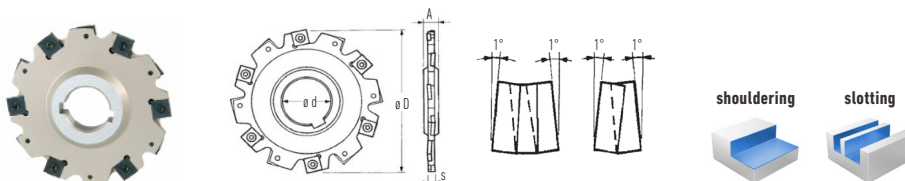


Grooving and cut off mill F3000



- open grooves
- deep grooves
- compound tool milling (group assembly)
- material division



Version for thorn 1/2

Order code	Dimensions (mm)						Max. depth of cut	Number of teeth	Insert	Insert screw	Key	Stock
	D	d	s	L	D ₁	Zef.						
F3000.63.N22.8.Z4.04	63	22	4	8	34	4	14	8	SNHX1102T	VTX 3503	BT 09	○
F3000.63.N22.8.Z4.05	63	22	5	8	34	4	14	8	SNHX1103T	VTX 3504	BT 09	○
F3000.63.N22.8.Z3.06	63	22	6	8	34	3	14	6	SNHX1203T	VTX 405	BT 15	○
F3000.80.N22.8.Z5.04	80	22	4	8	34	5	22	10	SNHX1102T	VTX 3503	BT 09	○
F3000.80.N22.8.Z5.05	80	22	5	8	34	5	22	10	SNHX1103T	VTX 3504	BT 09	○
F3000.80.N22.8.Z4.06	80	22	6	8	34	4	22	8	SNHX1203T	VTX 405	BT 15	○
F3000.100.N27.12.Z6.04	100	27	4	12	45	6	25	12	SNHX1102T	VTX 3503	BT 09	○
F3000.100.N27.12.Z6.05	100	27	5	12	45	6	25	12	SNHX1103T	VTX 3504	BT 09	○
F3000.100.N27.12.Z5.06	100	27	6	12	45	5	25	10	SNHX1203T	VTX 405	BT 15	○
F3000.100.N27.12.Z5.10	100	27	10	12	45	5	25	10	SNHX1205T	VTX 408	BT 15	○
F3000.125.N40.12.Z6.04	125	40	4	12	58	6	31	12	SNHX1102T	VTX 3503	BT 09	○
F3000.125.N40.12.Z6.05	125	40	5	12	58	6	31	12	SNHX1103T	VTX 3504	BT 09	○

○ = available under request

Version for thorn 2/2

Order code	Dimensions (mm)						Max. depth of cut	Number of teeth	Insert	Insert screw	Key	Stock
	D	d	s	L	B	Zef.						
F3000.125.N40.12.Z6.06	125	40	6	12	58	6	31	12	SNHX1203T	VTX 405	BT 15	○
F3000.125.N40.12.Z6.10	125	40	10	12	58	6	31	12	SNHX1205T	VTX 408	BT 15	○
F3000.160.N40.12.Z9.04	160	40	4	12	68	9	44	18	SNHX1102T	VTX 3503	BT 09	○
F3000.160.N40.12.Z9.05	160	40	5	12	68	9	44	18	SNHX1103T	VTX 3504	BT 09	○
F3000.160.N40.12.Z8.06	160	40	6	12	68	8	44	16	SNHX1203T	VTX 405	BT 15	○
F3000.160.N40.12.Z8.10	160	40	10	12	68	8	44	16	SNHX1205T	VTX 408	BT 15	○
F3000.160.N40.14.Z5.14	160	40	14	14	68	5	44	15	SNHX1205T	VTX 408	BT 15	○
F3000.200.N50.12.Z9.04	200	50	4	12	72	9	62	18	SNHX1102T	VTX 3503	BT 09	○
F3000.200.N50.12.Z9.05	200	50	5	12	72	9	62	18	SNHX1103T	VTX 3504	BT 09	○
F3000.200.N50.12.Z9.06	200	50	6	12	72	9	62	18	SNHX1203T	VTX 405	BT 15	○
F3000.200.N50.12.Z9.10	200	50	10	12	72	9	62	18	SNHX1205T	VTX 408	BT 15	○
F3000.200.N50.14.Z6.14	200	50	14	14	72	6	62	18	SNHX1205T	VTX 408	BT 15	○
F3000.250.N50.12.Z12.10	250	50	10	12	72	12	87	24	SNHX1205T	VTX 408	BT 15	○

○ = available under request

Grooving and cut off mill F3000

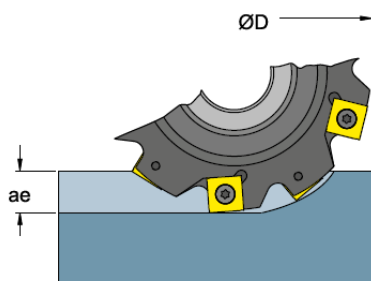


Overview of suitable inserts

Order code	P	M	K	N	S	H
SNHX 1102T P25	○					
SNHX 1103T P25	○					
SNHX 1102T TIN	○	○				
SNHX 1103T TIN	○	○				
SNHX 1203T P25	○					
SNHX 1205T P25	○					
SNHX 1203T TIN	○	○				
SNHX 1205T TIN	●	●				

Order code	P	M	K	N	S	H
SNHX 1102T TIALN	○	○	○			
SNHX 1103T TIALN	○	○	○			
SNHX 1203T TIALN	○	○	○			
SNHX 1205T TIALN	○	○	○			
SNHX 1102 ALU K15				○		
SNHX 1103 ALU K15				○		
SNHX 1203 ALU K15				○		
SNHX 1205 ALU K15				○		

● = stock item ○ = available under request



ae/D	0,5-1 50 - 100%	0,2 20%	0,1 10%	0,05 5%
Vc	Vc (min)-----Vc (max)			
	R-----M-----F			

ae/D	0,3 30%	0,2 20%	0,1 10%	0,05 5%	0,02 2%
Kae	1,2	1,5	2,1	3	4,8

Recommended cutting conditions

		Coated insert					Feed fz (mm/t)	Chip depth Ap (mm)	
		SNHX 11...P25	SNHX 11...TIN	SNHX 12...P25	SNHX 12...TIN	SNHX...TIALN			SNHX...ALU
		Cutting speed Vc (m/min.)							
P	Steel	70-90	140-160	70-90	140-160	120-200	0,05-0,15	0,1-12	
M	Stainless steel		90-120		90-120	70-130	0,05-0,15	0,1-12	
K	Cast iron					130-210	0,08-0,15	0,1-10	
N	Aluminium and non ferrous					200-500	0,08-0,15	0,1-10	