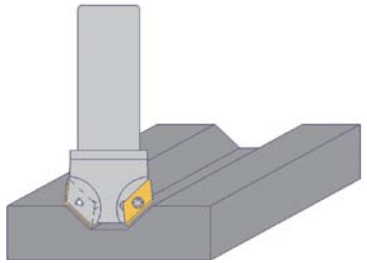
Milling Cutters Series

YOUNG CUTTINGTOOLS

Product Application

Type of operation

1



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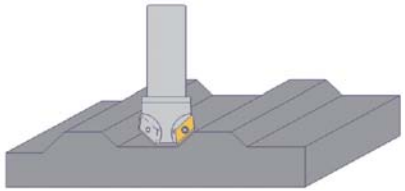

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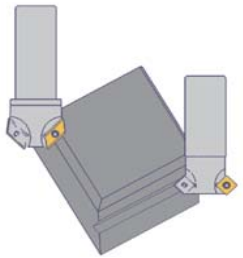

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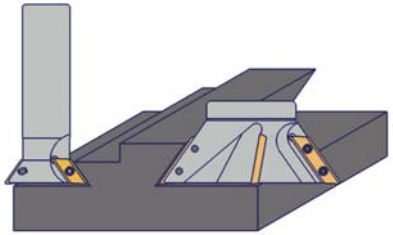
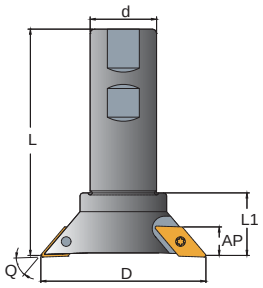


PRODUCT SPECIFICATIONS

Dovetails

- Insert P. 277
- Cutting Data P. 277 - 278



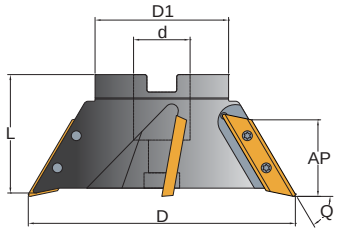
XD

Order code	Dimensions(mm)							KG	MAX RPM	Insert	Screw	Key
	D	d	Q	L	AP	L1						
XD2040-50	40	20	50	100	10	30	2	0.5	17000	XDGT 120308	C03507	T10P
XD2040-55			55		10.5							
XD2040-60			60		11							
XD3260-50	60	32	50	110	14		3	0.9	7500	XDGT 190408	C04011	T15P
XD3260-55			55		15							
XD3260-60			60		16							
XD3280-50	80		50		14		4	1.2	6500			
XD3280-55			55		15							
XD3280-60			60		16							

Dovetail Milling Cutter

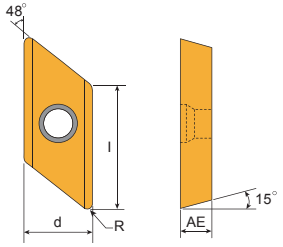
- Insert P. 277
- Cutting Data P. 277 - 278

XV



Order code	Dimensions(mm)							KG	MAX RPM	Insert	Screw	Key
	D	D1	d	L	AP	Q						
XV120-50-25.4	120	60	25.4	55	31	50	4	1.2	6000	XDGT 400408	C04011	T15P
XV120-55-25.4					33	55						
XV120-60-25.4					35	60						
XV120-50-27			27		31	50						
XV120-55-27					33	55						
XV120-60-27					35	60						

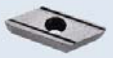
Recommended Insert Grade

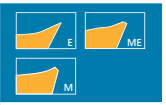


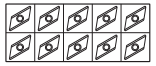
Tolerances (mm)

	d	AE	l
XDGT12	±0.03	±0.025	±0.03
XDGT19	±0.03	±0.025	±0.03
XDGT40	±0.03	±0.025	±0.03

Size	Dimensions in mm				
	l	d	AE	Q	Q1
12	12	8.5	3.18	-	-
19	19	10.6	4.76	-	-
40	40	10.6	4.76	-	-

