

NEU/NEW

MESSERKÖPFE UND FRÄSPLATTEN MILLING HEADS AND INSERTS



SCHWARZ

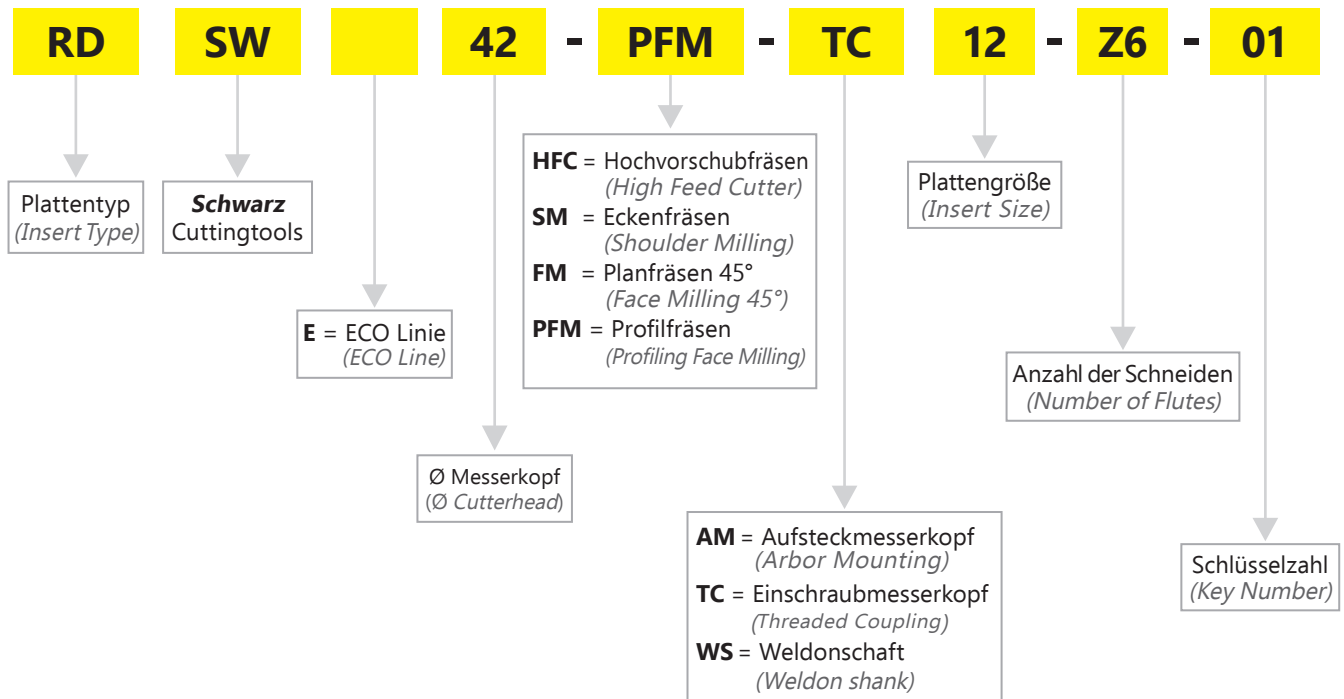
Zerspanungswerkzeuge

Cuttingtools



PRODUKTBEZEICHNUNG (PRODUCT IDENTIFICATION)

BEISPIEL (EXAMPLE) : RDSW 42-PFM-TC 12-Z6-01



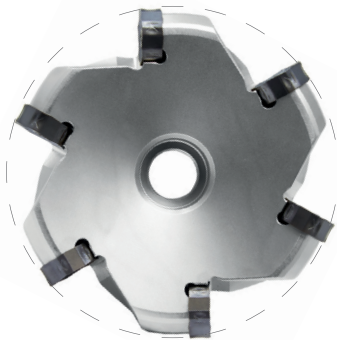
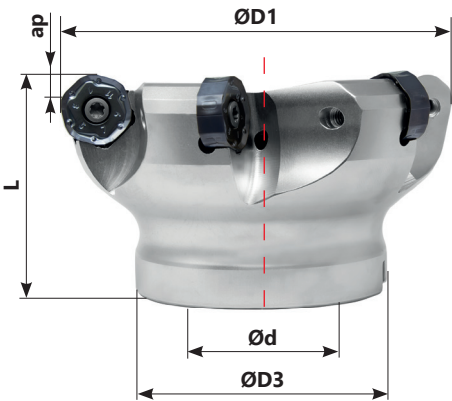
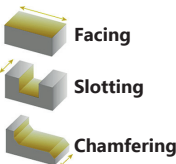
FORCE LINE



PLANFRÄSEN 45° (FACE MILLING 45°)

HNKU...AM08...


Aufsteckmesserkopf
(Arbor Mounting)




Bestellcode (Ordering Code)	Bezeichnung (Identification)	Platten (Inserts)		Maße (Dimensions) in mm					Preis (Price)
		Typ (Type)	Anzahl (Number)	D1	D3	d	L	ap	
SW141-40	HNSW40-FM-AM08-Z4-01	HN...08	4	40	38	16	40	0.2- 4.5	343,98
SW141-50	HNSW50-FM-AM08-Z4-01	HN...08	4	50	43	22	40	0.2- 4.5	349,27
SW141-63	HNSW63-FM-AM08-Z5-01	HN...08	5	63	48	22	40	0.2- 4.5	492,16
SW141-80	HNSW80-FM-AM08-Z6-01	HN...08	6	80	58	27	50	0.2- 4.5	563,60

FRÄSPLATTEN
(MILLING INSERTS)

Bestellcode (Ordering Code)	Qualität (Grades)									Preis (Price) in €	
	P		M		K			N	S		H
	CVD		PVD	CVD	PVD			UNC	-		PVD
	SW22230	SW11245	SW12240	SW22535							

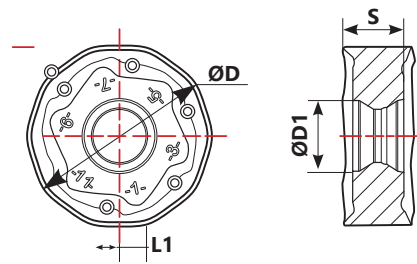


HNKU 0806AZER-HCM	▲	▲									16,57
HNKU 0806AZER-SCM				▲							18,48



HOKU 0806AZER-HCM	▲	▲									19,53
HOKU 0806AZER-SCM			▲								19,53
HOKU 0806AZER-SCM				▲							24,42

PLATTEN - TECHNISCHE DATEN (INSERTS - TECHNICAL DETAILS)



Bestellcode (Ordering Code)	Maße (Dimensions) in mm			
	D	S	L1	D1
HN... 08...	14.7	5.3	1.5	4.1
HO... 08...	14.7	5.3	1.5	4.1

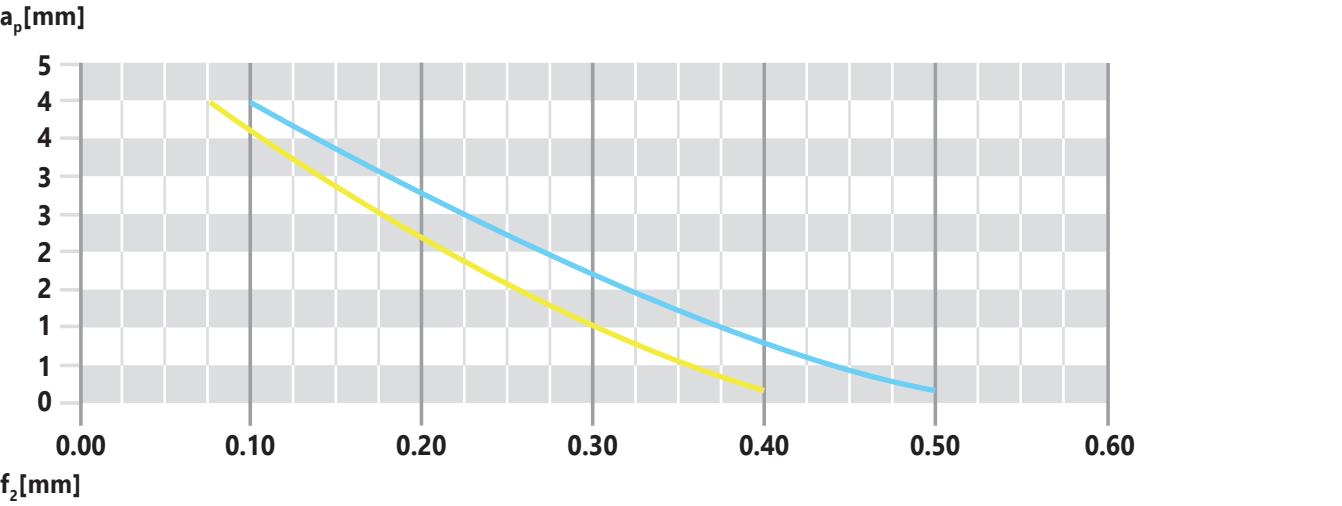
SCHNITTDATEN
(CUTTING DATA)

Zu bearbeitendes Material (Material to be machined)		HB	Verschleißfestigkeit (Wear Resistance)						Vorschub/Zahn (feed/tooth) in mm
			Vc (m/min)						
			Zähigkeit (Toughness)						
			SW22230	SW11235	SW22535	SW12240	SW11245	.	
P	Unlegierter Stahl (Unalloyed Steel)	155-220	160-220	160-220	-	-	-	-	0,1-0,5
	Niedrig legierter Stahl (Low-Alloyed Steel)	220-280	100-200	100-200	-	-	-	-	
	Hoch legierter Stahl (High-Alloyed Steel)	280-380	60-120	60-120	-	-	-	-	
M	Rostfreier Stahl, ferritisch (Stainless Steels-Ferritic)	200-330	-	-	120-200	-	-	-	0,08-0,4
	Rostfreier Stahl, austenitisch (Stainless Steel-Austenitic)	200-330	-	-	60-160	-	-	-	

Alle Schnittdaten dienen zur Orientierung (All cutting datas serve to orientation)

SCHNITTDATEN HNKU/HOKU (CUTTING DATA HNKU/HOKU)

Startparameter (Starting parameters)



ERSATZTEILE (SPARE PARTS)

Werkzeugdurchmesser (Tool Diameter) ØDc	Spannschraube (Insert Screw)	Torx Schlüssel (Torx Key)	Unterlegplatte / Unterlegscheibe (Shim / Washer)	Klemmschraube (Screw Clamp)
				
HNSW...	SW1345432	T15	-	-

LNKU...


