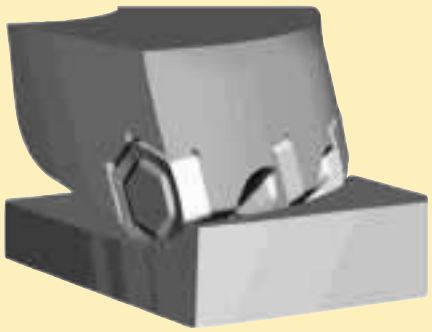
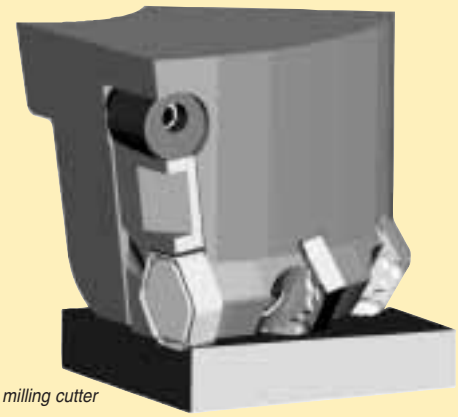
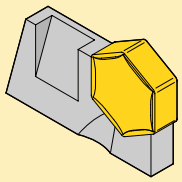


45° HexaCut milling cutter

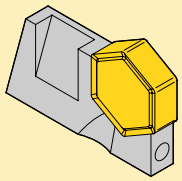


30° HexaCut milling cutter



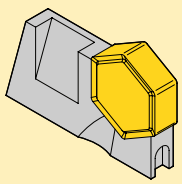
See 1.

catalog number right-hand 1 274 85 002 00
catalog number left-hand 1 274 85 001 00



See 2.

catalog number right-hand 1 274 85 004 00
catalog number left-hand 1 274 85 003 00



See 3.

catalog number right-hand 1 274 85 034 00
catalog number left-hand 1 274 85 035 00

Roughing face mill

For a cutting depth of ≤ .256 (6,5 mm)
and an achievable surface finish of RA > 125

Use roughing insert:

HNGX 090516-MR, HNGX 090508-MH,

HNGX 090520-MM, HNGX 090520-ML.

1. Roughing face mill with roughing anvil (not marked)

For a cutting depth of ≤ .315 (8 mm) and an achievable surface finish of RA > 125.

Use roughing insert: HNGX 090516-MR, HNGX 090508-MH, HNGX 090520-MM, HNGX 090520-ML in all insert seats.

2. Face mill for roughing/finishing with finishing anvil (marked ●)

a) For a cutting depth of ≤ .315 (8 mm) and an achievable surface finish of RA 125.

Use roughing insert: HNGX 090516-MR, HNGX 090508-MH, HNGX 090520-MM, HNGX 090520-ML in the fixed insert seats.

Use roughing/finishing insert: HNGF 090504-MT in the finishing anvil.

b) For a cutting depth of ≤ .040 (1 mm) and an achievable surface finish of RA 63.

Use roughing insert: HNGX 090504-MM, HNGX 090520-MM, HNGX 090520-ML in the fixed insert seats.
Use finishing insert: HNGF 090504-MF in the finishing anvil.

3. Face mill for roughing/finishing using finishing anvil with corrected straight cutting edge position to reduce axial force (marked ▬)

a) For a cutting depth of ≤ .315 (8 mm) and an achievable surface finish of RA 125.

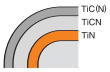
Use roughing insert: HNGX 090516-MR, HNGX 090508-MH, HNGX 090520-MM, HNGX 090520-ML in the fixed insert seats.

Use roughing/finishing insert: HNGF 090504-MT in the finishing anvil.

b) For a cutting depth of ≤ .040 (1 mm) and an achievable surface finish of RA 63. Use roughing insert: HNGX 090504-MM, HNGX 090520-MM, HNGX 090520-ML in the fixed insert seats.
Use finishing insert: HNGF 090504-MF in the finishing anvil.

Note regarding 2 and 3. Loading order is always four roughing inserts and one finishing insert, which is inserted axially ≈ .0015 (0,03 mm) in front of the roughing inserts.

Grade Descriptions

type	grade designation		grade description	standard designation	application range area of use: wear resistance ↔ toughness (01 05 10 15 20 25 30 35 40 45 50)
Uncoated	THM	 HW-K15	uncoated carbide grade - light and general machining - for machining cast iron andall non-ferrous metals and non-metals	P M K N S H	
Uncoated	TTM	 HW-P25	uncoated carbide grade - balanced toughness/wear ratio - general machining - for machining all types of steel	P M K N S H	
CVD	TN25M	 HC-P25	coated micro-grain grade - CVD-TiC-TiCN-TiN coating - light and general machining - for machining austenitic stainless steel as well as nodular cast iron	P M K N S H	
CVD	TN450	 HC-P30	coated carbide grade - CVD-TiN-TiCN-TiN multi-layer coating - general and heavy machining - for machining all types of steel and nodular cast iron - coolant recommended - extremely tough grade, resistant to changes in temperature	P M K N S H	
CVD	TN2510	 HC-H10	coated carbide grade - MT-CVD-TiN-TiCN composite coating - light machining - machining of hardened steel, stellite and cast iron up to 64 HRC - very good wear resistance	P M K N S H	
CVD	TN5505	 HC-K05	coated micro-grain grade - MT-CVD-TiN-TiCN-Al2O3 coating - light machining - for machining all types of cast iron - for use with very high cutting speeds	P M K N S H	
CVD	TN5515	 HC-K15	coated carbide grade - MT-CVD-TiN-TiCN-Al2O3 coating - light and general machining - for machining all types of cast iron - balanced toughness/wear ratio	P M K N S H	
CVD	TN5520	 HC-K20	coated carbide grade - MT-CVD-TiN-TiCN-Al2O3 coating - general and heavy machining - for machining all types of cast iron excellent toughness with good wear-resistance	P M K N S H	
CVD	TN7525	 HC-P25	coated carbide grade - MT-CVD-TiN-TiCN-Al2O3-TiN coating - light and general machining - for machining all types of steel and nodular cast iron	P M K N S H	
CVD	TN7535	 HC-P35	coated carbide grade - CVD-TiN-TiCN-Al2O3 multi-layer coating - general and heavy machining - for machining all types of steel and nodular cast iron - for use in unfavorable conditions	P M K N S H	
uncoated cermet	TTI25	 HT-P15	uncoated cermet grade - light and general machining - use at very high cutting speeds - use dry or with air blast	P M K N S H	