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NEW FACE MILLING CUTTERS WITH INSERTS HNGX 06 / XNGX 06
AVAILABLE ALSO IN NEW GRADES WITH MT-CVD COATING

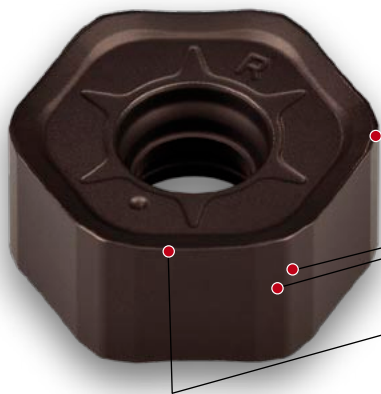
HNGX 06

HNGX 09

 **PRAMET**

NEW TOOLS FOR MILLING WITH INSERTS **HNGX 06** and **XNGX 06**

PRAMET
AGE MILL

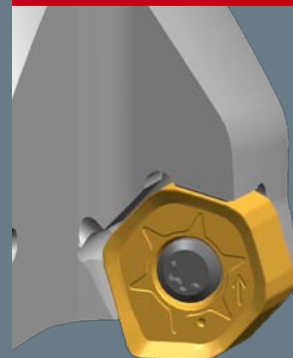


- + 12 cutting edges**
 - economical solutions of insert
- + Neutral design**
 - for left and right rotation
- + Unique geometry**
 - general geometry F, M, R for particular operation
 - for finishing to roughing
 - high quality of machined surface
 - smooth insert for increase surface quality

HNGX 06 / XNGX 06 and HNGX 09 / XNGX 09 geometry overview



CORRECT CLAMPING OF SMOOTH INSERT



Particular example of XNGX smoothing insert clamping in right-hand cutter. Insert face is marked by point and arrow indicator aim to the top.

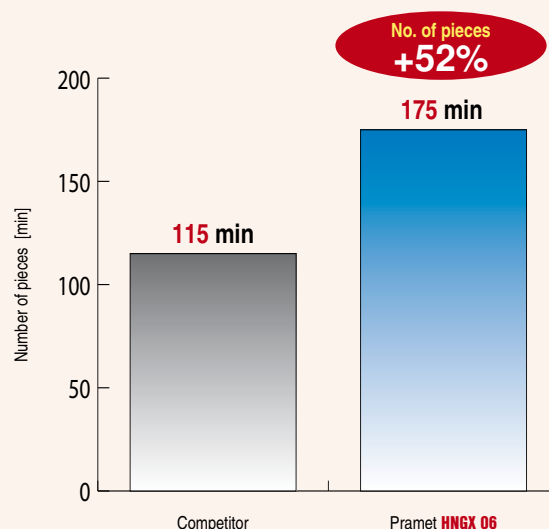
Practical example of milling with HNGX 06 inserts

EXAMPLE

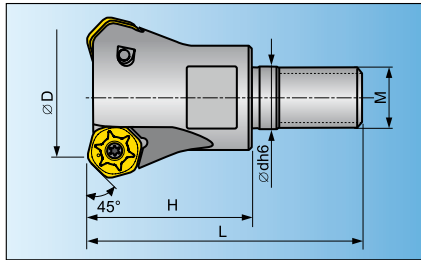
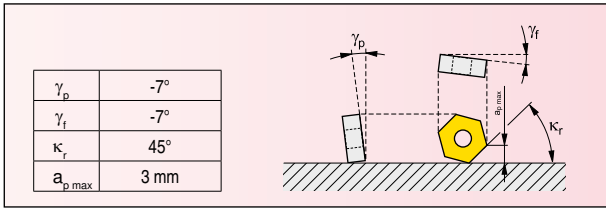
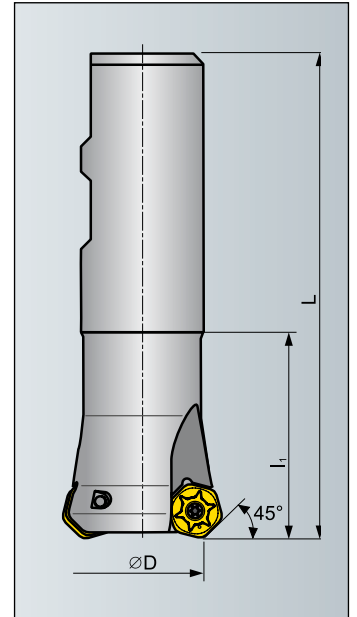
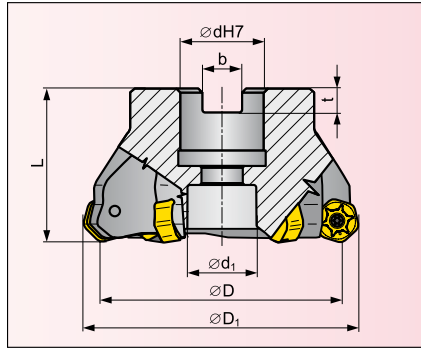
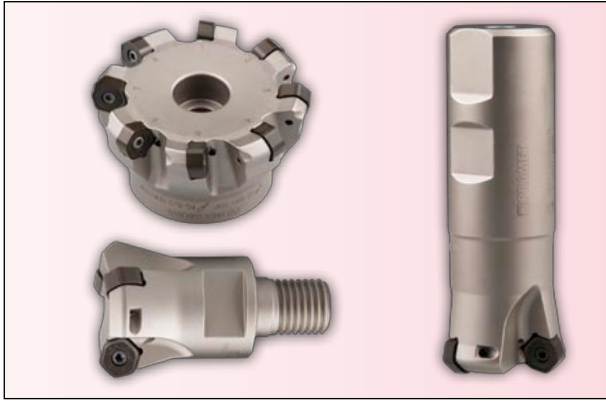
MACHINING WITH INSERT HNGX 06:

