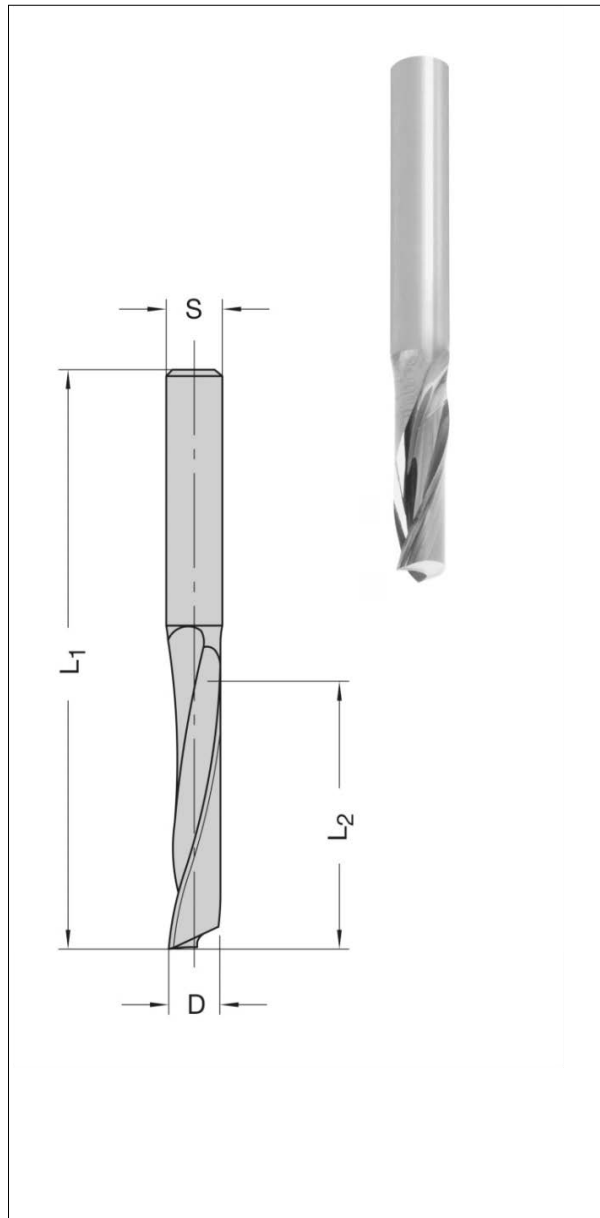


C6 COMPOSITE TOOLING

Thermoplastics Program 2021



C6 Single-tooth finishing cutters Z1 VHW



93103 HW 04

D	L ₂	L ₁	Shank	Order number
2	5	50	6	60003713
4	15	50	6	60003714
6	20	60	6	60003715
8	25	70	8	60003716
10	30	70	10	60003717

93113 HW 08

D	L ₂	L ₁	Shank	Order number
6	20	60	6	60003718
8	25	70	8	60003719

VERSION

Single-edged spiral solid carbide cutters in standard (HW 04) and finest grain carbide quality (HW 08), with special cutting edge geometry for best surface quality. With polished flute and additionally polished flank for good chip transport and exceptionally good milling results. Clockwise rotation - right-hand twist.

USAGE

For the processing (gloss milling, grooving, formatting and cutting) of thermoplastics such as PMMA (acrylic glass), PC (polycarbonate), PE (polyethylene), PP (polypropylene), PS (polystyrene), ABS (acrylonitrile-butadiene-styrene) and PVC (polyvinyl chloride)

Nearly crystal clear surface of the edges to be processed by pre-milling in counter-direction and subsequent finish milling (with low chip removal) in synchronous operation.

