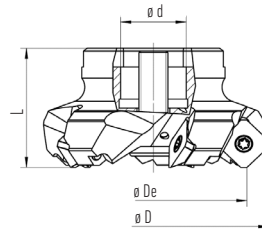


Face mill F2400



- very high quality surface after processing
- positive milling, 4 edges
- positive geometry reduces the occurrence of vibrations
- pressed or ground inserts
- suitable for both roughing and finishing
- internal cooling



Arbor mounting

Order code	Dimensions (mm)					Insert	Insert screw	Key	Shim + Screw	Torque value (Nm)	Stock
	De	D	d	L	Z						
F2400.50.N22.40.5.Z4.C	50	63,4	22	40	4	SEET 13T3 ASGN SEET 13T3 AFGN	P0351200	XT15	CS130300+T0503509	3	○
F2400.50.N22.40.5.Z5.C	50	63,4	22	40	5						●
F2400.63.N22.40.5.Z5.C	63	76,6	22	40	5						○
F2400.63.N22.40.5.Z6.C	63	76,6	22	40	6						●
F2400.80.N27.50.5.Z6.C	80	93,5	27	50	6						○
F2400.80.N27.50.5.Z8.C	80	93,5	27	50	8						●
F2400.100.N32.50.5.Z9.C	100	113,5	32	50	9						○
F2400.100.N32.50.5.Z7.CP	100	113,5	32	50	7						●
F2400.125.N40.63.5.Z10.C	125	138,5	40	63	10						○
F2400.125.N40.63.5.Z8.CP	125	138,5	40	63	8						●
F2400.160.N40.63.5.Z11.C	160	173,5	40	63	11						○
F2400.160.N40.63.5.Z10.CP	160	173,5	40	63	10						●

● = stock item ○ = available under request C - internal cooling P - with shim

Overview of suitable inserts

	P	M	K	N		
High speed / light machining				●		
Common use	●		●			
Roughing	●	●	●	●		
Order code	PK19	PMK19	PMK19	PK19	PMK19	AL19
SEET 13T3 ASGN	●	●	●	●	●	
SEET 13T3 AFGN						○

● = stock item ○ = available under request

Recommended cutting conditions

	HB	Coating		SEET 13T3 ASGN	SEET 13T3 AFGN	SEET 13T3 ASGN
		AL19	PK19	PMK19	AL19	PK19
		Cutting Speed Vc (m/min)			Feed fz (mm/t)	
P	Unalloyed steel	125-220	150-230	130-160	0,10-0,25	0,10-0,30
	Low-alloyed steel	220-280	140-220	120-150	0,10-0,20	0,10-0,30
	High-alloyed steel	280-380	130-180	100-130	0,10-0,20	0,10-0,30
M	SS - Ferritic / Martensitic	200-330		100-120	0,10-0,20	
	SS - Austenitic	200-330		80-110	0,10-0,20	
	SS - austenitic - ferritic (Duplex)	230-260		70-100	0,10-0,20	
K	Grey cast iron	180-245	150-280	130-250	0,10-0,25	0,10-0,30
	Malleable cast Iron	130-230	130-230	110-220	0,10-0,25	0,10-0,30
		160-250	80-190	80-170	0,10-0,20	0,10-0,30
N	Aluminium and non ferrous	30-130	350-1400		0,10-0,20	