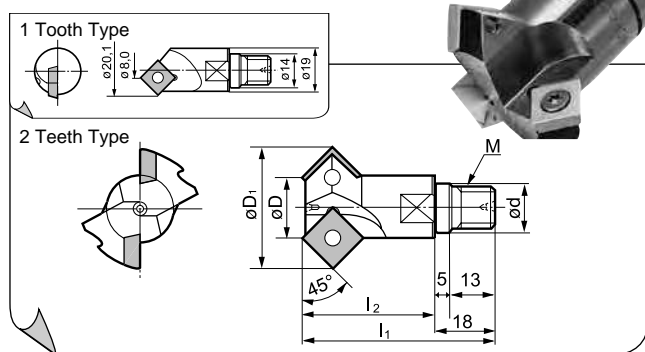


# Chamfering Endmills SCP Type



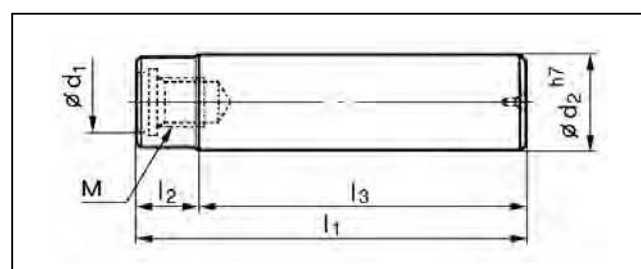
## Body

| Cat. No. | Stock | Dimensions (mm) |                  |     |                |                |     | No. of teeth |
|----------|-------|-----------------|------------------|-----|----------------|----------------|-----|--------------|
|          |       | ø D             | ø D <sub>1</sub> | ø d | l <sub>1</sub> | l <sub>2</sub> | M   |              |
| SCP 308  | ●     | 8               | 20,1             | 14  | 50             | 32             | M12 | 1            |
| SCP 419  | ●     | 19              | 35,6             | 14  | 56             | 38             | M12 | 2            |
| SCP 432  | ●     | 32              | 48,6             | 20  | 60             | 42             | M16 | 3            |

## Inserts


| Cat. No.      | Carbide |      |  |  | Fig. | Applicable Endmill |
|---------------|---------|------|--|--|------|--------------------|
|               | A30N    | G10E |  |  |      |                    |
| SDMA 090308   |         | ●    |  |  | 1.   | SCP 308            |
| SDMA 090308 T | ●       |      |  |  |      |                    |
| SPMA 120408   |         | ●    |  |  | 2.   | SCP 419            |
| SPMA 120408 T | ●       |      |  |  |      | SCP 432            |

## Holder for SCP



| Cat. No. | Stock | Dimensions (mm)  |                  |     |                |                |                | Applicable Endmill |
|----------|-------|------------------|------------------|-----|----------------|----------------|----------------|--------------------|
|          |       | ø d <sub>1</sub> | ø d <sub>2</sub> | M   | l <sub>1</sub> | l <sub>2</sub> | l <sub>3</sub> |                    |
| SCA 20   | ●     | 14               | 20               | M12 | 105            | 20             | 85             | SCP 308<br>SCP 419 |
| SCA 32   | ●     | 20               | 32               | M16 | 130            | 20             | 110            | SCP 432            |

## Spare Parts

| SCP      | Screw                                                                               | Wrench                                                                              |
|----------|-------------------------------------------------------------------------------------|-------------------------------------------------------------------------------------|
|          |  |  |
| 308      | BFTX 0407 N                                                                         | TRX 10                                                                              |
| 419, 432 | BFTX 0511 N                                                                         | TRX 20                                                                              |

## Application Examples



## Recommended Cutting Conditions for SCP

( min. - **optimal** - max.)

| Multi-Mills | ø D (mm)    | Tooling      | Cutting Conditions        | General steel         |                     |                     | Cast iron             |
|-------------|-------------|--------------|---------------------------|-----------------------|---------------------|---------------------|-----------------------|
|             |             |              |                           | Less than HRC25       | HRC25 ~ 35          | HRC35 ~ 45          | (GG20)                |
| SCP 308     | 8,5 ~ 19,5  | Chamfering   | v <sub>c</sub> (m/min)    | 80 - <b>100</b> - 140 | 50 - <b>60</b> - 80 | 20 - <b>40</b> - 60 | 90 - <b>110</b> - 130 |
| SCP 419     | 19,5 ~ 35,1 |              | f <sub>t</sub> (mm/tooth) | 0,15 - 0,4            | 0,1 - 0,25          | 0,05 - 0,15         | 0,2 - 0,5             |
| SCP 432     | 32,5 ~ 48,1 | Face milling | v <sub>c</sub> (m/min)    | 80 - <b>100</b> - 140 | 50 - <b>60</b> - 80 | 20 - <b>40</b> - 60 | 90 - <b>110</b> - 130 |
|             |             |              | f <sub>t</sub> (mm/tooth) | 0,1 - 0,2             | 0,05 - 0,1          | 0,04 - 0,08         | 0,1 - 0,3             |

● = Euro stock