



CROSSCARB

SHOULDER 6 TRUE SHOULDER MILLS WITH 6 CORNER INSERTS



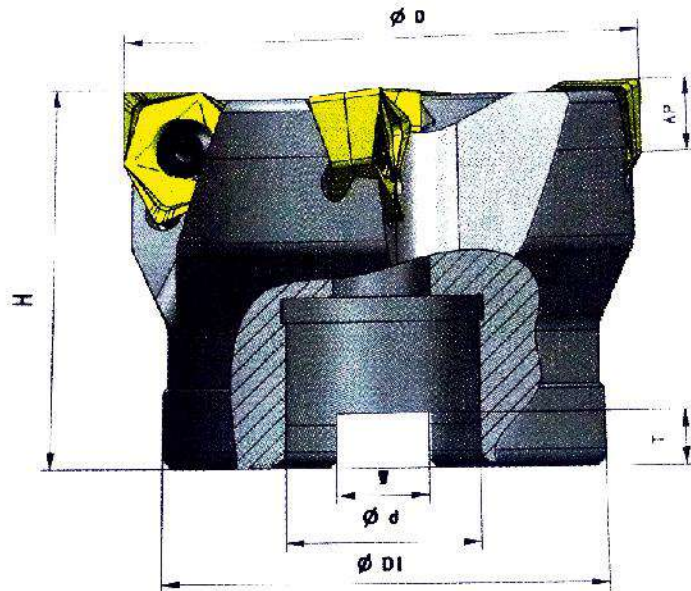
SHOULDER 6

milling cutters are our eco mills. The Trigon inserts with three cutting edges on either side help lower the cost per cutting edge. Our portfolio of Shoulder 6 milling cutters is offered in size 4 and 8mm with unlimited options of geometries for unmatched performance on all kinds of materials, operations and conditions.

FEATURES

Low Cutting Force due to High Rake Angle helps in reducing cutting forces.
Productive for low power machines with more cutting edges
Slant Design helps in balanced entry and exit during cutting
Higher rake helps in reduction of chatter in over hang applications
Economical Double-sided 6-edge Insert.
Superior Fracture Resistance due to Strong Cutting Edge.
Covers Wide Range of Applications
Self clamping design of insert helps in very secure seating

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Type of Milling Tools

Type	Dimensions (mm)							Adapter	Tooth	Weight (Kg)
	D	D ₁	d	H	W	a _p	T			
SH0610.08A22.063.03	63	47	22	40	10.4	8	6.3	A	3	0.5
SH0610.08A27.080.04	80	60	27	50	12.4	8	6.3	A	4	1.0
SH0610.08B32.100.05	100	70	32	50	14.4	8	8	B	5	1.3
SH0610.08B40.125.06	125	80	40	63	16.4	8	9	B	6	2.5
SH0610.08B40.160.08	160	100	40	63	16.4	8	9	B	8	3.8
SH0610.08C60.200.10	200	150	60	63	25.7	8	14	C	10	6.0
SH0610.08C60.250.12	250	180	60	63	25.7	8	14	C	12	8.4
SH0610.08A22.063.02	63	47	22	40	10.4	8	6.3	A	4	0.5
SH0610.08A27.080.05	80	60	27	50	12.4	8	6.3	A	5	1.0
SH0610.08B32.100.07	100	70	32	50	14.4	8	8	B	7	1.3
SH0610.08B40.125.08	125	80	40	63	16.4	8	9	B	8	2.5
SH0610.08B40.160.10	160	100	40	63	16.4	8	9	B	10	3.8
SH0610.08C60.200.12	200	150	60	63	25.7	8	14	C	12	6.0
SH0610.08C60.250.14	250	180	60	63	25.7	8	14	C	14	8.4

