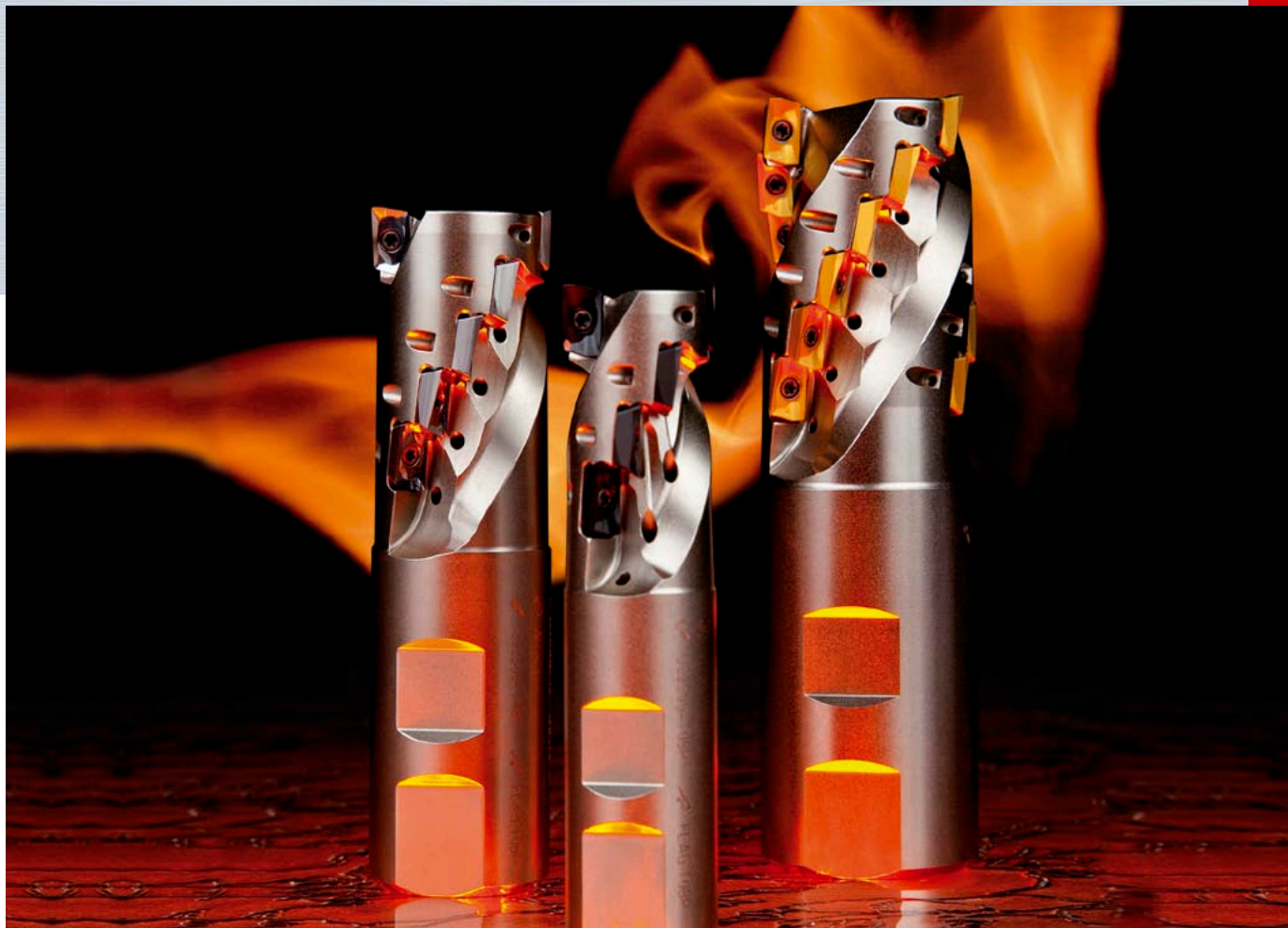


HOT TOOLS



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COMPLETE ASSORTMENT OF TOOLS
WITH ADMX11 INSERTS

ADMX 11

 **PRAMET**

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AGE **MILL**

INSERTS AND TOOLS FOR MILLING **ADMX 11**

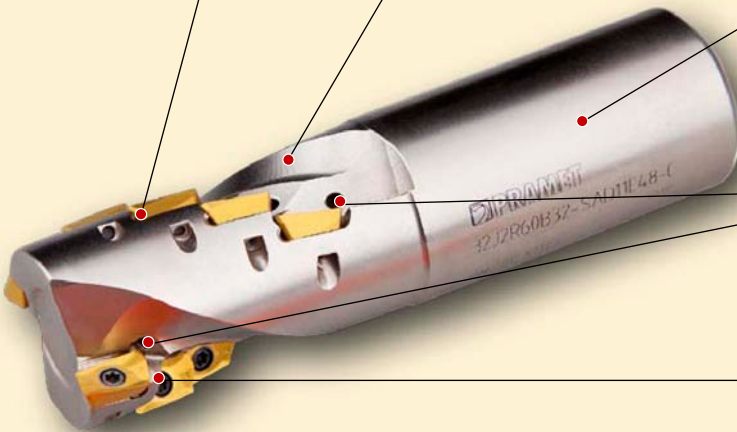
- + **Highly Positive Geometry (rake angle 23°)**
 - lower machine power
- + **Optimized Cutting Edge Shape**
 - higher impact resistance
 - lower cutting forces
 - smooth machining
- + **Smooth Cutting Edge Continuity**
 - higher tool life
 - better roughness quality