Inserts	Part No .	Grades										
		Coated					cermet			Uncoated		
		B100	C200	C250	F20	F30	CE25	CE60		K10	CE	
	XDGT120308R-E											
	XDGT120308R-ME	◎										
	XDGT120308TR-M	◎										
	XDGT190408R-E											
	XDGT190408R-ME	◎										
	XDGT190408TR-M	◎										
	XDGT400408R-E											
	XDGT400408R-ME	◎										
	XDGT400408TR-M	◎										





Inserts 10 PCS / Box

Inserts
2 PCS / Box

- Steel Stainless Steel Steel/Stainless Steel Cast Iron Aluminum Steel/Cast Iron Steel/Stainless Steel/Cast Iron
- Correct price and stock are based on current situation
- Please specify model number and grade of insert, ie.: XDGT120308R-E, F20

XDGT Instert Grade Selection

Data reference

Material Group No.	Recom. feed fz mm/ tooth	Insert			
		XDGT ... M	XDGT ... ME	XDGT ... E	
1	0.08-0.25	C250/B100	B100	-	-
2	0.08-0.25	C250/B100	B100	-	-
3	0.08-0.25	C250/B100	B100	-	-
4	0.08-0.25	C250/B100	B100	-	-
5	0.06-0.20	C250/B100	B100	-	-
6	0.06-0.20	C250/B100	B100	-	-
7	0.08-0.15	C250/B100	B100	-	-
8	0.08-0.15	-	B100	-	-
9	0.07-0.15	-	B100	-	-
10	0.06-0.15	-	B100	-	-
11	0.10-0.15	-	B100	-	-
12	0.10-0.25	-	F30	-	-
13	0.10-0.25	-	F30	-	-
14	0.10-0.20	-	F30	-	-
15	0.05-0.20	-	F30	-	-
16	0.05-0.25	-	-	F20	-
17	0.06-0.25	-	-	F20	-
18	0.06-0.25	-	-	F20	-
19	0.05-0.08	-	B100	-	-
20	0.05-0.08	-	B100	-	-
21	0.06-0.08	-	B100	-	-
22	0.05-0.08	-	B100	-	-

Recommended Cutting Data

• Recommended Cutting speed, Vc(m/min)

Data reference

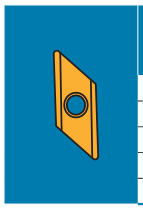
Material group No.	Grades						
	B100	C250	F20	CE60	CE	K10	F30
	Feed fz (mm/tooth)						
	0.08 0.15 0.20	0.08 0.15 0.20	0.08 0.15 0.25				0.08 0.15 0.25
	Cutting SPEED, V_c (m/min)						
1	240 190 170	192 152 136	-	-	-	-	-
2	210 165 145	168 132 116	-	-	-	-	-
3	170 148 125	136 118 100	-	-	-	-	-
4	155 130 105	124 104 84	-	-	-	-	-
5	135 115 -	108 92 -	-	-	-	-	-
6	115 90 -	92 72 -	-	-	-	-	-
7	40 35	32 28 -	-	-	-	-	-
8	108 89 79	-	-	-	-	-	-
9	92 76 66	-	-	-	-	-	-
10	76 60 54	-	-	-	-	-	-
11	54 45 -	-	-	-	-	-	-
12	-	-	-	-	-	-	170 145 125
13	-	-	-	-	-	-	155 125 115
14	-	-	-	-	-	-	110 90 -
15	-	-	-	-	-	-	90 70 -
16	-	-	1080 900 780	-	-	-	-
17	-	-	950 900 770	-	-	-	-
18	-	-	1080 900 780	-	-	-	-
19	50 40 -	40 32 -	-	-	-	-	-
20	35 30 -	28 24 -	-	-	-	-	-
21	50 40 -	40 32 -	-	-	-	-	-
22	50 40 -	40 32 -	-	-	-	-	-

• Cutting Data

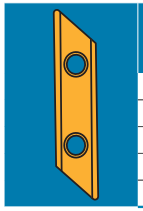
Data reference

Operations	Ae/Dc	Recom. feed fz mm/tooth			Speed factor
Full engagement	100%	0.02	0.07	0.12	1.00
Side milling	5%	0.06	0.20	0.34	1.60
	10%	0.04	0.14	0.25	1.50
	25%	0.03	0.09	0.16	1.30
Average chip thickness	-	0.01	0.04	0.08	-