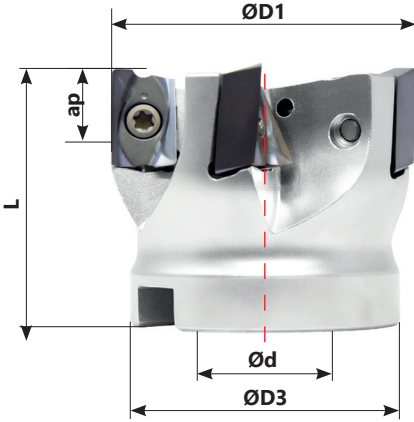
Aufsteckmesserkopf
(Arbor Mounting)

Facing

Helical Interpolation

Shouldering

Slotting





Bestellcode (Ordering Code)	Bezeichnung (Identification)	Platten (Inserts)		Maße (Dimensions) in mm					Preis (Price)
		Typ (Type)	Anzahl (Number)	D1	D3	d	L	ap	
SW142-50	LNSW50-SM-AM12-Z5-01	L... 12...	5	50	43	22	40 / 40.44*	2.0 - 12	347,61

*mit LOKU Platte (with LOKU insert)

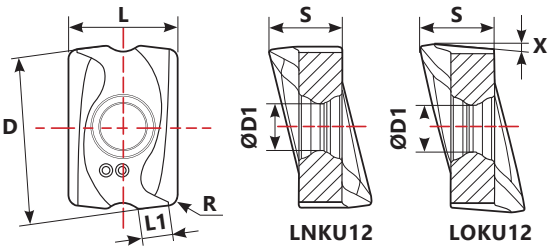
FRÄSPLATTEN
(MILLING INSERTS)

Bestellcode (Ordering Code)	Qualität (Grades)									Preis (Price) in €	
	P		M		K			N	S		H
	CVD	PVD	PVD	CVD	PVD			UNC	-		PVD
	SW22230	SW11235	SW11245	SW22535				SW00915	SW22535		

	LNKU 120608-HCM	▲	▲									16.96
	LNKU 120608-SCM			▲								16.96

	LOKU 120608-SCM			▲								23.69
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PLATTEN - TECHNISCHE DATEN (INSERTS - TECHNICAL DETAILS)



Bestellcode (Ordering Code)	Maße (Dimensions) in mm						
	D	D1	S	L	L1	R	X
LKNU... 12...	15.27	4.4	6.78	10	2.84	0.8	-
LOKU... 12...	15.86	4.4	6.87	10	2.57	0.8	5

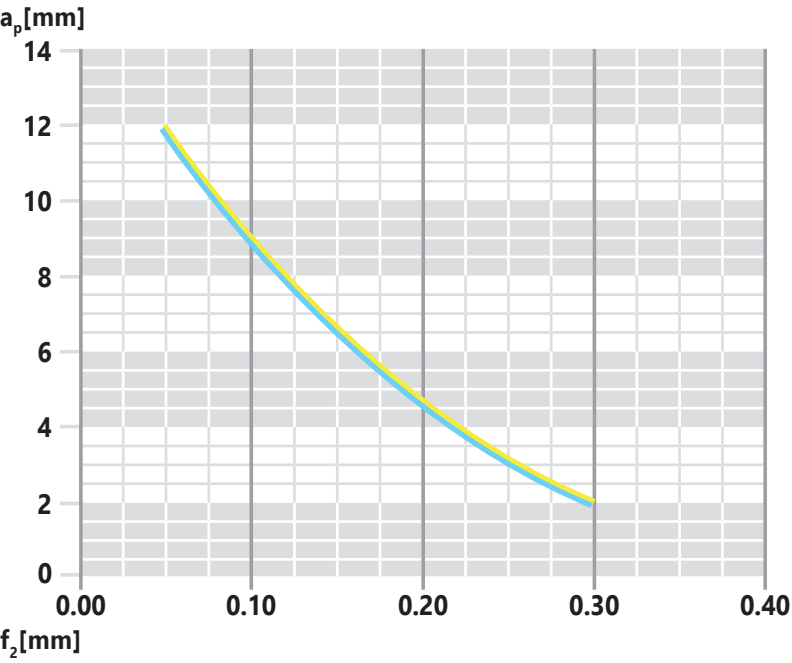
SCHNITTDATEN
(CUTTING DATA)

Zu bearbeitendes Material (Material to be machined)		HB	Verschleißfestigkeit (Wear Resistance)						Vorschub/Zahn (feed/tooth) in mm
			Vc (m/min)				Zähigkeit (Toughness)		
			SW22230	SW11235	SW12240	SW22535	SW22415	SW00915	
P	Unlegierter Stahl (Unalloyed Steel)	155-220	150-220	150-220	-	-	-	-	0,05-0,3
	Niedrig legierter Stahl (Low-Alloyed Steel)	220-280	100-200	100-200	-	-	-	-	
	Hoch legierter Stahl (High-Alloyed Steel)	280-380	60-150	60-150	-	-	-	-	
M	Rostfreier Stahl, ferritisch (Stainless Steels-Ferritic)	200-330	-	-	100-200	-	-	-	0,05-0,3
	Rostfreier Stahl, austenitisch (Stainless Steel-Austenitic)	200-330	-	-	60-150	-	-	-	

Alle Schnittdaten dienen zur Orientierung (All cutting datas serve to orientation)

SCHNITTDATEN LNKU/LOKU (CUTTING DATA LNKU/LOKU)

Startparameter (Starting parameters)



ERSATZTEILE (SPARE PARTS)


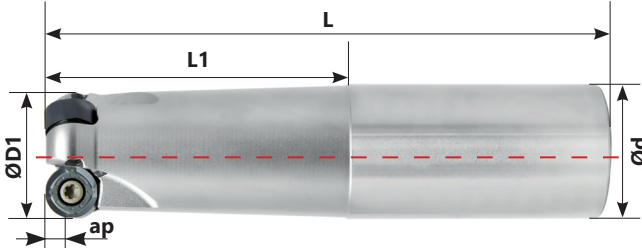
Werkzeugdurchmesser (Tool Diameter) ØDc	Spannschraube (Insert Screw)	Torx Schlüssel (Torx Key)	Unterlegplatte / Unterlegscheibe (Shim / Washer)	Klemmschraube (Screw Clamp)
LNSW...				
LNSW...	SW11042274	-	-	-
LNSW...	-	-	-	SW11040298

RN...RO...

Weldonschaft
(Weldon Shank)

Facing

Slotting




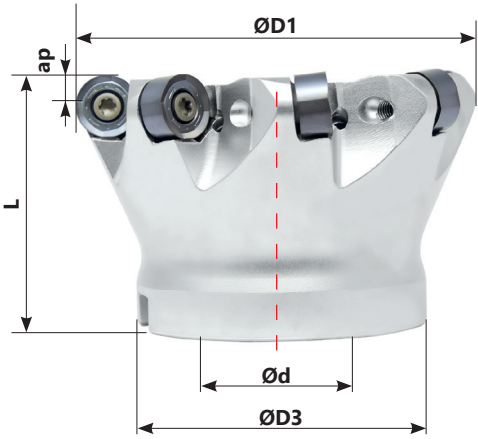
Bestellcode (Ordering Code)	Bezeichnung (Identification)	Platten (Inserts)		Maße (Dimensions) in mm					Preis (Price)
		Typ (Type)	Anzahl (Number)	D1	d	L	L1	ap	
SW144-32-1	RNROSW32131-FM-WS12-Z3-01	RN... RO...	3	32	32	70	131	0.5- 3,0	267,25
SW144-32-2	RNROSW32165-FM-WS12-Z3-01	RN... RO...	3	32	32	70	165	0.5- 3,0	254,02

RN...RO...

Aufsteckmesserkopf
(Arbor Mounting)

Facing

Slotting



Bestellcode (Ordering Code)	Bezeichnung (Identification)	Platten (Inserts)		Maße (Dimensions) in mm					Preis (Price)
		Typ (Type)	Anzahl (Number)	d	D1	D3	L	ap	
SW145-40	RNROSW40-FM-AM12-Z4-01	RN... RO...	4	16	40	38	40	0.5- 3,0	330,75
SW145-50	RNROSW50-FM-AM12-Z5-01	RN... RO...	5	22	50	43	40	0.5- 3,0	402,19
SW145-63	RNROSW63-FM-AM12-Z6-01	RN... RO...	6	22	63	48	40	0.5- 3,0	497,45
SW145-80	RNROSW80-FM-AM12-Z8-01	RN... RO...	8	27	80	58	50	0.5- 3,0	571,54
SW145-100	RNROSW80-FM-AM12-Z8-01	RN... RO...	8	32	100	78	50	0.5- 3,0	664,15

RN...RO...

Aufsteckmesserkopf
(Arbor Mounting)

Facing

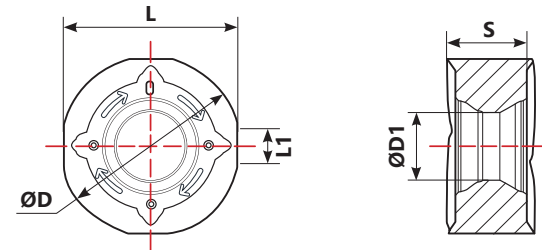
Slotting

Technical drawing of a face mill showing dimensions: ØD1 (outer diameter), ap (cutting edge radius), L (length), Ød (arbor diameter), and ØD3 (base diameter).

Bestellcode (Ordering Code)	Bezeichnung (Identification)	Platten (Inserts)		Maße (Dimensions) in mm					Preis (Price)
		Typ (Type)	Anzahl (Number)	d	D1	D3	L	ap	
SW143-63	RNROSW63-FM-AM16-Z5-01	RN... RO...	5	22	63	38	40	0.5-4.0	480,69

Bestellcode (Ordering Code)	Qualität (Grades)								Preis (Price) in €
	P		M		K	N	S	H	
	CVD	PVD	PVD	CVD	PVD	UNC	-	PVD	
	SW22230	SW11235	SW11245	SW22535		SW00915	SW22535		
RNKU 1204MOER-HCM	▲	▲							14,12
ROHU 1204MOER-SCM			▲	▲					25,67
RNKU 1604MOER-HCM	▲	▲							14,12
ROHU 1604MOER-SCM			▲	▲					25,67

PLATTEN - TECHNISCHE DATEN (INSERTS - TECHNICAL DETAILS)



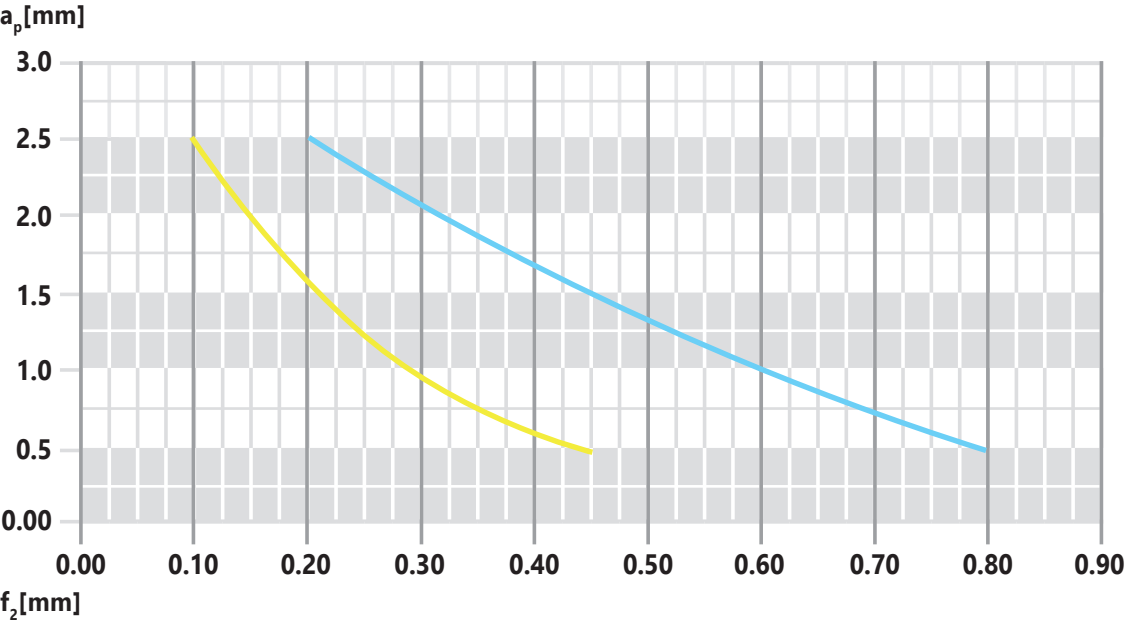
Bestellcode (Ordering Code)	Maße (Dimensions) in mm				
	D	D1	S	L1	X
RNKU... 12...	12	4.5	5.9	11.8	0
ROHU... 12...	12	4.5	5.9	11.8	3
RNKU... 16...	16	5.8	6.7	15.7	0
ROHU... 16...	16	5.8	6.7	15.7	3

