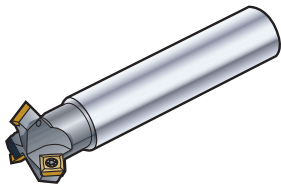
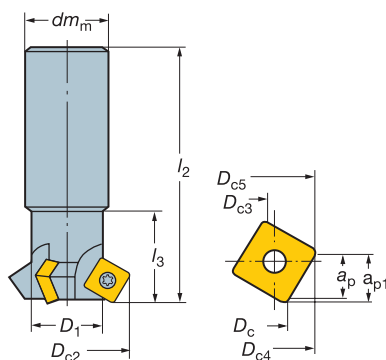


U-Max® chamfering endmill

Diameter 11.7-36.5 mm Negative rake



Cylindrical



l_1 = programming length

Entering angle κ_r	D_c mm	Ordering code	Pitch		Dimensions, mm												
			Even pitch	Differential pitch	D_1	D_{c2}	D_{c3}	D_{c4}	l_2	l_3	dm_m	Max a_p	Max a_{p1}	$n_{max}^{(2)}$			
12	45	Cylindrical shank															
		R215.64-12A20-4512	1	-	19.4	27.1		26.7	175	37.8	20	7.9	8.1	25845			
	32.5	R215.64-32A32-4512	3	-	31.4	48.6		48.2	175	36	32	7.9	8.1	9385			
	60	11.7	R215.64-12A20-6012	1	-	19.4	27.1		26.7	175	37.8	20	9.6	10.0	25200		
36.5		R215.64-36A32-6012	3	-	27.2	47.8	27.79	47.6	175	36	32	9.6	10.0	8855			

1) Inserts are ordered separately.

2) n_{max} (max. rev/min) for holders must also be considered.

Ordering example: 2 pieces R215.64-12A20-4512

- = Even pitch
- = Differential pitch

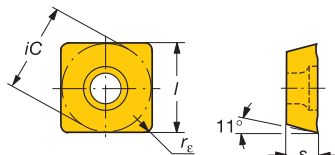
Inserts for U-MAX chamfering endmill



SPMT -WL



SPMT -WH



Maximum chamfer size

U-MAX 45°



U-MAX 60°



Ordering code	Dimensions, mm				
	ic	l	s	r_e	
12	12.7	12.7	4.76	0.8	
	12.7	12.7	4.76	0.8	

Ordering example: 10 pieces SPMT 12 04 08-WL



D129



G3



D2



D154

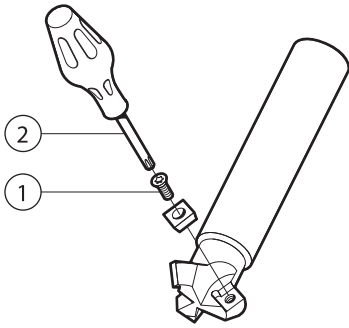


GC

D172

Spare parts for U-Max chamfering endmill

R215.64



Cutter	1	2			
	Insert screw	Key (Torx Plus)	Torque value (Nm)	Torque wrench	Molykote
D_c mm					
R215.64- 12 38	5513 020-29	5680 042-02 (15IP)	3.0	5680 100-06 ¹⁾	5683 010-01

1) Accessories, must be ordered separately

Ordering example: 10 pieces 5513 020-29

A

General Turning

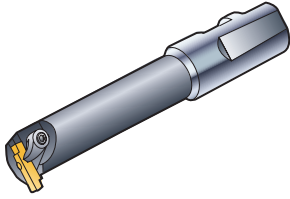
MILLING T-Max® grooving cutter

T-Max grooving cutter, single edge

Insert width 3 mm Positive rake

B

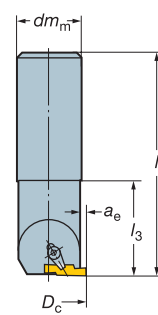
Parting and Grooving



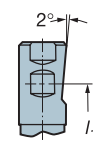
C

Threading

Cylindrical



Weldon/Whistle Notch

 l_1 = programming length

D

Dimensions, mm									
	D_c mm	Ordering code			l_1	l_2	l_3	dm_m	a_e max.
Cylindrical shank									
03	21.5	R331.91-022-3-018	1	0.3		134.6	30	18	1.6
	32	R331.91-032-3-028	1	1.0		174.6	40	28	1.85
Weldon/Whistle Notch									
03	21.5	R331.91-022-3-520	1	0.3	110.1		84.6	20	1.6
	32	R331.91-032-3-532	1	1.0	138.6		114.6	32	1.85

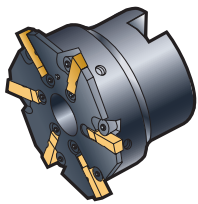
Ordering example: 2 pieces R331.91-022-3-018

