

Technical Information

CUTTING CONDITIONS ($a_e / D = 10 \%$):

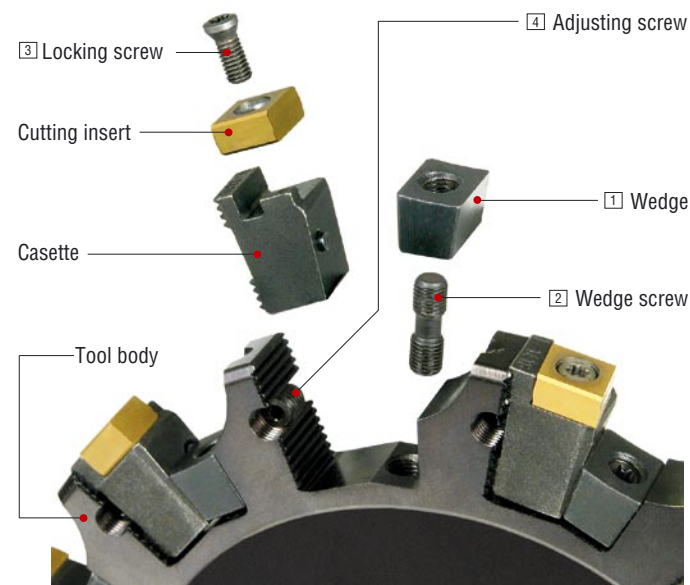
Group	Machined materials	Indexable cutting insert	Grade	Recommended cutting speed [m.min ⁻¹]		
				Feed f_z [mm.teeth ⁻¹]		
				0,16	0,25	0,42
P	Easy machinable and common steels ($R_m < 700$ MPa)	CNHQ1005AZ TN; XNHQ1205AZ TN; XNHQ1606AZ TN	8026	190	170	145
		CNHQ1005AZ TN; XNHQ1205AZ TN; XNHQ1606AZ TN	8040	170	155	130
	Tough steels ($R_m < 1200$ MPa)	CNHQ1005AZ TN; XNHQ1205AZ TN; XNHQ1606AZ TN	8026	125	110	95
		CNHQ1005AZ TN; XNHQ1205AZ TN; XNHQ1606AZ TN	8040	110	100	85
M	Easy machinable and common stainless steels	CNHQ1005AZ TN; XNHQ1205AZ TN; XNHQ1606AZ TN	8026	195	175	150
		CNHQ1005AZ TN; XNHQ1205AZ TN; XNHQ1606AZ TN	8040	180	160	135
	Heavy machinable stainless steels	CNHQ1005AZ TN; XNHQ1205AZ TN; XNHQ1606AZ TN	8026	165	150	125
		CNHQ1005AZ TN; XNHQ1205AZ TN; XNHQ1606AZ TN	8040	150	135	115
K	Easy machinable and common cast iron	CNHQ1005AZ TN; XNHQ1205AZ TN; XNHQ1606AZ TN	8026	165	150	125
		CNHQ1005AZ TN; XNHQ1205AZ TN; XNHQ1606AZ TN	8040	150	135	115
	Hard and modular cast iron	CNHQ1005AZ TN; XNHQ1205AZ TN; XNHQ1606AZ TN	8026	125	110	-
		CNHQ1005AZ TN; XNHQ1205AZ TN; XNHQ1606AZ TN	8040	110	100	-
N	Non ferrous metals	CNHQ1005AZ TN; XNHQ1205AZ TN; XNHQ1606AZ TN	8026	760	680	580
		CNHQ1005AZ TN; XNHQ1205AZ TN; XNHQ1606AZ TN	8040	690	615	525
S	Super alloys	CNHQ1005AZ TN; XNHQ1205AZ TN; XNHQ1606AZ TN	8026	35	30	-
		CNHQ1005AZ TN; XNHQ1205AZ TN; XNHQ1606AZ TN	8040	35	30	-

CUTTING CONDITIONS SIDE MILLING:

Application	a_e / D	Recommended feed f_z [mm.feed ⁻¹]			Speed factor
Radial infeed	-	0,08	0,12	0,20	0,65
Side milling	2%	0,35	0,55	0,92	1,20
	5%	0,23	0,35	0,59	1,10
	10%	0,16	0,25	0,42	1,00
	20%	0,12	0,18	0,30	0,90
	30%	0,10	0,15	0,25	0,85
Average chip thickness	-	0,05	0,08	0,13	-

Instructions:
Fix a_e / D , choose the feed and multiply the value of cutting speed by speed factor.