ADMX

New generation of helical cutters with ADMX11 / ADEX 11 inserts

- + **Special Surface Finishing**
 - better corrosion resistance
 - abrasive wear reduction
 - lower friction resistance
- + **Specially Shaped Groove**
 - easy and fast chip removal
- + **New Technology and Heat Treatment**
 - higher tool accuracy
- + **Internal Fluid Supply**
 - optimal cooling
- + **Construction of cutting part**
 - axial underpinning of inserts in first line

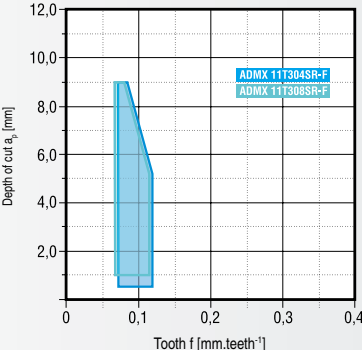
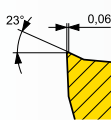


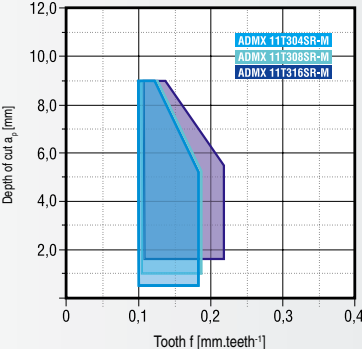
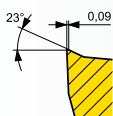
Cutters with ADMX11 / ADEX 11 inserts

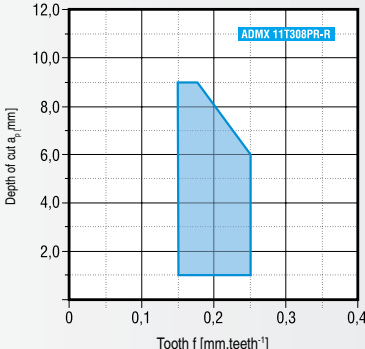
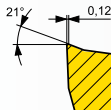


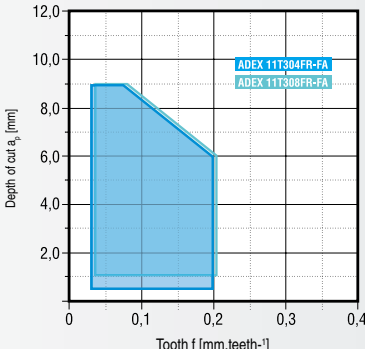
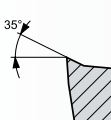
- + **Long-Life Laser Marking**
 - identification of inserts and spare parts
- + **Internal Fluid Supply**
 - optimal cooling
- + **Highly Positive Geometry**
 - cutting forces reduction
 - higher productivity

Overview of geometries ADMX11 / ADEX 11

Geometry	Photo	Workpiece material group					Diagram of application	Description	Applied to inserts: ADMX 11T308SR-F ADMX 11T304SR-F
		Milling	P	M	K	N			
ADMX11-F		Finishing	■	■	■	■	■		- High positive geometry with narrow T-land - Suitable for machining of materials all groups except group H - Especially for light-duty machining conditions
	Profile of cutting edge	Medium	■	■	■	■	■		
		Roughing	□	□	□	□	□		
	Range of cutting conditions:								
f_z								0,07 ÷ 0,12 [mm.tooth ⁻¹]	
a_p								(0,5) 1,0 ÷ 9,0 [mm]	

Geometry	Photo	Workpiece material group					Diagram of application	Description
		Milling	P	M	K	S		
ADMX11-M		Finishing	■	■	■	■		Applied to inserts: ADMX 11T308SR-M ADMX 11T304SR-M, ADMX 11T316SR-M
	Profile of cutting edge	Medium	■	■	■	■		
		Roughing	□	□	□	□		
	Range of cutting conditions:							
f_z					0,1 ÷ 0,18 (0,22) [mm.tooth ⁻¹]			
a_p					(0,5) 1,0 (1,8) ÷ 9,0 [mm]			

Geometry	Photo	Workpiece material group					Diagram of application	Description	Applied to inserts: ADMX 11T308PR-R
		Milling	P	M	K	S			
ADMX11-R		Finishing	■	■	■	■	■		- Positive geometry with duple T-land - Suitable for machining of materials groups P, M, K and S - Geometry suitable also for less stable working conditions
	Profile of cutting edge	Medium	■	■	■	■	■		
		Roughing	■	■	■	■	■		
Range of cutting conditions:									
f_z 0,15 ÷ 0,25 [mm.tooth ⁻¹]									
a_p 1,0 ÷ 9,0 [mm]									

Geometry	Photo	Workpiece material group					Diagram of application	Description	Applied to inserts:	
		Milling	P	M	K	N			S	T
ADEX11-FA		Finishing	☐	☐	☐	☒	☐		- Geometry with positive rake angle and minimum honing of cutting edge - Suitable for machining of non-ferrous metals (ISO Group N)	
	Medium				☒					
	Roughing					☒				
	Profile of cutting edge							Range of cutting conditions:		
								f_z	0,03 ÷ 0,20 [mm.tooth ⁻¹]	
								a_p	0,5 (1,0) ÷ 9,0 [mm]	