Operation: face milling
 Tools: 63A08R-S45HN06C-C
 Grades: GGG40
 Inserts: ONMU 050505 TN 5100 - competitor
 HNGX 0604ANSN-M; Pramet (K10-K30)
 Cooling: no

Cutting conditions		Competitor	Pramet	
Cutting speed	v_c	690	690	m.min ⁻¹
Feed	f_z	0,2	0,2	mm
Axial depth of cut	a_p	3,0	3,0	mm
Number of pieces	T	115	175	min



Milling cutters for inserts HNGX 06 a XNGX 06

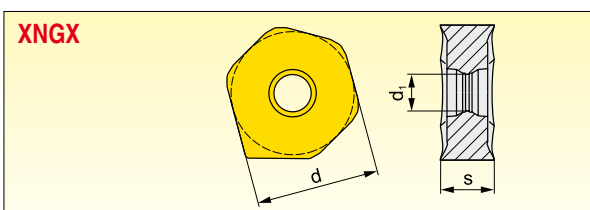
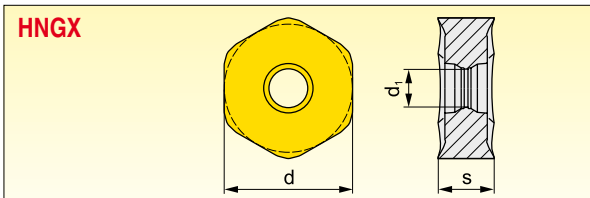


ISO	Assortment	Dimensions [mm]												Spare parts				Inserts		
		D	dH6	dH7	d ₁	M	L	D ₁	H	l	b	t	Z*	Cooling	[kg]	Shank	Handle		Screwdriver	Screw
Face milling cutters S45HN06																				
40A05R-S45HN06C-C	●	40		16	14		40	47,3			8,4	5,6	5	+	0,25	D-T07P/T09P	FG-15	-	US3007-T09P	HNGX 0604ANSN- XNGX 0604ANSN
50A04R-S45HN06C-C	●	50		22	18		40	57,3			10,4	6,3	4	+	0,42					
50A06R-S45HN06C-C	●	50		22	18		40	57,3			10,4	6,3	6	+	0,40					
63A06R-S45HN06C-C	●	63		22	18		40	70,3			10,4	6,3	6	+	0,55					
63A08R-S45HN06C-C	●	63		22	18		40	70,3			10,4	6,3	8	+	0,55					
80A07R-S45HN06C-C	●	80		27	38,0		50	86,8			12,4	7,0	7	+	1,09					
80A10R-S45HN06C-C	●	80		27	38,0		50	86,8			12,4	7,0	10	+	1,08					
100A08R-S45HN06C-C	●	100		32	45,0		50	107,1			14,4	8,0	8	+	1,81					
100A12R-S45HN06C-C	●	100		32	45,0		50	107,1			14,4	8,0	12	+	1,78					
125A10R-S45HN06C-C	●	125		40	56,0		63	132,2			16,4	9,0	10	+	3,35					
125A16R-S45HN06C-C	●	125		40	56,0		63	132,2			16,4	9,0	16	+	3,31					
End milling cutters SHN06																				
25N2R042B25-SHN06C-C	●	25	25				99	32,2					2	+	0,32	-	-	Flag T09P		
32N3R042B32-SHN06C-C	●	32	32				103	39,3					3	+	0,56					
Exchangeable heads for modular system SHN06																				
25N2R033M12-SHN06C-C	●	25	12,5				M12	56					2	+	0,10	-	-	Flag T09P		
32N3R043M16-SHN06C-C	●	32	17				M16	66					3	+	0,22					
40N4R043M16-SHN06C-C	●	40	17				M16	66					4	+	0,27					

● Stock Assortment ○ Non-stock Assortment

All dimensions in [mm]