Zu bearbeitendes Material (Material to be machined)		HB	Vc (m/min)					Vorschub/Zahn (feed/tooth) in mm	
			Verschleißfestigkeit (Wear Resistance)				Zähigkeit (Toughness)		
			SW22230	SW11235	SW12240	SW22535	SW22415	R...12...	R...16...
P	Unlegierter Stahl (Unalloyed Steel)	155-220	120-220	120-220	-	-	-	0,2-0,8	0,25-0,8
	Niedrig legierter Stahl (Low-Alloyed Steel)	220-280	100-200	100-20	-	-	-		
	Hoch legierter Stahl (High-Alloyed Steel)	280-380	60-150	60-150	-	-	-		
M	Rostfreier Stahl, ferritisch (Stainless Steels-Ferritic)	200-330	-	-	100-200	100-200	-	0,1-0,45	0,2-0,6
	Rostfreier Stahl, austenitisch (Stainless Steel-Austenitic)	200-330	-	-	60-150	60-150	-		

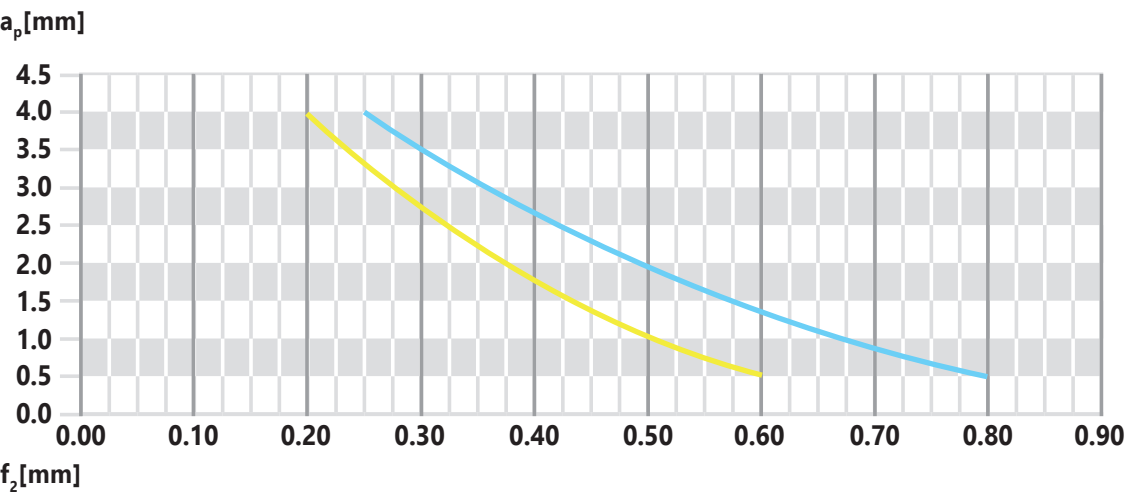
Alle Schnittdaten dienen zur Orientierung (All cutting datas serve to orientation)

SCHNITTDATEN RNKU/ROHU (CUTTING DATA RNKU/ROHU)

Startparameter R12 (Starting parameters R12)



Startparameter R16 (Starting parameters R16)



EMPFOHLENE SCHNITTWERTE (RECOMMENDED PARAMETERS)

Platte (Insert)	Indexing (4 times)		Indexing (8 times)
	ap	ap max	ap max
RN... RO... 12...	3.0	5.5	1.7
RN... RO... 16...	4.0	7.5	2.3

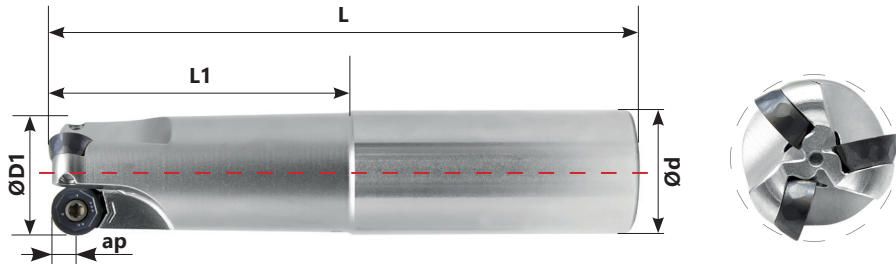
ERSATZTEILE (SPARE PARTS)

Werkzeugdurchmesser (Tool Diameter) ØDc	Spannschraube (Insert Screw)	Torx Schlüssel (Torx Key)	Unterlegplatte / Unterlegscheibe (Shim / Washer)	Klemmschraube (Screw Clamp)
				
RNROSW...AM...	SW1345432		-	-
RNROSW...WS...	SW11037484	-	-	-

RP...RD...

Weldonschaft
(Weldon Shank)

- Facing
- Slotting
- Profiling
- Helical Interpolation
- Plunging

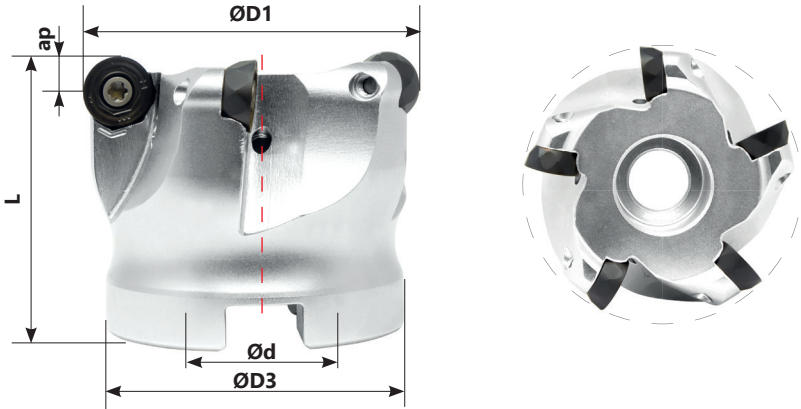


Bestellcode (Ordering Code)	Bezeichnung (Identification)	Platten (Inserts)		Maße (Dimensions) in mm					Preis (Price)
		Typ (Type)	Anzahl (Number)	d	D1	L	L1	ap	
SW146-20-1	RDSW20102-PFM-WS10-Z2-01	RP... RD... 10	2	20	20	102	50	0.1 - 5	177,28
SW146-20-2	RDSW20165-PFM-WS10-Z2-01	RP... RD... 10	2	20	20	165	50	0.1 - 5	177,28
SW146-25-1	RDSW25116-PFM-WS10-Z3-01	RP... RD... 10	3	25	25	116	60	0.1 - 5	224,91
SW146-25-2	RDSW25165-PFM-WS10-Z3-01	RP... RD... 10	3	25	25	165	60	0.1 - 5	238,14
SW146-32-1	RDSW32130-PFM-WS10-Z4-01	RP... RD... 10	4	32	32	130	70	0.1 - 5	253,85
SW146-32-2	RDSW32165-PFM-WS10-Z4-01	RP... RD... 10	4	32	32	165	70	0.1 - 5	269,89

RP...RD...

Aufsteckmesserkopf
(Arbor Mounting)

- Facing
- Slotting
- Profiling
- Helical Interpolation
- Plunging

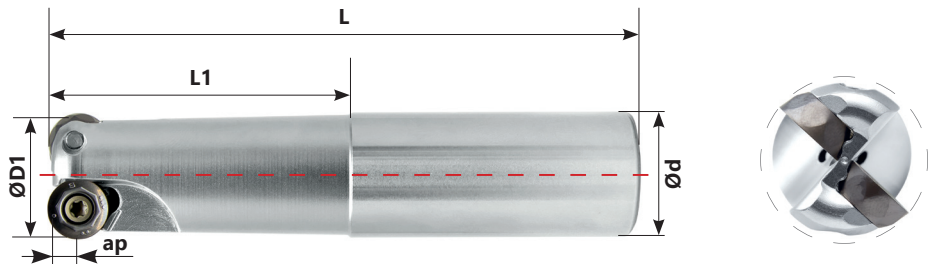


Bestellcode (Ordering Code)	Bezeichnung (Identification)	Platten (Inserts)		Maße (Dimensions) in mm					Preis (Price)
		Typ (Type)	Anzahl (Number)	D1	D3	d	L	ap	
SW147-40	RDSW40-PFM-AM10-Z4-01	RP... RD... 10	4	40	38	16	40	0.1 - 5	256,66
SW147-50	RDSW50-PFM-AM10-Z5-01	RP... RD... 10	5	50	43	22	40	0.1 - 5	285,77

RP...RD...

Weldonschaft
(Weldon Shank)

- Facing
- Slotting
- Profiling
- Helical Interpolation
- Plunging

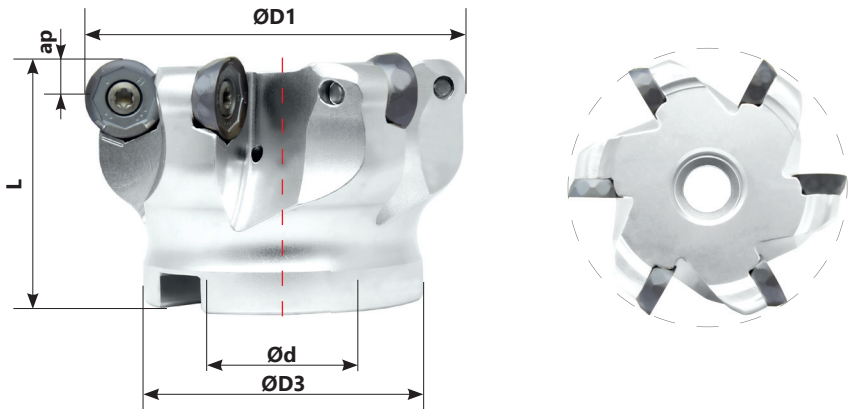


Bestellcode (Ordering Code)	Bezeichnung (Identification)	Platten (Inserts)		Maße (Dimensions) in mm					Preis (Price)
		Typ (Type)	Anzahl (Number)	d	D1	L	L1	ap	
SW148-25-1	RDSW2586-PFM-WS12-Z2-01	RP... RD... 12	2	25	25	86	30	0.1 - 6	185,22
SW148-25-2	RDSW25116-PFM-WS12-Z2-01	RP... RD... 12	2	25	25	116	60	0.1 - 6	219,62
SW148-32-1	RDSW32100-PFM-WS12-Z3-01	RP... RD... 12	3	32	32	100	40	0.1 - 6	238,14
SW148-32-2	RDSW32130-PFM-WS12-Z3-01	RP... RD... 12	3	32	32	130	70	0.1 - 6	251,37

RP...RD...

