

Milling cutters for Polcomm® SO.. 08 inserts

optimized geometry
for high feed machining

4-edges inserts

insert geometry with positive rake angle
reduces cutting forces

efficient internal cooling

excellent chip evacuation



Milling inserts SOEX 08 Polcomm®

ID	description	application	machining	Vc [m/min]	fz [mm]	ap [mm]		
							01	05
87102	SOEX 080315 MMS PC828		▽	150-320	0,4-1,8	0,2-1,0		
				90-180	0,4-1,3	0,2-1,0		
				30-80	0,2-0,5	0,2-0,7		
94919	SOEX 080315 MMS PC830		▽	120-220	0,1-1,8	0,2-1,0		
				100-210	0,1-1,8	0,2-1,0		
30-110				30-110	0,1-1,8	0,2-1,0		
87676	SOGW 080310 PMZ PC228		▽	140-250	0,3-1,8	0,5-1,0		
				120-270	0,3-1,8	0,5-1,0		
64139	SOGW 080310 PMZ PC230		▽	120-220	0,3-1,8	0,5-1,0		
				150-250	0,3-1,8	0,5-1,0		

MATERIAL GROUPS (DIN ISO 513)

- P steel
- M stainless steel
- K cast iron
- N non-ferrous metals
- S heat-resistant alloys
- H hardened steel

APPLICATION

- recommended
- alternative
- medium machining
- rough machining



PARAMETERS

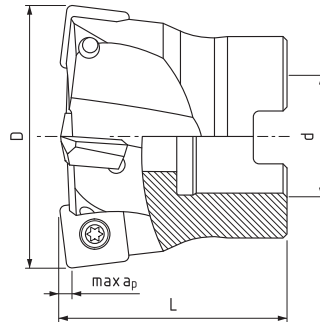
- Vc cutting speed
- fz feed per tooth
- ap depth of cut

MILLING TYPES



- shoulder milling
- face milling
- ramp milling
- helical interpolation
- profiling

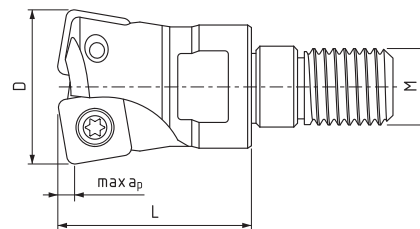
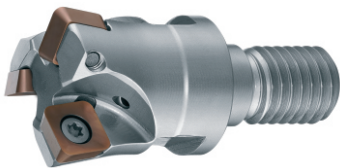
Arbor-type milling cutters for SO.. 08 inserts

ID	D [mm]	L [mm]	d [mm]	Z	max ap [mm]		
GN140 040A16 04005I	40	40	16	5	1	N01-004743 PC60 M3x7,4	N01-003201 T9
GN140 050A22 04506I	50	45	22	6	1		
GN140 052A22 04506I	52	45	22	6	1		
GN140 066A27 05007I	66	50	27	7	1		





Screw-type milling cutters for SO.. 08 inserts

ID	D [mm]	L [mm]	M	Z	max ap [mm]		
GW140 020M10 02502I	20	25	M10	2	1	N01-004743 PC60 M3x7,4	N01-003201 T9
GW140 025M12 02803I	25	28	M12	3	1		
GW140 032M16 03504I	32	35	M16	4	1		
GW140 035M16 03504I	35	35	M16	4	1		
GW140 042M16 03505I	42	35	M16	5	1		



Shank-type milling cutters for SO.. 08 inserts

ID	D [mm]	L2 [mm]	L [mm]	d [mm]	Z	max ap [mm]		
GT140 020W20 13002I	20	75	130	20	2	1	N01-004743 PC60 M3x7,4	N01-003201 T9
GT140 020W20 19002I	20	110	190	20	2	1		
GT140 025W25 14003I	25	80	140	25	3	1		
GT140 025W25 20003I	25	130	200	25	3	1		
GT140 032W32 15004I	32	90	150	32	4	1		
GT140 032W32 20004I	32	130	200	32	4	1		