Indexable cutting inserts HNGX 06 / XNGX 06




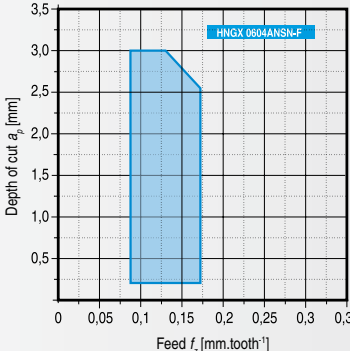
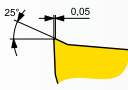
Size	d	s	d ₁
0604	10,50	5,26	3,70


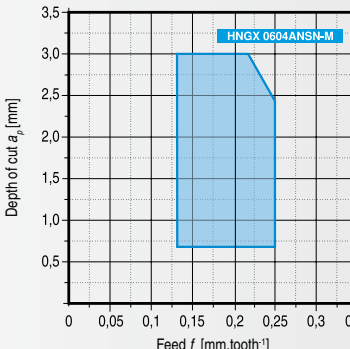
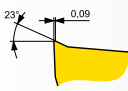
Geometry	ISO	ANSI	Grades								
			M5315	M9315	M9325	8215	8230	8240			
	HNGX 0604ANSN-F	HNGX -54ANSN-F				●	●	●			
	HNGX 0604ANSN-M	HNGX -54ANSN-M	●	●	●	●	●	●			
	HNGX 0604ANSN-R	HNGX -54ANSN-R	●	●	●	●	●	●			
	XNGX 0604ANSN	XNGX -54ANSN				●					


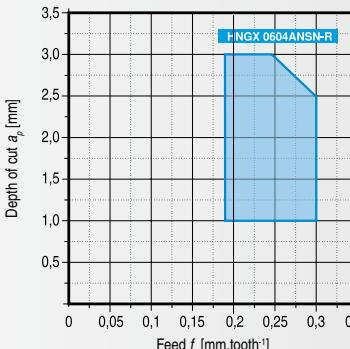
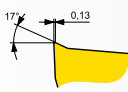
● Stock Assortment ○ Non-stock Assortment


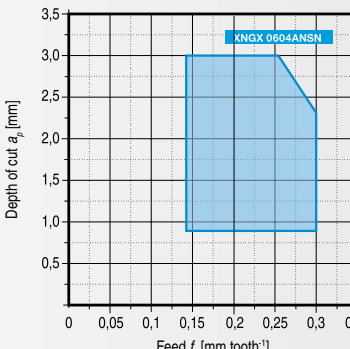
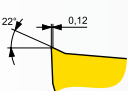
All dimensions in [mm]

Overview of inserts geometry HNGX 06 / XNGX 06

Geometry	Photo	Workpiece material group						Diagram of application	Description
		Milling	P	M	K	N	S		
HNGX 06-F		Finishing	■	□	□	□	□		Applied to inserts: HNGX 0604ANSN-F
	Profile of cutting edge	Medium	■	□	□	□	□		
		Roughing	□	□	□	□	□		
Range of cutting conditions:								f_z	0,08 ÷ 0,17 [mm.tooth ⁻¹]
								a_p	0,3 ÷ 3,0 [mm]

Geometry	Photo	Workpiece material group						Diagram of application	Description
		Milling	P	M	K	N	S		
HNGX 06-M		Finishing	■	□	■	□	□		Applied to inserts: HNGX 0604ANSN-M
	Profile of cutting edge	Medium	■	□	■	□	□		
		Roughing	□	□	□	□	□		
Range of cutting conditions:								f_z	0,13 ÷ 0,25 [mm.tooth ⁻¹]
								a_p	0,7 ÷ 3,0 [mm]

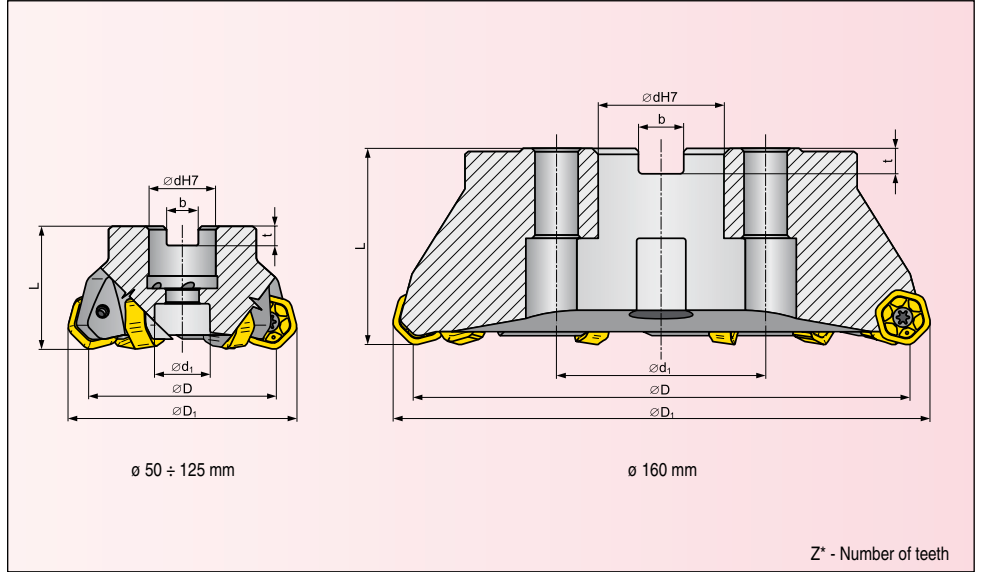
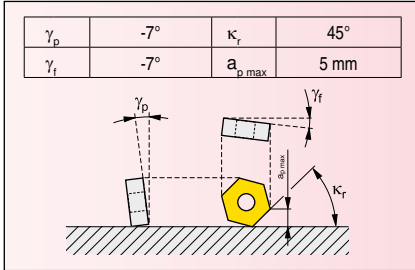
Geometry	Photo	Workpiece material group						Diagram of application	Description
		Milling	P	M	K	N	S		
HNGX 06-R		Finishing	■	□	■	□	□		Applied to inserts: HNGX 0604ANSN-R
	Profile of cutting edge	Medium	■	□	■	□	□		
		Roughing	■	□	■	□	□		
Range of cutting conditions:								f_z	0,18 ÷ 0,3 [mm.tooth ⁻¹]
								a_p	1,0 ÷ 3,0 [mm]

