.800		15.000		13.300		11.900	10.600	9.400			
						14.500		13.000		11.500		10.300	9.200	8.100			
				20.000		17.900		16.000		14.100		12.600	11.300	10.000			
						15.300		13.700		12.100		10.800	9.700	8.500			
		30.100		26.900		24.100		21.500		19.000		17.000					
				20.000		17.900		16.000		14.100		12.600	11.300	10.000			
						15.300		13.700		12.100		10.800	9.700	8.500			
			23.100	22.100	20.700	20.200	18.500	18.100	16.500	16.100							
		29.400		26.300		23.500		21.000		18.600		16.600	14.900	13.100			
						19.600		17.500		15.500		13.800	12.400	10.900	9.800		

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