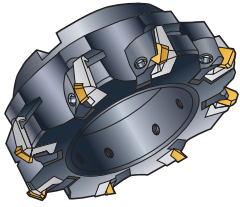


Modulmill milling system



A complete milling system of high capacity, reliable cutters, of fixed pocket design with low service requirements.

Modulmill is a system of milling cutters with entering angles of 45°, 75°, 90° and round inserts covering all types of face and square shoulder milling. The cutters are available in both close and differential coarse pitch.

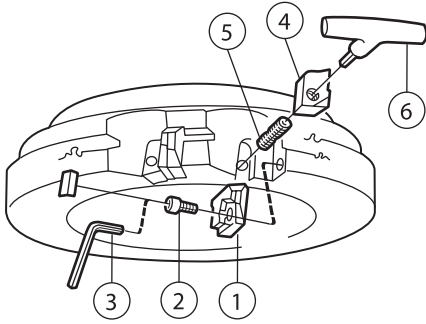
Ordering code		Insert size	
D_c mm	Close pitch	Coarse pitch Differential	
K_r 90° Positive rake			
80	R282.2-080-10	5	16
100	R282.2-100-10	6	
125	R282.2-125-10	8	R282.2-125-20 6
160	R282.2-160-10	10	R282.2-160-20 8
200	R282.2-200-10	12	R282.2-200-20 10
250	R282.2-250-10	16	R282.2-250-20 12
315	R282.2-315-10	20	R282.2-315-20 14
80	R282.2-080-30	5	22
100	R282.2-100-30	6	
125	R282.2-125-30	8	R282.2-125-40 6
160	R282.2-160-30	10	R282.2-160-40 8
200	R282.2-200-30	12	R282.2-200-40 10
250	R282.2-250-30	16	R282.2-250-40 12
315	R282.2-315-30	20	R282.2-315-40 14
K_r 90° Positive rake			
80	R282.2-080-50	5	- 15
100	R282.100-50	6	-
125	R282.125-50	8	R282.2-125-60 6
160	R282.160-50	10	R282.2-160-60 8
200	R282.200-50	12	R282.2-200-60 10
250	R282.250-50	16	R282.2-250-60 12
125	R282.2-125-70	8	R282.2-125-80 6 19
160	R282.2-160-70	10	R282.2-160-80 8
200	R282.2-200-70	12	R282.2-200-80 10
250	R282.2-250-70	16	R282.2-250-80 12
Positive rake			
66	R285.2-080-10	5	- 16
86	R285.2-100-10	6	-
111	R285.2-125-10	8	R285.2-125-20 6
146	R285.2-160-10	10	R285.2-160-20 8
186	R285.2-200-10	12	R285.2-200-20 10
236	R285.2-250-10	16	R285.2-250-20 12
111	R285.2-315-10	8	R285.2-315-20 6 20
146	R285.2-080-15	10	- 8
186	R285.2-100-15	12	- 10
236	R285.2-125-15	16	R285.2-125-25 12

	P			M				K			N S				
	CT	GC	GC -	SM30	GC	GC	530	S6	GC	GC	H13A	H1P	690	H13A	H10F
Inserts															
TPKR TPKN															
TPKR 16 03 PP R-WH	☆	☆	☆								☆				
TPKN 16 03 PP R	☆	☆	☆	☆			☆		☆	☆		☆			
TPKR 16 04 PD R-WH	☆	☆	☆	☆							☆				
TPKN 16 04 PD R	☆	☆	☆	☆	☆	☆	☆		☆	☆	☆	☆	☆		
Inserts															
BPKX BPEX wiper															
BPKX 15 04 PD R				☆	☆				☆						
BPKX 19 04 PD R				☆	☆				☆						
Wiper															
BPEX 15 04 PD R-1W													☆		
Inserts															
RCMN															
RCMN 16 04 M0				☆					☆		☆				
RCMN 20 06 M0				☆					☆		☆				



