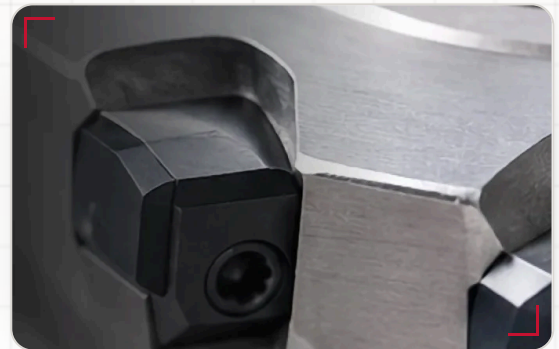
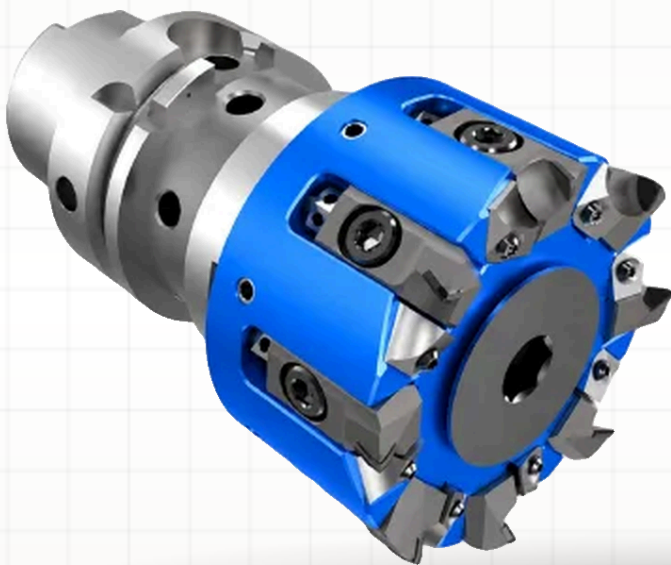


PRODUCT DATASHEET

PCD CARTRIDGES FOR FACE MILL CUTTERS



FINISHING

FACING

CORNER MILLING

HSC OPERATIONS

BALANCED TO DIN
69888

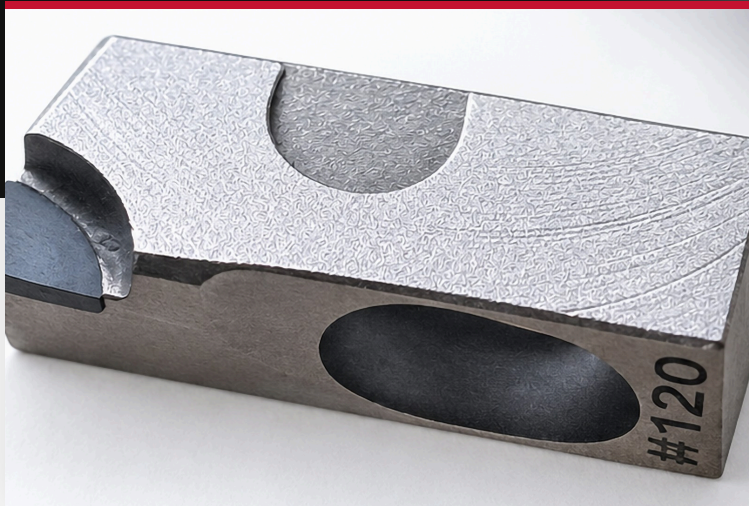
— FACE MILLING · HSC OPERATIONS

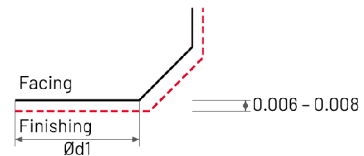
PCD Cartridges For Face Mill Cutters

FINISHING

FACING

CORNER MILLING

HSC

 COMBINATION FINISHING & FACING
 SETUP

0.006 – 0.008 mm


High-precision PCD cartridges

Polycrystalline diamond cutting edges for finishing, facing and corner milling.