Milling

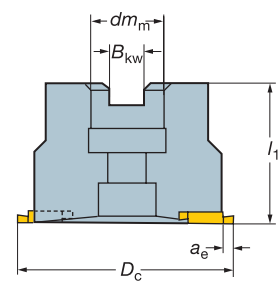
T-Max grooving cutter, multi edge

E

Drilling



Arbor

 l_1 = programming length

F

Boring

Dimensions, mm									
	D_c mm	Ordering code			l_1	B_{KW}	dm_m	a_e max.	
Arbor									
03	63	R331.91-063-3	5	0.6	40	10.4	22	3.8	
05	80	R331.91-080-5	6	1.0	50	12.4	27	5.8	

Ordering example: 2 pieces R331.91-063-3

G

Toolholding Systems

H

Multi-Task Machining

I

General Information



D131



D131



G3

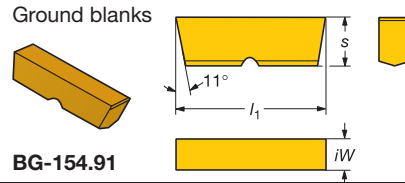
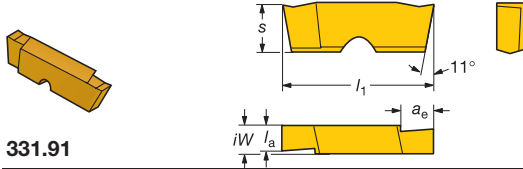


D2

D 130

Inserts for T-Max grooving cutter

R331.91



Insert size	Ordering code	Material						Dimensions, mm							
		P	M	K	N	S									
		S6	SM30	S6	SM30	H13A	H13A	H13A							
									<i>iW</i>	<i>l</i> ₁	<i>s</i>	<i>l</i> _a	<i>a</i> _e max.	<i>a</i> _e Rec.	
3	A331.91-3A105-1	☆	☆	☆	☆	☆	☆	☆	3.1	16	5.26	1.1	2.1	0.4	
	331.91-3110-1	☆	☆	☆	☆	☆	☆	☆	3.1	16	5.26	1.3	2.3	0.5	
	331.91-3130-1	☆	☆	☆	☆	☆	☆	☆	3.1	16	5.26	1.6	2.6	1	
	331.91-3160-1	☆	☆	☆	☆	☆	☆	☆	3.1	16	5.26	1.85	2.9	1.25	
	331.91-3185-1	☆	☆	☆	☆	☆	☆	☆	3.1	16	5.26	2.15	3.2	1.5	
	331.91-3215-1	☆	☆	☆	☆	☆	☆	☆	3.1	16	5.26	2.65	3.7	1.8	
	331.91-3265-1	☆	☆	☆	☆	☆	☆	☆	3.1	16	5.26	3	4	1.8	
	331.91-3300-1	☆	☆	☆	☆	☆	☆	☆	3.1	16	5.26	3	4	1.8	
5	331.91-5315-1	☆	☆	☆	☆	☆	☆	☆	5.1	22	6.26	3.15	4.2	1.8	
	331.91-5415-1	☆	☆	☆	☆	☆	☆	☆	5.1	22	6.26	4.15	4.2	2.5	
	331.91-5500-1	☆	☆	☆	☆	☆	☆	☆	5.1	22	6.26	5	6	4	

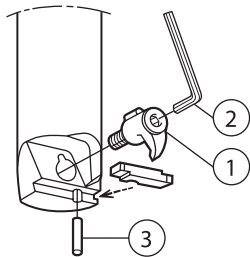
Ordering example: 10 pieces 331.91-3110-1 SM30

Note!

For grade description, see page D172.

Spare parts for T-Max grooving cutters, single edge

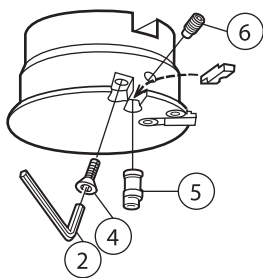
Single edge



Cutter	1	2	3	4	5	6
<i>D</i> _c mm	Clamp set	Key (mm)	Parallel pin	Clamping screw	Eccentric	Locking screw
R331.91- 21.5 - 32	174.9-831-2	174.1-863 (2.5)	3111 020-405	-	-	-

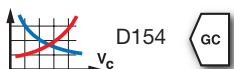
Ordering example: 10 pieces 174.9-831-2

Multi edge



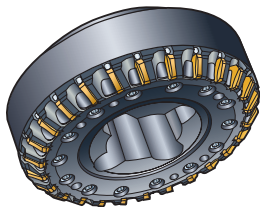
Cutter	1	2	3	4	5	6
<i>D</i> _c mm	Clamp set	Key (mm)	Parallel pin	Clamping screw	Eccentric	Locking screw
R331.91- 63 - 80	-	174.1-863 (2.5)	-	5513 018-01	5333 012-01	3214 020-307

