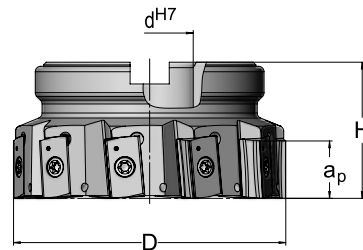


SHOULDER MILLING CUTTERS

LN90



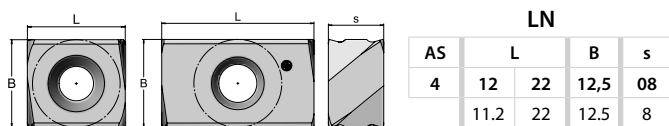
With insert sizes for extremely high depths of cut in 90° machining
 Enormous stability due to sturdy cutting wedge
 Achieves excellent roughing and finishing surface quality



LN90 Plug-in milling cutters								INS
Article	D	d ^{H7}	H	z ^{eff}	a _p	lc	kg	
04L.0550.003	50	22	50	5	20.0	yes	0.52	LN..2208..L
04L.0540.030	50	22	40	6	10.0	yes	0.37	LN..1208..L*
04L.0650.005	63	22	50	6	20.0	yes	0.84	LN..2208..L
04L.0640.030	63	22	40	7	10.0	yes	0.57	LN..1208..L*
04L.0850.005	80	27	50	8	20.0	yes	1.33	LN..2208..L
04L.0850.030	80	27	50	10	10.0	yes	1.11	LN..1208..L
04L.1050.005	100	32	50	10	20.0	yes	2.05	LN..2208..L
04L.1050.030	100	32	50	12	10.0	yes	1.82	LN..1208..L
04L.1263.005	125	40	63	13	20.0	yes	3.54	LN..2208..L
04L.1263.030	125	40	63	15	10.0	yes	3.43	LN..1208..L
04L.1663.030	160	40	63	18	10.0	yes	4.55	LN..1208..L

* Note that the screw length required varies depending on the insert used

INS SHAPE LN



Matching of machining parameters
with the AV material groups

				Steel						
	Article	Designation		A22	A21	A20	A19	A18	A17	A16
LN..1208..	LN.1208.002.01 SKY77	LNHQ 120810 TL-28S	h_{max}	0.23	0.20	0.18	-	-	-	-
			v_c	280-320	220-280	180-230	-	-	-	-
LN..2208..	LN.2208.003.01 SKY77	LNHQ 220805 SL-28	h_{max}	0.23	0.20	0.18	-	-	-	-
			v_c	280-320	220-280	180-230	-	-	-	-

				Cast iron					
	Article	Designation		D21	D20	D19	D18	D17	D16
LN..1208..	LN.1208.002.01 SKY77	LNHQ 120810 TL-28S	h_{max}	0.28	0.26	0.22	0.20	0.16	0.12
			v_c	240-280	200-240	170-200	150-190	120-160	120-150
	LN.1208.002.01 CAN ² 77	LNHQ 120810 TL-28S	h_{max}	0.28	0.26	0.22	0.20	0.16	0.12
			v_c	300-380	270-320	230-280	170-220	150-200	120-150
LN..2208..	LN.2208.003.01 SKY77	LNHQ 220805 SL-28	h_{max}	0.28	0.26	0.22	0.20	0.16	0.12
			v_c	240-280	200-240	170-200	150-190	120-160	120-150
	LN.2208.003.01 CAN ² 77	LNHQ 220805 SL-28	h_{max}	0.28	0.26	0.22	0.20	0.16	0.12
			v_c	300-380	270-320	230-280	170-220	150-200	120-150

INS		
LN..1208...	08B.0416.7991	TX215
LN..1208...*	08B.0412.7991	TX215
LN..2208...	08B.0513.7991	TX220

* Note that the screw length required varies depending on the insert used