Aufsteckmesserkopf
(Arbor Mounting)

- Facing
- Slotting
- Profiling
- Helical Interpolation
- Plunging

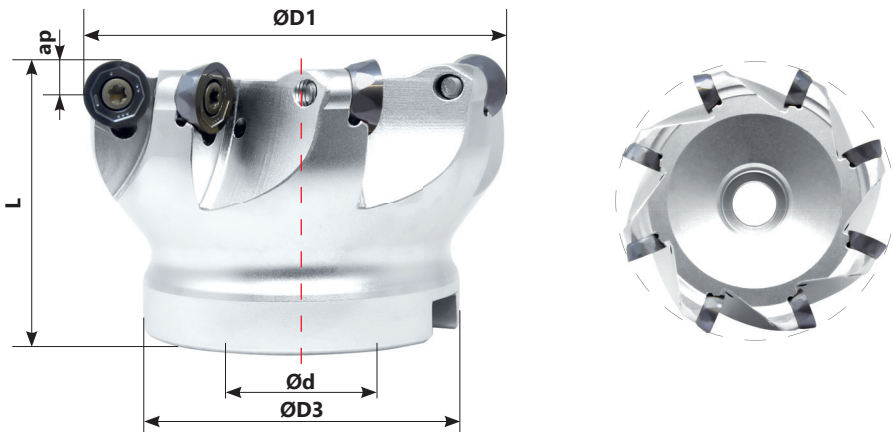


Bestellcode (Ordering Code)	Bezeichnung (Identification)	Platten (Inserts)		Maße (Dimensions) in mm					Preis (Price)
		Typ (Type)	Anzahl (Number)	D1	D3	d	L	ap	
SW151-50	RDSW50-PFM-AM16-Z3-01	RP... RD... 16	3	50	48	22	40	0.1 - 8	349,27
SW151-63	RDSW63-PFM-AM16-Z5-01	RP... RD... 16	5	63	48	22	40	0.1 - 8	441,88
SW151-80	RDSW80-PFM-AM16-Z6-01	RP... RD... 16	6	80	58	27	50	0.1 - 8	537,14
SW151-100	RDSW100-PFM-AM16-Z7-01	RP... RD... 16	7	100	78	32	50	0.1 - 8	608,58
SW151-125	RDSW125-PFM-AM16-Z8-01	RP... RD... 16	8	125	88	40	63	0.1 - 8	701,19

RP...RD...


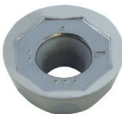
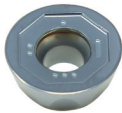

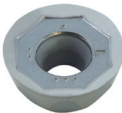
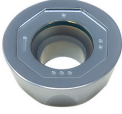

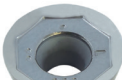
Aufsteckmesserkopf
(Arbor Mounting)

- Facing
- Slotting
- Profiling
- Helical Interpolation
- Plunging



Bestellcode (Ordering Code)	Bezeichnung (Identification)	Platten (Inserts)		Maße (Dimensions) in mm					Preis (Price)
		Typ (Type)	Anzahl (Number)	D1	D3	d	L	ap	
SW149-40	RDSW40-PFM-AM12-Z4-01	RP... RD... 12	4	40	38	16	40	0.1 - 6	254,02
SW149-50	RDSW50-PFM-AM12-Z5-01	RP... RD... 12	5	50	43	22	40	0.1 - 6	285,77
SW149-63	RDSW63-PFM-AM12-Z6-01	RP... RD... 12	6	63	48	22	40	0.1 - 6	317,52
SW149-80	RDSW80-PFM-AM12-Z8-01	RP... RD... 12	8	80	58	27	50	0.1 - 6	423,36
SW149-100	RDSW100-PFM-AM12-Z10-01	RP... RD... 12	10	100	78	32	50	0.1 - 6	510,68

FRÄSPLATTEN
(MILLING INSERTS)

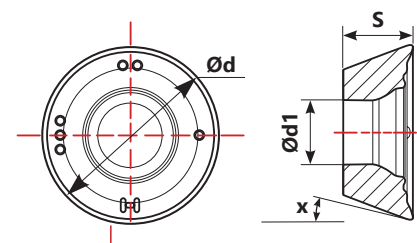
Bestellcode (Ordering Code)		Qualität (Grades)										Preis (Price) in €	
		P			M		K	N	S		H		
		CVD	PVD		PVD	CVD	PVD		UNC	-			PVD
		SW22230	SW11235		SW11245	SW22535			SW00915	SW22535	SW22540	SW12115	
	RPMX 10T3MO-HCM	▲	▲										9,27
	RPMX 10T3MO-SCM				▲	▲							11,65
	RDHX 10T3MO-LMM							▲					12,64
	RPHX 10T3MO-XCM								▲	▲			14,22
	RDHW 10T3MOSN										▲		12,64
	RPMX 1204MO-HCM	▲	▲										9,64
	RPMX 1204MO-SCM				▲	▲							12,47
	RDHX 1204MO-LMM							▲					13,70
	RPHX 1204MO-XCM								▲	▲			15,41
	RDHW 1204MOSN										▲		13,70
	RPMX 1605MO-HCM	▲	▲										13,60
	RPMX 1605MO-SCM				▲	▲							17,95
	RPHX 1605MO-XCM								▲	▲			19,07

SCHNITTDATEN
(CUTTING DATA)

Zu bearbeitendes Material <i>(Material to be machined)</i>		HB	Verschleißfestigkeit <i>(Wear Resistance)</i>							Zähigkeit <i>(Toughness)</i>		Plattengröße <i>((Insert size)</i>	fz (mm)	ap(mm)
			Vc (m/min)											
			SW22230	SW11235	SW11245	SW22535	SW22540	SW00915	SW12115					
P	Unlegierter Stahl <i>(Unalloyed Steel)</i>	155-220	120-220	120-220	-	-	-	-	-	RD... 10 RD... 12 RD... 16	≤0,15 ≤0,20 ≤0,25	≤0,50 ≤0,80 ≤0,80		
	Niedrig legierter Stahl <i>(Low-Alloyed Steel)</i>	220-280	90-190	90-190	-	-	-	-	-					
	Hoch legierter Stahl <i>(High-Alloyed Steel)</i>	280-380	60-160	60-160	-	-	-	-	-					
M	Rostfreier Stahl, ferritisch <i>(Stainless Steels-Ferritic)</i>	200-330	-	-	100-200	100-200	-	-	-	RD... 10 RD... 12 RD... 16	≤0,10 ≤0,10 ≤0,20	≤0,15 ≤0,20 ≤0,25		
	Rostfreier Stahl, austenitisch <i>(Stainless Steel-Austenitic)</i>	200-330	-	-	60-160	60-160	-	-	-					
N	Aluminium und NE-Metalle <i>(Aluminium and Non Ferrous)</i>	30-130	-	-	-	-	-	<2000	-	RD... 10 RD... 12	≤0,10 ≤0,10	≤0,40 ≤0,50		
S	Heat Resistant Super Alloys <i>(Heat Resistant Super Alloys)</i>	200-320	-	-	-	25-75	25-75	-	-	RD... 10 RD... 12 RD... 16	≤0,08 ≤0,10 ≤0,10	≤0,25 ≤0,30 ≤0,30		
H	Gehärteter Stahl <i>(Hardened Steel)</i>	40-55 HRc	-	-	-	-	-	-	100-180	RD... 10 RD... 12	≤0,10 ≤0,10	≤0,20 ≤0,25		

Alle Schnittdaten dienen zur Orientierung (All cutting datas serve to orientation)

PLATTEN - TECHNISCHE DATEN (INSERTS - TECHNICAL DETAILS)



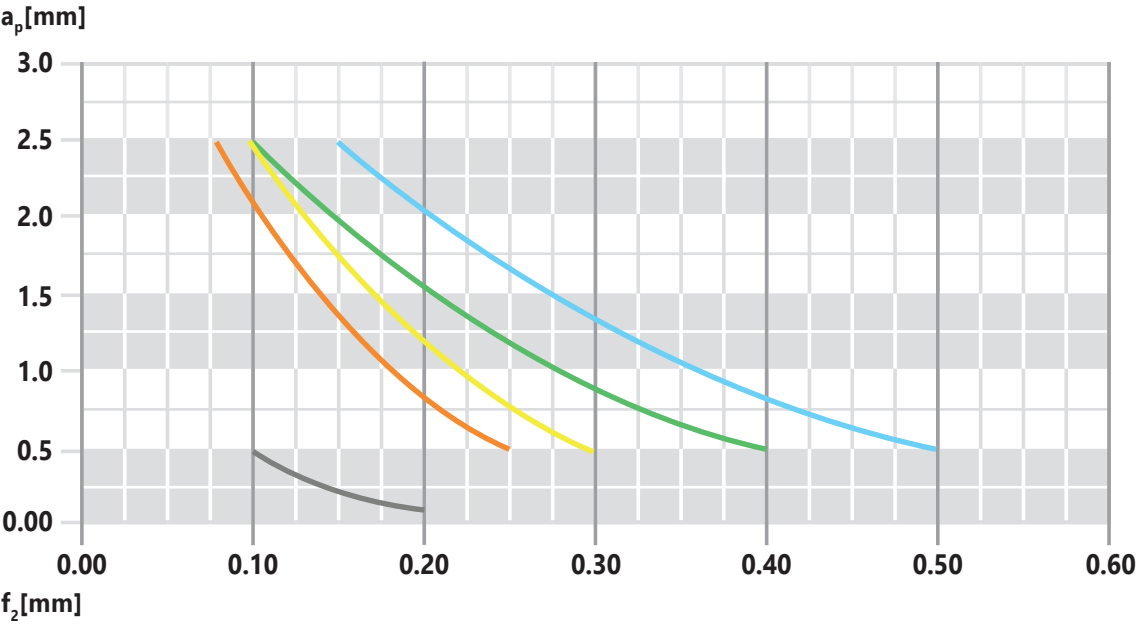
Bestellcode (Ordering Code)	Maße (Dimensions) in mm			
	d	S	d1	x
RP... 10...	10	3.97	3.4	11
RD... 10...	10	3.97	3.4	15
RP... 12...	12	4.76	4.4	11
RD... 12...	12	4.76	4.4	15
RP... 16...	16	5.56	5.5	11

EMPFOHLENE SCHNITTWERTE (RECOMMENDED PARAMETERS)

Platte (Insert)	Indexing (4 times)		Indexing (8 times)
	ap	ap max	ap max
RD...10	2,50	4,50	1,40
RD...12	3,00	5,50	1,70
RD...16	4,00	7,50	2,30