ADJUSTABLE DISC MILLING CUTTERS SYSTEM:



set up the width yourself



General purpose
High productivity
Adjustable width up to 30,5 mm

ADJUSTABLE DISC MILLING CUTTERS



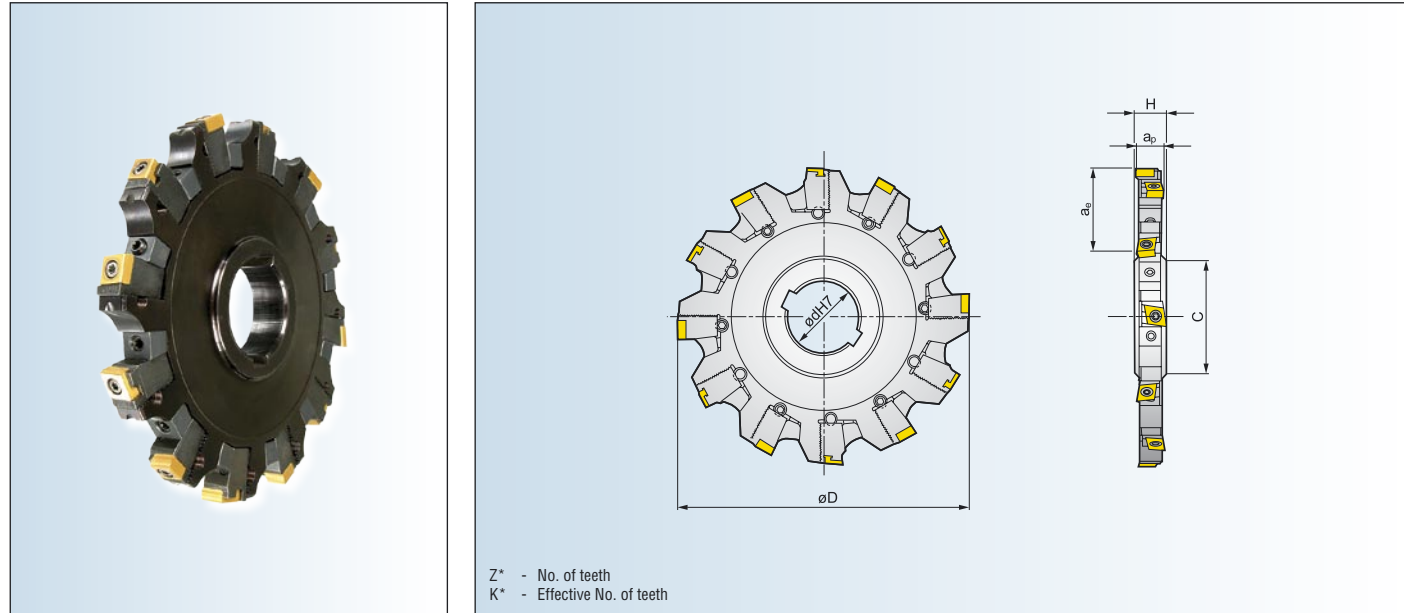
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Disc Milling Cutters - Type A



