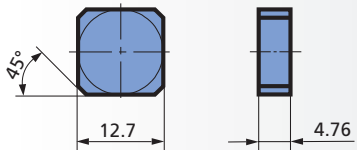



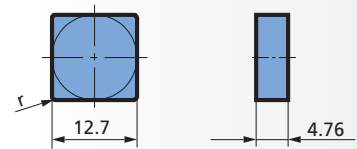



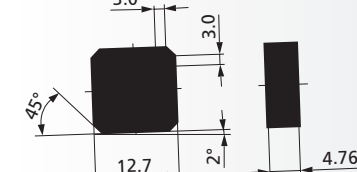



INSERTS FOR MILLING CUTTERS PMK AND PMK S

SPK INNOVATION MILLING

INSERT	ISO	GRADE	SPK-REF.NO.
SNCN 12 04 ZN T 	SNCN 12 04 ZN T00520	SL808 	17.10.409.03.1
	SNCN 12 04 ZN T00520	SL854 C  	17.10.409.03.9
SNGN 12 04 12 T 	SNGN 12 04 12 T01020	SL808 	17.10.058.20.1
	SNGN 12 04 12 T01020	SL858 C  	21.10.058.20.1
SNGN 12 04 ZN T - S 88Z300 	SNGN 12 04 ZN T-S 88Z300	WBN115 	12.12.085.37.1



PMK MILLING CUTTER SERIES

WITH HIGH-SPEED ROUGH MILLING AND FINISHING OF CAST IRON

PMK – HIGH-SPEED ROUGH MILLING AND FINISHING

The PMK face milling cutter system is ideally suited for the rough milling and finishing of GJL (grey cast iron) and GJS (ductile cast iron) materials. These milling cutters work with an approach angle of 88°.

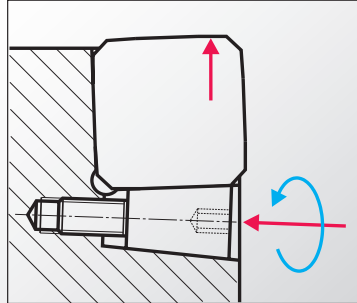


FINISHING OPERATIONS USING PMK

In order to attain outstanding surface qualities during finishing, the PMK series has been fitted with insert seatings that can be set in the Z-direction. This setting option allows users to pre-set the specially-developed broad finishing inserts in the μm range. The inserts in the fixed insert seating take over the cutting work, while, thanks to their slightly elevated position, the finishing inserts can generate surface roughness values of up to 0.5 μm .

The mixed assembly of the milling process – the main work is performed with ceramics, the surface quality with PCBN – facilitates highly productive milling and high feed rate speeds, with outstanding tool lives. The mixed assembly also means that the cutting material can be optimally adapted to the material.

Micro setting



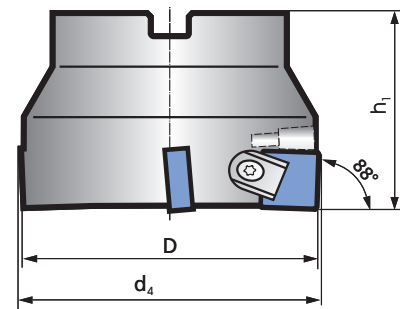
ROUGH MILLING USING PMK

For high-performance rough milling operations using the PMK milling cutter system, the adjustable insert seatings are equipped with roughing inserts and set to the same height as the inserts in the fixed insert seatings. With the appropriate milling cutter diameters, a cutting depth of up to 5 mm at a feed rate of 0.30 mm per tooth can be reliably achieved during rough milling operations.

EASY CHANGE TECHNOLOGY

Thanks to the simple procedure for switching between rough milling and finishing in the milling cutter system, compounded by the high cutting data that can be attained, this high-performance system offers outstanding productivity. It also significantly reduces the production costs for milling.

PMK FACE MILLING CUTTERS



Axial rake angle $\gamma_a = -6^\circ$
Radial rake angle depending on σ : $\lambda_r = -6^\circ$ bis -9°
Dimension table according to DIN 8030

Recommended application

■ GJL (grey cast iron) ■ GJS (ductile cast iron)

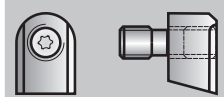
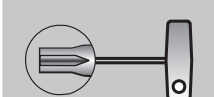
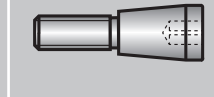
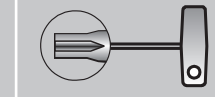
WORKPIECE thin-walled ✗ unstable ✗ stable ✓

$f_z = 0.16 - 0.3$ mm/tooth

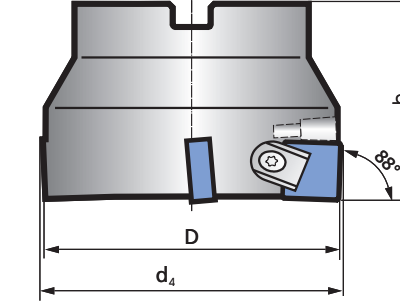
12.5 / 6.3 / 0.5

TYPE	SPK-REF.NO.	DIMENSIONS				
		D	Tooth t	h_1	d_4	$n_{\max}(\text{min}^{-1})$
PMK-050-05SN1288R	771.11.422.04	50	5 (4+1)	40	51	18000
PMK-063-06SN1288R	771.11.423.04	63	6 (5+1)	40	64	13000
PMK-080-08SN1288R	771.11.424.04	80	8 (7+1)	50	81	10000
PMK-100-10SN1288R	771.11.425.04	100	10 (9+1)	50	101	8000
PMK-125-12SN1288R	771.11.426.04	125	12 (10+2)	63	126	8000
PMK-160-14SN1288R	771.11.427.04	160	14 (12+2)	63	161	6000

Spare parts

 70.91.55.583	 Torx 15 70.91.55.220.0	 70.91.50.356.0	 Torx 15 70.91.55.220.0
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PMK FACE MILLING CUTTERS - COARSE PITCH



Axial rake angle $\gamma_a = -6^\circ$
Radial rake angle depending on σ : $\lambda_r = -6^\circ$ bis -9°
Dimension table according to DIN 8030
For thin-walled and unstable parts

Recommended application

■ GJL (grey cast iron) ■ GJS (ductile cast iron)

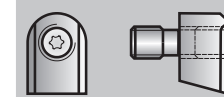
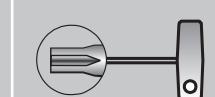
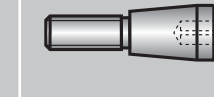
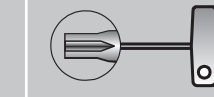
WORKPIECE thin-walled ✓ unstable ✓ stable ✓

$f_z = 0.16 - 0.3$ mm/tooth

12.5 / 6.3 / 0.5

TYPE	SPK-REF.NO.	DIMENSIONS				
		D	Tooth t	h_1	d_4	$n_{\max}(\text{min}^{-1})$
PMK S 080-05SN1288R	778.11.405.04	80	5 (4+1)	50	81	10000
PMK S 100-05SN1288R	778.11.401.04	100	5 (4+1)	50	101	8000
PMK S 125-06SN1288R	778.11.403.04	125	6 (5+1)	63	126	8000
PMK S 160-08SN1288R	778.11.404.04	160	8 (7+1)	63	161	6000

Spare parts

 D = 63 mm - 160 mm 70.91.55.584.0	 Torx 15 70.91.55.220.0	 70.91.50.356.0	 Torx 15 70.91.55.220.0
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