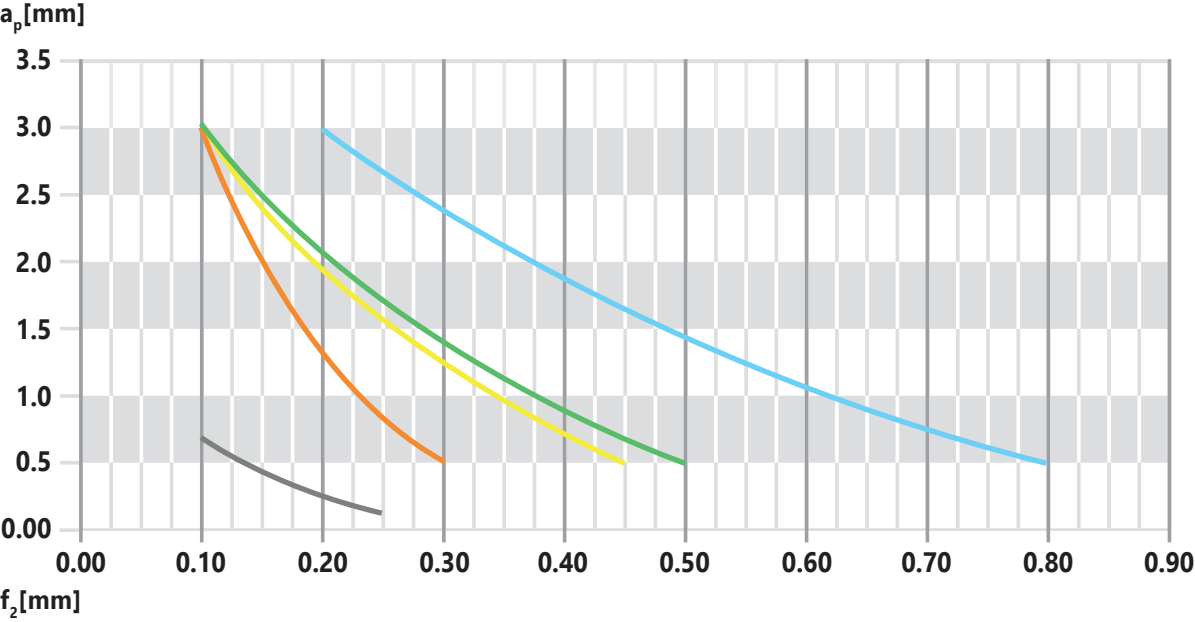
SCHNITTDATEN R10 (CUTTING DATA R10)

Startparameter (Starting parameters)



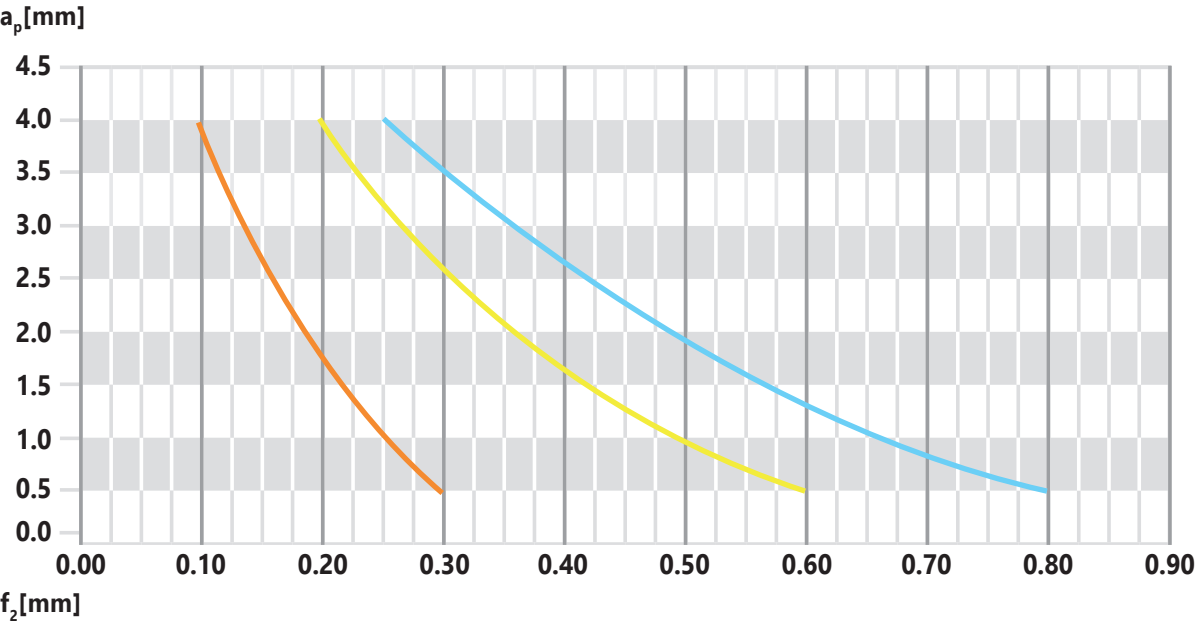
SCHNITTDATEN R12 (CUTTING DATA R12)

Startparameter (Starting parameters)



SCHNITTDATEN R16 (CUTTING DATA R16)

Startparameter (Starting parameters)



ERSATZTEILE (SPARE PARTS)

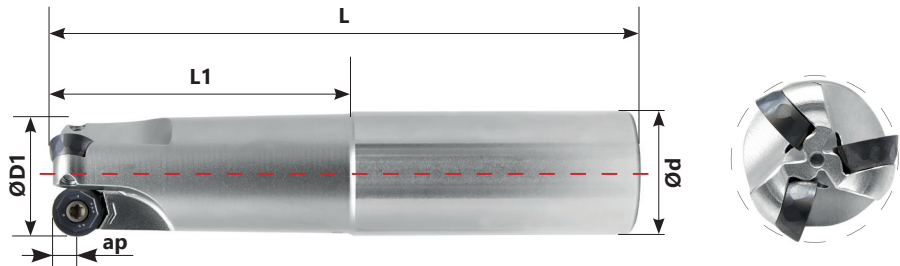
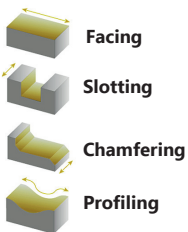
Werkzeugdurchmesser (Tool Diameter) ØDc	Spannschraube (Insert Screw)	Torx Schlüssel (Torx Key)	Unterlegplatte / Unterlegscheibe (Shim / Washer)	Klemmschraube (Screw Clamp)
R...10...	SW11689894	-	-	-
R...10...	-	-	-	SW11036880
R...12...AM...	SW4011654	-	-	-
R...12...WS...	SW7818428	-	-	-
RDSW40-PFM-AM12-Z4-01	-	-	-	SW7818267
R...16...	SW4513250	-	-	-
R...16...	SW7818268	-	-	-

Schrägeintauchen (Ramping)				Helixinterpolation (Helical Interpolation)		
Platte (Insert)	ØDc	Max Ramp α°	Max ap	ØDHmin	ØDHmax	Max Pitch/Rev.
RD... 10...	20	1,3	5	26	30	1,3
	25	2,0	5	37	40	1,8
	32	3,0	5	50	54	1,5
	40	3,3	5	64	70	1,1
	50	2,4	5	68	74	1,1
RD... 12...	25	6,4	6	31	38	2,2
	32	4,0	6	46	52	1,7
	40	2,8	6	62	68	1,4
	50	2,6	6	81	88	1,1
	63	1,9	6	107	114	0,9
	80	1,3	6	142	148	0,7
	100	1,0	6	181	188	0,5
RD... 16...	50	4,0	8	75	84	1,5
	63	2,8	8	101	110	1,1
	80	2,0	8	135	144	0,9
	100	1,5	8	175	184	0,7
	125	1,0	8	225	234	0,5

Während der Helixinterpolation oder des Schrägeintauchens darf der maximale Steigungswinkel α° nicht überschritten werden
(During helical interpolation or ramping do not exceed max Pitch α°)

SDMX, EOMT, RPMX,

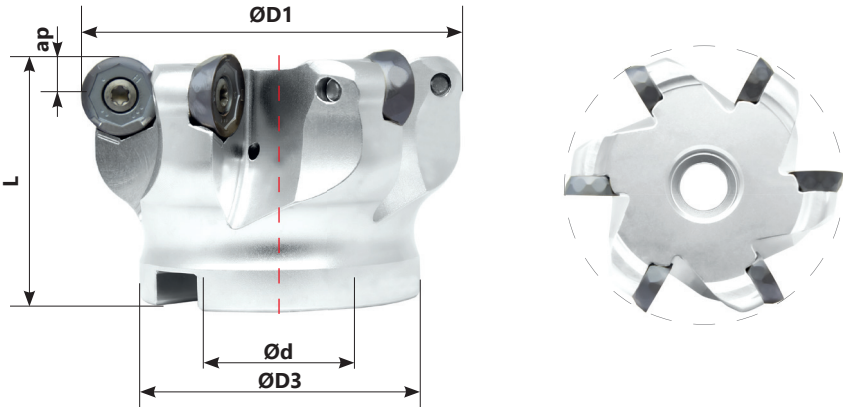
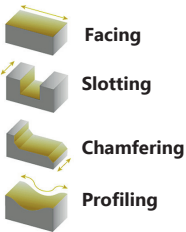
Weldonschaft
(Weldon Shank)



Bestellcode (Ordering Code)	Bezeichnung (Identification)	Platten (Inserts)		Maße (Dimensions) in mm					Preis (Price)
		Typ (Type)	Anzahl (Number)	D1	d	L	L1	ap	
SW153-25-1	SDRPEOSW25-PFM-WS11-Z2-01	SD... EO... RP...	2	25	25	86,3	30,3	0,1 - 5,5	185,22
SW153-25-2	SDRPEOSW25-PFM-WS11-Z2-01	SD... EO... RP...	2	25	25	116,3	60,3	0,1 - 5,5	219,62
SW153-32-1	SDRPEOSW32-PFM-WS11-Z3-01	SD... EO... RP...	3	32	32	100,3	40,3	0,1 - 5,5	238,14
SW153-32-2	SDRPEOSW32-PFM-WS11-Z3-01	SD... EO... RP...	3	32	32	70,3	70,3	0,1 - 5,5	251,37

SDMX, EOMT, RPMX,

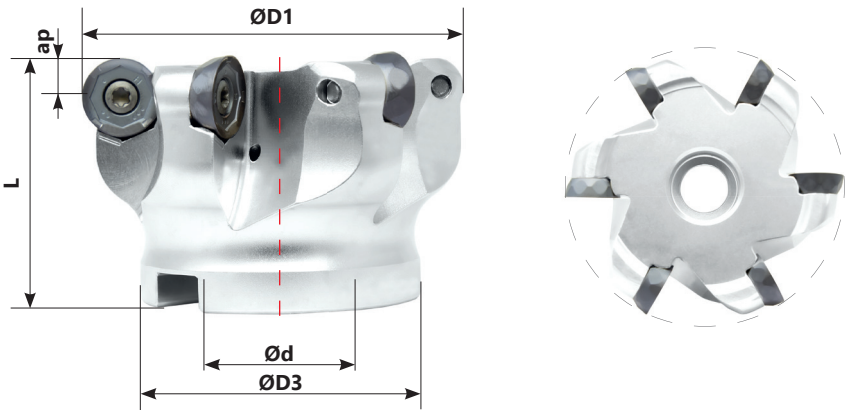
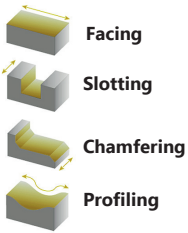
Aufsteckmesserkopf
(Arbor Mounting)