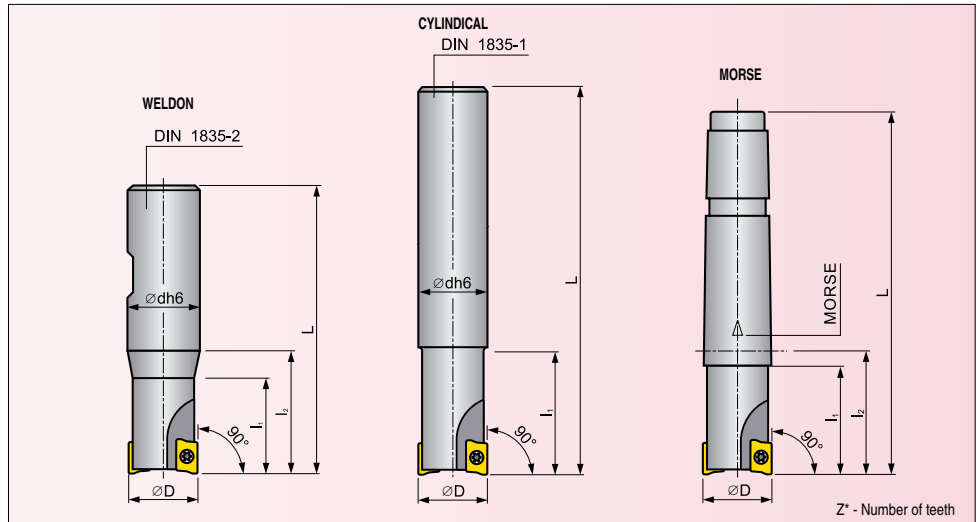
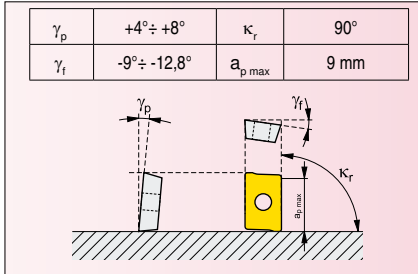
■ main area

□ other application

□ conditional application

SAD11E

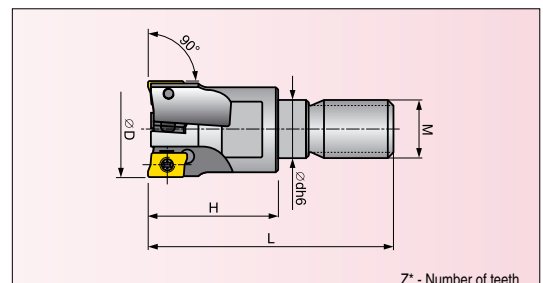
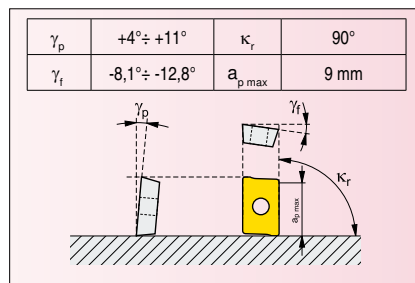
Shoulder end milling cutters with inserts ADMX11 / ADEX 11



ISO	Assortment	Dimensions								[kg]	Cooling	Spare parts		Inserts
		D	L	L ₁	L ₂	dh6	Morse	Z*						
WELDON	16A2R027B16-SAD11E-C	●	16	75	27	-	16	-	2	0,1	+	US2505-T08P	FLAG T08P	AD.X 11T3
	20A2R032B20-SAD11E-C	●	20	82	32	-	20	-	2	0,2	+			
	20A3R032B20-SAD11E-C	●	20	82	32	-	20	-	3	0,2	+			
	25A3R042B25-SAD11E-C	●	25	98	42	-	25	-	3	0,3	+			
	25A4R042B25-SAD11E-C	●	25	98	42	-	25	-	4	0,3	+			
	32A4R042B32-SAD11E-C	●	32	102	42	-	32	-	4	0,4	+			
	32A5R042B32-SAD11E-C	●	32	102	42	-	32	-	5	0,4	+			
	16A2R024A16-SAD11E-C	●	16	135	24	-	16	-	2	0,2	+			
CYLINDRICAL	16A2R050A16-SAD11E-C	●	16	135	50	-	16	-	2	0,2	+			
	20A2R029A20-SAD11E-C	●	20	150	29	-	20	-	2	0,3	+			
	20A2R070A20-SAD11E-C	●	20	150	70	-	20	-	2	0,3	+			
	20A3R029A20-SAD11E-C	●	20	150	29	-	20	-	3	0,3	+			
	25A3R034A25-SAD11E-C	●	25	170	34	-	25	-	3	0,5	+			
	25A3R080A25-SAD11E-C	●	25	170	80	-	25	-	3	0,5	+			
	25A4R034A25-SAD11E-C	●	25	170	34	-	25	-	4	0,5	+			
	32A3R090A32-SAD11E-C	○	32	195	90	-	32	-	3	0,9	+			
MORSE	32A5R034A32-SAD11E-C	●	32	195	34	-	32	-	5	0,9	+			
	16A2R030E02-SAD11E-C	●	16	94	25	30	-	2	2	0,1	+			
	20A3R035E03-SAD11E-C	●	20	116	30	35	-	3	3	0,2	+			
	25A4R043E03-SAD11E-C	●	25	124	38	43	-	3	4	0,3	+			

SAD11E

Exchangable heads for modular system with inserts ADMX11 / ADEX 11



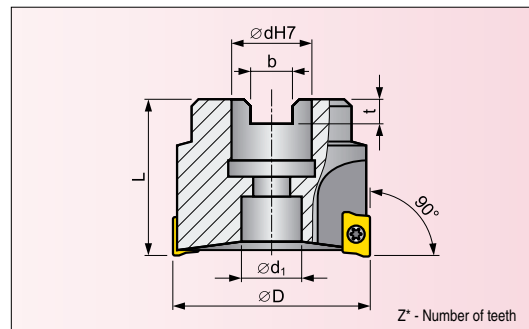
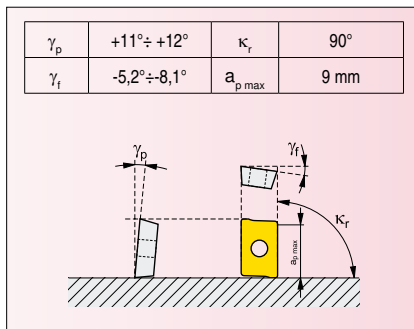
ISO	Assortment	Dimensions						[kg]	Cooling	Spare parts		Inserts
		D	L	H	M	dh6	Z*					
16A2R024M08-SAD11E-C	●	16	38	24	M8	8,5	2	0,1	+	US2505-T08P	FLAG T08P	AD.X 11T3
20A3R026M10-SAD11E-C	●	20	45	26	M10	10,5	3	0,1	+			
25A4R033M12-SAD11E-C	●	25	55	33	M12	12,5	4	0,1	+			
32A5R043M16-SAD11E-C	●	32	66	43	M16	17,0	5	0,1	+			
40A6R043M16-SAD11E-C	●	40	66	43	M16	17,0	6	0,2	+			