Ordering example: 10 pieces 171.9-831-2



Sandvik AUTO

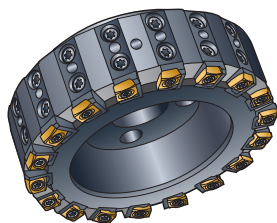
Sandvik AUTO – Roughing



R/L260.3
R/L260.31
Negative rake
Diameter 80 - 500 mm
Page D133



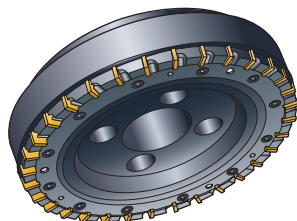
AUTO-AF –Finishing



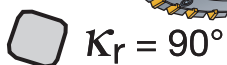
R/L260.8
R/L260.82
Sandvik AUTO -AF adjustable cutter for facemilling
Positive rake
Diameter 80 - 500 mm
Page D136



AUTO-FS – Finishing



R/L260.4
R/L260.42
Negative rake
Diameter 125 – 500 mm
Page D139



Cylinder boring



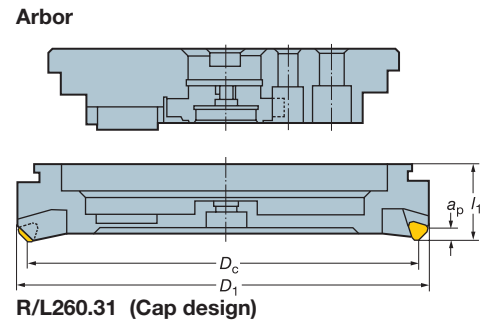
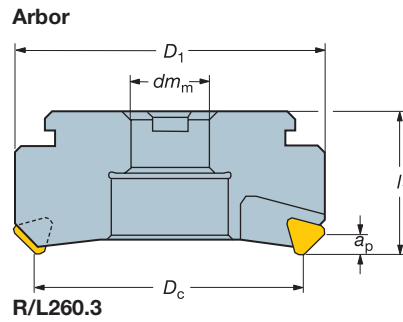
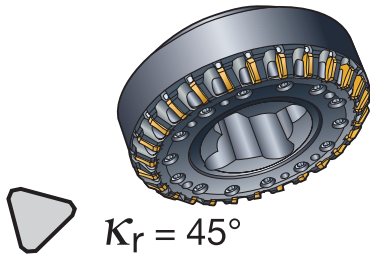
Tailor Made

R/L260.20
Positive rake
Diameter 63 - 101.6 mm
Page D142

For more technical information, see our Metalcutting Technical guide

Sandvik AUTO – Roughing

Facemill



Note!

Support body for Cap design must be ordered separately, see page D144.

l_1 = programming length

\square ¹⁾	D_c mm	Ordering code		Dimensions, mm							Support body	
		Close pitch				dm_m	D_1	l_1 ²⁾	Max a_p	n_{max} ³⁾		
		Arbor										
12	80	R/L260.3-080M-10	10	-	2.6	27	100.2	63	6	1700		
	100	R/L260.3-100M-10	14	-	3.8	32	120.2	63	6	1550		
	125	R/L260.3-125M-10	20	-	5.3	40	145.2	63	6	1400		
	160	R/L260.3-160M-10	26	-	8.9	40	180.2	63	6	1250		
	200	R/L260.3-200M-10	32	-	17.5	60	220.2	63	6	1100		
		Cap design										
	250	R/L260.31-250-10	40	-	19.0		270.2	63	6	1000	260-425M-1	
	315	R/L260.31-315-10	50	-	25.0		335.2	63	6	900	260-431M-1	
	355	R/L260.31-355-10	56	-	30.0		375.2	63	6	800	260-435M-1	
	400	R/L260.31-400-10	64	-	35.2		420.2	63	6	800	260-440M-1	
	500	R/L260.31-500-10	80	-	51.0		520.2	63	6	700	260-450M-1	

¹⁾ Inserts are ordered separately.

²⁾ With precision inserts.

³⁾ n_{max} (max. rev/min) for holders must also be considered.

Note!

Support body dimensions, see page D144.

Mounting dimensions, see Metalcutting Technical guide.