Bestellcode (Ordering Code)	Bezeichnung (Identification)	Platten (Inserts)		Maße (Dimensions) in mm					Preis (Price)
		Typ (Type)	Anzahl (Number)	D1	D2	D3	L	ap	
SW155-50	SDRPEOSW50-PFM-WS15-Z3-01	SD... EO... RP...	3	50	39,8	48	40,5		349,27
SW155-63	SDRPEOSW63-PFM-WS15-Z5-01	SD... EO... RP...	5	63	52,8	48	40,5		441,88
SW155-80	SDRPEOSW80-PFM-WS15-Z6-01	SD... EO... RP...	6	80	69,8	58	50,5		537,14
SW155-100	SDRPEOSW100-PFM-WS15-Z7-01	SD... EO... RP...	7	100	89,8	78	50,5		608,58
SW155-125	SDRPEOSW125-PFM-WS15-Z8-01	SD... EO... RP...	8	125	114,8	88	63,4		701,19

SDMX, EOMT, RPMX,

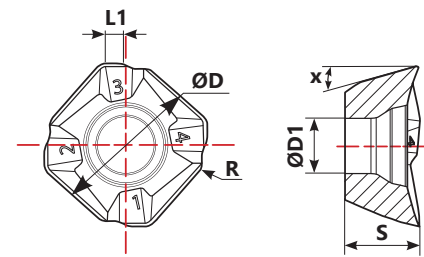
Aufsteckmesserkopf
(Arbor Mounting)



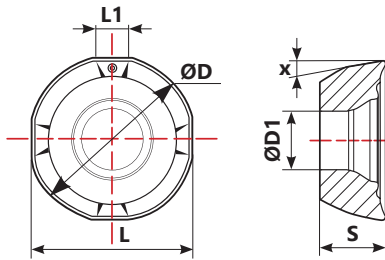
Bestellcode (Ordering Code)	Bezeichnung (Identification)	Platten (Inserts)		Maße (Dimensions) in mm					Preis (Price)
		Typ (Type)	Anzahl (Number)	D1	D2	D3	L	ap	
SW154-40	SDRPEOSW40-PFM-WS11-Z4-01	SD.EO.RP11/12	4	40	32,5	38	40,3	0,1 - 5,5	254,02
SW154-50	SDRPEOSW50-PFM-WS11-Z5-01	SD.EO.RP11/12	5	50	42,5	43	40,3	0,1 - 5,5	285,77
SW154-63	SDRPEOSW63-PFM-WS11-Z6-01	SD.EO.RP11/12	6	63	55,5	48	40,3	0,1 - 5,5	317,52
SW154-80	SDRPEOSW80-PFM-WS11-Z8-01	SD.EO.RP11/12	8	80	72,5	58	50,3	0,1 - 5,5	423,36
SW154-100	SDRPEOSW100-PFM-WS11-Z10-01	SD.EO.RP11/12	10	100	92,5	78	50,3	0,1 - 5,5	510,68

Bestellcode (Ordering Code)	Qualität (Grades)										Preis (Price) in €		
	P			M		K	N	S		H			
	CVD	PVD		PVD	CVD	PVD		UNC	-			PVD	
	SW22230	SW11235		SW11245	SW22535			SW00915	SW22535	SW22540		SW12115	
	EOMT 120416-HCM	▲	▲										9,37
	EOMT 120416-SCM				▲	▲							11,68
	RPMX 1204MO-MFHCM	▲	▲										9,64
	RPMX 1204MO-MFSCM				▲	▲							12,71
	RPMX 1605MO-MFHCM	▲	▲										13,53
	RPMX 1605MO-MFSCM				▲	▲							17,99
	SDMX 1105AEER-HCM	▲	▲										9,37
	SDMX 1105AEER-SCM				▲	▲							11,68
	SDMX 1506AEER-HCM	▲	▲										10,49
	SDMX 1506AEER-SCM				▲	▲							13,13

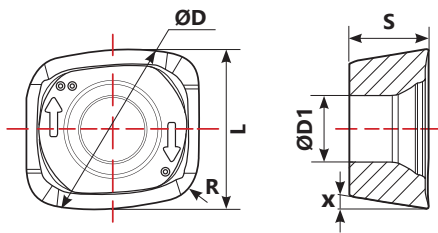
PLATTEN - TECHNISCHE DATEN (INSERTS - TECHNICAL DETAILS)



Bestellcode (Ordering Code)	Maße (Dimensions) in mm					
	D	D1	S	L1	R	x
SDMX... 11...	11.4	4.4	5.9	1.0	0.8	15
SDMX... 15...	15	5.5	6.5	1.5	0.8	15



Bestellcode (Ordering Code)	Maße (Dimensions) in mm					
	D	D1	S	L	L1	X
RPMX... 12...	12	4.4	4.76	11.75	2.4	11
RPMX... 16...	16	5.5	5.56	15.8	2.5	11



Bestellcode (Ordering Code)	Maße (Dimensions) in mm					
	D	D1	S	L	R	X
EOMT... 12...	12	4.4	5	10.5	16	9

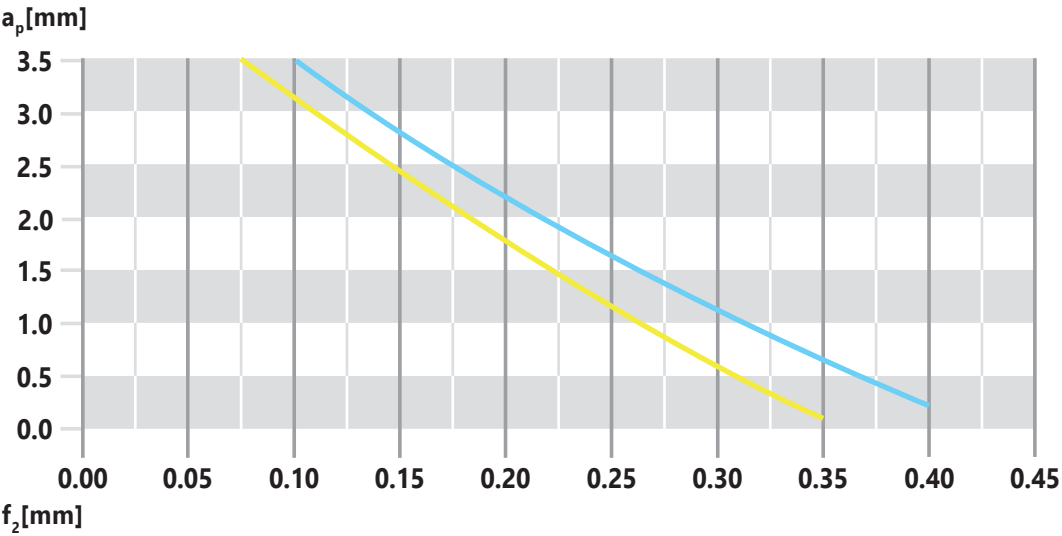
SCHNITTTDATEN
(CUTTING DATA)

Zu bearbeitendes Material (Material to be machined)		HB	Verschleißfestigkeit (Wear Resistance)									Vc (m/min)		Zähigkeit (Toughness)		
			SW22230	SW11235	SW11245	SW22535	Vorschub/Zahn (feed/tooth) in mm					SDMX11	SDMX15	R...12	R...16	EOMT12
P	Unlegierter Stahl (Unalloyed Steel)	155-220	120-220	120-220	-	-	0,1-0,4	0,1-0,5	0,12-0,45	0,25-0,8	0,1-2,5					
	Niedrig legierter Stahl (Low-Alloyed Steel)	220-280	100-200	100-200	-	-										
	Hoch legierter Stahl (High-Alloyed Steel)	280-380	60-160	60-160	-	-										
M	Rostfreier Stahl, ferritisch (Stainless Steels-Ferritic)	200-330	-	-	100-200	100-200	0,08-0,35	0,08-0,4	0,1-0,4	0,2-0,6	0,08-1,5					
	Rostfreier Stahl, austenitisch (Stainless Steel-Austenitic)	200-330	-	-	60-150	60-150										

Alle Schnittdaten dienen zur Orientierung (All cutting datas serve to orientation)

SCHNITTTDATEN SDMX... 11 (CUTTING DATA SDMX... 11)

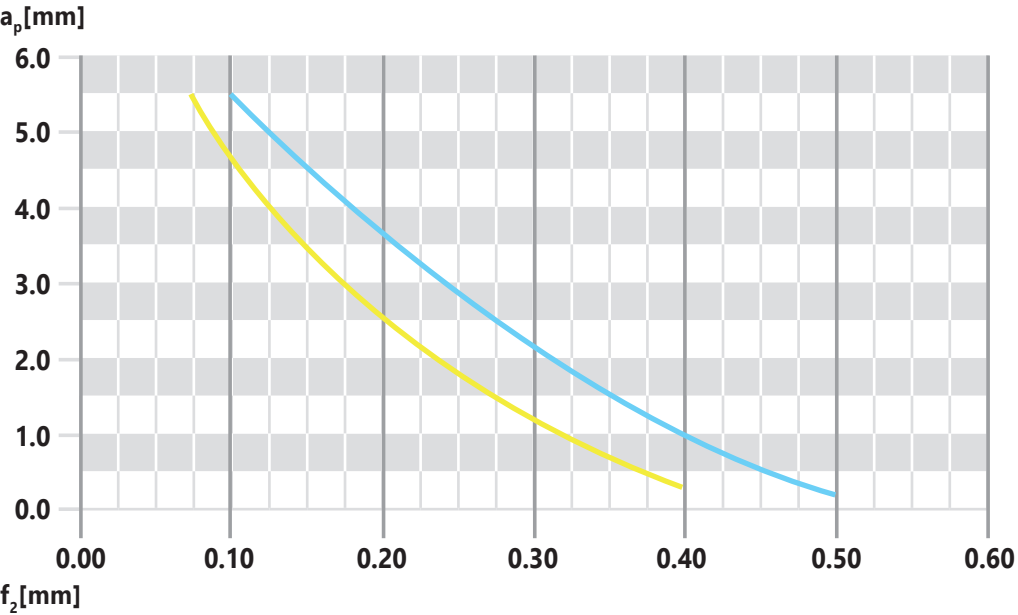
Startparameter (Starting parameters)



SCHNITTTDATEN
(CUTTING DATA)

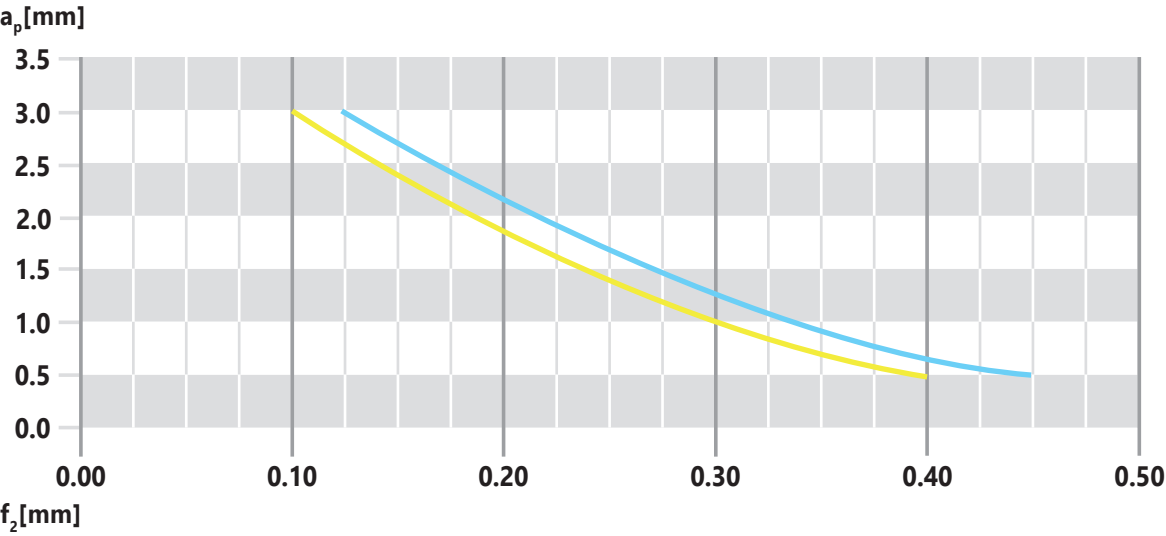
SCHNITTTDATEN RPMX... 15 (CUTTING DATA RPMX... 15)