• Type Of Insert



Style	Length of insert edge mm
120308	11
190408	18
-	-
-	-
-	-



Style	Length of insert edge mm
400408	39
-	-
-	-
-	-
-	-

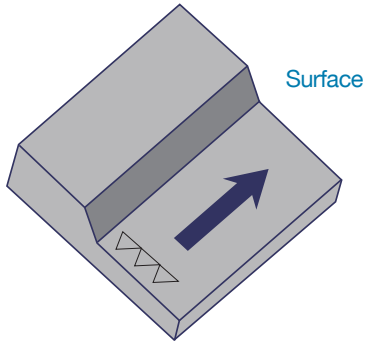
ALUMINIUM ALLOY FACE MILLING CUTTER

Features

- Available in materials — N
- Cost **150%** DOWN
- Variety of Machines — CNC Milling machine
- Efficiency **150%** UP
- Durability **150%** UP

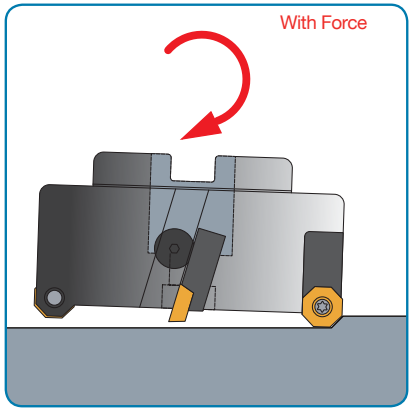
Clamping By A Wedge Centre-Lock Clamping

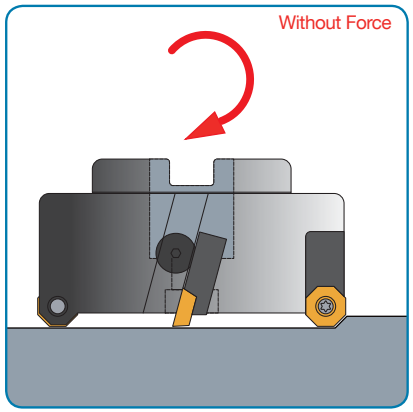
The Insert Are Held In Position By A Wedge And A Screw Which Clamps The Wedge (Example Shows Milling Cutter With Cassettes)

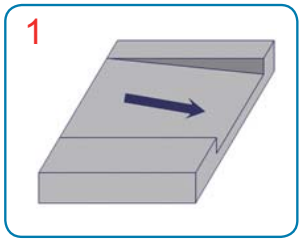


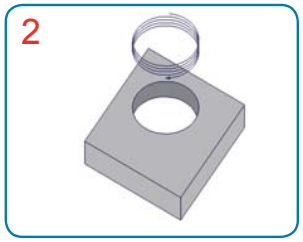
Surface Finish Ra < 10 µm

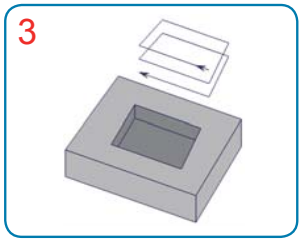
The Suggestion For The Octagon Milling Tool









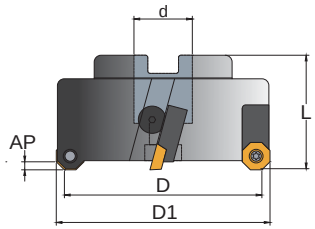


PRODUCT SPECIFICATIONS

Aluminium Alloy Face Milling Cutters

- Insert P. 283
- Cutting Data P. 283 - 284

MO

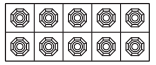


Order code	Dimensions(mm)						KG	MAX RPM	Insert ODGT	Screw	Key
	D	D1	d	L	AP						
MO-080R-AL-C-22	80	92	22	50	3	5	0.7	4600	ODGT 0504	C04011	T15P
MO-100R-AL-C-27	100	112	27			6	0.9	4100			
MO-125R-AL-C-27	125	137				7	1.8	3600			
MO-160R-AL-C-32	160	172	32	60		8	2.3	3100			
MO-200R-AL-C-40	200	212	40			10	3.2	2800			
MO-250R-AL-C-40	250	262				12	4.8	2500			
MO-300R-AL-C-40	300	312				14	7.2	2200			