● Stock Assortment ○ Non-stock Assortment

All dimensions in [mm]

S90AD11E

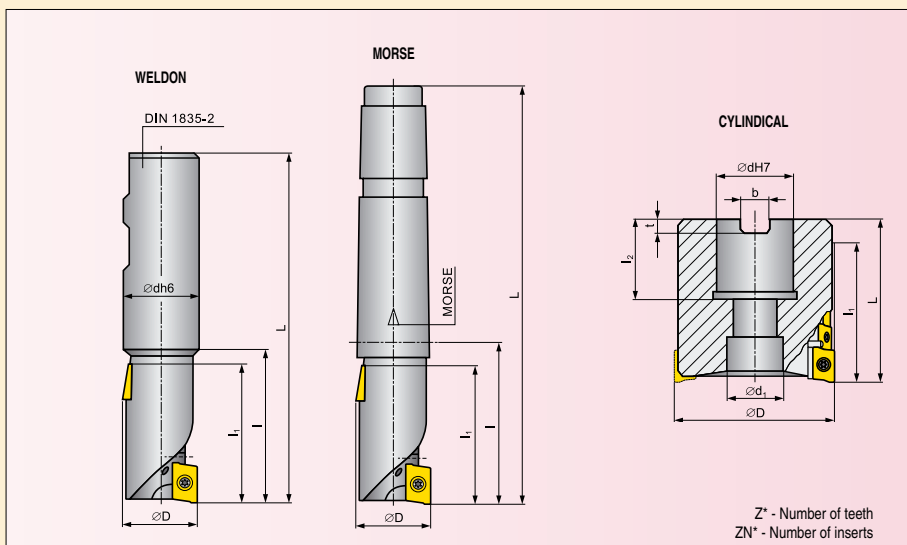
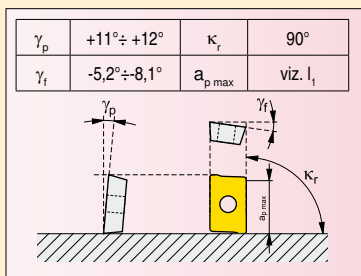
Shoulder milling cutters with inserts ADMX11 / ADEX 11



ISO	Sortiment	Dimensions							[kg]	Cooling	Spare parts			Inserts
		D	dH7	d ₁	L	b	t	Z*						
40A04R-S90AD11E-C	●	40	16	14	40	8,4	5,6	4	0,2	+	US2505-T08P	D-T08P/T15P	FG-15	ADX 11T3
40A06R-S90AD11E-C	●	40	16	14	40	8,4	5,6	6	0,2	+				
50A05R-S90AD11E-C	●	50	22	18	40	10,4	6,3	5	0,3	+				
50A07R-S90AD11E-C	●	50	22	18	40	10,4	6,3	7	0,3	+				
63A06R-S90AD11E-C	●	63	22	18	40	10,4	6,3	6	0,5	+				
63A09R-S90AD11E-C	●	63	22	18	40	10,4	6,3	9	0,5	+				
80A10R-S90AD11E-C	●	80	27	38	50	12,4	7,0	10	1,0	+				
100A11R-S90AD11E-C	●	100	32	45	50	14,4	8,0	11	1,7	+				
125A12R-S90AD11E-C	●	125	40	56	63	16,4	9,0	12	3,5	+				

SAD11E

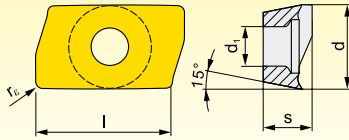
Helical milling cutters with inserts ADMX11 / ADEX 11



ISO		Sortiment	Dimensions											[kg]	Cooling	Spare parts			Inserts
			D	L	I	I ₁	dh6	Morse	-	-	Z*	ZN*					-		
WELDON	25J2R50B25-SAD11E38-C	●	25	106	50	38	25	-	-	-	2	8	0,3	+	US2506-T07P	FLAG T07P	-	AD.X 11T3	
	32J2R60B32-SAD11E47-C	●	32	120	60	47	32	-	-	-	2	10	0,6	+					
	40J2R60B40-SAD11E47-C	●	40	130	60	47	40	-	-	-	2	10	0,9	+					
	40J3R70B40-SAD11E56-C	●	40	140	70	56	40	-	-	-	3	18	1,0	+					
MORSE	25J2R55E03-SAD11E38-C	●	25	136	38	38	-	3	-	-	2	8	0,4	+					
	32J2R65E04-SAD11E47-C	●	32	167,5	47	47	-	4	-	-	2	10	0,7	+					
	40J3R75E04-SAD11E56-C	●	40	177,5	56	56	-	4	-	-	3	18	1,1	+					
ISO			D	L	I ₁	I ₂	d1	b	t	dh7	Z*	ZN*	[kg]	Cooling				Inserts	
CYLINDRICAL	50T03R-S90AD11E37-C	●	50	58	37	21	18	10,4	6,3	22	3	12	0,5	+	US2506-T07P	D-T07P/T09P	FG-15	AD.X 11T3	