= Even pitch

= Differential pitch

Ordering example: 2 pieces R260.3-080M-10



D134



D135

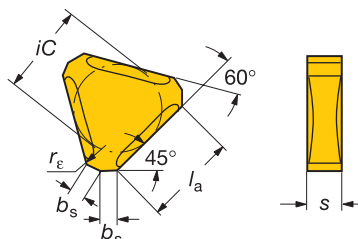


G3



D2

Inserts for Sandvik AUTO cutters



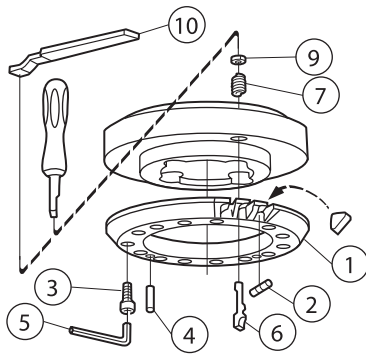
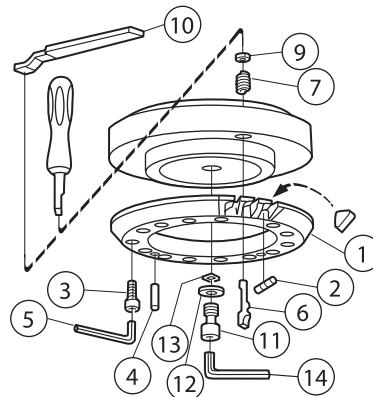
	Ordering code	Dimensions, mm																					
		P		M		K				N		S		H		Max a_p	iC	s	b_s	l_a	r_ϵ		
		GC	GC	GC	GC	GC	GC	GC	GC	CC	-	-	-	-	GC	GC	CC						
Light	TNEF 12 04 AN-WL	☆				☆	☆						☆		☆	☆		6	12.7	4.76	2.5	12	2
	TNHF 12 04 AN-WL		☆	☆				☆	☆					☆				6	12.7	4.76	1.75	12	2
	TNCN 12 04 ANE									☆							☆	6	12.7	4.76	2.5		
Medium	TNEF 12 04 AN-65	☆				☆	☆						☆		☆	☆		6	12.7	4.76	2.5	12	
	TNEF 12 04 AN-CA	☆				☆	☆						☆		☆	☆		6	12.7	4.76	1.5	12	3
	TNHF 12 04 AN-CA		☆	☆	☆			☆	☆					☆				6	12.7	4.76	1.5	12	3
	TNEF 12 04 AN-KM									☆			☆	☆				6	12.7	4.76	1.25	12	2
	TNHF 12 04 AN-65										☆		☆	☆				6	12.7	4.76	2.5	12	
	TNHN 12 04 AN										☆		☆	☆				6	12.7	4.76	2.5	12	
	TNEN 12 04 AN	☆				☆	☆						☆		☆	☆		6	12.7	4.76	2.5	12	2
Ceramics																							
12	TNCN 12 04 AN									☆							☆	6	12.7	4.76	2.5	12	

Ordering example: 10 pieces TNEF 12 04 AN-WL



Spare parts for Sandvik AUTO

R/L260.3

R/L260.31
Cap design

		1	2	3	4	5	6
Cutter	D_c mm	Seating ring	Location roller	Screw	Taper pin	Key (mm)	Wedge
R/L260.3-	080M	R R260.3-D ²⁾ M-80 ¹⁾	260.3-846	3212 010-361	3112 010-563	3021 010-050	260.3-822
	-10					(5.0)	260.3-823
	200M	L L260.3-D ²⁾ M-80 ¹⁾	260.3-847				260.3-822
R/L260.31-	250	R R260.3-D ²⁾ M-80 ¹⁾	260.3-846	3212 010-361	3112 010-563	3021 010-050	260.3-823
	-10					(5.0)	260.3-823
	500	L L260.3-D ²⁾ M-80 ¹⁾	260.3-847				
		7	9	10	11 ³⁾	12	13
Cutter	D_c mm	Spring	Bayonet washer	Indexing lever	Screw	Washer	Locking ring
R/L260.3-	080M	R					
	-10						
	200M	L	260.3-831	260.4-830	260.3-833M	-	-
R/L260.31-	250	R	260.3-831	260.4-830	260.3-833M	260.31-831	3411 011-170
	-10						260.31-840
	500	L	260.3-831	260.4-830	260.3-833M	260.31-831	3411 011-170
							260.31-840
							3021 010-140
							(14.0)










1) Incl. location rollers.

2) D = D_c = Cutter diameter.

3) Torque ≤120 Nm

Ordering example: 2 pieces R260.3-880M-80

Accessories¹⁾

						
Cutter		Mounting fixture for mounting location roller in seating ring	Location screw for location seating ring during assembly	Key (mm)	Puller screw for removing seating	Key (mm)
R/L260.3, R/L260.31	R	260.3-850	68/660	3021 010-050	3214 010-416	3021 010-040
	L			(5.0)		(4.0)
						
Cutter		Dummy insert Used when the recommended feed per tooth cannot be used.	Wedge	Nut	Wedge-key for removing bayonet washer	
R/L260.3, R/L260.31	R	260.3-845	260.3-824	260.3-844	260.3-835	
	L		260.3-825			

1) Accessories, must be ordered separately

Ordering example: 2 pieces 280.3-850

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