Geometry	Photo	Workpiece material group						Diagram of application	Description
		Milling	P	M	K	N	S		
XNGX 06		Finishing	■	■	□	□	□		Applied to inserts: XNGX 0604ANSN
	Profile of cutting edge	Medium	■	■	□	□	□		
		Roughing	□	□	□	□	□		
Range of cutting conditions:								f_z	0,13 ÷ 0,3 [mm.tooth ⁻¹]
								a_p	0,7 ÷ 3,0 [mm]

Main application
 Other applications
 Conditional applications

S45HN09C

Face milling cutters

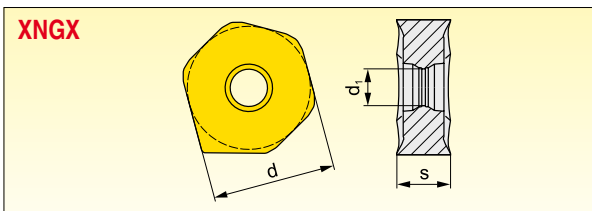
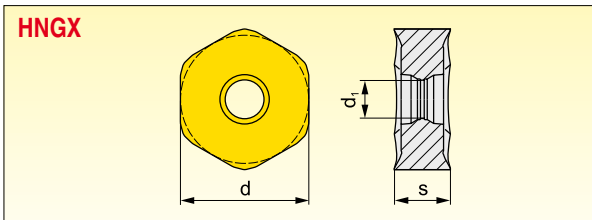


ISO	Assortment	Dimensions [mm]										Spare parts			Inserts
		D	dH7	d ₁	L	D ₁	b	t	Z*	Cooling	[kg]	Screw	Shank	Handle	
50A04R-S45HN09C-C	●	50	22	18,0	40	61,7	10,4	6,3	4	+	0,35	US3512Z-T15P	D-T8P/T15P	FG-15	HNGX 0906ANSN- XNGX 0906ANSN
63A06R-S45HN09C-C	●	63	22	18,0	40	74,7	10,4	6,3	6	+	0,49				
80A06R-S45HN09C-C	●	80	27	38,0	50	91,7	12,4	7,0	6	+	1,06				
80A08R-S45HN09C-C	●	80	27	38,0	50	91,7	12,4	7,0	8	+	1,06				
100A06R-S45HN09C-C	●	100	32	45,0	50	111,7	14,4	8,0	6	+	1,74				
100A08R-S45HN09C-C	●	100	32	45,0	50	111,7	14,4	8,0	8	+	1,74				
100A10R-S45HN09C-C	●	100	32	45,0	50	111,7	14,4	8,0	10	+	1,74				
125A06R-S45HN09C-C	●	125	40	56,0	63	136,7	16,4	9,0	6	+	3,24				
125A10R-S45HN09C-C	●	125	40	56,0	63	136,7	16,4	9,0	10	+	3,24				
125A12R-S45HN09C-C	●	125	40	56,0	63	136,7	16,4	9,0	12	+	3,24				
160C08R-S45HN09C	●	160	40	66,7	63	171,7	16,4	9,0	8		5,70				
160C12R-S45HN09C	●	160	40	66,7	63	171,7	16,4	9,0	12		5,70				
160C14R-S45HN09C	●	160	40	66,7	63	171,7	16,4	9,0	14		5,70				
200C10R-S45HN09C	●	200	60	101,6	63	211,7	25,7	14,0	10		9,00				
250C14R-S45HN09C	●	250	60	101,6	63	261,7	25,7	14,0	14		12,8				
315C16R-S45HN09C	○	315	60	101,6	80	326,7	25,7	14,0	16		32,20				

● Stock Assortment ○ Non-stock Assortment

All dimensions in [mm]