Z* - No. of teeth
K* - Effective No. of teeth

Tool TYPE A	Assortment	Dimensions								[kg]	Maximal [RPM]	Indexable cutting insert	Grade
		D	dH7	H	c	a_p	a_e	Z*	K*				
Width 14 ÷ 18 mm													
125H04N-S90CN10N18	●	125	40	18	56	14 ÷ 18,5	34	8	4	1,0	7800	CNHQ 1005AZ TN	8026; 8040
160H06N-S90CN10N18	●	160					50	12	6	1,5	6900		
200J07N-S90CN10N18	●	200	60	14	7	2,0	6100						
250J09N-S90CN10N18	●	250	85	18	9	3,0	5500						
315J12N-S90CN10N18	●	315	110	24	12	4,0	4900						
Width 19 ÷ 24 mm													
160H05N-S90XN12N24	●	160	40	24	56	18,5 ÷ 24,3	50	10	5	2,0	6000	XNHQ 1205AZ TN	8026; 8040
200J06N-S90XN12N24	●	200					60	12	6	2,5	5300		
250J08N-S90XN12N24	●	250	85	16	8	3,5	4800						
315J10N-S90XN12N24	●	315	110	20	10	4,5	4200						
Width 25 ÷ 30 mm													
200J06N-S90XN16N30	●	200	50	30	71	24,3 ÷ 30,5	60	12	6	3,0	4000	XNHQ 1606AZ TN	8026; 8040
250J08N-S90XN16N30	●	250					85	16	8	4,0	3600		
315K10N-S90XN16N30	●	315	60	85	20	10	5,0	3200					

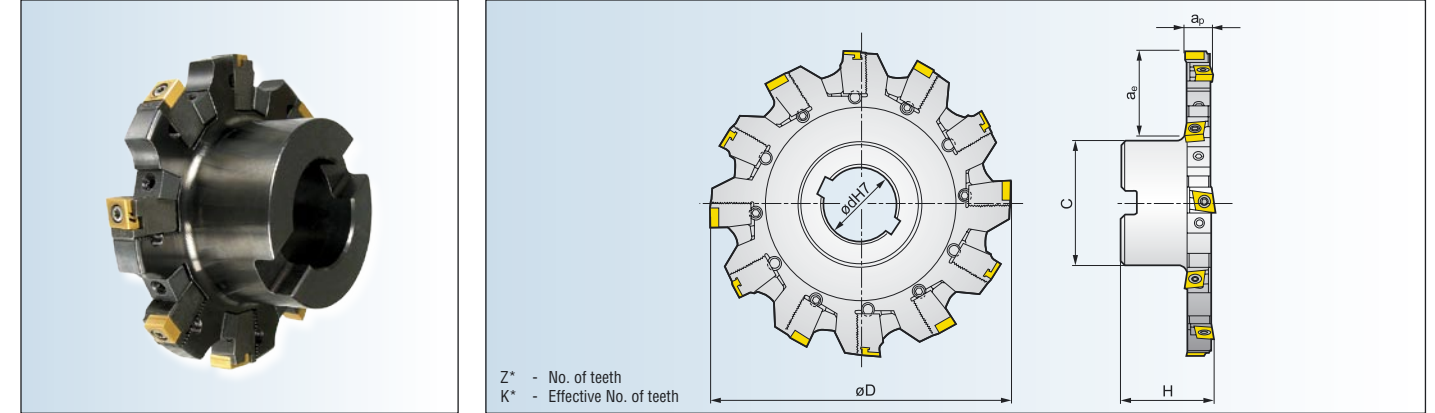
SPARE PARTS

Tool TYPE A	Cutter	Cassette L	Cassette R	1] Wedge	2] Wedge screw	Key	3] Locking screw	Screwdriver	4] Adjusting screw	Screwdriver
Width 14 ÷ 18 mm										
125H04N-S90CN10N18	125H04N-S-14-08	KL-1418-CN10	KR-1418-CN10	KS 613F	DS 6018F	SDR T20	US 4011-T15P	SDR T15P	SS 6005	SDR T09
160H06N-S90CN10N18	160H06N-S-14-12									
200J07N-S90CN10N18	200J07N-S-14-14									
250J09N-S90CN10N18	250J09N-S-14-18									
315J12N-S90CN10N18	315J12N-S-14-24									
Width 19 ÷ 24 mm										
160H05N-S90XN12N24	160H05N-S-19-10	KL-1924-XN12	KR-1924-XN12	KS 617M	DS 6500	HXK 4	US 4011-T15P	SDR T15P	SS 6005	SDR T09
200J06N-S90XN12N24	200J06N-S-19-12									
250J08N-S90XN12N24	250J08N-S-19-16									
315J10N-S90XN12N24	315J10N-S-19-20									
Width 25 ÷ 30 mm										
200J06N-S90XN16N30	200J06N-S-25-12	KL-2530-XN16	KR-2530-XN16	KS 623M	DS 6500	HXK 4	US 5012-T15P	SDR T15P	SS 6005	SDR T09
250J08N-S90XN16N30	250J08N-S-25-16									
315K10N-S90XN16N30	315K10N-S-25-20									

