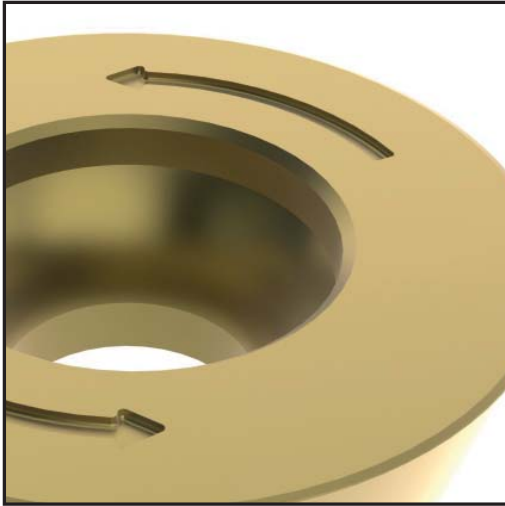

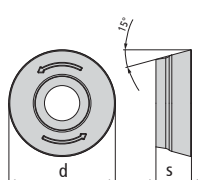


NEW ROUND INSERTS FOR STEEL MACHINING



- ⊕ new reference for roughing tool steels with medium strength (up to 1.100 N/mm²)
- ⊕ highest process reliability at extreme high feed rates with medium to big depth of cut
- ⊕ excellent performance at cutting speeds from 150 up to 180 m/min
- ⊕ designed for machining with long overhang and heavy interrupted conditions.
- ⊕ extra thick [8µm] and wear resistant PVD coating, brand name „PVGO“
- ⊕ Video clip: round inserts for steel machining in action: 

Indexable insert	Catalogue no.	ISO Standard	Carbide Grade	Coating				
					d	s	r	M
	02 10 846	RDMX1003M0 SN	P 40	PVGO	10	3,18	5	M 3,5
	03 12 846K	RDMX12T3M0 SN	P 40	PVGO	12	3,97	6	M 3,5

Pokolm milling cutter bodies for round inserts

A wide range of different diameters for round inserts alone, plus numerous additional geometries and sizes – combined with two different rake angles in our milling cutter bodies – provide optimum cutting conditions for almost every application you can think of.

The patent-protected, specially developed insert seats in our milling cutter bodies absorb all axial and radial milling forces, because the insert is not only fixed with a Torx® screw, it is also supported by being embedded into the cutter body. Compared to open insert seats, our incorporated insert seats allow stronger teeth, clearly improving the rigidity of our milling cutters. This results in longer tool life and allows higher feed rates. Additional double clamps provide excellent support, even under extreme cutting conditions.

Our chip spaces were specially designed for exceptionally easy chip flow, thus protecting both body and workpiece from damage. Specially selected materials and extra-hard coatings offer higher tensile strength and heat resistance, making Pokolm tools and arbor systems unbeatable in durability and long-life-cycles.



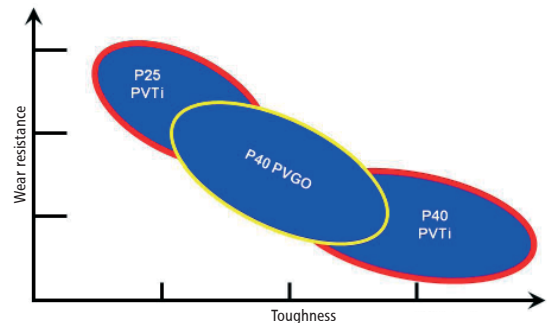
TECHNICAL INFORMATION

Cutting speed V_c in m/min | Feed per tooth (f_z) | d.o.c. (a_p)

Material	Application	Insert radius		Machining rates	P40 PVGO	Feed per tooth (f_z) d.o.c. (a_p)	
		5	10			P40 PVGO	P40 PVGO
Steel		5	10	roughing	120-200	f_z (mm)	0.2 - 1.0
				finishing	200-350	a_p (mm)	0.15 - 1.5
Cast iron		5	10	roughing	100-200	f_z (mm)	0.2 - 0.8
				finishing	200-350	a_p (mm)	0.15 - 1.2
Steel		6	12	roughing	120-200	f_z (mm)	0.25 - 1.0
				finishing	200-350	a_p (mm)	0.2 - 2.0
Cast iron		6	12	roughing	100-200	f_z (mm)	0.25 - 0.8
				finishing	200-350	a_p (mm)	0.2 - 1.8

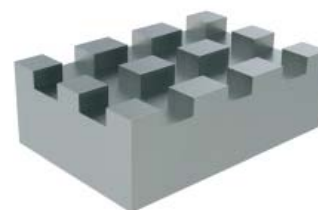
Application field - PVD coated milling grades

Carbide Grade Coating	Description	Application area
P25 PVTi	850	Stable conditions at high feed rates.
P40 PVGO	846	Dry machining in all conditions. Special at high feed rates and interrupt cut.
P40 PVTi	840	Weak materials at medium cutting speeds and high feed rates.

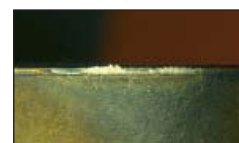


Random test - heavy interrupted

	Pokolm 03 12 846K	Competitive product
Component	400 x 300 x 150 mm	400 x 300 x 150 mm
Material	1,2312	1,2312
Cutter body	52 310/7	52 mm diam.
Arbor	50 22 710	50 22 710
ISO Standard	RDMX12T3M0 SN	RDMW12T3M0 SN
V_c (speed)	155 m/min	155 m/min
V_f (feed rate)	3500 mm/min	3500 mm/min
Machining time	120 min	120 min
Life length	420 mm	420 mm
Chip volume	109 cm ³ /min	109 cm ³ /min



Wear pattern



Pokolm 03 12 846K

Competitive product

A direct comparison confirms considerable lower wear of the Pokolm indexable round inserts.

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