Indexable cutting inserts ADEX11 / ADMX11

ADMX 11 / ADEX 11



Size	(l)	d	s	d ₁	r _e
11	11,000	6,530	3,97	2,9	0,4 - 1,6

● Stock Assortment ○ Non-stock Assortment

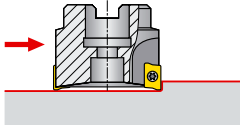
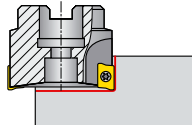
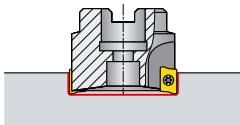
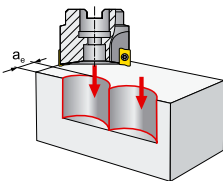
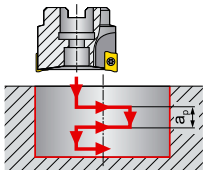
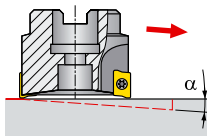
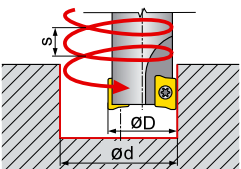
ISO	ANSI	Grades								Radius
		2215	2230	8016	8230	8240	HF7			
ADMX 11T304SR-F	ADMX -(2.5)1SR-F				●	●				0,4
ADMX 11T308SR-F	ADMX -(2.5)2SR-F				●	●				0,8
ADMX 11T304SR-M	ADMX -(2.5)1SR-M				●	●				0,4
ADMX 11T308SR-M	ADMX -(2.5)2SR-M			●	●	●				0,8
ADMX 11T316SR-M	ADMX -(2.5)4SR-M				●	●				1,6
ADMX 11T308PR-R	ADMX -(2.5)2PR-R	●	●	●	●	●				0,8
ADEX 11T304FR-FA	ADMX -(2.5)1FR-FA						●			0,4
ADEX 11T308FR-FA	ADMX -(2.5)2FR-FA						●			0,8

All dimensions in [mm]

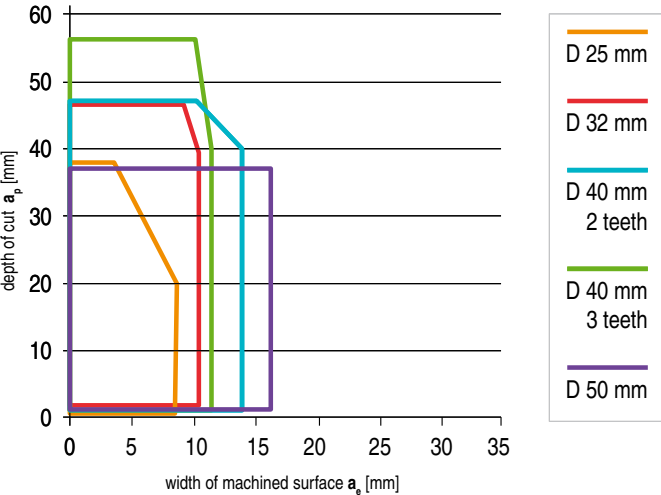
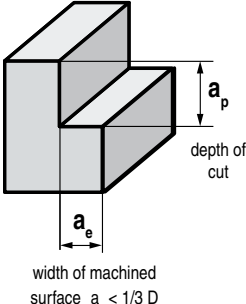
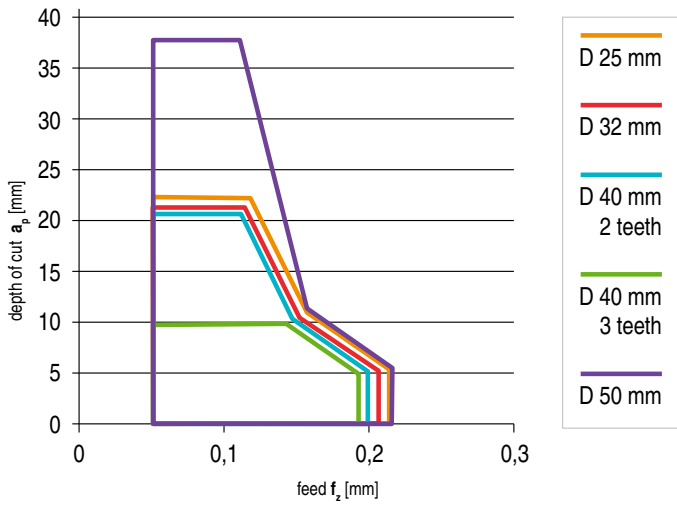
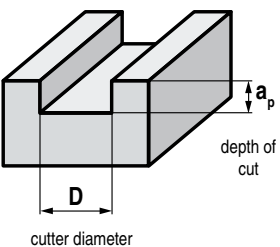
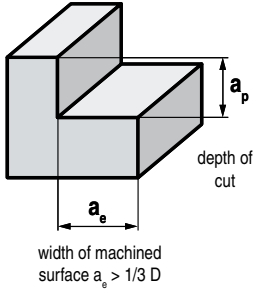
Assortment of inserts ADMX11 / ADEX 11