RECOMMENDATION FOR USE

Roughing in up-cut

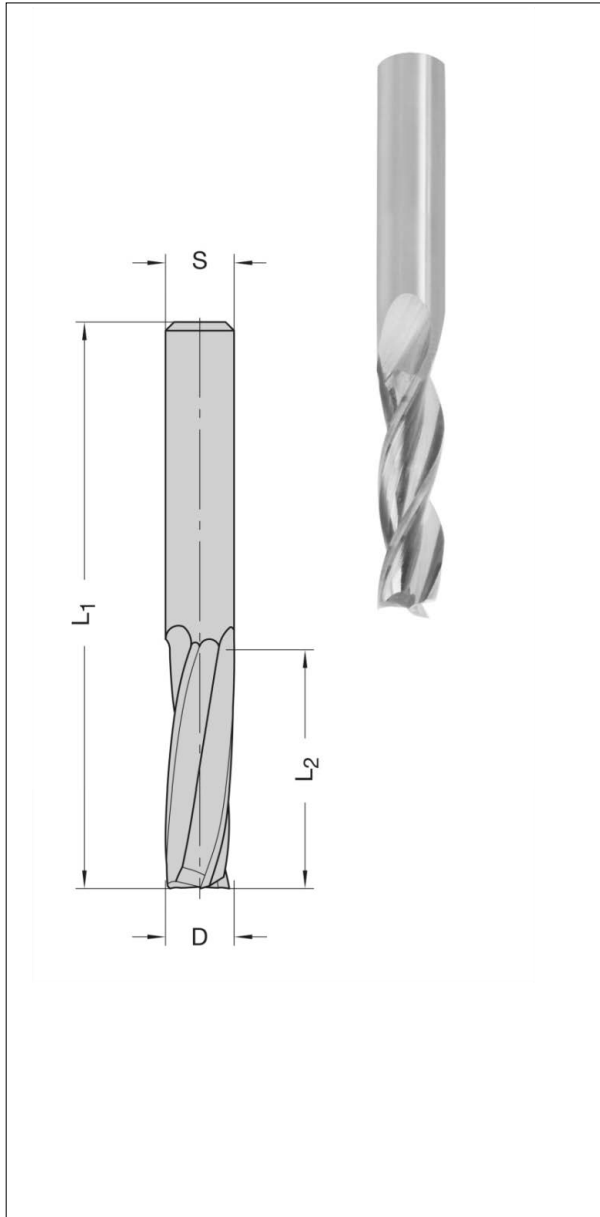
$n = 18\,000 - 24\,000 \text{ min}^{-1}$, feed rate $v_f = 2 - 6 \text{ m/min}$

Finishing in synchronism

$n = 18\,000 - 24\,000 \text{ rpm}$, feed rate $v_f = 0.1 - 0.4 \text{ m/min}$, lateral infeed $a_e = 0.1 \text{ mm} - 0.3 \text{ mm}$

In order to avoid heat formation and possibly white cracking, it is recommended to support the chip removal by compressed air.

C6 Multi-tooth finishing cutters VHW



93303 HW 04 Z3

D	L ₂	L ₁	Shank	Order number
6	20	50	6	60003720

93503 HW 04 Z5

D	L ₂	L ₁	Shank	Order number
8	30	70	8	60003721
10	40	70	10	60003722

VERSION

Single-edged spiral solid carbide cutters in standard (HW 04) and finest grain carbide quality (HW 08), with special cutting edge geometry for best surface quality. With polished flute and additionally polished flank for good chip transport and exceptionally good milling results. Clockwise rotation - right-hand twist.

USAGE

For the processing (gloss milling, grooving, formatting and cutting) of thermoplastics such as PMMA (acrylic glass) PC (polycarbonate), PE (polyethylene), PP (polypropylene), PS (polystyrene), ABS (acrylonitrile butadiene styrene) and PVC (polyvinyl chloride).

Nearly crystal clear surface of the edges to be processed by pre-milling in the counter direction and subsequent Finish milling (with low chip removal) in synchronous operation.

