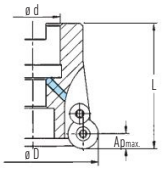
Profile mill F2680, F2610

- milling cutters for general use
- the highest strength and durability of the blades
- large number of cutting edges per insert
- particularly suitable for machining refractory alloys ISO S
- calm and fluent course

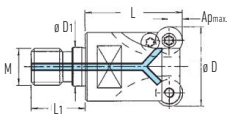
Arbor mounting



Order Code	Dimensions (mm)					Insert	Insert screw	Key	Shim	Stock
	D	d	L	$Ap_{max.}$	Z					
F2680.52.N22.50.8.Z5.C	52	22	50	6	5	RD..12T3	VT35	BT15	CVB 35	O
F2680.52.N22.50.6.Z4.C	52	22	50	8	4	RD..1604	VT45	BT20	CVB 45	O
F2680.66.N27.50.8.Z6.C	66	27	50	6	6	RD..12T3	VT35	BT15	CVB 35	O
F2680.66.N27.50.6.Z5.C	66	27	50	8	5	RD..1604	VT45	BT20	CVB 45	O
F2680.80.N27.50.8.Z7.C	80	27	50	6	7	RD..12T3	VT35	BT15	CVB 35	O
F2680.80.N27.50.6.Z6.C	80	27	50	8	6	RD..1604	VT45	BT20	CVB 45	O
F2680.100.N32.55.8.Z7.C	100	32	55	8	7	RD..1604	VT45	BT20	CVB 45	O
F2680.125.N40.55.8.Z8.C	125	40	55	8	8	RD..1604	VT45	BT20	CVB 45	O

O = available under request

Threaded coupling



Order Code	Dimensions (mm)							Insert	Insert screw	Key	Shim	Stock
	D	L	M	D_1	L1	$Ap_{max.}$	Z					
F2610.20.M10.30.5.Z2.C	20	30	10	10,5	20	5	2	RD..1003	VT35	BT15		O
F2610.25.M12.35.5.Z2.C	25	35	12	12,5	22	5	2	RD..1003				O
F2610.25.M12.35.5.Z3.C	25	35	12	12,5	22	5	3	RD..1003				O
F2610.30.M16.43.5.Z4.C	30	43	16	17,0	24	5	4	RD..1003				O
F2610.35.M16.43.6.Z3.C	35	43	16	17,0	24	6	3	RD..12T3			CVB 35	O
F2610.35.M16.43.5.Z4.C	35	43	16	17,0	24	5	4	RD..1003				O
F2610.42.M16.43.6.Z4.C	42	43	16	17,0	24	6	4	RD..12T3			CVB 35	O
F2610.42.M16.43.5.Z5.C	42	43	16	17,0	24	5	5	RD..1003				O

O = available under request

Profile mill F2680, F2610

Overview of suitable inserts

Order code	P	M	K	N	S	H
RDMT 10T3M0TN CY250	○	○	○			
RDMT 1204M0TN JP4020		○	○		○	○
RDMT 1604M0TN JP4020		○	○		○	○
RDMW 1003M0TN CY250	○	○	○			
RDMW 1003M0TN TB6045	○	○	○			
RDMW 12T3M0TN CY250	○	○	○			
RDMW 12T3M0TN TB6045	○	○	○			
RDMW1604M0TN CY250	○	○	○			
RDHX 1003M0TN JP4020		○	○		○	○
RDHX 1003M0TN JP4005						○
RDHX 12T3M0TN JP4020		○	○		○	○
RDHX 12T3M0TN JP4005						○

○ = available under request

Recommended cutting conditions

		Cutting speed Vc (m/min.)			Feedfz (mm/t)			Chip depth Ap (mm)		
		RD...10	RD...12	RD...16	RD...10	RD...12	RD...16	RD...10	RD...12	RD...16
P	Steel	160-250	160-250	160-250	0,35-0,80	0,35-0,80	0,40-1,00	0,8-1,6	0,5-2,0	0,7-3,0
M	Stainless steel	170-200	170-200	170-200	0,50-0,80	0,50-0,80	0,60-1,00	0,8-1,6	1,2-2,0	1,5-3,0
K	Cast iron	120-150	120-150	120-150	0,50-0,80	0,50-0,80	0,60-1,00	0,8-1,6	1,2-2,0	1,5-3,0
S	High temperature alloys	120-160	120-160	120-160	0,35-0,50	0,35-0,50	0,40-0,60	0,3-0,6	0,4-0,8	0,7-1,4
H	Hardened steel	80	80	80	0,20-0,25	0,20-0,30	0,25-0,40	0,25-0,5	0,3-0,6	0,4-0,8