Basic shape of insert		Cutting condition	Initial cutting conditions					
			P	M	K	N	S	H
ADMX 11T304SR-F 8230		feed [mm.tooth ⁻¹]	0,07 ÷ 0,12	0,07 ÷ 0,09	0,07 ÷ 0,12	0,07 ÷ 0,12	0,07 ÷ 0,07	–
		depth of cut [mm]	0,5 ÷ 9,0	0,5 ÷ 6,8	0,5 ÷ 9,0	0,5 ÷ 9,0	0,5 ÷ 5,4	–
		cutting speed [m.min ⁻¹]	175 ÷ 265	105 ÷ 155	165 ÷ 250	260 ÷ 925	35 ÷ 75	–
ADMX 11T304SR-F 8240		feed [mm.tooth ⁻¹]	0,07 ÷ 0,12	0,07 ÷ 0,09	0,07 ÷ 0,12	–	0,07 ÷ 0,07	–
		depth of cut [mm]	0,5 ÷ 9,0	0,5 ÷ 6,8	0,5 ÷ 9,0	–	0,5 ÷ 5,4	–
		cutting speed [m.min ⁻¹]	145 ÷ 210	85 ÷ 125	135 ÷ 195	–	25 ÷ 60	–
ADMX 11T308SR-F 8230		feed [mm.tooth ⁻¹]	0,07 ÷ 0,12	0,07 ÷ 0,09	0,07 ÷ 0,12	0,07 ÷ 0,12	0,07 ÷ 0,07	–
		depth of cut [mm]	1,0 ÷ 9,0	1,0 ÷ 6,8	1,0 ÷ 9,0	1,0 ÷ 9,0	1,0 ÷ 5,4	–
		cutting speed [m.min ⁻¹]	210 ÷ 290	125 ÷ 170	195 ÷ 275	315 ÷ 1015	40 ÷ 85	–
ADMX 11T308SR-F 8240		feed [mm.tooth ⁻¹]	0,07 ÷ 0,12	0,07 ÷ 0,09	0,07 ÷ 0,12	–	0,07 ÷ 0,07	–
		depth of cut [mm]	1,0 ÷ 9,0	1,0 ÷ 6,8	1,0 ÷ 9,0	–	1,0 ÷ 5,4	–
		cutting speed [m.min ⁻¹]	175 ÷ 230	105 ÷ 135	165 ÷ 215	–	35 ÷ 65	–
ADMX 11T304SR-M 8230		feed [mm.tooth ⁻¹]	0,10 ÷ 0,18	0,10 ÷ 0,14	0,10 ÷ 0,18	–	0,10 ÷ 0,11	–
		depth of cut [mm]	0,5 ÷ 9,0	0,5 ÷ 6,8	0,5 ÷ 9,0	–	0,5 ÷ 5,4	–
		cutting speed [m.min ⁻¹]	160 ÷ 245	95 ÷ 145	150 ÷ 230	–	30 ÷ 70	–
ADMX 11T304SR-M 8240		feed [mm.tooth ⁻¹]	0,10 ÷ 0,18	0,10 ÷ 0,14	0,10 ÷ 0,18	–	0,10 ÷ 0,11	–
		depth of cut [mm]	0,5 ÷ 9,0	0,5 ÷ 6,8	0,5 ÷ 9,0	–	0,5 ÷ 5,4	–
		cutting speed [m.min ⁻¹]	145 ÷ 205	85 ÷ 120	135 ÷ 190	–	25 ÷ 60	–
ADMX 11T308SR-M 2230		feed [mm.tooth ⁻¹]	0,10 ÷ 0,18	0,10 ÷ 0,14	0,10 ÷ 0,18	–	–	–
		depth of cut [mm]	1,0 ÷ 9,0	1,0 ÷ 6,8	1,0 ÷ 9,0	–	–	–
		cutting speed [m.min ⁻¹]	200 ÷ 285	120 ÷ 170	190 ÷ 270	–	–	–
ADMX 11T308SR-M 8016		feed [mm.tooth ⁻¹]	0,10 ÷ 0,18	0,10 ÷ 0,14	0,10 ÷ 0,18	–	0,10 ÷ 0,11	–
		depth of cut [mm]	1,0 ÷ 9,0	1,0 ÷ 6,8	1,0 ÷ 9,0	–	1,0 ÷ 5,4	–
		cutting speed [m.min ⁻¹]	165 ÷ 240	95 ÷ 140	155 ÷ 225	–	30 ÷ 70	–
ADMX 11T308SR-M 8230		feed [mm.tooth ⁻¹]	0,10 ÷ 0,18	0,10 ÷ 0,14	0,10 ÷ 0,18	–	0,10 ÷ 0,11	–
		depth of cut [mm]	1,0 ÷ 9,0	1,0 ÷ 6,8	1,0 ÷ 9,0	–	1,0 ÷ 5,4	–
		cutting speed [m.min ⁻¹]	195 ÷ 275	115 ÷ 165	185 ÷ 260	–	35 ÷ 80	–
ADMX 11T308SR-M 8240		feed [mm.tooth ⁻¹]	0,10 ÷ 0,18	0,10 ÷ 0,14	0,10 ÷ 0,18	–	0,10 ÷ 0,11	–
		depth of cut [mm]	1,0 ÷ 9,0	1,0 ÷ 6,8	1,0 ÷ 9,0	–	1,0 ÷ 5,4	–
		cutting speed [m.min ⁻¹]	170 ÷ 225	100 ÷ 135	160 ÷ 210	–	30 ÷ 65	–
ADMX 11T316SR-M 8230		feed [mm.tooth ⁻¹]	0,10 ÷ 0,22	0,10 ÷ 0,17	0,10 ÷ 0,22	–	0,10 ÷ 0,13	–
		depth of cut [mm]	1,8 ÷ 9,0	1,8 ÷ 6,8	1,8 ÷ 9,0	–	1,8 ÷ 5,4	–
		cutting speed [m.min ⁻¹]	210 ÷ 285	125 ÷ 170	195 ÷ 270	–	40 ÷ 85	–
ADMX 11T316SR-M 8240		feed [mm.tooth ⁻¹]	0,10 ÷ 0,22	0,10 ÷ 0,17	0,10 ÷ 0,22	–	0,10 ÷ 0,13	–
		depth of cut [mm]	1,8 ÷ 9,0	1,8 ÷ 6,8	1,8 ÷ 9,0	–	1,8 ÷ 5,4	–
		cutting speed [m.min ⁻¹]	185 ÷ 230	110 ÷ 135	175 ÷ 215	–	35 ÷ 65	–
ADMX 11T308PR-R 2215		feed [mm.tooth ⁻¹]	0,15 ÷ 0,25	–	0,15 ÷ 0,25	–	–	0,10 ÷ 0,20
		depth of cut [mm]	1,0 ÷ 9,0	–	1,0 ÷ 9,0	–	–	0,3 ÷ 1,5
		cutting speed [m.min ⁻¹]	240 ÷ 320	–	225 ÷ 300	–	–	45 ÷ 60
ADMX 11T308PR-R 2230		feed [mm.tooth ⁻¹]	0,15 ÷ 0,25	0,15 ÷ 0,19	0,15 ÷ 0,25	–	–	0,10 ÷ 0,20
		depth of cut [mm]	1,0 ÷ 9,0	1,0 ÷ 6,8	1,0 ÷ 9,0	–	–	0,3 ÷ 1,5
		cutting speed [m.min ⁻¹]	190 ÷ 265	110 ÷ 155	180 ÷ 250	–	–	35 ÷ 50
ADMX 11T308PR-R 8016		feed [mm.tooth ⁻¹]	0,15 ÷ 0,25	0,15 ÷ 0,19	0,15 ÷ 0,25	–	0,15 ÷ 0,19	0,10 ÷ 0,20
		depth of cut [mm]	1,0 ÷ 9,0	1,0 ÷ 6,8	1,0 ÷ 9,0	–	1,0 ÷ 5,4	0,3 ÷ 1,5
		cutting speed [m.min ⁻¹]	155 ÷ 220	90 ÷ 130	145 ÷ 205	–	30 ÷ 65	30 ÷ 40
ADMX 11T308PR-R 8230		feed [mm.tooth ⁻¹]	0,15 ÷ 0,25	0,15 ÷ 0,19	0,15 ÷ 0,25	–	0,15 ÷ 0,19	0,10 ÷ 0,20
		depth of cut [mm]	1,0 ÷ 9,0	1,0 ÷ 6,8	1,0 ÷ 9,0	–	1,0 ÷ 5,4	0,3 ÷ 1,5
		cutting speed [m.min ⁻¹]	185 ÷ 255	110 ÷ 150	175 ÷ 240	–	35 ÷ 75	35 ÷ 50
ADMX 11T308PR-R 8240		feed [mm.tooth ⁻¹]	0,15 ÷ 0,25	0,15 ÷ 0,19	0,15 ÷ 0,25	–	0,15 ÷ 0,19	–
		depth of cut [mm]	1,0 ÷ 9,0	1,0 ÷ 6,8	1,0 ÷ 9,0	–	1,0 ÷ 5,4	–
		cutting speed [m.min ⁻¹]	165 ÷ 220	95 ÷ 130	155 ÷ 205	–	30 ÷ 65	–
ADEX 11T304FR-FA HF7		feed [mm.tooth ⁻¹]	–	–	–	0,03 ÷ 0,20	–	–
		depth of cut [mm]	–	–	–	0,5 ÷ 9,0	–	–
		cutting speed [m.min ⁻¹]	–	–	–	90 ÷ 505	–	–
ADEX 11T308FR-FA HF7		feed [mm.tooth ⁻¹]	–	–	–	0,03 ÷ 0,20	–	–
		depth of cut [mm]	–	–	–	1,0 ÷ 9,0	–	–
		cutting speed [m.min ⁻¹]	–	–	–	110 ÷ 560	–	–