Indexable cutting inserts HNGX 09 / XNGX 09




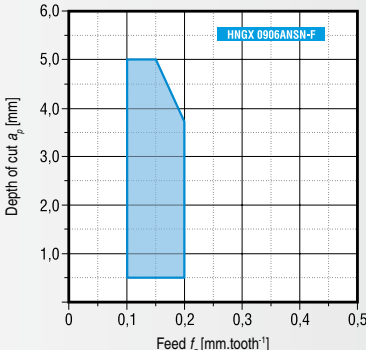
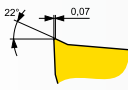
Size	d	s	d ₁
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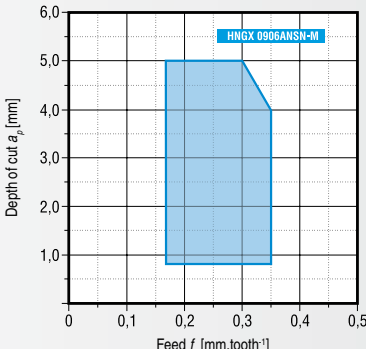
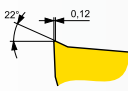
Geometry	ISO	ANSI	Grades														
			M5315	M9315	M9325	2215	2230	8215	8230	8240							
	HNGX 0906ANSN-F	HNGX -54ANSN-F						●	●	●							
	HNGX 0906ANSN-M	HNGX -54ANSN-M	●	●	●	●	●	●	●	●	●						
	HNGX 0906ANSN-R	HNGX -54ANSN-R	●	●	●	●	●	●	●	●	●						
	XNGX 0906ANSN	XNGX -54ANSN															●


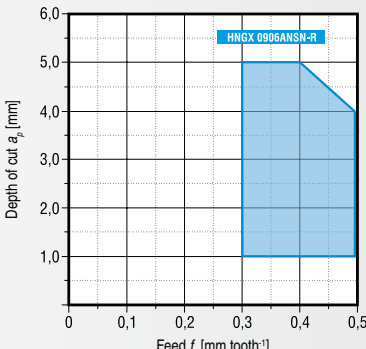
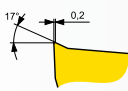
● Stock Assortment ○ Non-stock Assortment


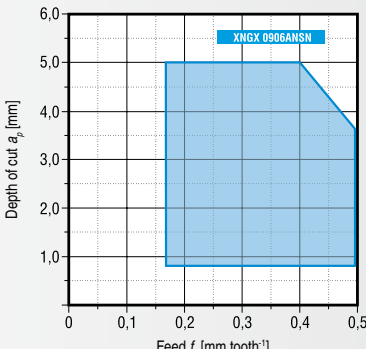
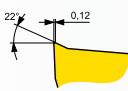
All dimensions in [mm]

Overview of inserts geometry HNGX 09 / XNGX 09















Geometry	Photo	Workpiece material group						Diagram of application	Description
		Milling	P	M	K	N	S		
HNGX 09-F		Finishing	<input checked="" type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>		Applied to inserts: HNGX 0906ANSN-F <ul style="list-style-type: none"> - high positive geometry with narrow T-land - suitable for machining of material groups P conditionally for groups K, M, N and S - especially suitable for light and medium machining
	Profile of cutting edge	Medium	<input checked="" type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>		
		Roughing	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>		
Range of cutting conditions:									
f_z									0,1 ÷ 0,2 [mm.tooth ⁻¹]
a_p									0,5 ÷ 5,0 [mm]

Geometry	Photo	Workpiece material group						Diagram of application	Description
		Milling	P	M	K	N	S		
HNGX 09-M		Finishing	<input checked="" type="checkbox"/>	<input type="checkbox"/>	<input checked="" type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>		Applied to inserts: HNGX 0906ANSN-M <ul style="list-style-type: none"> - high positive geometry with medium T-land - suitable for machining of material groups P and K conditionally for groups N, M and S - especially suitable for medium machining
	Profile of cutting edge	Medium	<input checked="" type="checkbox"/>	<input type="checkbox"/>	<input checked="" type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>		
		Roughing	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>		
Range of cutting conditions:									
f_z									0,17 ÷ 0,35 [mm.tooth ⁻¹]
a_p									0,8 ÷ 5,0 [mm]

Geometry	Photo	Workpiece material group						Diagram of application	Description
		Milling	P	M	K	N	S		
HNGX 09-R		Finishing	<input checked="" type="checkbox"/>	<input type="checkbox"/>	<input checked="" type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>		Applied to inserts: HNGX 0906ANSN-R <ul style="list-style-type: none"> - positive geometry with medium T-land - suitable for machining of material groups P, K and for groups M, S and H - especially suitable for medium to heavy machining
	Profile of cutting edge	Medium	<input checked="" type="checkbox"/>	<input type="checkbox"/>	<input checked="" type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>		
		Roughing	<input checked="" type="checkbox"/>	<input type="checkbox"/>	<input checked="" type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>		
Range of cutting conditions:									
f_z									0,3 ÷ 0,5 [mm.tooth ⁻¹]
a_p									1,0 ÷ 5,0 [mm]

