

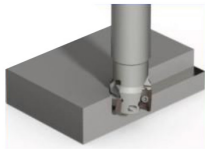
SNMU1206

8 Corner 88° Milling Inserts

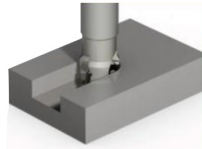


Application

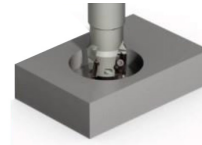
Shoulder Face Milling



Slot milling

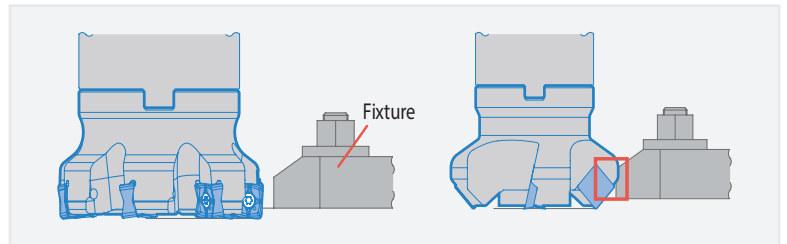


Helical milling

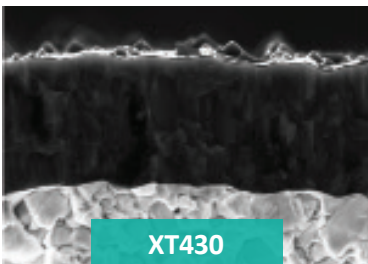


Benefits

- Facing Without Interfering with Fixtures
- Economical Inserts with 8 Cutting Edges
- Suitable for Shoulder Roughing
- 1 grade → XT430 for all multipurpose general applications.


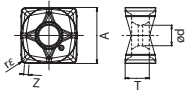


GRADE DESCRIPTION



Quality PVD Grade
General purpose for continued
and interrupted machining
Black coating. ALTiN 3~4um
P10-P30/M10-M25/K10-K20

Applicable Inserts

Shape	Description	Dimensions (mm)					Grade	ap	Feed
		A	T	ød	Z	rε			
 	SNMU 1206EN-GM	13	5.51	4.7	1	0.8	● XT430	0.3-3.5	0.06-0.3

Face Mill Cutter Dimensions

Rake Angle	Radial Rake	
	∅D = 50 : -12°	∅D = 100 : -8°
	∅D = 63 : -10°	∅D = 125 : -7.5°
	∅D = 80 : -9°	∅D = 160 : -7°

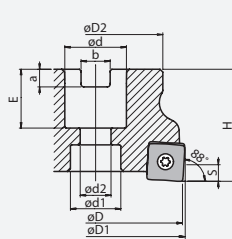
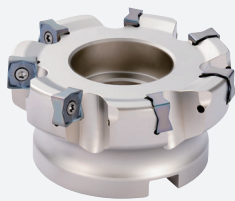


Fig. 1

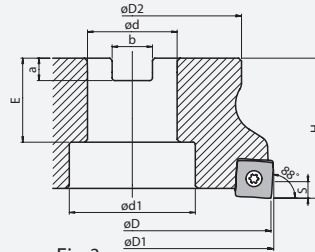

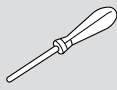


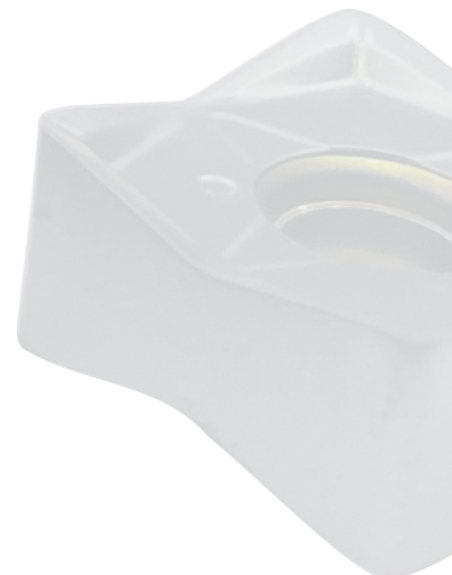
Fig. 2

Description	Stock	No. of Inserts Dimensions (mm)	Dimensions (mm)									
			∅D	∅D1	∅D2	∅d	∅d1	∅d2	H	E	a	b
XTSM-D40-Z3-SN-MU1206-88°	●	3	40	52	48	22	17.5	11	40	21	6.3	10.4
XTSM-D50-Z4-SN-MU1206-88°	●	4	50	65			18					
XTSM-D63-Z5-SN-MU1206-88°	●	5	63	82	70	27	20	13	50	24	7	12.4
XTSM-D80-Z7-SN-MU1206-88°	●	7	80	102	78	32	45			30	8	14.4
XTSM-D100-A32-Z7-SNMU1206-88°	●	7	100	127	89	40	55	-	63	33	9	16.4
XTSM-D125-A40-Z9-SNMU1206-88°	●	9	125	162	110							

Spare Parts for Face Mill

Description	Spare parts	
	Clamp screw	Wrench
		
	M3.5x9	T15

* Shank type cutter on request



RECOMMENDED CUTTING CONDITIONS

XT430

ISO	Material Group	Relative Materials(DIN)	Hardness HB	Cutting speed (m/min)
P	Non-alloy steel	9 SMn 28, C35C50, C40E, C45E, 49 CrMo 4	125 - 250	150 - 250
	Low alloy steel	13 CrMo 44, 40NiCrM022, 58 CrV 4	200 - 350	150 - 250
	High alloy steel	X 40 CrMoV 5 1, X100 CrMoV 5 1, S6-5-5	200 - 325	80 - 200
M	Ferritic/martensitic Stainless steel	X6Cr13, X10CrA118, X20CrNi175	200 - 240	80 - 160
	Austenitic Stainless steel	X5 CrNi 18 9, X5 CrNiMo 17 13 3 X6 CrNiTi 18 9	180	80 - 200
K	Grey cast iron	GG15, GG20, GGG40, GG-35	180 - 260	90 - 200
	Malleable castiron	GTS-35-10, GTS-35,GTS70-02, 20mN5	130 - 230	90 - 200

Authorised Dealer