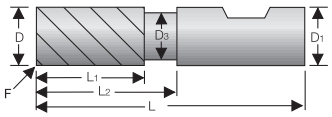
SARA® Trochoidal milling cutter Basic Line

VHM | 42° | e8 | h5 | Z 5 | AlCrN | i Vc/fz | 780

- With clearance
- **Milling cutter designed for TVC use**
- Reinforced core
- With chip breaker
- **Cutting material: superfine rain solid carbide**
- Irregular tooth pitch for a strong head centre
- **ae steel max. 20 %**
- **ae stainless steel max. 15 %**
- **fz based on 0.1xD**



material

● very well suited ○ well suited	steel			stainless steel			cast iron		titanium alloys	superalloys Fe/NiCo-based		aluminium		copper	graphite	hardened steel		
	< 700 N/mm²	< 1000 N/mm²	< 1400 N/mm²	ferrit./martens.	austenitic	duplex	GG/GTS	GGG		< 30 HRc	≥ 30 HRc	< 8 % Si	≥ 8 % Si	Cu-alloy	GRP/CFP/thermo.	< 55 HRc	< 60 HRc	≥ 60 HRc
	●	●	●	●	●				○	○						○	○	
	300	250	210	170	190				130	80						100	90	
Cutting speed Vc m/min.																		

Please adjust these guidelines according to clamping operation and machine set-up.

D mm	L1 mm	L2 mm	L mm	D3 mm	D1 mm	F x 45° mm	Z	Feed fz steel < 1000 N/mm² mm/tooth	art.no.	€
6.0	18	24	62	5.7	6.0	0.12	5	0.03	254117 0060	34,10
8.0	24	30	68	7.6	8.0	0.16	5	0.04	254117 0080	45,40
10.0	30	38	80	9.5	10.0	0.20	5	0.05	254117 0100	59,10
12.0	36	46	93	11.5	12.0	0.24	5	0.06	254117 0120	78,30
14.0	42	50	100	13.5	14.0	0.28	5	0.07	254117 0140	112,–
16.0	48	58	108	15.5	16.0	0.32	5	0.08	254117 0160	137,50
18.0	54	67	115	17.5	18.0	0.36	5	0.09	254117 0180	192,50
20.0	60	74	126	19.5	20.0	0.40	5	0.10	254117 0200	213,–
25.0	75	92	150	24.0	25.0	0.50	5	0.13	254117 0250	410,–

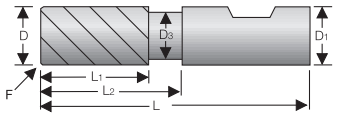
2148

ATORN Trochoidal end milling cutter (aluminium)

VHM | Typ W | 20° | e8 | h5 | Z 4 | TVC | i Vc/fz | 780

- With clearance
- **Milling cutter designed for TVC use**
- Reinforced core
- **Cutting material: superfine rain solid carbide**
- Polished cutting edges for perfect chip removal
- **ae max. 30 %**

Trochoidal



material

● very well suited ○ well suited	steel			stainless steel			cast iron		titanium alloys	superalloys Fe/NiCo-based		aluminium		copper	graphite	hardened steel		
	< 700 N/mm²	< 1000 N/mm²	< 1400 N/mm²	ferrit./martens.	austenitic	duplex	GG/GTS	GGG		< 30 HRc	≥ 30 HRc	< 8 % Si	≥ 8 % Si	Cu-alloy	GRP/CFP/thermo.	< 55 HRc	< 60 HRc	≥ 60 HRc
												●	●					
												400	600					
Cutting speed Vc m/min.																		

Please adjust these guidelines according to clamping operation and machine set-up.

D mm	L1 mm	L2 mm	L mm	D3 mm	D1 mm	F x 45° mm	Z	Feed fz aluminium < 8 % Si mm/tooth	art.no.	€
4	13	14.0	62	3.8	6	0.08	4	0.06	254159 0040	53,30
5	16	17.5	62	4.8	6	0.1	4	0.08	254159 0050	53,30
6	19	21.0	62	5.8	6	0.12	4	0.1	254159 0060	53,30
8	26	28.0	68	7.8	8	0.16	4	0.12	254159 0080	68,20
10	32	35.0	80	9.8	10	0.2	4	0.15	254159 0100	116,–
12	38	42.0	93	11.8	12	0.24	4	0.17	254159 0120	158,50
16	50	56.0	108	15.8	16	0.32	4	0.20	254159 0160	287,–
20	62	70.0	126	19.8	20	0.4	4	0.25	254159 0200	420,–

2153