Geometry	Photo	Workpiece material group						Diagram of application	Description
		Milling	P	M	K	N	S		
XNGX 09		Finishing	<input checked="" type="checkbox"/>	<input type="checkbox"/>	<input checked="" type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>		Applied to inserts: XNGX 0906ANSN <ul style="list-style-type: none"> - smooth geometry - suitable for machining of material groups P and K - especially suitable for light and medium machining conditions
	Profile of cutting edge	Medium	<input checked="" type="checkbox"/>	<input type="checkbox"/>	<input checked="" type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>		
		Roughing	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>		
Range of cutting conditions:									
f_z									0,17 ÷ 0,5 [mm.tooth ⁻¹]
a_p									0,8 ÷ 5,0 [mm]

Main application
 Other applications
 Conditional applications

Basic shape of insert		Cutting condition		Initial cutting conditions					
				P	M	K	N	S	H
	HNGX 0604ANSN-F 8215	feed	[mm.tooth ⁻¹]	0,08 - 0,17	0,08 - 0,13	0,08 - 0,17	0,08 - 0,17	0,08 - 0,10	-
		depth of cut	[mm]	0,3 - 3	0,3 - 2,25	0,3 - 3	0,3 - 3	0,3 - 1,8	-
		cutting speed	[m.min ⁻¹]	250 - 365	150 - 215	235 - 345	375 - 1275	50 - 105	-
	HNGX 0604ANSN-F 8230	feed	[mm.tooth ⁻¹]	0,08 - 0,17	0,08 - 0,13	0,08 - 0,17	0,08 - 0,17	0,08 - 0,10	-
		depth of cut	[mm]	0,3 - 3	0,3 - 2,25	0,3 - 3	0,3 - 3	0,3 - 1,8	-
		cutting speed	[m.min ⁻¹]	230 - 365	135 - 215	215 - 345	345 - 1275	45 - 105	-
	HNGX 0604ANSN-F 8240	feed	[mm.tooth ⁻¹]	0,08 - 0,17	0,08 - 0,13	0,08 - 0,17	-	0,08 - 0,10	-
		depth of cut	[mm]	0,3 - 3	0,3 - 2,25	0,3 - 3	-	0,3 - 1,8	-
		cutting speed	[m.min ⁻¹]	200 - 290	120 - 170	190 - 275	-	40 - 85	-
	HNGX 0604ANSN-M M5315	feed	[mm.tooth ⁻¹]	-	-	0,13 - 0,25	-	-	-
		depth of cut	[mm]	-	-	0,7 - 3	-	-	-
		cutting speed	[m.min ⁻¹]	-	-	255 - 435	-	-	-
	HNGX 0604ANSN-M M9315	feed	[mm.tooth ⁻¹]	0,13 - 0,25	-	0,13 - 0,25	-	-	-
		depth of cut	[mm]	0,7 - 3	-	0,7 - 3	-	-	-
		cutting speed	[m.min ⁻¹]	285 - 455	-	270 - 430	-	-	-
	HNGX 0604ANSN-M M9325	feed	[mm.tooth ⁻¹]	0,13 - 0,25	0,13 - 0,19	-	-	0,13 - 0,15	-
		depth of cut	[mm]	0,7 - 3	0,7 - 2,25	-	-	0,7 - 1,8	-
		cutting speed	[m.min ⁻¹]	300 - 445	180 - 265	-	-	60 - 130	-
	HNGX 0604ANSN-M 8215	feed	[mm.tooth ⁻¹]	0,13 - 0,25	0,13 - 0,19	0,13 - 0,25	0,13 - 0,25	0,13 - 0,15	-
		depth of cut	[mm]	0,7 - 3	0,7 - 2,25	0,7 - 3	0,7 - 3	0,7 - 1,8	-
		cutting speed	[m.min ⁻¹]	245 - 320	145 - 190	230 - 300	365 - 1120	45 - 95	-
	HNGX 0604ANSN-M 8230	feed	[mm.tooth ⁻¹]	0,13 - 0,25	0,13 - 0,19	0,13 - 0,25	0,13 - 0,25	0,13 - 0,15	-
		depth of cut	[mm]	0,6 - 3	0,6 - 2,3	0,6 - 3	0,6 - 3	0,6 - 1,8	-