Spare parts for Modulmills

R/L260.22, R285.1, R285.2



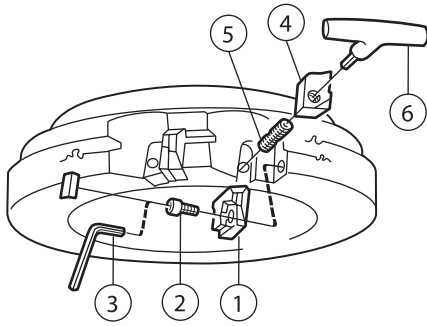
Cutter	D _c mm		1	2	3	4	5	6
			Seat	Screw	Key (mm)	Wedge	Screw	Key (mm)
45° R/L260.22-	125	R	260.22-390	5512 041-01	265.2-818	260.22-292A ¹⁾	5516 010-011)	265.2-821
		L	260.22-391		(2.38)	260.22-293A ¹⁾		(4.0)
	25	R	260.22-390	5512 041-01	265.2-818	260.22-290A ¹⁾	5516 010-011)	265.2-821
		L	260.22-391		(2.38)	260.22-291A ¹⁾		(4.0)
	30	R	260.22-392	265.2-824	265.2-818	260.22-292A ¹⁾	5516 010-011)	265.2-821
		L	260.22-393		(2.38)	260.22-293A ¹⁾		(4.0)
40	R	260.22-392	265.2-824	265.2-818	260.22-290A ¹⁾	5516 010-011)	265.2-821	
	L	260.22-393		(2.38)	260.22-291A ¹⁾		(4.0)	
75° Negative	100		285.1-354	265.2-824	265.2-818	285.1-230	5516 010-02	265.2-817
					(2.38)			(3.0)
	125	R	285.1-356	265.2-824	265.2-818	285.1-232	5516 010-01	265.2-821
		L	285.1-356		(2.38)			(4.0)
250	R	285.1-356	265.2-824	265.2-818	285.1-234	5516 010-01	265.2-821	
	L	285.1-356		(2.38)			(4.0)	
75° Positive	100	R	285.2-340	265.2-824	265.2-818	285.2-214	5516 010-02	265.2-817
		L	285.2-340		(2.38)			(3.0)
	125	R	285.2-342	265.2-824	265.2-818	285.2-216	5516 010-01	265.2-821
		L	285.2-342		(2.38)			(4.0)
	150	R	285.2-346	265.2-824	265.2-818	285.2-214	5516 010-02	265.2-817
		L	285.2-346		(2.38)			(3.0)
	175	R	285.2-348	265.2-824	265.2-818	285.2-216	5516 010-01	265.2-821
		L	285.2-348		(2.38)			(4.0)
	200	R	285.2-342	265.2-824	265.2-818	285.2-218	5516 010-01	265.2-821
		L	285.2-342		(2.38)			(4.0)
	225	R	285.2-348	265.2-824	265.2-818	285.2-218	5516 010-01	265.2-821
		L	285.2-348		(2.38)			(4.0)
250	R	285.2-336	265.2-824	265.2-818	285.2-220	5516 010-02	265.2-817	
	L	285.2-336		(2.38)			(3.0)	
275	R	285.2-350	265.2-824	265.2-818	285.2-222	5516 010-01	265.2-821	
	L	285.2-350		(2.38)			(4.0)	
300	R	285.2-350	265.2-824	265.2-818	285.2-224	5516 010-01	265.2-821	
	L	285.2-350		(2.38)			(4.0)	
325	R	285.2-352	265.2-824	265.2-818	285.2-222	5516 010-01	265.2-821	
	L	285.2-352		(2.38)			(4.0)	
350	R	285.2-352	265.2-824	265.2-818	285.2-224	5516 010-01	265.2-821	
	L	285.2-352		(2.38)			(4.0)	




1) Tightening torque for wedge screw 6 Nm.

