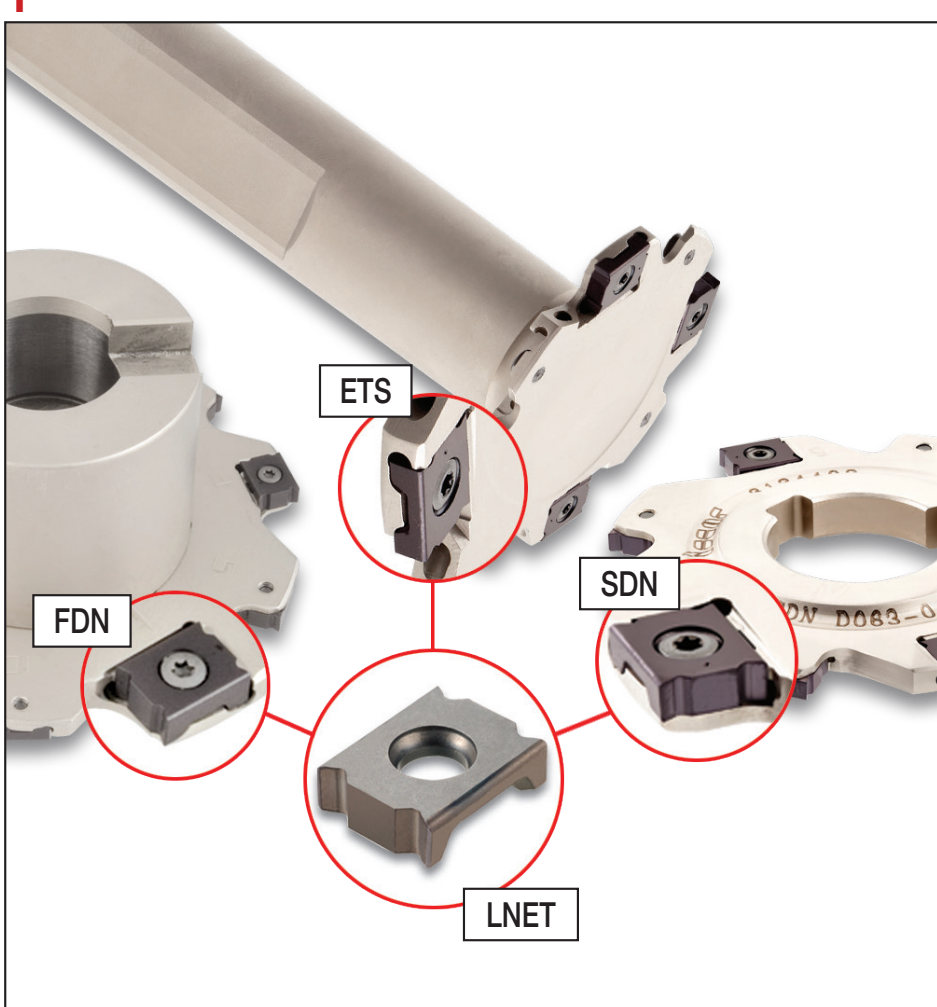
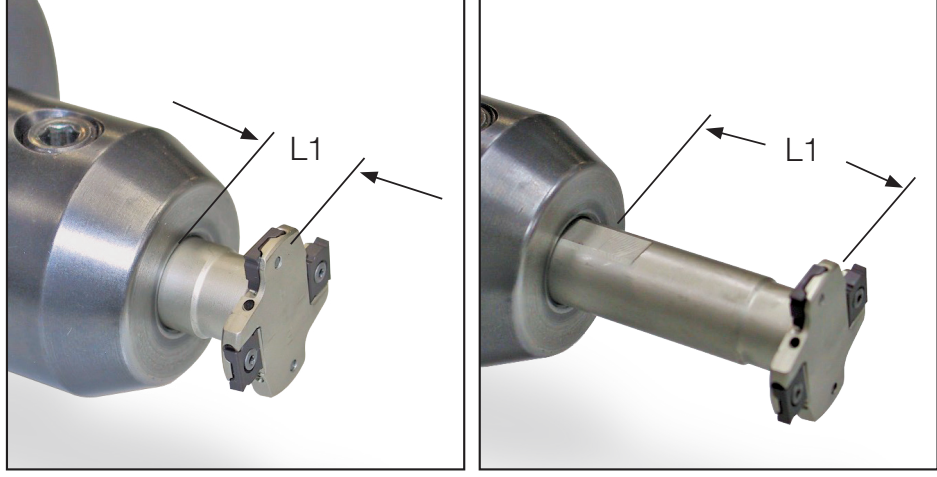
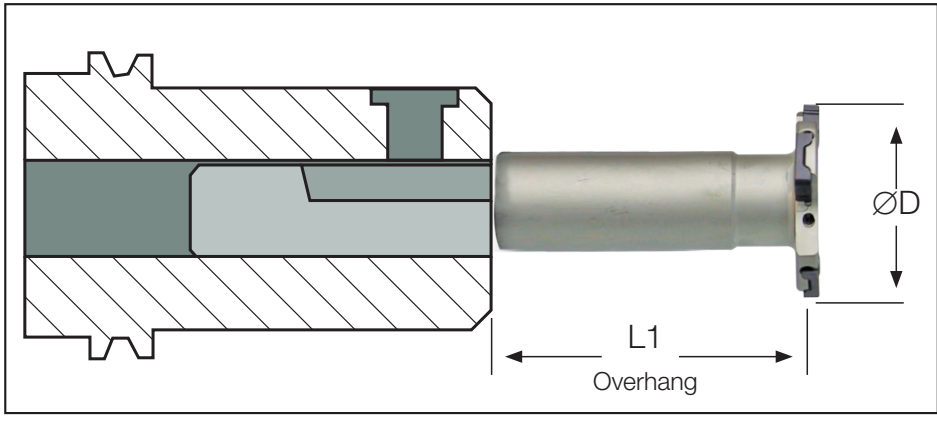