		cutting speed	[m.min ⁻¹]	215 - 310	125 - 185	200 - 290	320 - 1085	40 - 90	-
	HNGX 0604ANSN-M 8240	feed	[mm.tooth ⁻¹]	0,13 - 0,25	0,13 - 0,19	0,13 - 0,25	-	0,13 - 0,15	-
		depth of cut	[mm]	0,7 - 3	0,7 - 2,25	0,7 - 3	-	0,7 - 1,8	-
		cutting speed	[m.min ⁻¹]	195 - 260	115 - 155	185 - 245	-	35 - 75	-
	HNGX 0604ANSN-R M5315	feed	[mm.tooth ⁻¹]	-	-	0,18 - 0,3	-	-	-
		depth of cut	[mm]	-	-	1 - 3	-	-	-
		cutting speed	[m.min ⁻¹]	-	-	230 - 355	-	-	-
	HNGX 0604ANSN-R M9315	feed	[mm.tooth ⁻¹]	0,18 - 0,3	-	0,18 - 0,3	-	-	0,1 - 0,2
		depth of cut	[mm]	1 - 3	-	1 - 3	-	-	0,3 - 1,5
		cutting speed	[m.min ⁻¹]	270 - 390	-	255 - 370	-	-	50 - 75
	HNGX 0604ANSN-R M9325	feed	[mm.tooth ⁻¹]	0,18 - 0,3	0,18 - 0,23	-	-	0,18 - 0,23	-
		depth of cut	[mm]	1 - 3	1 - 2,25	-	-	1 - 1,8	-
		cutting speed	[m.min ⁻¹]	285 - 390	170 - 230	-	-	55 - 115	-
	HNGX 0604ANSN-R 8215	feed	[mm.tooth ⁻¹]	0,18 - 0,3	0,18 - 0,23	0,18 - 0,3	-	0,18 - 0,23	0,1 - 0,2
		depth of cut	[mm]	1 - 3	1 - 2,25	1 - 3	-	1 - 1,8	0,3 - 1,5
		cutting speed	[m.min ⁻¹]	240 - 300	140 - 180	225 - 285	-	45 - 90	45 - 60
	HNGX 0604ANSN-R 8230	feed	[mm.tooth ⁻¹]	0,18 - 0,3	0,18 - 0,23	0,18 - 0,3	-	0,18 - 0,23	0,1 - 0,2
		depth of cut	[mm]	1 - 3	1 - 2,25	1 - 3	-	1 - 1,8	0,3 - 1,5
		cutting speed	[m.min ⁻¹]	210 - 275	125 - 165	195 - 260	-	40 - 80	40 - 55
	HNGX 0604ANSN-R 8240	feed	[mm.tooth ⁻¹]	0,18 - 0,3	0,18 - 0,23	0,18 - 0,3	-	0,18 - 0,23	-
		depth of cut	[mm]	1 - 3	1 - 2,25	1 - 3	-	1 - 1,8	-
		cutting speed	[m.min ⁻¹]	195 - 245	115 - 145	185 - 230	-	35 - 70	-
	XNGX 0604ANSN 8215	feed	[mm.tooth ⁻¹]	0,13 - 0,25	0,13 - 0,19	0,13 - 0,25	0,13 - 0,25	0,13 - 0,15	-
		depth of cut	[mm]	-	0,7 - 2,25	0,7 - 3	0,7 - 3	0,7 - 1,8	-
		cutting speed	[m.min ⁻¹]	-	125 - 165	200 - 265	320 - 980	40 - 80	-
	HNGX 0906ANSN-M M5315	feed	[mm.tooth ⁻¹]	-	-	0,17 - 0,35	-	-	-
		depth of cut	[mm]	-	-	0,8 - 5	-	-	-
		cutting speed	[m.min ⁻¹]	-	-	200 - 375	-	-	-
	HNGX 0906ANSN-R M5315	feed	[mm.tooth ⁻¹]	-	-	0,3 - 0,5	-	-	-
		depth of cut	[mm]	-	-	1 - 5	-	-	-
		cutting speed	[m.min ⁻¹]	-	-	175 - 280	-	-	-
	HNGX 0906ANSN-M M9315	feed	[mm.tooth ⁻¹]	0,17 - 0,35	-	0,17 - 0,35	-	-	-
		depth of cut	[mm]	0,8 - 5	-	0,8 - 5	-	-	-
		cutting speed	[m.min ⁻¹]	240 - 405	-	225 - 380	-	-	-
	HNGX 0906ANSN-R M9315	feed	[mm.tooth ⁻¹]	0,3 - 0,5	-	0,3 - 0,5	-	-	0,1 - 0,2
		depth of cut	[mm]	1 - 5	-	1 - 5	-	-	0,3 - 1,5
		cutting speed	[m.min ⁻¹]	215 - 325	-	200 - 305	-	-	40 - 65
	HNGX 0906ANSN-M M9325	feed	[mm.tooth ⁻¹]	0,17 - 0,35	0,17 - 0,26	-	-	0,17 - 0,21	-
		depth of cut	[mm]	0,8 - 5	0,8 - 3,75	-	-	0,8 - 3	-
		cutting speed	[m.min ⁻¹]	260 - 405	155 - 240	-	-	50 - 120	-
