

## Feed per tooth (fz) | d.o.c. (ap)

Material		steel	stainless steel	cast iron	non-ferrous materials	high-temperature alloys	hardened steel
Quality Coating	Feed per tooth   d.o.c.						
K10 polished	f <sub>z</sub> (mm) a <sub>p</sub> (mm)	-	-	-	0,02-1 0,05-1	-	-
K10 PVTi	f <sub>z</sub> (mm) a <sub>p</sub> (mm)	-	0,02-0,4 0,02-0,3	-	0,02-1 0,05-1	0,02-0,1 0,02-0,15	-
M40 PVST	f <sub>z</sub> (mm) a <sub>p</sub> (mm)	-	0,03-0,6 0,05-1	-	-	0,03-0,6 0,05-1	-

## Cutting speed (Vc in m/min)

Material		steel	stainless steel	cast iron	non-ferrous materials	high-temperature alloys	hardened steel
Quality Coating	Application		▽▽		▽▽	▽▽	
K10 polished	roughing finishing	-	-	-	100 450 800 100 450 800	-	-
K10 PVTi	roughing finishing	-	90 120 150 120 150 180	-	100 450 800 100 450 800	35 68 100	-
M40 PVST	roughing finishing	-	80 145 210 120 185 250	-	-	30 60 90 60 90 120	-

▽ major application    ▽ minor application

▽▽ roughing

▽▽ pre-finishing

▽▽ finishing

## Extended operation data

Plunging	
Cutter diam. d1	X <sub>max</sub>
32	0.7

Ramping		
Cutter diam. d1	α°	y
32	<1	26

Helix		
Cutter diam. d1	D <sub>min</sub>	D <sub>max</sub>
32	57	63



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# PRODUCT RANGE EXTENSION FOR HIGH-FEED-CUTTERS **SLOTWORX® HP S**



**Milling cutter body Ø 32 mm with 7 teeth and indexable inserts for milling of aluminium as well as stainless acid- and heat-resistant materials**



- ➔ Milling cutter body Ø 32 mm with 7 teeth for outstanding economical machining
- ➔ Indexable inserts for milling of stainless acid- and heat-resistant materials, quality M40, PVST coating
- ➔ Indexable inserts for milling of aluminium, quality K10, polished
- ➔ Indexable inserts for milling of aluminium-alloys with more than 10 % Si-content, quality K10, PVTi coating

Milling cutter bodies	Catalogue no.	$d_1$	$l$	$r$	$l_3$	$l_2$	$l_1$	$d_2$	$d_3$	$z$	Accessories	Features
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Threaded shank end mill bodies												
	7 32 266	32	6,2	2	32	0.7	-	M 16	29	7	A, B, C, D, E, F	

Accessories					
<p>21 500 P Torx screw A</p>	<p>POKOLM 06 500 P Torx-screwdriver B</p>	<p>TV 04-1, Screwdriver torque Vario®-S with window scale, C</p>	<p>TV 500 Torque Vario®, setter adjusting tool D</p>	<p>T6 500 P Torx interchangeable bit for Torque Vario® E</p>	<p>T6 502 P, Torx MagicSpring compatible bit f. Torque Vario®, F</p>

Indexable inserts	Catalogue no.	DIN Specification	Carbide Grade	Coating				
					$l$	$s$	$r$	M
	02 66 820 R20	XCHT 062220 FN	K10	polished	6.2	2.2	2	M 2.0
	02 66 860 R20	XCHT 062220 FN	K10	PVTi	6.2	2.2	2	M 2.0
	02 66 890 R20	XCHT 062220 EN	M40	PVST	6.2	2.2	2	M 2.0

stock item, subject to confirmation