1



2 Setting the Overhang

ETS... T-type Slotting Cutters			
Designation	D	L Overhang	
		Min	Max
ETS D32	32	20	49
ETS D40	40	34	63
ETS D50	50	27	66
ETS D63	63	27	66

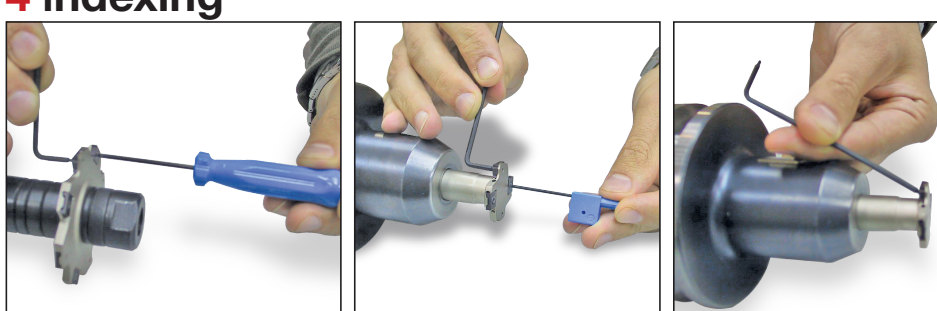


3 Lubrication - Important!

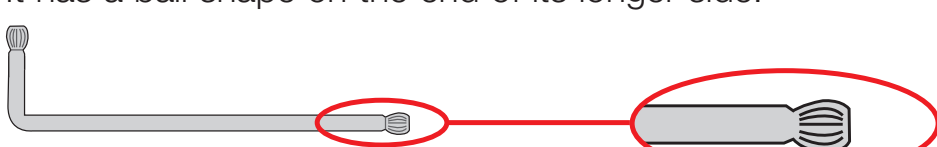
For every indexing, lubricate screws before mounting. Grease should cover the screw's thread and cone head.