Startparameter (Starting parameters)



SCHNITTTDATEN RPMX... 12 (CUTTING DATA RPMX... 12)

Startparameter (Starting parameters)

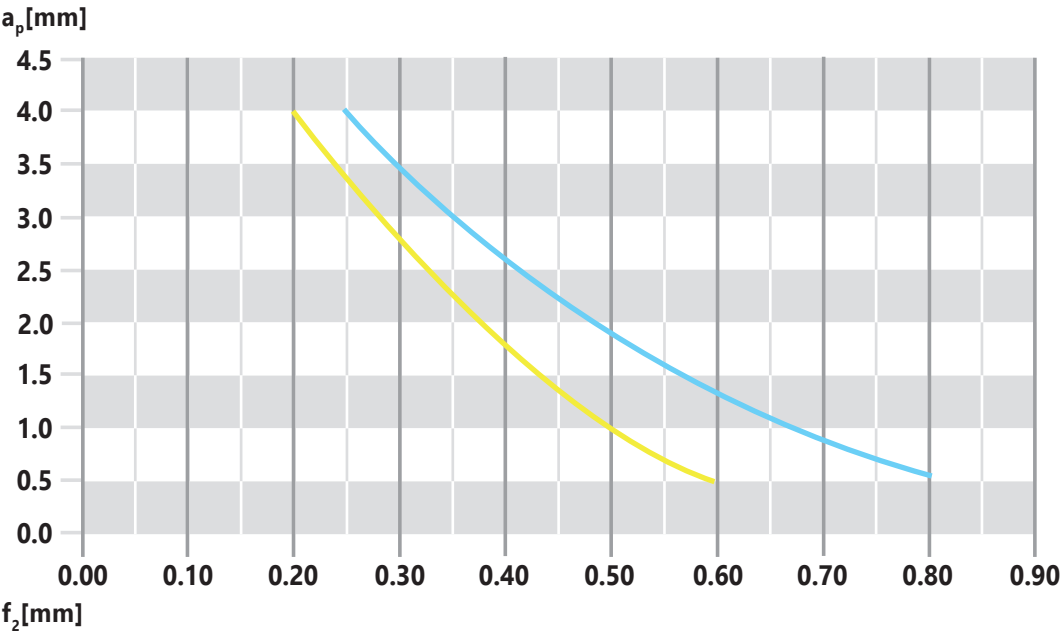


EMPFOHLENE SCHNITTWERTE (RECOMMENDED PARAMETERS)

Indexing (4 times)		
Ø	ap	ap max
12	3.0	5.5
16	4.0	7.5

SCHNITTDATEN RPMX... 16 (CUTTING DATA RPMX... 16)

Startparameter (Starting parameters)

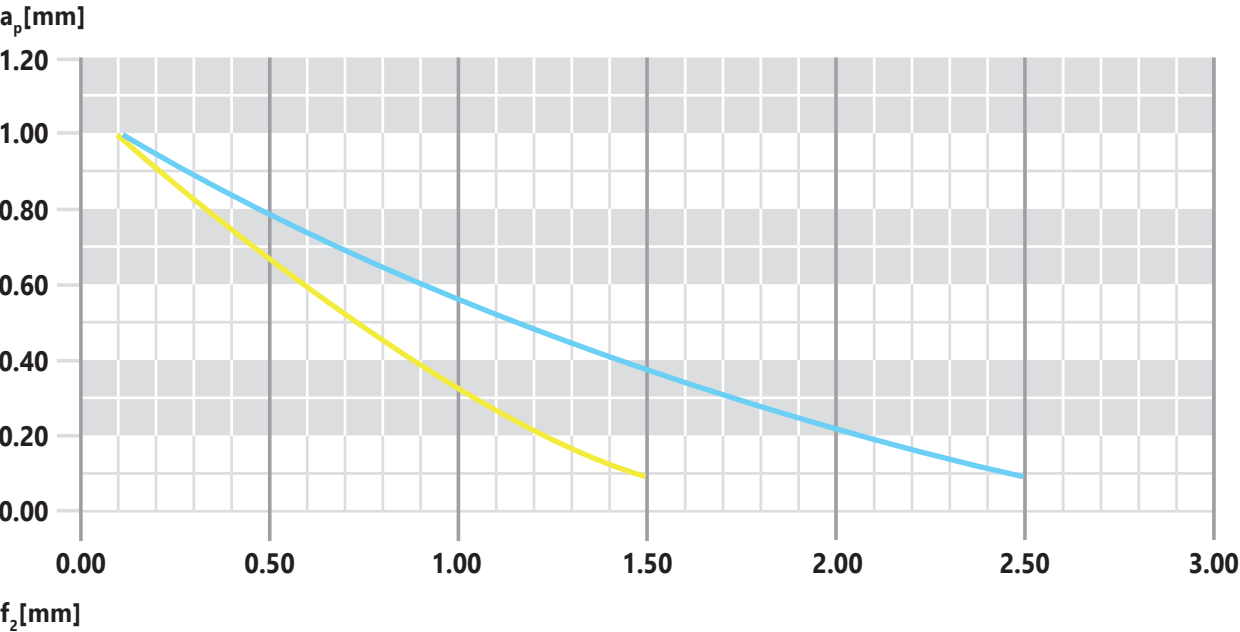


EMPFOHLENE SCHNITTWERTE (RECOMMENDED PARAMETERS)

Ø	Indexing (4 times)	
	ap	ap max
12	3.0	5.5
16	4.0	7.5

SCHNITTDATEN EOMT (CUTTING DATA EOMT)

Startparameter (Starting parameters)



ERSATZTEILE (SPARE PARTS)

Werkzeugdurchmesser (Tool Diameter) ØDc	Spannschraube (Insert Screw)	Torx Schlüssel (Torx Key)	Unterlegplatte / Unterlegscheibe (Shim / Washer)	Klemmschraube (Screw Clamp)
				
AM...	SW1345432	-	-	-
WS...	SW11037484	-	-	-
SDRPEOSW40-PFM-WS11-Z4-01	-	-	-	SW11036880

PLANFRÄSEN 45°
(FACE MILLING 45°)

FRÄSPLATTEN
(MILLING INSERTS)

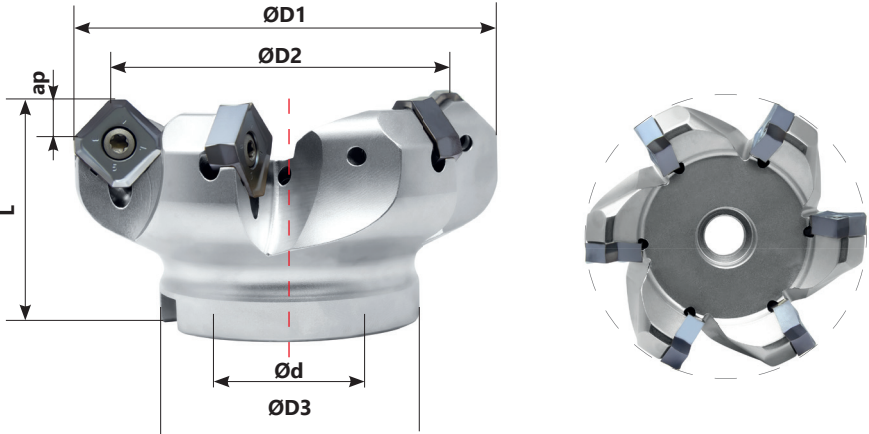
SOSW

Aufsteckmesserkopf
(Arbor Mounting)

Facing

Slotting

Chamfering



Bestellcode (Ordering Code)	Bezeichnung (Identification)	Platten (Inserts)		Maße (Dimensions) in mm					Preis (Price)
		Typ (Type)	Anzahl (Number)	D1	D2	d	L	ap	
SW151-40	SOSW40-FM-AM12-Z4-01	SO... 12...	4	52,4	40	16	45	0,2 - 6,0	362,50
SW151-50	SOSW50-FMAM12-Z5-01	SO... 12...	5	62,4	50	22	45	0,2 - 6,0	370,44
SW151-63	SOSW63-FMAM12-Z6-01	SO... 12...	6	75,4	63	22	45	0,2 - 6,0	513,32
SW151-80	SOSW80-FMAM12-Z8-01	SO... 12...	8	92,4	80	27	50	0,2 - 6,0	584,77
SW151-100	SOSW100-FMAM12-Z10-01	SO... 12...	10	112,4	100	32	50	0,2 - 6,0	677,38
SW151-125	SOSW125-FMAM12-Z12-01	SO... 12...	12	137,4	125	40	63	0,2 - 6,0	767,34

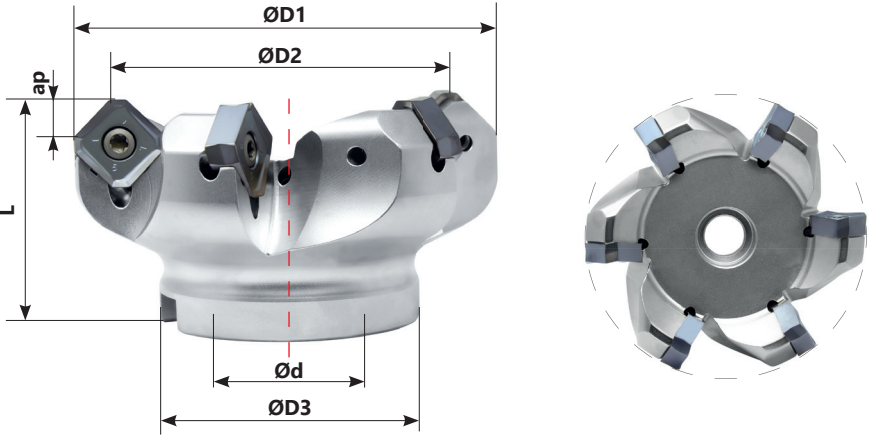
SOSW

Aufsteckmesserkopf
(Arbor Mounting)

