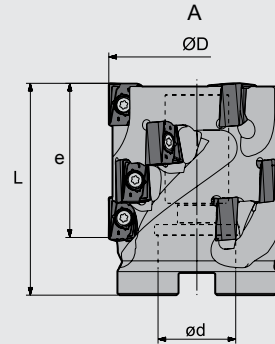


Square Shoulder Milling Tools · Eckfräser

Kr:90°



EMP13 P K









■ Specification of tools · Werkzeug Beschreibung

Type Typ	Stock Lager		Dimension (mm) Abmessung				No. of flutes Zähne	No. of inserts	Mounting style	Weight Gewicht (kg)
	R	L	ØD	Ød	L	e				
EMP13	-050X43-A22-AN11-03	○	50	22	60	43	3	12	A	0.52
	-063X65-A27-AN11-04	○	63	27	80	64	4	24	A	1.15
	-063X53-A27-AN15-03	○	63	27	75	53	3	12	A	1.14
	-080X56-A32-AN15-04	○	80	32	75	53	4	16	A	1.82

● Ex stock / ab Lager ○ On demand / auf Anfrage

■ Spare Parts · Ersatzteile

Diameter Durchmesser Ø D	Insert WSP	Screw Schraube	Drehmoment Torque	Wrench Schlüssel
Ø50-Ø63	 ANGX110504PNR-GM	 I60M3X9	2 Nm	 WT09IS
Ø63-Ø80	 ANGX150608PNR-GM	 I60M4X12	3 Nm	 WT15IS

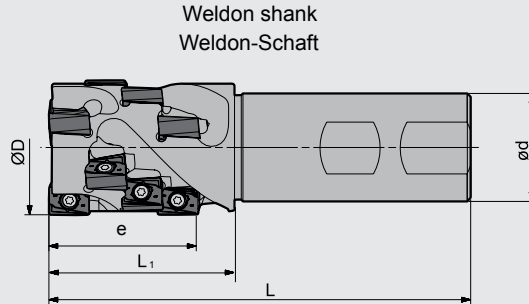


Square Shoulder Milling Tools · Eckfräser

Kr:90°



EMP13 **P** **K**









■ Specification of tools · Werkzeug Beschreibung

Type Typ	Stock Lager	Dimension (mm) Abmessung						No. of flutes Zähne	No. of inserts Aufnahme	Weight Gewicht (kg)
		R	L	ØD	Ød	L	L ₁			
EMP13	○		32	32	115	48	43	2	8	0.61
	○		40	32	125	55	43	3	12	0.79
	○		40	32	115	55	40	2	6	0.79
	○		50	40	145	70	53	2	8	1.53

● Ex stock / ab Lager ○ On demand / auf Anfrage

■ Spare Parts · Ersatzteile

Diameter Durchmesser Ø D	Insert WSP	Screw Schraube	Drehmoment Torque	Wrench Schlüssel
Ø32-Ø40	 ANGX110504PNR-GM	 I60M3X9	2 Nm	 WT09IS
Ø40-Ø50	 ANGX150608PNR-GM	 I60M4X12	3 Nm	 WT15IS

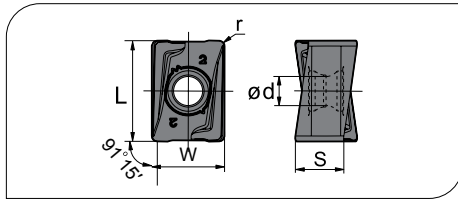


We recommend to use torque wrenches · Wir empfehlen den Einsatz von Drehmomentschlüsseln

Milling · Fräsen

Indexable Milling Tools · Wendeschneidplattenfräser

Applicable inserts · Wendeschneidplatten



- Ideal Machining Condition / Gute Bearbeitungsbedingungen
- Normal Machining Condition / Normale Bearbeitungsbedingungen
- Unfavorable Machining Condition / Ungünstige Bearbeitungsbedingungen

Workpiece Material / Werkstoff	P	M	K	N	S	YBC301	YBC302	YBC401	YBM251	YBM253	YBM351	YBD152	YBD252	YBG102	YBG202	YBG205	YBG302	YBG152	YBG252	YNG151	YNG151C	YC30S	YD101	YD201
P Steel / Stahl	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●
M Stainless Steel / Rostfreier Stahl	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●
K Cast iron / Gusseisen	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●
N Non-ferrous material / Ne Metalle	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●
S Heat-resistant steel / Warmfester Stahl	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●

Insert shape / Plattenform	Type / Typ	Dimension (mm) / Abmessung					CVD Coating / CVD Beschicht.						PVD Coating / PVD Beschicht.				Cermet / Cermet	Carbide uncoat. / unbe. Hartmetall									
		L	W	S	Ø d	r	YBC301	YBC302	YBC401	YBM251	YBM253	YBM351	YBD152	YBD252	YBG102	YBG202		YBG205	YBG302	YBG152	YBG252	YNG151	YNG151C	YC30S	YD101	YD201	
	ANGX110504PNR-GM	11.85	8.4	5.7	3.5	0.8					●		●				●										
	ANGX110508PNR-GM	11.85	8.4	5.7	3.5	0.4					●		●				●										
	ANGX150608PNR-GM	15.43	11.0	7.3	4.4	0.8					●		●				●										
	ANGX150616PNR-GM	15.43	11.0	7.3	4.4	1.6					●		●				●										

Recommended cutting data · Empfohlene Schnittdaten

Workpiece material / Werkstückstoff	Hardness HB / Härte	Grade / Sorte	Cutting data / Schnittdaten		
			V (m/min)	f (mm/z)	a _p max
P Low-carbon steel / Soft steel / Niedriglegierter Kohlenstoffstahl	≤180	YBM253	270 (220-350)	0.25 (0.1-0.4)	11.2 (AN11) 14.5 (AN15)
		YBG205			
Alloy tool steel / Leg. Werkzeugstahl	180-350	YBM253	240 (180-320)	0.2 (0.1-0.4)	
		YBG205			
M Stainless steel / Rostfreier Stahl	≤270	YBM253	230 (180-300) 160 (110-270)	0.15 (0.1-0.3)	
		YBG205			
K Cast iron / Gusseisen	180-250	YBD152	270 (150-300)	0.25 (0.1-0.4)	

Mounting double side inserts:

Montage von doppelseitigen Wendeschneidplatten bei Fräsen:



Please make sure that the faces with same marks are in the same direction.

Bitte stellen Sie sicher, dass die Platten mit derselben Markierung in dieselbe Richtung angebracht werden.