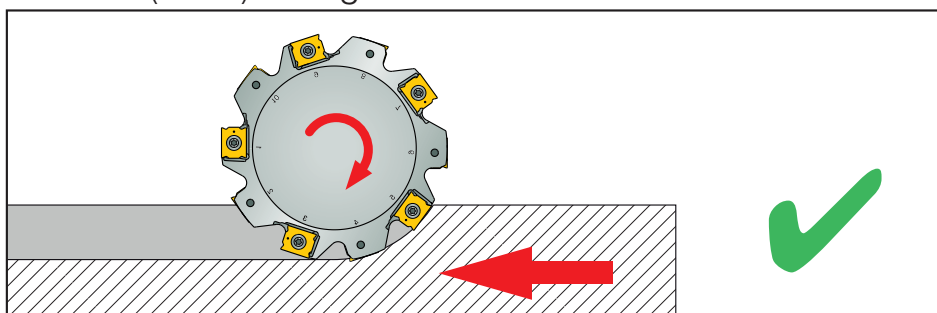
4 Indexing



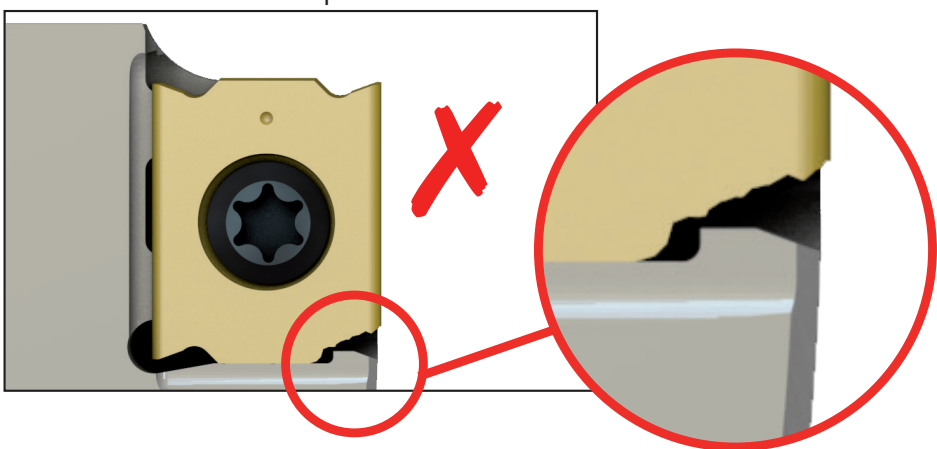
L -type key is added to the cutter package. It has a ball shape on the end of its longer side.



Feed Direction:
Down (climb) milling is recommended.



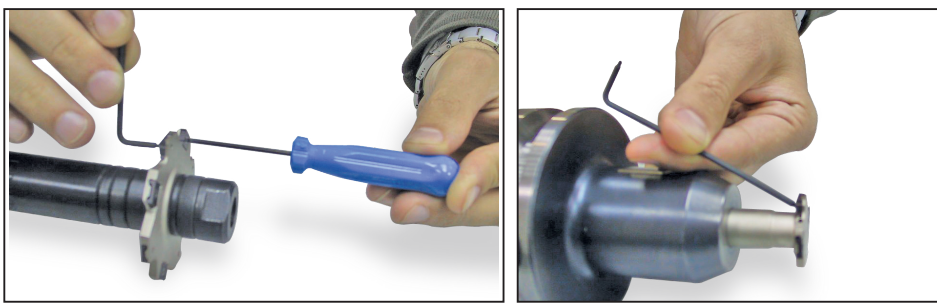
Do not clamp insert with a broken corner in the outer bottom position.



5 Tightening Torque

60-70 N x cm

6 Tightening



Use the short side for tightening and initial release

Use the long side for quick driving and release

Important note:
To avoid indexing problems, insert clamping screws and replace keys on a regular basis according to their wear.

7 Width of cut -

for $a_p = 3 - 6.5 \text{ mm}$ - use the following table

a_p	Insert	Screw	Key
3.00	LNET 081804-TN-N	SR 114-018-L2.50	T-6/5 T-6/5-L
4.00	LNET 082604-TN-N	SR 114-018-L3.40	
4.50	LNET 082804-TN-N	SR 114-018-L4.40	
5.00	LNET 083004-TN-N	SR 114-018-L4.40	
5.50	LNET 083204-TN-N	SR 114-018-L4.40	
6.00	LNET 083504-TN-N	SR 114-018-L5.30	
6.50	LNET 083704-TN-N		

8 Recommended Cutting Speed

ISO class DIN/ISO 513	Description	Workpiece Material			ISCAR mat. group**	Cutting speed V_c , m/min	Insert	Grade	Coolant
		Typical Example							
P	Non-alloy steel	1020	1.0402	130-180	1	130-200	LN...08	IC928	Air blow
	Alloy steel	4340	1.6582	260-300	8	120-170	LN...08	IC928	
	Alloy steel	3135	1.5710	HRC 35-40*	9	100-120	LN...08	IC928	
	High alloy steel	H13	1.2344	200-220	10	100-150	LN...08	IC928	
	Martensitic s.s.	420	1.4021	200	12	100-140	LN...08	IC928	
M	Austenitic s.s.	304L	1.4306	200	14	70-120	LN...08	IC928	Wet (emulsion)
	Austenitic s.s.	316L	1.4404	140	14	80-120	LN...08	IC928	
K	Grey cast iron	Class 40	0.6025 (GG25)	250	16	180-230	LN...08	IC910	Air blow
	Nodular cast iron	Class 65-45-12	0.7050 (GGG50)	200	17	150-200	LN...08	IC910	
S	High temp. alloys	AMS R56400	3.7165 (Ti6Al4V)	HRC 40-45	37	35-45	LN...08	IC928	Wet (emulsion)