RECOMMENDATION FOR USE

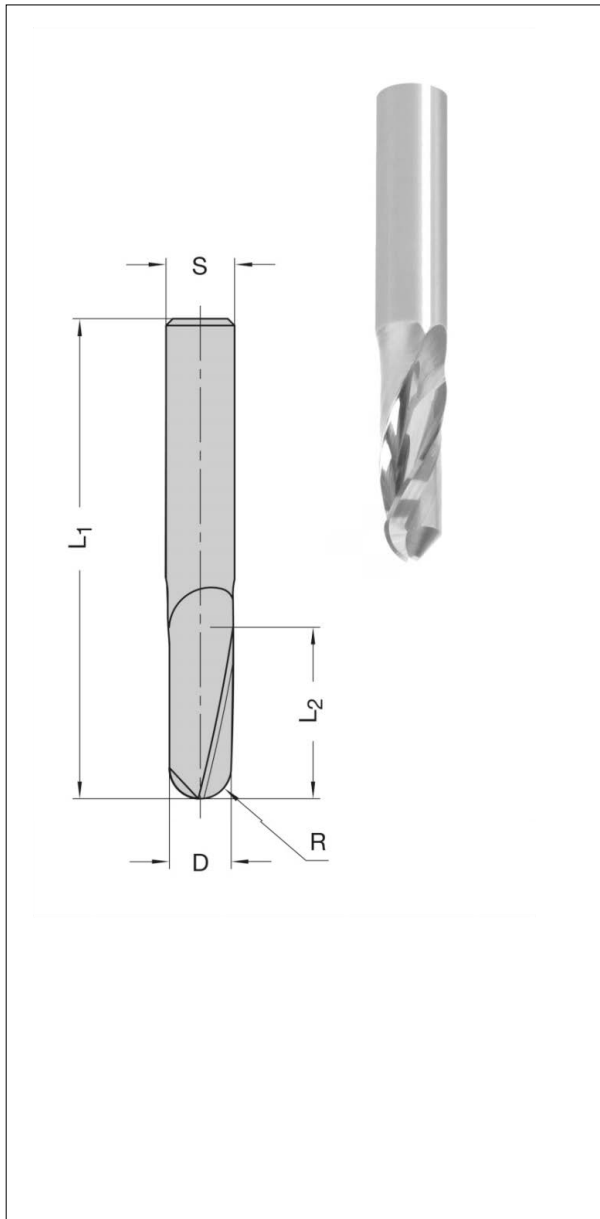
Roughing

n = 18 000 - 24 000 rpm, feed vf = 6 - 10 m/min (Z3) or 8 - 15 m/min (Z5)

Finishing in synchronism

n = 18 000 - 24 000 rpm, feed rate vf = 0.3 - 0.8 m/min, lateral infeed ae = 0.1 - 0.3 mm

C6 Hollow chamfer finishing cutter



93103 HW 04

D	L ₂	R	L ₁	Shank	Order number
2	5	1	50	6	60003723
4	15	2	50	6	60003724
6	20	3	60	6	60003725
8	25	4	70	8	60003726
10	30	5	70	10	60003727

VERSION

Single-edged spiral solid carbide cutters with special cutting edge geometry for best surface quality. With polished flute and additionally polished flank for good chip transport and exceptionally good milling results. Clockwise rotation - right-hand twist.

USAGE

For the processing (font milling, chamfer milling, 3D milling, formatting, cutting and drilling) of Thermoplastics such as PMMA (acrylic glass), PC (polycarbonate), PE (polyethylene), PP (polypropylene), PS (polystyrene), ABS (Acrylonitrile-Butadien-Styrene) and PVC (Polyvinylchloride).

RECOMMENDATION FOR USE

Pre-milling

n = 16 000 - 24 000 min⁻¹, feed rate vf = 2 - 6 m/min

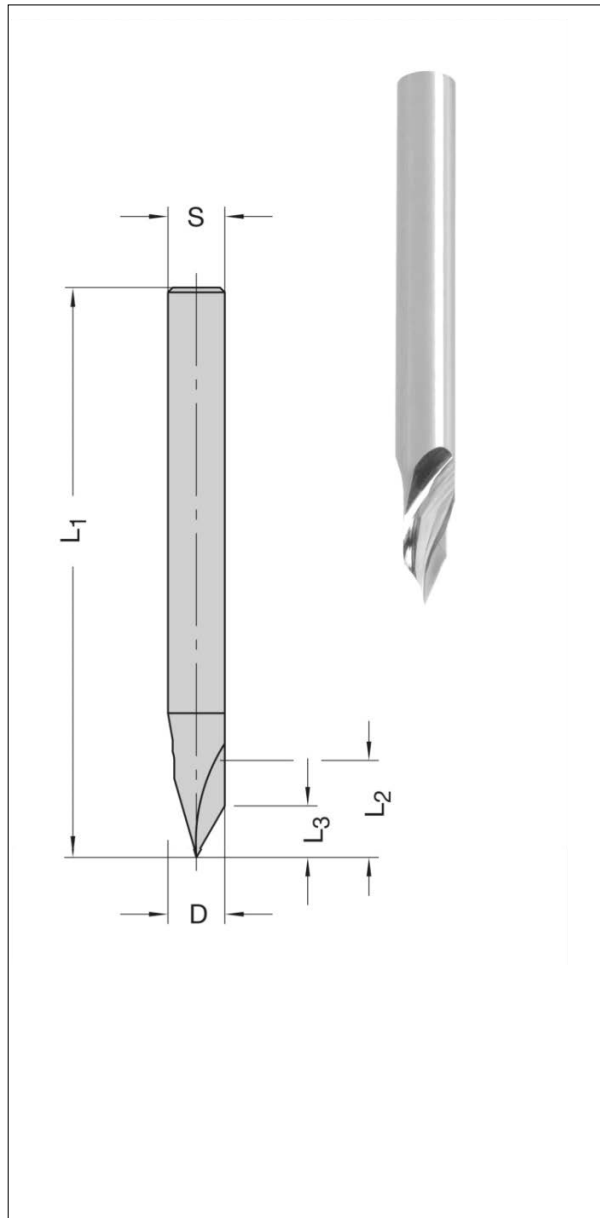
Finish Milling

n = 16 000 - 24 000 min⁻¹, feed rate vf = 0.3 - 0.6 m/min, axial infeed ap = 0.5 - 1.0 mm

Drilling

n = 16 000 - 24 000 rpm, feed rate vf = 0.5 - 1.0 m/min, lateral infeed ae = 0.1 - 0.3 mm

C6 V-groove milling cutter Z1 VHW



96123 HW 04

D	L ₂ / L ₃	Angle	L ₁	Shank	Order number
6	10/5	60°	60	6	60003728
6	10/3	90°	60	6	60003729

VERSION

Single-edged spiral solid carbide cutters with special cutting edge geometry for best surface quality. With polished flute and additionally polished flank for good chip transport and exceptionally good milling results. Clockwise rotation - right-hand twist.

