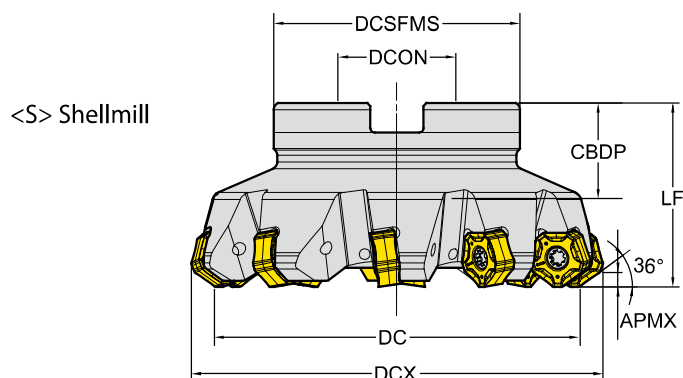


Milling - Face Milling - Cutter

Cutters for PNMU

Cutting Angle : 36°
10 Corner Negative



CICT : Number of Inserts
CDBP : Connection Bore Depth

p. 158

Unit:mm

Series	APMX	Designation	EDP 1700..	DC	DCX	CICT	LF	TYPE	DCON	CDBP	DCSFMS	PCD1	PCD2	
PNMU 1206	4.0	F36 - PNMU12 - D50Z4S22	0774	50	63.6	4	40	Shellmill	22	20	42	-	-	●
		F36 - PNMU12 - D50Z5S22	0785	50	63.6	5	40		22	20	42	-	-	●
		F36 - PNMU12 - D63Z5S22	0775	63	76.6	5	40		22	20	48	-	-	●
		F36 - PNMU12 - D63Z6S22	0483	63	76.6	6	40		22	20	48	-	-	●
		F36 - PNMU12 - D80Z8S27	0466	80	93.6	8	50		27	23	58	-	-	●
		F36 - PNMU12 - D100Z10S32	0467	100	113.6	10	50		32	26	67	-	-	●
		F36 - PNMU12 - D125Z10S40	0786	125	138.6	10	63		40	29	89	-	-	●

* Clamping Torque (Nm) 3.0Nm

PNMU12	Screw	Wrench	Handle	BIT
Description	TP154008	TPWBTP15	DH-H4	DB-TP15
EDP	18000006	18000217	18000189	18000208

Milling Grades		P Steel					M Stainless steel				K Cast iron				N Non-ferrous				S Superalloys				H Hardened Steel			
		P05	P15	P25	P35	P45	M05	M15	M25	M35	K05	K15	K25	K35	N05	N15	N25	N35	S05	S15	S25	S35	H05	H15	H25	H35
PVD	YG012		012																				012			
	YG712		712																							
	YG713		713																							
	YG612			612					612												612					
	YG613				613				613																	
	YG501										501															
CVD	YG5020										5020															
Uncoated	YG50														50											

YG MILL GRADES



YG012 P10 - P30 H10 - H30

Optimized Milling Grade for Pre-Hardened & Hardened steel



YG501 K05 - K25

Hard Milling grade for Cast Iron



YG712 P10 - P30

Milling Grade for Medium of Steel Application



YG5020 K01 - K30

CVD grade for Cast Iron



YG612 P20 - P40 M20 - M40 S20 - S40

Specialized Multi-Nano Coated Grade with high wear resistance and chipping resistance



YG50 N05 - N20

Uncoated Milling Grade for Aluminium



YG613 P30 - P50 M30 - M40

Milling Grade for Stainless Steel Application

YG MILL CHIP BREAKERS

-AL



- For Aluminum
- Very Sharp Geometry

-ST



- For Stainless Steel, Super Alloy
- Sharp Geometry

General Inserts
(GN)



- First Choice for General Application

-TR



- For Hardened Steels
- Reinforced Geometry

...W / ...N

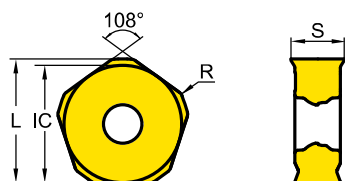


- For Hardened Material and Cast Irons

Milling - Face Milling - Inserts

PNMU - Face Milling Negative (10 Corners)

Series	KRINS	IC	S
PNMU 1206	36	14.0	5.84



EDP 1200..

●: Stock item ○: Order made item

H20	P15	P25	P30	P30	P30	P40	K10	K15
			K30	M30 S30	M30	M40 S40		
YG012	YG712	YG713	YG622	YG612	YG602	YG613	YG5020	YG5016
● 0753	● 0596	○ 0645		● 0826	● 0535	● 0671	● 0534	● 0538
					● 0761	● 0760		

[illegible]

Milling

Cutting Speed																						
ISO	VDI	Sub Group	YG012		YG712		YG713		YG622		YG612		YG602		YG613		YG501(G)		YG5020		YG50	
			Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max
P	1-5	Non-Alloyed Steel	180	280	170	300	200	300	140	400	180	280	180	270	100	210	-	-	-	-	-	-
	6-9	Low-Alloyed Steel	150	250	180	250	170	270	120	320	150	250	150	240	70	180	-	-	-	-	-	-
	10-11	High-Alloyed Steel	80	150	100	140	85	145	70	170	70	140	70	130	40	90	-	-	-	-	-	-
M	12-13	Ferritic & Martensitic			-	-	-	-	-	-	120	200	120	180	70	180	-	-	-	-	-	-
	14	Austenitic Stainless Steel			-	-	-	-	-	-	130	250	30	230	70	200	-	-	-	-	-	-
K	15-16	Grey Cast Iron			-	-	-	-	120	270			120	250	-	-	160	300	200	350	-	-
	17-18	Nodular Cast Iron			-	-	-	-	130	240			120	220	-	-	130	210	150	300	-	-
N	21-30	Non-Ferrous Metals (Al)			-	-	-	-	-	-			-	-	-	-	-	-	-	-	300	800
S	31-37	Superalloys & Titanium			-	-	-	-	-	-	25	45	5	45	-	-	-	-	-	-	-	-
H	38-41	Hard Materials	70	120	-	-	-	-	40	100					-	-			-	-	-	-