Ordering example: 10 pieces 260.22-390

Spare parts for Modulmills

R282.2, R280.2



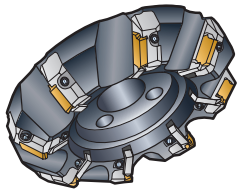
Cutter			1	2	3	4	5	6
	D_c mm		Seat	Screw	Key (mm)	Wedge	Screw	Key (mm)
90° 	R282.2-	080	282.2-370	5512 041-01	265.2-818 (2.38)	282.2-240	5516 010-02	265.2-817 (3.0)
		-10						
	R282.2-	100	282.2-372	5512 041-01	265.2-818 (2.38)	282.2-242	5516 010-01	265.2-821 (4.0)
		-10						
	R282.2-	125	282.2-372	5512 041-01	265.2-818 (2.38)	282.2-244	5516 010-01	265.2-821 (4.0)
		-20						
R282.2-	315	282.2-310	265.2-824	265.2-818 (2.38)	285.2-220	5516 010-02	265.2-817 (3.0)	
	-30							
R282.2-	100	282.2-312	265.2-824	265.2-818 (2.38)	285.2-222	5516 010-01	265.2-821 (4.0)	
	-30							
R282.2-	125	282.2-312	265.2-824	265.2-818 (2.38)	285.2-224	5516 010-01	265.2-821 (4.0)	
	-40							
90° 	R282.2-	080	282.2-316	265.2-824	265.2-818 (2.38)	285.2-220	5516 010-02	265.2-817 (3.0)
		-50						
	R282.2-	100	282.2-318	265.2-824	265.2-818 (2.38)	285.2-222	5516 010-01	265.2-821 (4.0)
		-50						
	R282.2-	125	282.2-318	265.2-824	265.2-818 (2.38)	285.2-224	5516 010-01	265.2-821 (4.0)
		-60						
R282.2-	250	282.2-320	265.2-824	265.2-818 (2.38)	285.2-222	5516 010-01	265.2-821 (4.0)	
	-70							
R282.2-	125	282.2-320	265.2-824	265.2-818 (2.38)	285.2-224	5516 010-01	265.2-821 (4.0)	
	-80							
Positive 	R280.2-	080	280.2-300	265.2-824	265.2-818 (2.38)	280.2-200	5516 010-02	265.2-817 (3.0)
		-10						
	R280.2-	100	280.2-302	265.2-824	265.2-818 (2.38)	280.2-202	5516 010-01	265.2-821 (4.0)
		-10						
	R280.2-	125	280.2-302	265.2-824	265.2-818 (2.38)	280.2-204	5516 010-01	265.2-821 (4.0)
		-20						
R280.2-	250	280.2-304	265.2-824	265.2-818 (2.38)	280.2-202	5516 010-01	265.2-821 (3.0)	
	-30							
R280.2-	125	280.2-304	265.2-824	265.2-818 (2.38)	280.2-204	5516 010-01	265.2-821 (4.0)	
	-40							

Ordering example: 10 pieces 282.2-370

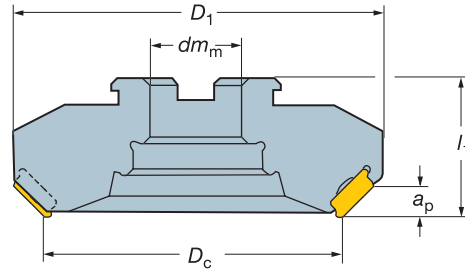
Heavy duty facemill T-Max 45

Facemill

Diameter 100 - 400 mm
Adjustable
Positive/negative rake



$K_r = 45^\circ$



l_1 = programming length

Insert size ¹⁾	D_c mm	Ordering code				Dimensions, mm						
		Coarse pitch		Close pitch		$\frac{kg}{cm^3}$	dm_m	D_1	l_1	Max a_p	$n_{max}^{2)}$	
18	100	-	-	R260.7-100-30	6							-
	125	-	-	R260.7-125-30	8	-	8.4	40.0	158.6	63	12.0	4500
160	-	-	6	-	-	-	4.25	40.0	158.6	63	12.0	4500
	-	-	-	R260.7-160-30	10	-	10.0	40.0	192.2	63	12.0	4000
200	-	-	-	R260.7-200-30	14	-	14.0	60.0	231.1	63	12.0	3500
	-	-	10	-	-	-	14.0	60.0	231.1	63	12.0	3500
250	-	-	-	R260.7-250-40	-	-	20.0	60.0	280.2	63	12.0	3000
	-	-	10	-	-	-	20.0	60.0	280.2	63	12.0	3000
315	-	-	-	R260.7-315-40	-	-	34.0	60.0	344.4	80	12.0	2800
	-	-	12	-	-	-	34.0	60.0	344.4	80	12.0	2800
400	-	-	-	R260.7-400-40	-	-	50.0	60.0	428.7	80	12.0	2500
	-	-	16	-	-	-	50.0	60.0	428.7	80	12.0	2500

¹⁾ Inserts are ordered separately.

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

Ordering example: 2 pieces R260.7-100-30

Note!

Mounting dimensions, see Metalcutting Technical guide.

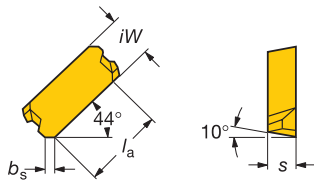
= Even pitch

= Differential pitch

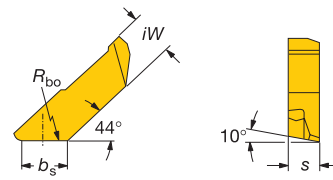
Inserts for heavy duty facemill T-MAX 45



