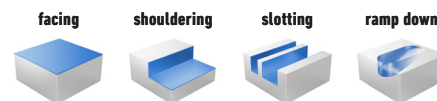
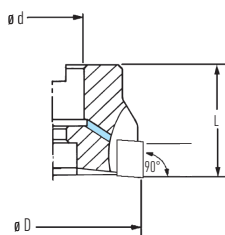


Shoulder milling F1180



- maximum utilization thanks to stable clamping insert
- positive milling, 2 edges
- sharp edge geometry for high-quality machining
- tool body with internal cooling
- cost-effective bodies without internal cooling



Arbor mounting

Order code	Dimension (mm)				Screw	Key	Stock
	D	d	L	Z			
F1180.40.N16.40.10.Z6.C	40	16	40	6	VT25	BT08	○
F1180.50.N22.40.10.Z7.C	50	22	40	7			○
F1180.63.N22.40.10.Z8.C	63	22	40	8			○
F1180.80.N27.50.10.Z11.C	80	27	50	11			○
F1180.100.N32.50.10.Z12.C	100	32	50	12			○
F1180.40.N16.40.10.Z6.ECO	40	16	40	6			○
F1180.50.N22.40.10.Z7.ECO	50	22	40	7			○

○ = available under request

ECO = version without internal

Overview of suitable inserts

	P	M	K	N	S	H
APKT 1003 PDR-S PK19	○		○			
APKT 1003 PDR-S PM19	○	○				
APKT 1003 PDR-S PMK19	○	○	○			
APKT 1003 PDR-M PMK20	○	○	○			
APKT 1003 PDF IT AL19				○		

○ = available under request

Recommended cutting conditions

		P	M	K	N
PK19	mat.	P10-P20		K10-K20	
	fz	0,05-0,3		0,05-0,3	
	ap	0,1-4		0,1-0,4	
	Vc	180-280		160-270	
PM19	mat.	P30-P40	M30-M40		
	fz	0,05-0,25	0,05-0,25		
	ap	0,1-4	0,1-4		
	Vc	110-120	90-160		
PMK19	mat.	P25-P40	M20-M40	K20-K40	
	fz	0,1-0,3	0,1-0,3	0,1-0,3	
	ap	0,1-4	0,1-4	0,1-4	
	Vc	100-170	70-130	120-230	
PMK20	mat.	P25-P40	M20-M40	K20-K40	
	fz	0,1-0,3	0,1-0,3	0,1-0,3	
	ap	0,1-4	0,1-4	0,1-4	
	Vc	110-170	70-130	120-230	
AL19	mat.				K10-K15
	fz				0,06-0,2
	ap				0,1-4
	Vc				300-500