

## **Chamfering milling cutters with spiral-fluted cutting edges**

- fast, cost-effective production of large chamfers
- soft cut for soft and tough materials
- optimum surface finish qualities in one cut

## **SpyroTec 90° Chamfering milling cutters**

# SpyroTec

THE SPIRAL-FLUTED 90° CHAMFERING MILLING CUTTER,  
5 CUTTING EDGES

**Face cutting** for use of the full cutting edge length up to the base of components.

**5 different spiral angles (20°-24°)** and an **uneven cutting edge spacing** reliably reduce vibrations.

The **spiral cutting edge geometry with a positive rake angle** ensures a smooth cutting and optimum surface finish with large chamfers.

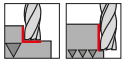
The combination of robust **finest grain carbide and TiAlN coating** results in a long tool life.

Ratio®





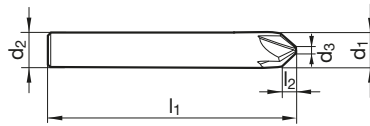
90° Chamfering milling cutters, spiral-fluted



P	•
M	•
K	○
N	•
S	•
H	

- face cutting
- without centre cutting

Tool material	Solid carbide	
Surface	A	A
Type	N	N
Shank form	HA	HB
	NEW	NEW



						Article no.	6992	6993
d1 js9	d2 h6	d3	l1	l2	Z	Code no.		
mm	mm	mm	mm	mm				
6.000	6.000	1.500	57.000	2.250	5	6.000		
8.000	8.000	2.000	63.000	3.000	5	8.000		
10.000	10.000	2.500	72.000	3.750	5	10.000		
12.000	12.000	3.000	83.000	4.500	5	12.000		
16.000	16.000	4.000	92.000	6.000	5	16.000		
20.000	20.000	5.000	104.000	7.500	5	20.000		

ISO	Hardness	v <sub>c</sub>	f <sub>z</sub> (mm/z) / Ø							v <sub>c</sub>	f <sub>z</sub> (mm/z) / Ø						
			3	6	8	10	12	16	20		3	6	8	10	12	16	20
P	≤ 850 N/mm <sup>2</sup>	192	0,018	0,036	0,048	0,06	0,08	0,10	0,13	250	0,030	0,060	0,080	0,11	0,13	0,17	0,21
	≥ 850 N/mm <sup>2</sup>	140	0,016	0,032	0,042	0,06	0,07	0,09	0,12		180	0,026	0,053	0,070	0,10	0,12	0,16
M	≤ 750 N/mm <sup>2</sup>	120	0,013	0,025	0,034	0,05	0,05	0,07	0,09	160	0,021	0,042	0,056	0,08	0,09	0,12	0,15
	≥ 750 N/mm <sup>2</sup>	80	0,009	0,019	0,025	0,04	0,04	0,06	0,07		100	0,016	0,032	0,042	0,06	0,07	0,10
K	≤ 240 HB	170	0,017	0,033	0,044	0,06	0,07	0,09	0,12	230	0,028	0,056	0,074	0,10	0,12	0,16	0,20
N	≥ 7 % Si	250	0,023	0,047	0,062	0,08	0,10	0,13	0,17	330	0,039	0,078	0,104	0,14	0,17	0,22	0,28



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