Insert - ODGT

Tolerances ±0.03 (mm)

Dimensions in mm		
SIZE	S	I
0504	4.7	12.7

Inserts	Part No .	Grades									
		Carbide					Metal cermet		Uncoated		
		B100	C200	C250	F20	F30	CE25	CE60	K10	CE	
	ODGT050408N-E								■		Inserts Sequencing Position (one left after than one right)  Inserts 10 PCS / Box

- ■ Steel ■ Stainless Steel ■ Steel/Stainless Steel ■ Cast Iron ■ Aluminum ■ Steel/Cast Iron ■ Steel/Stainless Steel/Cast Iron
- Correct price and stock are based on current situation
- Please specify model number and grade of insert, ie.: ODGT050408N-E, K10

Standard Spare Parts

For Cutter					
MO-080~300	OD05AR	C04011	SL16	CX5015	S0610

Recommended Instert Grade

Data reference

Material group No.	Recom. feed fz mm/ tooth	Insert			
		ODGT05 ... M	ODGT05...ME	ODGT05...E	
1	-	-	-	-	-
2	-	-	-	-	-
3	-	-	-	-	-
4	-	-	-	-	-
5	-	-	-	-	-
6	-	-	-	-	-
7	-	-	-	-	-
8	-	-	-	-	-
9	-	-	-	-	-
10	-	-	-	-	-
11	-	-	-	-	-
12	-	-	-	-	-
13	-	-	-	-	-
14	-	-	-	-	-
15	-	-	-	-	-
16	0.06-0.13	-	-	K10	-
17	0.06-0.12	-	-	K10	-
18	0.06-0.11	-	-	K10	-
19	-	-	-	-	-
20	-	-	-	-	-
21	-	-	-	-	-
22	-	-	-	-	-

Recommended Cutting Data

• Recommended Cutting speed, Vc(m/min)

Data reference

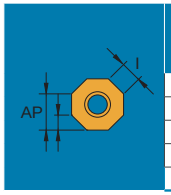
Material group No.	Grades						
	B100	C250	F20	CE60	CE	K10	F30
	Feed fz (mm/tooth)						
						0.13 0.25 0.40	
	Cutting SPEED, V_c (m/min)						
1	-	-	-	-	-	-	-
2	-	-	-	-	-	-	-
3	-	-	-	-	-	-	-
4	-	-	-	-	-	-	-
5	-	-	-	-	-	-	-
6	-	-	-	-	-	-	-
7	-	-	-	-	-	-	-
8	-	-	-	-	-	-	-
9	-	-	-	-	-	-	-
10	-	-	-	-	-	-	-
11	-	-	-	-	-	-	-
12	-	-	-	-	-	-	-
13	-	-	-	-	-	-	-
14	-	-	-	-	-	-	-
15	-	-	-	-	-	-	-
16	-	-	-	-	-	1200 1000 850	-
17	-	-	-	-	-	1050 850 750	-
18	-	-	-	-	-	1200 1000 850	-
19	-	-	-	-	-	-	-
20	-	-	-	-	-	-	-
21	-	-	-	-	-	-	-
22	-	-	-	-	-	-	-

• Surface Finisn

Data reference

Type Of Insert	Feed mm / Rev <=	Ra um
ODGT050408	1.5	<1.5

• Type Of Insert



Insert Size	Max D.O.C. AP
5	3.5(8.5)
-	-
-	-
-	-
-	-

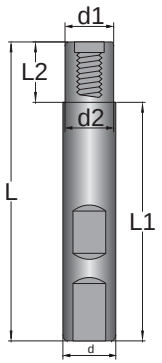
COMBIMASTER TOOLHOLDERS

Features

- Maximum Run Out At 3XD Is 5μm
- Cost **150%** DOWN
- Variety of Machines CNC Milling machine
- Efficiency **150%** UP
- Durability **150%** UP

