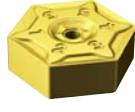


S-60

Face mill 60° for cast iron with double sided hexagonal inserts



KL



KM

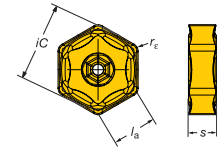


KH

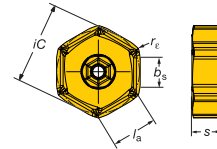


R/L-KW

Insert



Wiper insert



	□	Ordering code	Max a_p , mm, inch	K				Dimensions, mm, inch				
				GC1020M	GC1020	GC1010	GC1020W	iC	s	l_a	r_e	b_s
Light	09	HNEF 09 05 04-KL	6.0 .236	☆	☆	☆	☆	16.20 .638	5.56 .219	9.40 .370	0.4 .016	1.6 .063
	09	HNEF 09 05 08-KM	6.0 .236	☆	☆	☆	☆	16.20 .638	5.56 .219	9.40 .370	0.8 .031	-
Medium	09	HNEF 09 05 16-KH	6.0 .236	☆	☆	☆	☆	16.20 .638	5.56 .219	9.40 .370	1.6 .063	-
	09	HNEF 09 05 08 L-KW	6.0 .236	☆	☆	☆	☆	16.26 .638	5.56 .219	9.38 .369	0.8 .031	5.0 .197
Heavy		HNEF 09 05 08 R-KW	6.0 .236	☆	☆	☆	☆	16.26 .638	5.56 .219	9.38 .369	0.8 .031	5.0 .197

ISO K	MC No.	CMC No.	Material	Specific cutting force k_{c1} N/mm ²	Hardness Brinell HB	mc	K20M	GC1020	GC1010	K20W
							Max chip thickness, h_{ex} mm			
							0.1-0.2-0.3	0.1-0.2-0.3	0.1-0.2-0.3	0.1-0.2-0.3
							Cutting speed v_c , m/min			
			Malleable cast iron							
K1.1.C.NS	07.1		Ferritic (short chipping)	790	130	0.28	255-210-170	205-170-140	225-185-150	225-185-150
	07.2		Pearlitic (long chipping)	900	230	0.28	210-170-140	170-140-115	185-155-125	185-150-125
			Grey cast iron							
K2.1.C.UT	08.1		Low tensile strength	890	180	0.28	275-225-185	225-185-150	245-200-165	245-200-165
K2.2.C.UT	08.2		High tensile strength	1100	245	0.28	220-180-150	180-145-120	195-160-130	195-160-130
			Nodular cast iron							
K3.1.C.UT	09.1		Ferritic	900	160	0.28	175-140-115	140-115-95	155-125-105	155-125-105
K3.3.C.UT	09.2		Pearlitic	1350	250	0.28	160-130-110	130-105-90	145-120-95	140-115-95

Grades for S-60

- 1010 For finishing under stable conditions, wet and dry
- 1020 First choice in Nodular Cast iron, wet and dry
- K20W First choice for milling WET
- K20M First choice for milling DRY