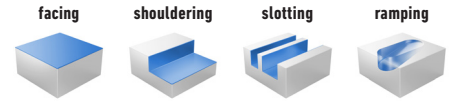
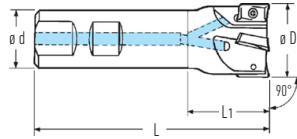


Shoulder mill F1100



- 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



Cylindrical shank

Order code	Dimensions (mm)				Z	Maximum immersion angle	Insert screw	Key	Stock
	D	d	L	L ₁					
F1100.10.W16.80.10.Z1.C	10	16	80	28	1	11°	VT25	BT08	○
F1100.12.W16.80.10.Z1.C	12	16	80	28	1	9°			○
F1100.14.W16.80.10.Z1.C	14	16	80	28	1	8°			○
F1100.15.W16.85.10.Z2.C	15	16	85	28	2	4°			○
F1100.15.7.W16.85.10.Z2.C	15,7	16	85	28	2	3,5°			○
F1100.16.W16.85.10.Z2.C	16	16	85	37	2	3,5°			○
F1100.17.W16.85.10.Z2.C	17	16	85	37	2	3°			○
F1100.18.W20.85.10.Z2.C	18	20	85	37	2	2,5°			○
F1100.19.7.W20.90.10.Z3.C	19,7	20	90	40	3	1,5°			○
F1100.20.W20.90.10.Z3.C	20	20	90	40	3	1,5°			○
F1100.22.W25.95.10.Z3.C	22	25	95	49	3	1,5°			○
F1100.24.7.W25.95.10.Z3.C	24,7	25	95	49	3	0,9°			○
F1100.25.W25.95.10.Z3.C	25	25	105	49	3	0,9°			○
F1100.25.W25.105.10.Z4.C	25	25	105	49	4	0,9°			○
F1100.28.W25.105.10.Z4.C	28	25	105	49	4	0,9°			○
F1100.30.W25.105.10.Z4.C	30	25	105	49	4	0,8°			○
F1100.32.W25.95.10.Z5.C	32	25	110	54	5	0,6°			○
F1100.10.W16.150.10.Z1.C	10	16	150	50	1	11°			○
F1100.12.W16.150.10.Z1.C	12	16	150	50	1	9°			○
F1100.16.W16.150.10.Z2.C	16	16	150	100	2	3,5°			○
F1100.20.W20.150.10.Z3.C	20	20	150	100	3	1,5°			○
F1100.25.W20.150.10.Z4.C	25	20	150	100	4	0,9°			○
F1100.32.W25.150.10.Z5.C	32	25	150	55	5	0,6°			○
F1100.16.W16.85.10.Z2.ECO	16	16	85	37	2	3,5°			○
F1100.20.W20.90.10.Z3.ECO	20	20	90	40	3	1,5°			○
F1100.25.W25.95.10.Z4.ECO	25	25	95	49	4	0,9°			○

○ = 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