LNCX -31
LNCX -32



LNCX-1W
Wiper



Ordering code	P						M					K				N		S		H			Dimensions, mm									
	GC	GC	GC	GC	GC	-	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	l_a	s	iW	b_s	R_{bo}					
18 LNCX 18 06 AZ R-31	2040	3040	4020	4030	4040	S6	SM30	2040	4030	4040	S6	SM30	3020	3040	4020	4030	4040	H13A	H1P	H13A	2040	H13A	3020	3040	4020	H1P	18.62	6.4	10	2		
LNCX 18 06 AZ R-11	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	18.77	6.4	10	2	
LNCX 18 06 AZ R-32	☆			☆				☆	☆						☆						☆						☆	18.62	6.8	10	2.2	
LNCX 18 06 AZ R-1W							☆					☆							☆								☆		10.5	9.28	10	400

Ordering example: 10 pieces LNCX 18 06 AZ R-11 4020

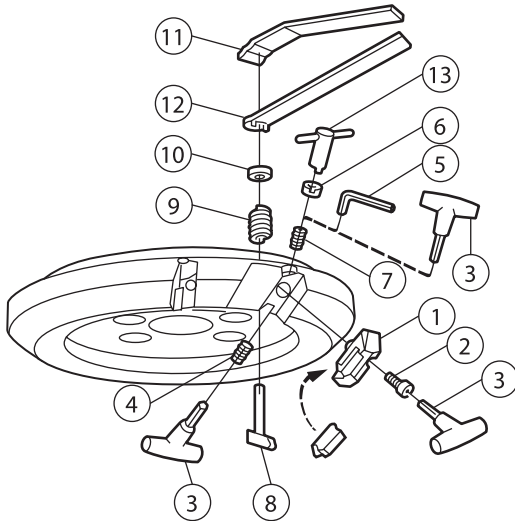
Note!

For grade description, see page D172.



Spare parts for T-Max 45

R260.7



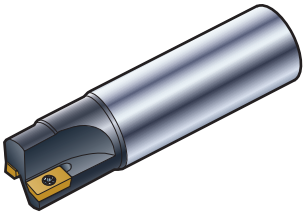
Cutter	1	2	3	4	5	6	7
D_c mm	Seat	Screw	Key (mm)	Screw	Key (mm)	Nut	Screw
R260.7- 100 -30 200	260.7-830M	3212 010-310	265.2-821 (4.0)	3214 010-409	3021 010-040 (4.0)	260.7-842	3214 010-408
R260.7- 125 -40 400	260.7-830M	3212 010-310	265.2-821 (4.0)	3214 010-409	3021 010-040 (4.0)	260.7-842	3214 010-408
Cutter	8	9	10	11	Accessories ²⁾		
D_c mm	Clamp	Spring	Bayonet washer	Indexing lever	Seat for wiper inserts	Clamp removal key for bayonet washer	Locking key for relocking shim location in event of the cutter re-setting
R260.7- 100 -30 200	260.7-820	260.7-841	260.7-840	260.7-856M	5321-046-01	260.7-857 ¹⁾	260.7-855M
R260.7- 125 -40 400	260.7-820	260.7-841	260.7-840	260.7-856M	5321-046-01	260.7-857 ¹⁾	260.7-855M

1) For cutters with diameter 100 mm, use key 260.7-858.

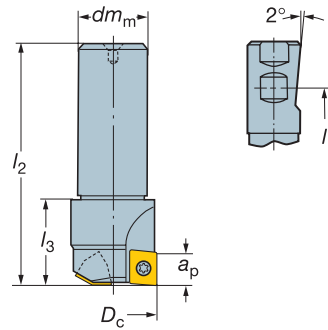
2) Accessories, must be ordered separately

Ordering example: 10 pieces 260.7-830M

U-Max® drilling endmill
Diameter 12 – 40 mm



Cylindrical threaded Weldon/Whistle Notch



l_1 = programming length

D_c mm	Ordering code			Dimensions, mm							$n_{max}^{(2)}$	Inserts		
					l_1	l_2	l_3	dm_m	Max a_p	Peripheral		Central		
Cylindrical shank														
20	R216.2-020	1	-	0.3	115	39.7	20	15	15120		R216.2-170308-2			
25	R216.2-025	2	-	0.5	120	39.9	25	15	12095	R216.2-15T308-1	R216.2-07T3			
32	R216.2-032	2	-	0.8	130	39.9	32	15	9460	R216.2-15T308-1	R216.2-07T3			
40	R216.2-040	2	-	1.1	160	39.9	32	15	8460	R216.2-15T312-2	R216.2-09T3			
Weldon														
12	R216.2-712 ¹⁾	1	-	0.1	49	73	20	16	8	25200		R216.2-080204-1A		
16	R216.2-716 ¹⁾	1	-	0.2	54	78	25	16	10	18900		R216.2-100204		
20	R216.2-520	1	-	0.5	65	90	37.3	20	15	15120		R216.2-170308-2		
25	R216.2-525	2	-	0.4	64	96	39.9	25	15	12095	R216.2-15T308-1	R216.2-07T3		
32	R216.2-532	2	-	0.6	64	100	40.3	32	15	9460	R216.2-15T308-1	R216.2-07T3		
40	R216.2-540	2	-	0.7	67	103	40.6	32	15	8460	R216.2-15T312-2	R216.2-09T3		

¹⁾ Weldon/Plain parallel only.