Wide area of applications of new milling cutters with inserts ADMX11

FACE MILLING currently achieved roughness by geometry F $R_a \leq 0,5 \text{ } [\mu\text{m}]$ 	SHOULDER MILLING areas link-up $x_{\text{max}} \leq 0,03 \text{ } [\text{mm}]$ 	SLOT MILLING achieved roughness $R_a \leq 1,6 \text{ } [\mu\text{m}]$ 	PLUNGE MILLING $a_{\text{emax}} = 4,5 \text{ } [\text{mm}]$ 	PROGRESSIVE PLUNGING $a_{\text{pmax}} = 1,7 \text{ } [\text{mm}]$ 																																																		
RAMPING 	MILLING BY HELICAL INTERPOLATION  <table border="1"> <thead> <tr> <th>Ø cutter</th> <th>α_{max}</th> </tr> </thead> <tbody> <tr><td>ø 16</td><td>13,5°</td></tr> <tr><td>ø 20</td><td>9,0°</td></tr> <tr><td>ø 25</td><td>6,0°</td></tr> <tr><td>ø 32</td><td>5,3°</td></tr> <tr><td>ø 40</td><td>3,8°</td></tr> <tr><td>ø 50</td><td>2,8°</td></tr> <tr><td>ø 63</td><td>1,8°</td></tr> <tr><td>ø 80</td><td>1,6°</td></tr> <tr><td>ø 100</td><td>1,2°</td></tr> </tbody> </table> <table border="1"> <thead> <tr> <th>Ø cutter</th> <th>d_{min}</th> <th>s_{max}</th> <th>d_{max}</th> <th>s_{max}</th> </tr> </thead> <tbody> <tr><td>16</td><td>27</td><td>8,3</td><td>30</td><td>9,0</td></tr> <tr><td>20</td><td>35</td><td>7,5</td><td>38</td><td>9,0</td></tr> <tr><td>25</td><td>45</td><td>6,5</td><td>48</td><td>7,5</td></tr> <tr><td>32</td><td>59</td><td>4,0</td><td>62</td><td>4,5</td></tr> <tr><td>40</td><td>75</td><td>1,5</td><td>78</td><td>2,0</td></tr> </tbody> </table>				Ø cutter	α_{max}	ø 16	13,5°	ø 20	9,0°	ø 25	6,0°	ø 32	5,3°	ø 40	3,8°	ø 50	2,8°	ø 63	1,8°	ø 80	1,6°	ø 100	1,2°	Ø cutter	d_{min}	s_{max}	d_{max}	s_{max}	16	27	8,3	30	9,0	20	35	7,5	38	9,0	25	45	6,5	48	7,5	32	59	4,0	62	4,5	40	75	1,5	78	2,0
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Recommended cutting conditions for new helical cutters with ADMX11 inserts