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Spare Parts

Insert	Insert Screw	Wrench
WNGU080608	TL60 M5X13	T20T

Type of Inserts

Insert shape	Type	Basic dimensions (mm)					CVD Coating						PVD Coating					Cermet		Cemented carbide						
		L	I.W	S	d	r	CC4030	CC4040	CC4050	CC4330	CC4340	CC4350	CC3315	CC3325	CC1015	CC1025	CC1035	CC1115	CC1125	CC1135			CC302	CC001	CC101	CC201
	WNGU080608-TM	14.00	8	6.65	6.2	0.8				★			★	★		★		★								
	WNGU080608-HD	14.00	8	6.65	6.2	0.8				★			★	★		★		★								
	WNGU080608-CQ	14.00	8	6.65	6.2	0.8				★			★	★		★		★								

SHOULDER 6

TRUE SHOULDER MILLS WITH 6 CORNER INSERTS

1. Square Shoulder Milling

Recommended cutting parameters

Workpiece material		Hardness HB	Insert grade	Cutting parameters				
				V (m/min)	f (mm/z)			a (m)
					-GF	-GM	-GR	
P	Low-carbon steel soft steel	<180	CC2025 CC4130 CC4230	320 (240-400)	0.1 (0.08-0.2)	0.2 (0.1-0.3)	0.25(0.2-0.35)	<0.5D
			CC4140	260 (180-380)	0.1 (0.08-0.2)	0.2 (0.1-0.3)	0.25(0.2-0.35)	<0.5D
			CC1125	320 (200-400)	0.1 (0.08-0.2)	0.2 (0.1-0.3)	0.25(0.2-0.35)	<0.5D
			CC1135	280 (180-400)	0.1 (0.08-0.2)	0.2 (0.1-0.3)	0.25(0.2-0.35)	<0.5D
	High-carbon steel Alloy steel	180-280	CC2025 CC4130 CC4230	280 (210-380)	0.1 (0.08-0.2)	0.2 (0.1-0.3)	0.25(0.2-0.3)	<0.5D
			CC4140	240 (160-320)	0.1 (0.08-0.2)	0.2 (0.1-0.3)	0.25(0.2-0.35)	<0.5D
			CC1125	280 (180-350)	0.1 (0.08-0.2)	0.2 (0.1-0.3)	0.25(0.2-0.35)	<0.5D
			CC1135	260 (150-380)	0.1 (0.08-0.2)	0.2 (0.1-0.3)	0.25(0.2-0.35)	<0.5D
	Alloy tool steel	280-350	CC2035 CC4130 CC4230	260 (180-350)	0.1 (0.08-0.2)	0.2 (0.1-0.3)	0.25(0.2-0.3)	<0.5D
			CC4140	220 (150-280)	0.1 (0.08-0.2)	0.2 (0.1-0.3)	0.25(0.2-0.35)	<0.5D
			CC4125	260 (160-330)	0.1 (0.08-0.2)	0.2 (0.1-0.3)	0.25(0.2-0.35)	<0.5D
			CC1135	240 (120-350)	0.1 (0.08-0.2)	0.2 (0.1-0.3)	0.25(0.2-0.35)	<0.5D
M	Stainless steel	<270	CC2025	200 (120-270)	0.1 (0.08-0.2)	0.2 (0.1-0.3)	0.25(0.2-0.3)	<0.5D
			CC4140	180 (150-300)	0.1 (0.08-0.2)	0.2 (0.1-0.3)	0.25(0.2-0.3)	<0.5D
			CC1125	200 (110-300)	0.1 (0.08-0.2)	0.2 (0.1-0.3)	0.25(0.2-0.3)	<0.5D
			CC1135	170 (100-280)	0.1 (0.08-0.2)	0.2 (0.1-0.3)	0.25(0.2-0.3)	<0.5D
K	Cast iron	180-250	CC1105	220 (120-250)	0.1 (0.08-0.2)	0.2 (0.1-0.3)	-	<0.5D
			CC3125	200 (120-320)	0.1 (0.08-0.2)	0.2 (0.1-0.3)	-	<0.5D
N					-AH			<0.5D
	Aluminium alloy	—	CC101	300-	0.2 (0.8-0.4)			<0.5D
			CC201	300-	0.2 (0.8-0.4)			<0.5D