USAGE

For the machining (lettering milling, chamfer milling, 3D milling, formatting, cutting and drilling) of thermoplastics such as PMMA (acrylic glass), PC (polycarbonate), PE (polyethylene), PP (polypropylene), PS (polystyrene), ABS (acrylonitrile butadiene styrene) and PVC (polyvinyl chloride)

RECOMMENDATION FOR USE

Pre-milling

n = 16 000 - 24 000 min⁻¹, feed rate vf = 2 - 6 m/min

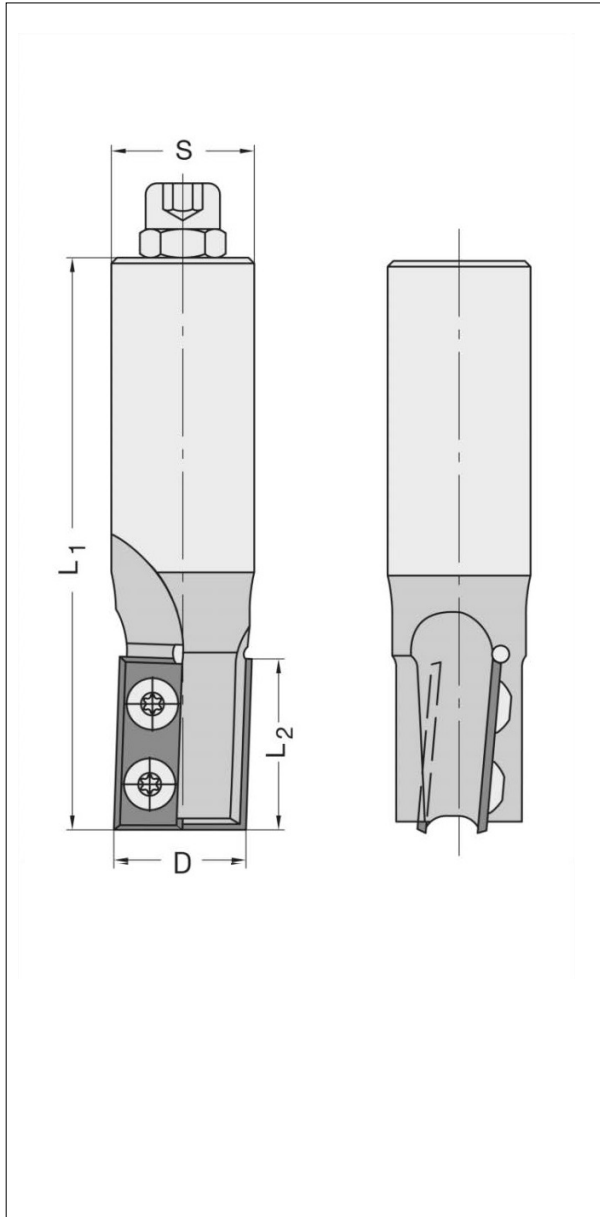
Finish Milling

n = 16 000 - 24 000 min⁻¹, feed rate vf = 0.3 - 0.6 m/min, axial infeed ap = 0.5 - 1.0 mm

Drilling

n = 16 000 - 24 000 rpm, feed rate vf = 0.5 - 1.0 m/min, lateral infeed ae = 0.1 - 0.3 mm

C6 Indexable insert end mills Z2 HW



22007

D	L ₂	L ₁	Shank	Order number
25	30	100	20 x 55 m.E. M 8	60003730
25	30	100	25 x 55 m.E. M 8	60003731

VERSION

Carrying body with two alternating diagonally arranged interchangeable blades HW 22 Special quality in polished VERSION, face and circumference cutting. Screwed to the back of the blade. Without drill-in cutting edge. Clockwise rotation. For mechanical feed.

USAGE

Especially suitable for grooving, joining, formatting, folding of acrylic glass (PMMA), thermoplastics, Makrolon, polycarbonate (PC), polyethylene (PE), polypropylene (PP).

Accessories / spare parts		Packaging units	Order number
HW-Changer Blades	30x12x1.5 / 4-sided HW 22	10	60003732
Torx clamping screw	M 4 x 5.9 large head, T15	10	60003733
Torx clamping screw	T15, handle key	1	60003734