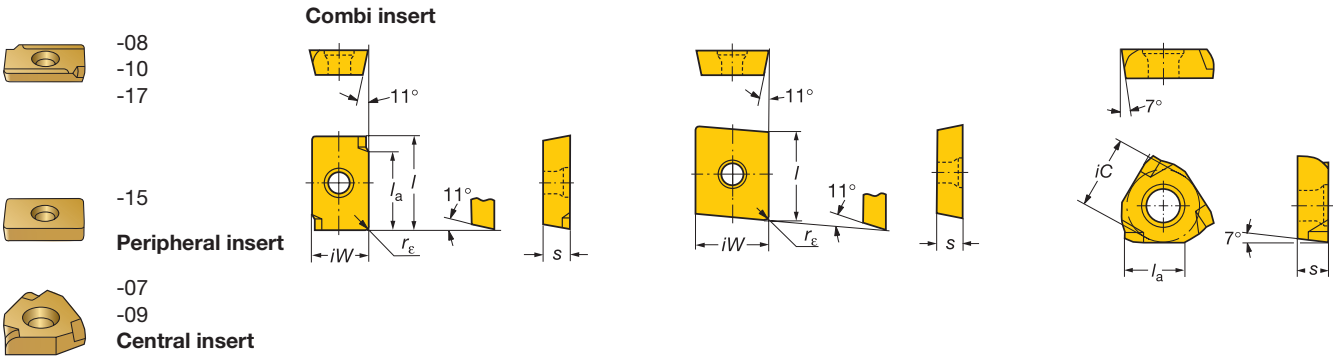
²⁾ n_{max} (max. rev/min) for holders must also be considered.

Ordering example: 2 pieces R216.2-712

= Even pitch

= Differential pitch

Inserts for U-MAX drilling endmill



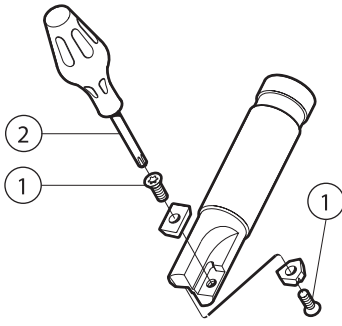
t	Ordering code	P		M		Dimensions, mm					
		S6	SM30	S6	SM30	l_a	l	iW	s	r_e	iC
08	R216.2-08 02 04-1A	☆	☆	☆	☆	8.2	9.5	6.3	2.38	0.4	
10	R216.2-10 02 04	☆	☆	☆	☆	10.2	11.5	8.3	2.38	0.4	
15	R216.2-15 T3 08-1	☆	☆	☆	☆		15.2	9.5	3.97	0.8	
	R216.2-15 T3 12-2	☆	☆	☆	☆		15.2	12.5	3.97	1.2	
	R216.2-17 03 08-1	☆	☆	☆	☆	15	17.5	9.52	3.18	0.8	
	R216.2-17 03 08-2	☆	☆	☆	☆	15	17.5	10	3.18	0.8	
07	R216.2-07 T3	☆	☆	☆	☆	7.6	7		3.97		9.5
09	R216.2-09 T3	☆	☆	☆	☆	9.3	9		3.97		13

Ordering example: 10 pieces R216.2-08 02 04-1A S6



Spare parts for U-Max drilling endmill

R216.2



Cutter	1		2			
	D_c mm	Insert screw	Key (Torx Plus)	Torque value (Nm)	Torque wrench	Molykote
R216.2- 16	12	5513 020-21	5680 046-03 (7IP)	0.9	5680 100-02 ¹⁾	5683 010-01
R216.2- 32	20	5513 020-16	5680 046-05 (10IP)	2.0	5680 100-05 ¹⁾	5683 010-01
R216.2- 40	32	5513 020-02	5680 046-02 (15IP)	3.0	5680 100-06 ¹⁾	5683 010-01

1) Accessories, must be ordered separately

Ordering example: 10 pieces 5513 020-21

This catalogue has been split into smaller parts
to enhance downloading speeds.

If you want to view the next page
please click [HERE!](#)