

NEW
EXTENDED
PROGRAMME



Chamfering milling cutters with spiral-fluted cutting edges

- fast, cost-effective production of large chamfers
- soft cut for soft and tough materials
- optimum surface finish qualities in one cut

SpyroTec Chamfering milling cutters

SpyroTec

THE SPIRAL-FLUTED CHAMFERING MILLING CUTTER, 5 CUTTING EDGES

Face cutting for use of the full cutting edge length up to the base of components.

5 different spiral angles and an **uneven cutting edge spacing** reliably reduce vibrations.

The spiral cutting edge geometry with a positive rake angle ensures a smooth cutting and optimum surface finish with large chamfers.

The combination of robust **finest grain carbide** and **TiAlN coating** results in a longer tool life.

Ratio®



PROGRAMME EXTENSION FOR EVEN MORE FLEXIBILITY

NEW

**SPIRAL-FLUTED
CHAMFERING
MILLING CUTTER**

page 6

/ 60°



// SpyroTec is also available as a special tool for all chamfer angles between 60° and 120°.

**SPIRAL-FLUTED
CHAMFERING
MILLING CUTTER**

page 4

/ 90°



NEW

**SPIRAL-FLUTED
CHAMFERING
MILLING CUTTER**

page 7

/ 120°



NEW

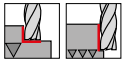
**SPIRAL-FLUTED
CHAMFERING
MILLING CUTTER SET**

page 5

/ 90°



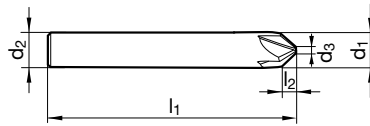
90° Chamfering milling cutters, spiral-fluted



P	•
M	•
K	○
N	•
S	•
H	

- face cutting
- without centre cutting

Tool material	Solid carbide	
Surface	A	A
Type	N	N
Shank form	HA	HB



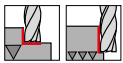
Article no. 6992 6993

d1 js9	d2 h6	d3	l1	l2	Z	Code no.
mm	mm	mm	mm	mm		
6.000	6.000	1.500	57.000	2.250	5	6.000
8.000	8.000	2.000	63.000	3.000	5	8.000
10.000	10.000	2.500	72.000	3.750	5	10.000
12.000	12.000	3.000	83.000	4.500	5	12.000
16.000	16.000	4.000	92.000	6.000	5	16.000
20.000	20.000	5.000	104.000	7.500	5	20.000

ISO	Hardness	v _c	f _z (mm/z) / Ø							v _c	f _z (mm/z) / Ø						
			3	6	8	10	12	16	20		3	6	8	10	12	16	20
P	≤ 850 N/mm ²	192	0,018	0,036	0,048	0,06	0,08	0,10	0,13	250	0,030	0,060	0,080	0,11	0,13	0,17	0,21
	≥ 850 N/mm ²	140	0,016	0,032	0,042	0,06	0,07	0,09	0,12	180	0,026	0,053	0,070	0,10	0,12	0,16	0,20
M	≤ 750 N/mm ²	120	0,013	0,025	0,034	0,05	0,05	0,07	0,09	160	0,021	0,042	0,056	0,08	0,09	0,12	0,15
	≥ 750 N/mm ²	80	0,009	0,019	0,025	0,04	0,04	0,06	0,07	100	0,016	0,032	0,042	0,06	0,07	0,10	0,12
K	≤ 240 HB	170	0,017	0,033	0,044	0,06	0,07	0,09	0,12	230	0,028	0,056	0,074	0,10	0,12	0,16	0,20
N	≥ 7 % Si	250	0,023	0,047	0,062	0,08	0,10	0,13	0,17	330	0,039	0,078	0,104	0,14	0,17	0,22	0,28



90° Chamfering milling cutters sets, spiral-fluted



P	•
M	•
K	○
N	•
S	•
H	

- face cutting
- without centre cutting
- consisting of art. no. 6992

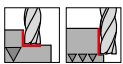
Tool material	Solid carbide
Surface	A
Type	N
Shank form	HA



Article no. **6994**

Ø-range	Pieces/set	Code no.
mm		
6/8/10/12	4	1.000

90° Chamfering milling cutters sets, spiral-fluted



P	•
M	•
K	○
N	•
S	•
H	

- face cutting
- without centre cutting
- consisting of art. no. 6993

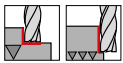
Tool material	Solid carbide
Surface	A
Type	N
Shank form	HB



