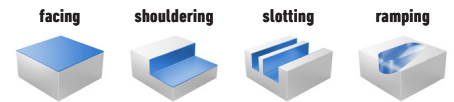
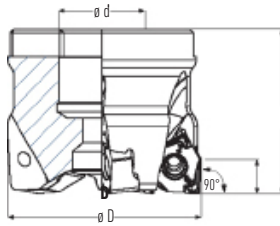


# Shoulder mill F1551



- robust inserts designed for roughing applications
- negative milling, 6 edges
- excellent processing quality at high  $A_p$
- economy mode by 6 edges
- tools body and insert stored in professional box
- internal cooling



## Arbor mounting

Order code	Dimension (mm)				Insert screw	Key	Stock
	D	d	L	Z			
F1551.50.N22.40.7.Z5.5	50	22	40	5	VT40 835	BT15	○
F1551.63.N22.40.7.Z6.C	63	22	40	6			○
F1551.80.N27.50.7.Z7.C	80	27	50	7			○
F1551.100.N32.50.7.Z8.C	100	32	50	8			○
F1551.125.N40.63.7.Z10.C	125	40	63	10			○
F1551.160.N40.63.7.Z11.C	160	40	63	11			○

○ = available under request

## Overview of suitable inserts

	P	M	K	N	S	H
WNEX 080608-JG PK19	●		●			
WNEX 080608-JG PM19	●	●				
WNEX 080608-JG PMK19	○	○	○			
WNEX 080608-IK AL19				○		

● = stock item

○ = available under request

**JG** = pressed insert with solid edge for roughing and medium finishing

**MT** = ground insert for medium roughing and finishing

**IK** = sharp geometry for machining non-ferrous metals

## Recommended cutting conditions

		P	M	K	N
PK19	mat.	P10-P20		K10-K20	
	fz	0,1-0,3		0,1-0,3	
	ap	0,5-6		0,5-6	
	Vc	110-220		110-220	
PM19	mat.	P30-P40	M30-M40		
	fz	0,1-0,3	0,1-0,3		
	ap	0,5-6	0,5-6		
	Vc	100-170	60-130		
PKM19	mat.	P25-P40	M20-M40	K20-K40	
	fz	0,1-0,3	0,1-0,3	0,1-0,3	
	ap	0,5-6	0,5-6	0,5-6	
	Vc	110-200	50-120	120-200	
AL19	mat.				K10-K20
	fz				0,1-0,3
	ap				0,5-6
	Vc				300-500