Internal coolant supply

Coolant routed through the body directly to each cutting edge.



Precision balancing to DIN 69888

Balanced for stable running at HSC spindle speeds.



Axial run-out adjustment

Each cartridge is set axially to micron level.



Secure clamping and adjusting screws

Cartridges are positively clamped and individually adjustable.



Lightweight aluminium-alloy body

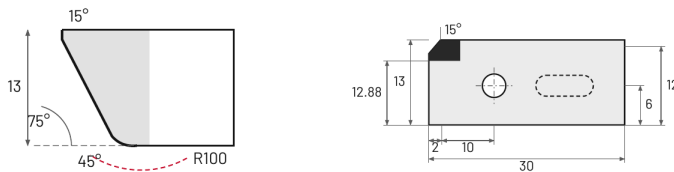
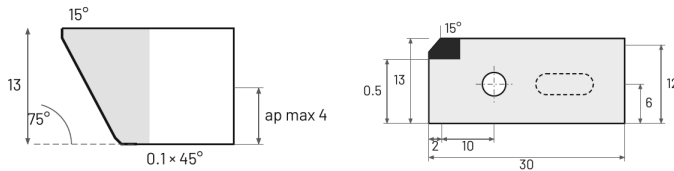
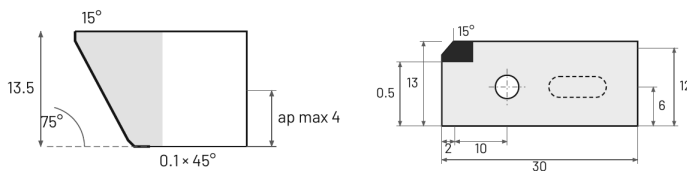
Low mass for high spindle speeds. Ø63 mm body in steel.

**PREMIUM PCD
MATERIAL**
**HIGH WEAR
RESISTANCE**
**CONSISTENT
PERFORMANCE**
**PRECISION ·
STABILITY · SURFACE
FINISH**

TECHNICAL DATA

PCD Finishing, Facing & Corner Milling Cartridges for HSC

All dimensions in mm
 Drawings schematic, not to scale

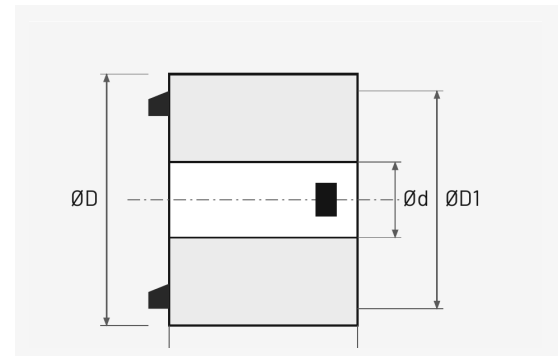
CARTRIDGES
TYPE A Wiper radius R100 · 45° lead

TYPE B 0.1 × 45° corner chamfer · ap max 4 mm

TYPE C 0.1 × 45° corner chamfer · ap max 4 mm

SPINDLE & CUTTING SPEEDS

Diameter Ø mm	Spindle speed max. min ⁻¹	Cutting speed max. m/min
63	20,000	3,960
80	24,360	6,120
100	21,650	6,800

$v_c = \pi \cdot D \cdot n / 1000$, rounded to 10 m/min. Permissible maximums; verify against tool, machine and workpiece conditions.

BASIC BODY

Dimensions to DIN 8030



Basic body supplied with: balancing screws and clamping screws fitted. Cartridges not included.

Cartridges supplied: without clamping screws.

ORDERING EXAMPLES

Corner mill, complete tool Ø63 mm, Z = 3

1 × basic body · 3 × corner cartridge

ORDER EXAMPLE

**Face milling cutter
 Ø80 mm, Z = 5**

1 × basic body

4 × facing cartridge

1 × finishing cartridge

Technical data are for guidance and subject to change without notice. Performance depends on machine, clamping, coolant and workpiece material. Special geometries and diameters available on request.

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