

# TECHNICAL INFORMATION

Cutting speed  $V_c$  in m/min

Material	Application	Insert radius	l	Machining rates		
				HSC05 PVTi	HSC05 PVTiH	
Steel		1,4	10	roughing	120-200	120-200
				finishing	200-350	200-350
Cast iron		1,4	10	roughing	100-200	100-200
				finishing	200-350	200-350
Hardened steel		1,4	10	roughing	35-150	35-150
				finishing	150-250	150-250

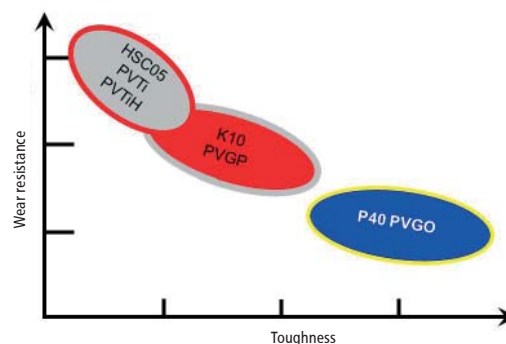
Feed per tooth ( $f_z$ ) | d.o.c. ( $a_p$ )

Material	Insert	Insert radius	l	feed per tooth ( $f_z$ ) d.o.c. ( $a_p$ )		HSC05 PVTi	HSC05 PVTiH
				$f_z$ (mm)	$a_p$ (mm)		
Steel		1.4	10	$f_z$ (mm)	0.5 - 1.6	0.5 - 1.6	
				$a_p$ (mm)	0.15 - 0.7	0.15 - 0.7	
Cast iron		1.4	10	$f_z$ (mm)	0.5 - 1.8	0.5 - 1.8	
				$a_p$ (mm)	0.15 - 0.7	0.15 - 0.7	
Hardened steel	1.4	10	$f_z$ (mm)	0.3 - 1.0	0.3 - 1.0		
			$a_p$ (mm)	0.1 - 0.5	0.1 - 0.5		

## Application area

Carbide Grade   Coating	Description	Application area
HSC 05 PVTi / PVTiH	835 / 836	DRY machining at high cutting speeds in all conditions.
K10 PVGP	862	DRY machining, roughing up to 54 HRC, stable conditions.
P40 PVGO	848	Soft steels at medium cutting speeds and high feed rates.

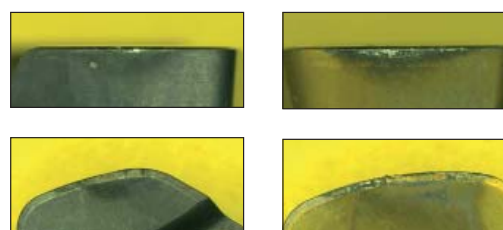
Insert 04 67 836 HF highly recommended for milling 1,2714 and other die steels such as warm work steel like 1,2343.



## Random test, strategy: one-way, climb milling

	Pokolm 04 67 835 HF	Competitive product
Component	120 x 120 x 80 mm	120 x 120 x 80 mm
Material	1,2343 53 HRC	1,2343 53 HRC
Cutter body	3 20 267	20 mm diam.
Arbor	50 10 A63	50 10 A63
ISO Standard	XDEW 10T3 SR	EPNW 0603TN-R08
$V_c$ (speed)	150 m/min	120 m/min
$V_f$ (feed rate)	7200 mm/min	5760 mm/min
Machining time	17 min	16.67 min
Life length	128.4 m	96 m
Chip volume	27 cm <sup>3</sup> /min	21.6 cm <sup>3</sup> /min

### Wear pattern



Pokolm 04 67 835 HF

Competitive product

A direct comparison confirms considerable lower wear of the Pokolm inserts and simultaneously 30 % higher metal removal rates.

## Pokolm Frästechnik GmbH & Co. KG

Adam-Opel-Straße 5  
D-33428 Harsewinkel  
Germany

fon: +49 5247 9361-0  
fax: +49 5247 9361-99

e-mail: info@pokolm.com  
internet: www.pokolm.com



# NEW SLOTWORX® „M“ HIGH FEED INSERTS



- ➔ for HighFeed machining of hardened materials up to 62 HRC
- ➔ fits into all SLOTWORX® „M“ milling cutter bodies
- ➔ PVTiH carbide grade and coating particularly suitable for machining silicon alloyed materials like 1.2714
- ➔ extremely long durability and very smooth running due to optimized cutting edge geometry
- ➔ Video clip: High Feed inserts with a SLOTWORX® „M“ milling cutter body in action



Indexable insert	Catalogue no.	ISO Standard	Carbide Grade	Coating				
					l	q	r	M
	04 67 835 HF	XDEW 10T3 SR	HSC 05	PVTi	10	3,59	1,4	M 2,5
	04 67 836 HF	XDEW 10T3 SR	HSC 05	PVTiH	10	3,59	1,4	M 2,5

## Milling cutter bodies SLOTWORX® „M“

Milling cutter bodies of the Slotworx® „M“ range are equipped with a maximum number of inserts for multifunctional use. Exceptionally precision-manufactured cutter bodies guarantee excellent milling results. Optimum coolant supply direct to the cutting edges avoids any chip built-up on the insert's cutting face and it ensures maximum process reliability and secure chip removal, also in difficult materials.

The Slotworx® „M“-range is available with threaded shanks, straight shank, shell type milling cutters and with our patent protected DuoPlug®-system for highest concentricity and maximum rigidity. Milling cutters with straight shank provide a flexible but cost-efficient solution for roughing.



DuoPlug®



Screw-on type



Straight shank



Shell type