Article no. **6995**

Ø-range	Pieces/set	Code no.
mm		
6/8/10/12	4	1.000

60° Chamfering milling cutters, spiral-fluted



P	•
M	•
K	○
N	•
S	•
H	

- face cutting
- without centre cutting

Tool material	Solid carbide	
Surface	A	A
Type	N	N
Shank form	HA	HB
	NEW	NEW



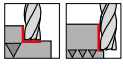
Article no. 6810 6811

d1 js9	d2 h6	d3	l1	l2	Z	Code no.
mm	mm	mm	mm	mm		
6.000	6.000	1.500	57.000	3.900	5	6.000
8.000	8.000	2.000	63.000	5.200	5	8.000
10.000	10.000	2.500	72.000	6.500	5	10.000
12.000	12.000	3.000	83.000	7.800	5	12.000
16.000	16.000	4.000	92.000	10.400	5	16.000
20.000	20.000	5.000	104.000	13.000	5	20.000

ISO	Hardness	v _c	f _z (mm/z) / Ø							v _c	f _z (mm/z) / Ø						
			3	6	8	10	12	16	20		3	6	8	10	12	16	20
P	≤ 850 N/mm ²	192	0,018	0,036	0,048	0,06	0,08	0,10	0,13	250	0,030	0,060	0,080	0,11	0,13	0,17	0,21
	≥ 850 N/mm ²	140	0,016	0,032	0,042	0,06	0,07	0,09	0,12		180	0,026	0,053	0,070	0,10	0,12	0,16
M	≤ 750 N/mm ²	120	0,013	0,025	0,034	0,05	0,05	0,07	0,09	160	0,021	0,042	0,056	0,08	0,09	0,12	0,15
	≥ 750 N/mm ²	80	0,009	0,019	0,025	0,04	0,04	0,06	0,07		100	0,016	0,032	0,042	0,06	0,07	0,10
K	≤ 240 HB	170	0,017	0,033	0,044	0,06	0,07	0,09	0,12	230	0,028	0,056	0,074	0,10	0,12	0,16	0,20
N	≥ 7 % Si	250	0,023	0,047	0,062	0,08	0,10	0,13	0,17	330	0,039	0,078	0,104	0,14	0,17	0,22	0,28



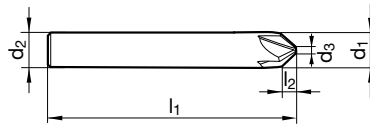
120° Chamfering milling cutters, spiral-fluted



P	•
M	•
K	○
N	•
S	•
H	

- face cutting
- without centre cutting

Tool material	Solid carbide	
Surface	A	A
Type	N	N
Shank form	HA	HB
	NEW	NEW



Article no.						6812	6813
d1 js9	d2 h6	d3	l1	l2	Z	Code no.	
mm	mm	mm	mm	mm			
6.000	6.000	1.500	57.000	1.300	5	6.000	
8.000	8.000	2.000	63.000	1.730	5	8.000	
10.000	10.000	2.500	72.000	2.170	5	10.000	
12.000	12.000	3.000	83.000	2.600	5	12.000	
16.000	16.000	4.000	92.000	3.460	5	16.000	
20.000	20.000	5.000	104.000	4.330	5	20.000	

ISO	Hardness	v _c	f _z (mm/z) / Ø							v _c	f _z (mm/z) / Ø						
			3	6	8	10	12	16	20		3	6	8	10	12	16	20
P	≤ 850 N/mm ²	192	0,018	0,036	0,048	0,06	0,08	0,10	0,13	250	0,030	0,060	0,080	0,11	0,13	0,17	0,21
	≥ 850 N/mm ²	140	0,016	0,032	0,042	0,06	0,07	0,09	0,12		180	0,026	0,053	0,070	0,10	0,12	0,16
M	≤ 750 N/mm ²	120	0,013	0,025	0,034	0,05	0,05	0,07	0,09	160	0,021	0,042	0,056	0,08	0,09	0,12	0,15
	≥ 750 N/mm ²	80	0,009	0,019	0,025	0,04	0,04	0,06	0,07		100	0,016	0,032	0,042	0,06	0,07	0,10
K	≤ 240 HB	170	0,017	0,033	0,044	0,06	0,07	0,09	0,12	230	0,028	0,056	0,074	0,10	0,12	0,16	0,20
N	≥ 7 % Si	250	0,023	0,047	0,062	0,08	0,10	0,13	0,17	330	0,039	0,078	0,104	0,14	0,17	0,22	0,28

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