	HNGX 0906ANSN-R M9325	feed	[mm.tooth ⁻¹]	0,3 - 0,5	0,3 - 0,38	-	-	0,3 - 0,38	-
		depth of cut	[mm]	1 - 5	1 - 3,75	-	-	1 - 3	-
		cutting speed	[m.min ⁻¹]	235 - 350	140 - 210	-	-	45 - 105	-
	HNGX 0906ANSN-F 8215	feed	[mm.tooth ⁻¹]	0,1 ÷ 0,2	0,1 ÷ 0,15	0,1 ÷ 0,2	0,1 ÷ 0,2	-	-
		depth of cut	[mm]	0,5 ÷ 5	0,5 ÷ 3,75	0,5 ÷ 5	0,5 ÷ 5	-	-
		cutting speed	[m.min ⁻¹]	290 ÷ 390	170 ÷ 230	275 ÷ 370	435 ÷ 1365	-	-
	HNGX 0906ANSN-F 8230	feed	[mm.tooth ⁻¹]	0,1 - 0,2	0,1 - 0,15	0,1 - 0,2	0,1 - 0,2	0,1 - 0,12	-
		depth of cut	[mm]	0,5 - 5,0	0,5 - 3,8	0,5 - 5,0	0,5 - 5,0	0,5 - 3,0	-
		cutting speed	[m.min ⁻¹]	300 - 440	180 - 260	285 - 415	450 - 1540	60 - 130	-
	HNGX 0906ANSN-F 8240	feed	[mm.tooth ⁻¹]	0,1 - 0,2	0,1 - 0,15	0,1 - 0,2	-	0,1 - 0,12	-
		depth of cut	[mm]	0,5 - 5,0	0,5 - 3,8	0,5 - 5,0	-	0,5 - 3,0	-
		cutting speed	[m.min ⁻¹]	270 - 365	160 - 215	255 - 345	-	50 - 105	-
	HNGX 0906ANSN-M 8215	feed	[mm.tooth ⁻¹]	0,17 ÷ 0,35	0,17 ÷ 0,26	0,17 ÷ 0,35	0,17 ÷ 0,35	-	-
		depth of cut	[mm]	0,8 ÷ 5	0,8 ÷ 3,75	0,8 ÷ 5	0,8 ÷ 5	-	-
		cutting speed	[m.min ⁻¹]	295 ÷ 375	175 ÷ 225	280 ÷ 355	440 ÷ 1310	-	-
	HNGX 0906ANSN-M 8230	feed	[mm.tooth ⁻¹]	0,17 - 0,35	0,17 - 0,26	0,17 - 0,35	0,17 - 0,35	0,17 - 0,21	-
		depth of cut	[mm]	0,8 - 5,0	0,8 - 3,8	0,8 - 5,0	0,8 - 5,0	0,8 - 3,0	-
		cutting speed	[m.min ⁻¹]	275 - 385	165 - 230	260 - 365	410 - 1345	55 - 115	-
	HNGX 0906ANSN-M 8240	feed	[mm.tooth ⁻¹]	0,17 - 0,35	0,17 - 0,26	0,17 - 0,35	-	0,17 - 0,21	-
		depth of cut	[mm]	0,8 - 5,0	0,8 - 3,8	0,8 - 5,0	-	0,8 - 3,0	-
		cutting speed	[m.min ⁻¹]	265 - 335	155 - 200	250 - 315	-	50 - 100	-
	HNGX 0906ANSN-R 8215	feed	[mm.tooth ⁻¹]	0,3 ÷ 0,5	0,3 ÷ 0,38	0,3 ÷ 0,5	-	-	0,1 ÷ 0,2
		depth of cut	[mm]	1 ÷ 5	1 ÷ 3,75	1 ÷ 5	-	-	0,3 ÷ 1,5
		cutting speed	[m.min ⁻¹]	290 ÷ 355	170 ÷ 210	275 ÷ 335	-	-	55 ÷ 70
	HNGX 0906ANSN-R 8230	feed	[mm.tooth ⁻¹]	0,3 - 0,5	0,3 - 0,38	0,3 - 0,5	-	0,3 - 0,38	0,1 - 0,2
		depth of cut	[mm]	1,0 - 5,0	1,0 - 3,8	1,0 - 5,0	-	1,0 - 3,0	0,3 - 1,5
		cutting speed	[m.min ⁻¹]	255 - 340	150 - 200	240 - 320	-	50 - 100	50 - 65
	HNGX 0906ANSN-R 8240	feed	[mm.tooth ⁻¹]	0,3 - 0,5	0,3 - 0,38	0,3 - 0,5	-	0,3 - 0,38	-
		depth of cut	[mm]	1,0 - 5,0	1,0 - 3,8	1,0 - 5,0	-	1,0 - 3,0	-
		cutting speed	[m.min ⁻¹]	255 - 320	150 - 190	240 - 300	-	50 - 95	-
	XNGX 0906ANSN 8230	feed	[mm.tooth ⁻¹]	0,17 - 0,5	-	0,17 - 0,5	-	-	-
		depth of cut	[mm]	0,8 - 5,0	-	0,8 - 5,0	-	-	-
		cutting speed	[m.min ⁻¹]	255 - 385	-	240 - 365	-	-	-

Initial cutting conditions for inserts HNGX 09 and XNGX 09 in grade 2215 and 2230 you can find on www.pramet.com/ecat of catalogue or Milling Pramet Tools.



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