Facing

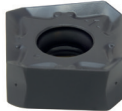
Slotting


Chamfering



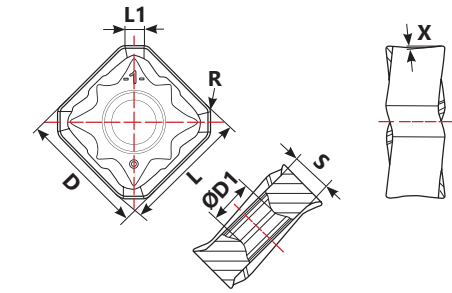
Bestellcode (Ordering Code)	Bezeichnung (Identification)	Platten (Inserts)		Maße (Dimensions) in mm						Preis (Price)
		Typ (Type)	Anzahl (Number)	D1	D2	D3	d	L	ap	
SW152-40	SOSW40-FM-AM15-Z4-01	SO... 15...	4	55	40	38	16	45	0.2 -6.5	259,31
SW152-50	SOSW50-FM-AM15-Z4-01	SO... 15...	4	65	50	43	22	45	0.2 -6.5	272,54
SW152-63	SOSW63-FM-AM15-Z5-01	SO... 15...	5	78	63	48	22	45	0.2 -6.5	328,10
SW152-80	SOSW80-FM-AM15-Z6-01	SO... 15...	6	95	80	58	27	50	0.2 -6.5	370,44
SW152-100	SOSW100-FM-AM15-Z7-01	SO... 15...	7	115	100	78	32	50	0.2 -6.5	463,05
SW152-125	SOSW125-FM-AM15-Z8-01	SO... 15...	8	140	125	88	40	63	0.2 -6.5	598,00
SW152-160	SOSW160-FM-AM15-Z10-01	SO... 15...	10	175	160	93.4	40	63	0.2 -6.5	804,83

Bestellcode (Ordering Code)	Qualität (Grades)										Preis (Price) in €	
	P			M		K	N	S		H		
	CVD	PVD		PVD	CVD	PVD		UNC	-			PVD
	SW22230	SW11235	SW22535	SW11245	SW22535	SW22415	SW12220	SW00915	SW22535	SW22540		SW12115

	SOKU 1205AZER-HCM	▲	▲	▲											17,23
	SOKU 1205AZER-SCM				▲	▲									19,07

	SOKU 1505AZER-HCM	▲	▲	▲											22,96
	SOKU 1505AZER-SCM				▲	▲									22,54
	SOKU 1505AZER-CCM						▲	▲							20,96

PLATTEN - TECHNISCHE DATEN (INSERTS - TECHNICAL DETAILS)



Bestellcode (Ordering Code)	Maße (Dimensions) in mm						
	D	D1	S	L	L1	R	x
SO... 12...	13	4.55	5	13	2	0.8	6
SO... 15...	15.875	5.74	6.0	15.875	2.7	1.0	6

SCHNITTDATEN
(CUTTING DATA)

Zu bearbeitendes Material (Material to be machined)		HB	Verschleißfestigkeit (Wear Resistance)							Vorschub/Zahn (feed/tooth) in mm
			Vc (m/min)			Zähigkeit (Toughness)				
			SW22230	SW22235	SW11235	SW11245	SW22535	SW22415	SW22415	
P	Unlegierter Stahl (Unalloyed Steel)	155-220	120-220	120-220	120-220	-	-	-	-	0,1-0,3
	Niedrig legierter Stahl (Low-Alloyed Steel)	220-280	80-180	80-180	80-180	-	-	-	-	
	Hoch legierter Stahl (High-Alloyed Steel)	280-380	60-160	60-160	60-160	-	-	-	-	
M	Rostfreier Stahl, ferritisch (Stainless Steels-Ferritic)	200-330	-	-	-	100-200	100-200	-	-	0,08-0,2
	Rostfreier Stahl, austenitisch (Stainless Steel-Austenitic)	200-330	-	-	-	60-160	60-160	-	-	
K	Temperguss (Unalloyed Steel)	130-230	-	-	-	-	-	200- 320	200- 320	0,08-0,45
	Grauguss (Grey Cast Iron)	180-245	-	-	-	-	-	150- 280	150- 280	
	Gusseisen mit Kugelgraphit (Spheroidal Cast Iron)	160-250	-	-	-	-	-	100- 220	100- 220	

Alle Schnittdaten dienen zur Orientierung (All cutting datas serve to orientation)

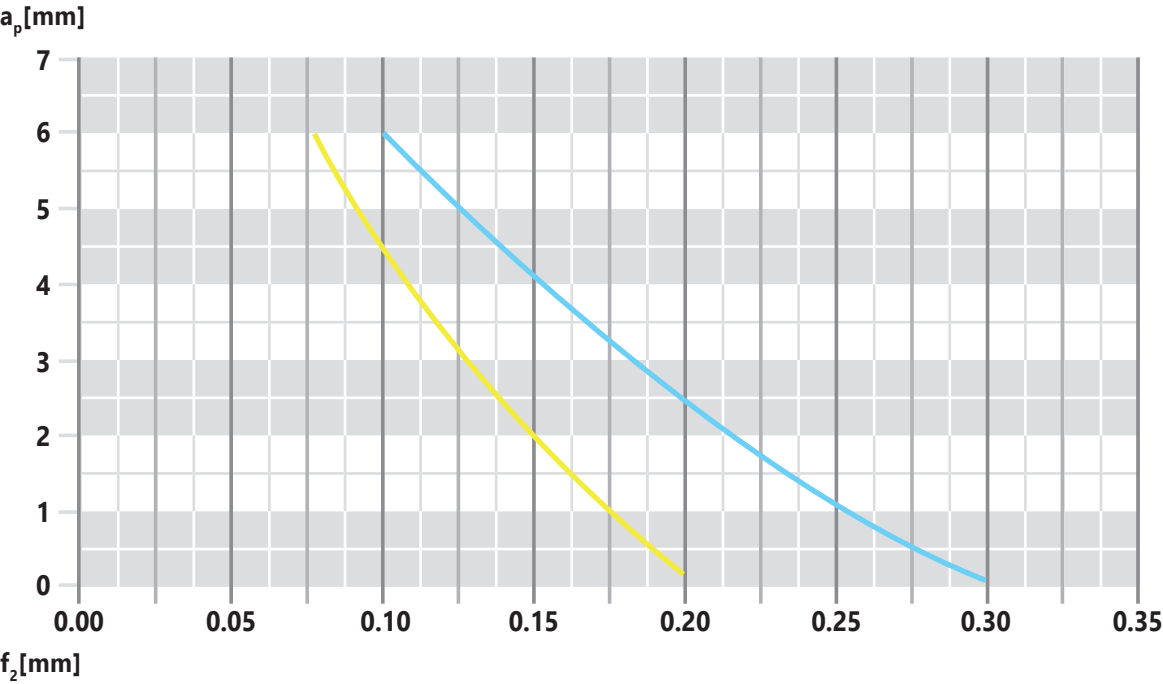
ERSATZTEILE (SPARE PARTS)

Werkzeugdurchmesser (Tool Diameter) ØDc	Spannschraube (Insert Screw)	Torx Schlüssel (Torx Key)	Unterlegplatte / Unterlegscheibe (Shim / Washer)	Klemmschraube (Screw Clamp)
				
AM...	SW1345432	-	-	-
WS...	SW11037484	-	-	-
SDRPEOSW40-PFM-AM11-Z4-01	-	-	-	SW11036880

SCHNITTDATEN
(CUTTING DATA)

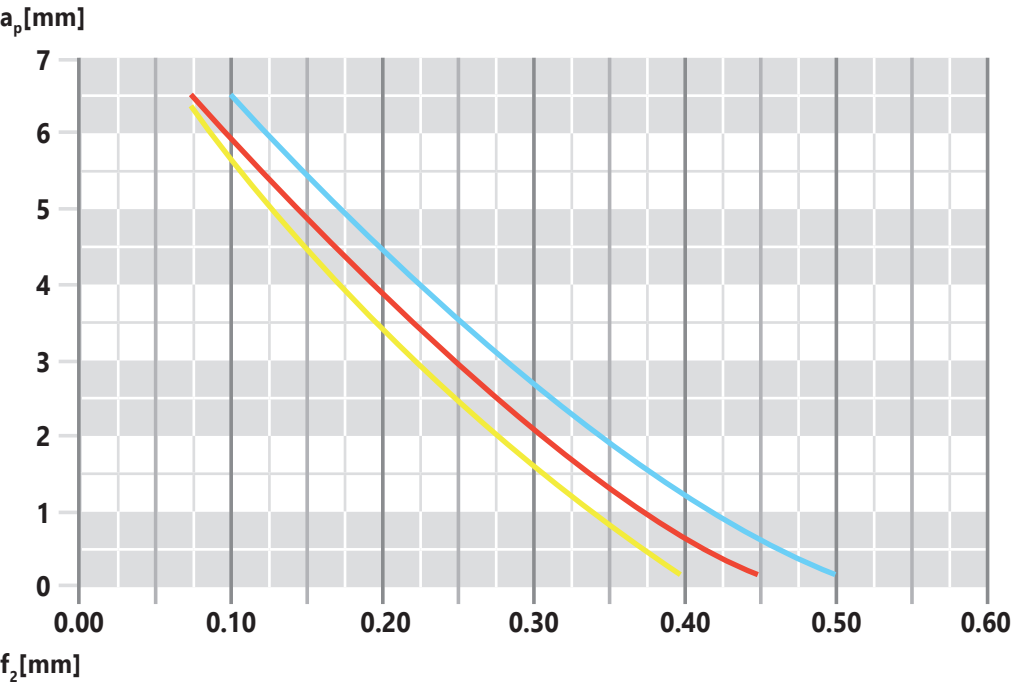
SCHNITTDATEN SDMX (CUTTING DATA SOKU12)

Startparameter (Starting parameters)

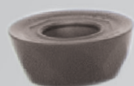
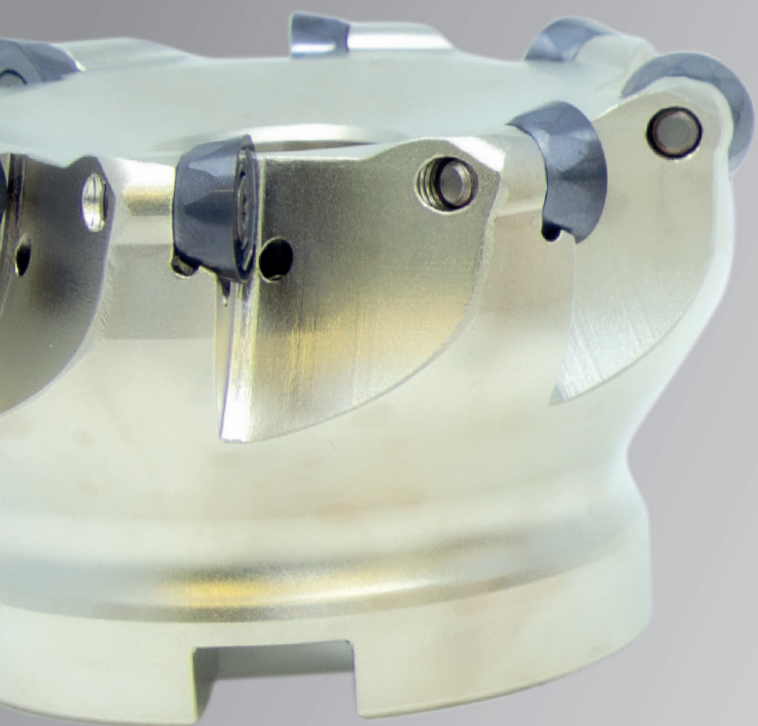


SCHNITTDATEN SDMX (CUTTING DATA SOKU15)

Startparameter (Starting parameters)







SCHWARZ Cuttingtools GmbH

Lembergstr. 33

70825 Korntal-Münchingen, Germany

Tel.: +49 (0) 711/51 87 88 10

Fax: + 49 (0) 711/51 87 88 06

www.schwarz-cuttingtools.com

info@schwarz-cuttingtools.com