PRODUCT SPECIFICATIONS

Combimaster Toolholders

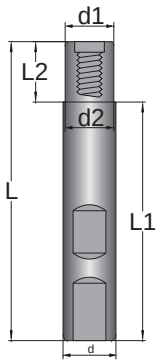


CBH

Order code	Dimensions(mm)						
	d	d1	d2	L1	L2	L	M
CBH-1010-80	10.0	10	10	-	-	60	M6
CBH-1009-100		9	9	60	20	80	
CBH-1212-80	12.0	12	12	-	-	60	
CBH-1211-100		11	11	60	20	80	
CBH-1211-120				80		100	
CBH-1211-140				100		120	
CBH-1616-100	16.0	16	16	-	-	70	M8
CBH-1615-120		15	15	70	20	90	
CBH-1615-150				95	25	120	

Combimaster Toolholders

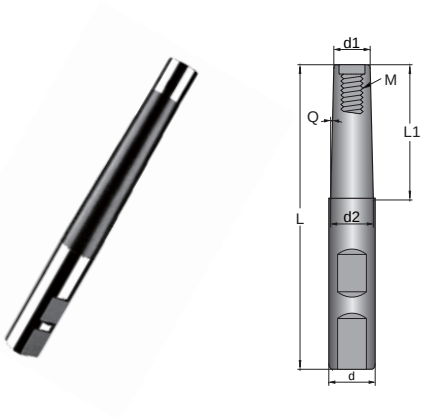
CBH



Order code	Dimensions(mm)						
	d	d1	d2	L1	L2	L	M
CBH-2020-100	20	20	20	-	-	70	M10
CBH-2019-120		19	19	70	20	90	
CBH-2019-160				95	25	120	
CBH-2523-130	25	23	23	70	20	90	M12
CBH-2523-170				100	30	130	
CBH-2523-210				140		170	
CBH-2523-240				170		200	
CBH-2525-110		25	25	-	-	70	
CBH-3232-120	32	32	32	-	-	80	M16
CBH-3230-140		30	30	80	20	100	
CBH-3230-200				130	30	160	
CBH-3230-240				170		200	
CBH-3230-300				210	50	260	
CBH-4240-220	42	40	40	130	20	150	M18
CBH-50.849-215	50.8	49	49				M25
CBH-50.849-265				170	30	200	

Combimaster Toolholders

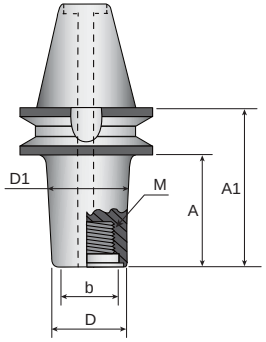
CBH



Order code	Dimensions(mm)						
	d	d1	d2	L1	L	M	Q
CBH-1209-120	12	9	11.9	40	100	M6	2 °
CBH-1611-120	16	11	15.5				
CBH-1611-150				60	130		2.5 °
CBH-2015-160	20	15	19.5			M8	2 °
CBH-2015-180				70	150		
CBH-2015-230				80	200		
CBH-2519-180	25	19	24	70	150	M10	
CBH-2519-220				90	190		
CBH-3223-200	32	23	28	75	160	M12	2 °
CBH-3223-240			31.5	80	200		
CBH-3230-240		30	39			M16	2.5 °
CBH-3230-280				110	240		2 °
CBH-4232-280	42	32	41.5				
CBH-4232-340				120	300		
CBH-4232-410				150	370		

Face Milling Arbor

BT



Order code	Dimensions(mm)					
	D	A	A1	b	D1	M
BT40-2380A	23	53	78	14	28	M12
BT40-23120A		93	118		31	
BT40-3080A	30	53	78	22	35	M16
BT40-30120A		93	118		38	
BT40-4080A	40	53	78	28	45	M18
BT40-40120A		93	118		48	
BT50-2380A	23	42	77	14	28	M12
BT50-23120A		82	117		31	
BT50-3080A	30	42	77	22	35	M16
BT50-30120A		82	117		38	
BT50-4080A	40	42	77	28	45	M18
BT50-40120A		82	117		48	
BT50-5080A	50	42	77	36	55	M25
BT50-50120A		82	117		58	
BT50-50160A		122	157		61	