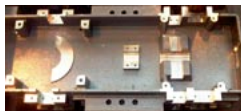
FOR SHOULDER MILLING $a_e < 1/3 D$   $f_z = h_m \cdot \sqrt{\frac{D}{a_e}}$ $h_m = 0,05 - 0,08 \text{ mm}$ a_e - width of machined surface D - cutter diameter Cutting conditions are determined for machined material: C 45, to 200 HB Insert: ADMX 11T308SR-M; 8230 Cutting speed: $v_c = 120 - 220 \text{ m} \cdot \text{min}^{-1}$ (max. cutting speed is limited because of vibration and overheating of cutter body during machining without cooling) Feed: $f_z = 0,15 - 0,35 \text{ mm} \cdot \text{tooth}^{-1}$ (for lower a_e to choose higher feed)	FOR SHOULDER MILLING AND SLOTTING $a_e > 1/3 D$    Cutting conditions are determined for machined material: C 45, to 200 HB Insert: ADMX 11T308SR-M; 8230 Cutting speed: $v_c = 90 - 180 \text{ m} \cdot \text{min}^{-1}$ (max. cutting speed is limited because of vibration and overheating of cutter body during machining without cooling) Feed: $f_z = 0,10 - 0,20 \text{ mm} \cdot \text{tooth}^{-1}$ By slotting is recommended to use cooling medium
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For steel from 200 to 300 HB is recommended to reduce feed and cutting speed by 15%. For stainless steel - group M is recommended to reduce feed and cutting speed by 30%. For steel from 300 to 450 HB is recommended to reduce feed and cutting speed by 30%. For cast iron - group K is possible to increase feed and cutting speed by 20%.

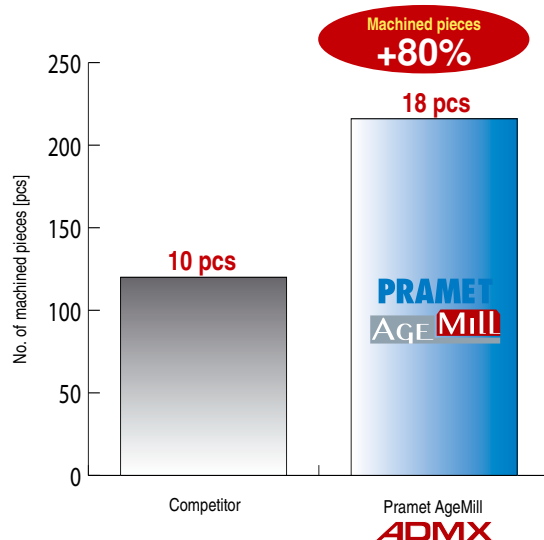
Practical example of milling cutters with inserts ADMX11

EXAMPLE 1:

Machine: Hedelius BC100
 Operation: shoulder milling
 Tool: 40J3R70B40-SAD11E-C
 Machined material: GG25
 Inserts: AONT10T308-MH competitor (K15)
 Cooling: ADMX 11T308SR-M; 8230 Pramet
 with cooling



Cutting conditions		Competitor	Pramet	
Cutting speed	v_c	163	163	m.min ⁻¹
Feed per tooth	f_z	0,25	0,25	mm.teeth ⁻¹
Axial depth of cut	a_p	20	20	mm
Radial depth of cut	a_e	2	2	mm
Material removal rate		120	216	min
No. of machined pieces		10	18	pcs

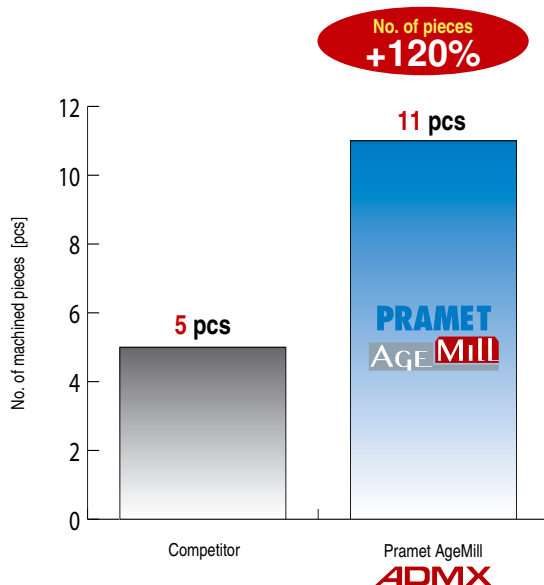


EXAMPLE 2:

Machine: DMU 60P
 Operation: slotting, copy and face milling
 Tool: 25A4R042B25-SAD11E-C
 Machined material: 34CrNiMo6; (40 - 44 HRC)
 Inserts: BDMT 11T308ER-JT competitor (P25)
 Cooling: ADMX 11T308SR-M; 8240 Pramet
 with cooling



Cutting conditions		Competitor	Pramet	
Cutting speed	v_c	100	100	m.min ⁻¹
Feed per tooth	f_z	0,11	0,11	mm.teeth ⁻¹
Axial depth of cut	a_p	3,0	3,0	mm
Radial depth of cut	a_e	15	15	mm
No. of machined pieces	-	5	11	pcs



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