● Stock assortment ○ Non-stock assortment

All dimensions in [mm]

Disc Milling Cutters - Type B



Z* - No. of teeth
K* - Effective No. of teeth

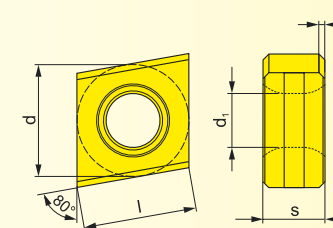
Tool TYPE B	Assortment	Dimensions								[kg]	Maximal [RPM]	Indexable cutting insert	Grade
		D	dH7	H	c	a_p	a_e	Z*	K*				
Width 14 ÷ 18 mm													
125B04R-S90CN10N18	●	125	40	50	70	14 ÷ 18,5	25	8	4	1,7	7800	CNHQ 1005AZ TN	8026; 8040
160B06R-S90CN10N18	●	160			44		12	6	2,7	6900			
200C07R-S90CN10N18	●	200			90		14	7	4,1	6100			
Width 19 ÷ 24 mm													
160B05R-S90XN12N24	●	160	40	50	70	18,5 ÷ 24,3	44	10	5	3,0	6000	XNHQ 1205AZ TN	8026; 8040
200C06R-S90XN12N24	●	200			90		12	6	4,5	5300			
Width 25 ÷ 30 mm													
200C06R-S90XN16N30	●	200	60	50	130	24,3 ÷ 30,5	34	12	6	4,5	4000	XNHQ 1606AZ TN	8026; 8040

SPARE PARTS

Tool TYPE B	Cutter	Cassette L	Cassette R	1] Wedge	2] Wedge screw		3] Locking screw		4] Adjusting screw	
					Key	Screwdriver	Screwdriver	Screwdriver		
Width 14 ÷ 18 mm										
125B04R-S90CN10N18	125B04R-S-14-08	KL-1418-CN10	KR-1418-CN10	KS 613F	DS 6018F	SDR T20	US 4011-T15P	SDR T15P	SS 6005	SDR T09
160B06R-S90CN10N18	160B06R-S-14-12									
200C07R-S90CN10N18	200C07R-S-14-14									
Width 19 ÷ 24 mm										
160B05R-S90XN12N24	160B05R-S-19-10	KL-1924-XN12	KR-1924-XN12	KS 617M	DS 6500	HXK 4	US 4011-T15P	SDR T15P	SS 6005	SDR T09
200C06R-S90XN12N24	200C06R-S-19-12									
Width 25 ÷ 30 mm										
200C06R-S90XN16N30	200C06R-S-25-12	KL-2530-XN16	KR-2530-XN16	KS 623M	DS 6500	HXK 4	US 5012-T15P	SDR T15P	SS 6005	SDR T09

Indexable Cutting Inserts

CNHQ / XNHQ



Dimensions	(l)	d	s	d_1	b
1005	10,0	10,0	5,4	4,7	0,5 × 45°
1205	12,7	10,0	5,4	4,7	0,5 × 45°
1606	16,0	12,0	6,4	5,9	0,5 × 45°

ISO	ANSI	Grades			
		8026	8040		
CNHQ 1005AZTN	CNHQ 3(3.5)AZTN	●	●		
XNHQ 1205AZTN	XNHQ 4(3.5)AZTN	●	●		
XNHQ 1606AZTN	XNHQ 5AZTN	●	●		

● Stock assortment ○ Non-stock assortment

All dimensions in [mm]