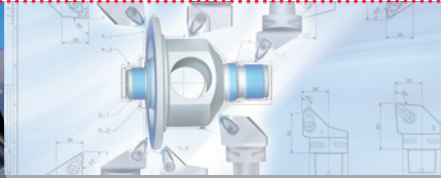


SPK INNOVATION

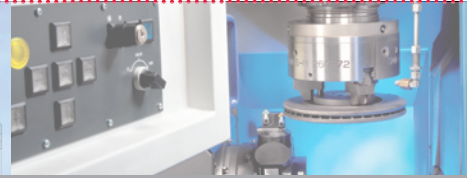
MILLING



TOOLS



TECHNOLOGY



APPLICATION



PFL MILLING CUTTER SERIES

HIGH-SPEED FACE MILLING OF CAST IRON

PFL – NEW MILLING CUTTER GENERATION FOR HIGH-SPEED MACHINING WITH A POSITIVE GEOMETRY

The PFL milling cutter family was especially designed for the highly-productive face milling of components made from GJL (grey cast iron) and GJS (ductile cast iron) with SiALON cutting materials.

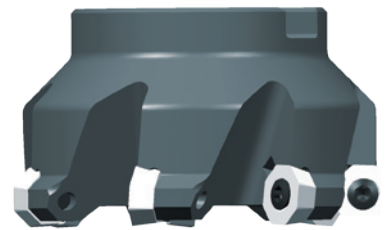
The PFL milling cutter family comprises two classic series with a positive geometry:

- PFL-OP: the milling cutter line for rough milling and finishing
- PFL SP: this milling cutter series was designed for finishing and for medium rough milling operations with low axial forces.

PFL-OP

This roughing and finishing specialist is equipped with positive octagon inserts. The design with eight cutting edges ensures a high level of efficiency. With a feed rate of up to 0.35 mm per tooth and a maximum

cutting depth of approx. 4 mm, the milling cutters in the PFL-OP series offer extremely productive milling operations at high machining speeds.



PFL-SP

With their positive quadratic cutting, the milling cutters of the PFL-SP series are ideal for machining even the most unstable or thin-walled workpieces under high-performance conditions. PFL-SP milling cutters are available with approach angles of 88°, 75°

and 45°. Edge breakage and burr formation can be reduced, while low axial forces can be achieved. The milling cutter allows cut depths up to 6 mm and a maximum feed rate of up to 0.3 mm per tooth.



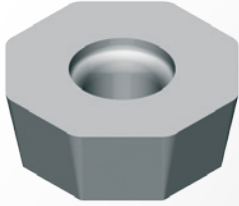
With the further expansion of the face milling cutter series with the PFL-OP and PFL-SP series, SPK Cutting Tools is bringing important innovations to the face milling industry. Minimum machining forces are obtainable with the highest cutting values – even under the most abrasive and unfavourable conditions. The positive milling

cutter geometries open up a broad scope of applications for the milling cutters, ranging from thin-walled to unstable and stable components. High productivity and a high degree of process reliability were the most important criteria during the series' development.

INSERTS FOR MILLING CUTTER PFL-OP

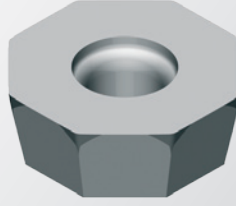
i

STANDARD-GEOMETRY



OPHX 05 05 ..
OPHX 06 06 ..

ZZ-GEOMETRY



OPHX 05 05 .. T-S 43Z150
OPHX 06 06 .. T-S 43Z150

Cutting Materials:

SiAlON SL808

SiAlON , coated SL858 C

PFL-SP FACE MILLING CUTTERS



Axial rake angle $\gamma_a = +5$
 Radial rake angle: $\lambda_r = -6^\circ$
 Dimension table according to DIN 8030
 For thin-walled and unstable parts

i Recommended application

■ GJL (grey cast iron) ■ GJS (ductile cast iron)

WORKPIECE

thin-walled ✓ unstable ✓ stable ✓

$f_z = 0.3$

$\nabla_{12.5}$ • $\nabla_{6.3}$

PFL - SP / 88°	Dimensions	Standard	Special versions
	D	Tooth t	Coarse pitch t_{min}
PFL-050-04SP1388R	50	4	4
PFL-063-05SP1388R	63	5	5
PFL-080-07SP1388R	80	7	5
PFL-100-09SP1388R	100	9	6
PFL-125-11SP1388R	125	11	7
PFL-160-13SP1388R	160	13	9

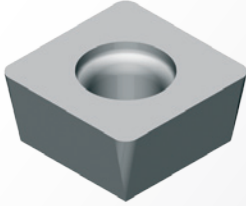
PFL - SP / 75°	Dimensions	Standard	Special versions
	D	Tooth t	Coarse pitch t_{min}
PFL-050-04SP1375R	50	4	4
PFL-063-05SP1375R	63	5	5
PFL-080-07SP1375R	80	7	5
PFL-100-09SP1375R	100	9	6
PFL-125-11SP1375R	125	11	7
PFL-160-13SP1375R	160	13	9

PFL - SP / 45°	Dimensions	Standard	Special versions
	D	Tooth t	Coarse pitch t_{min}
PFL-050-04SP1345R	50	4	3
PFL-063-05SP1345R	63	5	4
PFL-080-07SP1345R	80	7	5
PFL-100-09SP1345R	100	9	6
PFL-125-11SP1345R	125	11	7
PFL-160-13SP1345R	160	13	9

INSERTS FOR MILLING CUTTER PFL-SP

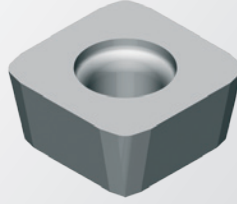


STANDARD-GEOMETRY



SPHX 13 06 ..

ZZ-GEOMETRY



SPHX 13 06 .. T 88Z150
SPHX 13 06 .. T 75Z150
SPHX 13 06 .. T 45Z150

Cutting Materials:
SiAlON SL808
SiAlON, coated SL858 C

CeramTec GmbH

SPK Cutting Tools Division

Hauptstrasse 56 • 73061 Ebersbach/Fils, Germany

Phone: +49 (0)7163 / 166-239 • Fax: +49 (0)7163 / 166-388

E-mail: info@spk-tools.de • Web: www.spk-tools.deE-mail: cutting_tools@ceramtec.de • Web: www.ceramtec.com