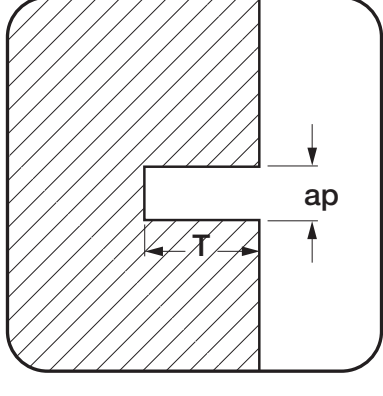
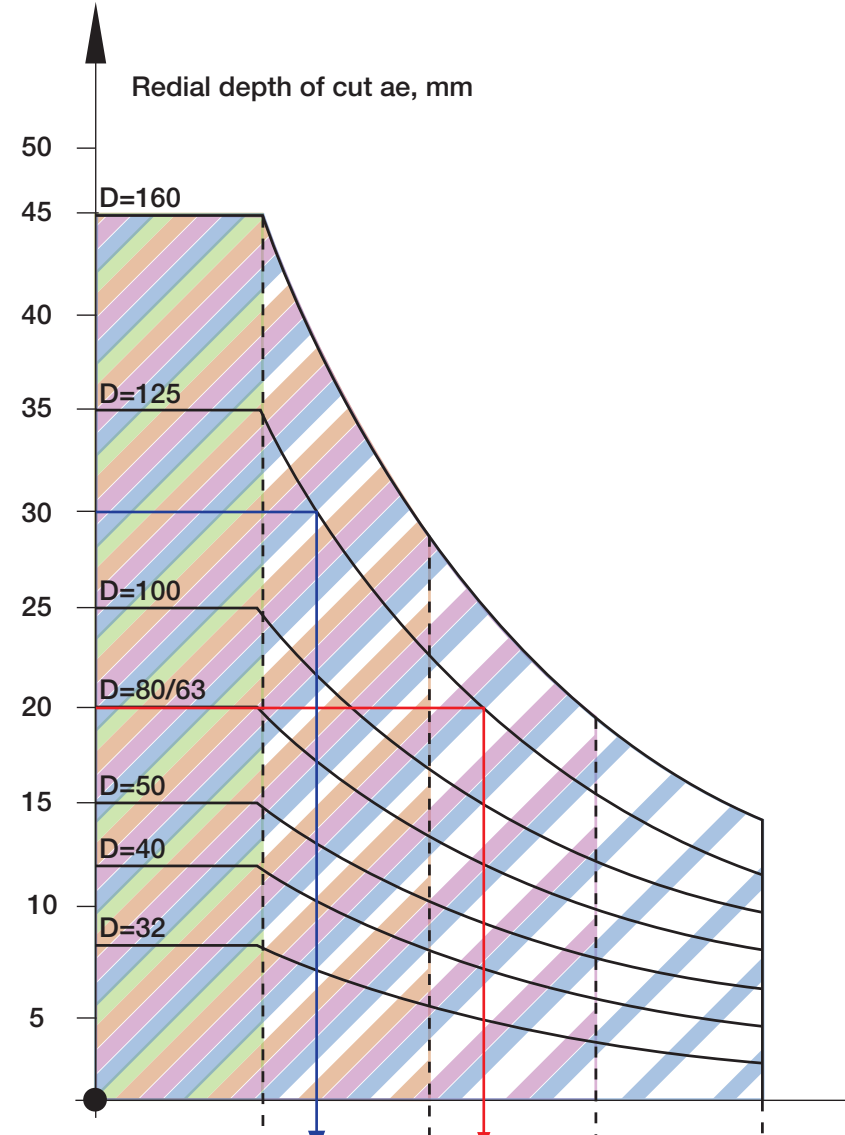
* Quenched and tempered

** ISCAR material group in accordance with VDI 3323 standard

9 MINI-TANGSLOT

Recommended feed per tooth for MINI-TANGSLOT cutters

carrying LN..08... inserts for $3 \text{ mm} \leq a_p < 7 \text{ mm}$



Example

Material - Alloy steel DIN 40NiCrMo6, W.-Nr.16565

D = 125 mm

ae = 30 mm

ap = 4 mm

fz = 0.2x0.75*

= 0.15 mm/tooth

D = 125 mm

ae = 20 mm

ap = 6 mm

fz = 0.25x1=0.25 mm/tooth

fz= fz0xK

a_p mm	K
from 3 to 4	0.60
from 4 up to 5	0.75
over 5 to 7	1

0.17	0.22	0.27	0.32	Non-alloy steel	1020 (DIN 1.0402)	1	P
0.15	0.2	0.25	0.3	Alloy steel	4340 (DIN 1.6582)	8	
0.1	0.13	0.15	0.2	Alloy steel	3135 (DIN 1.5710)	9	
0.1	0.13	0.16	0.22	High alloy steel	H13 (DIN 1.2344)	10	
0.13	0.16	0.2	0.25	Martensitic s.s.	420 (DIN 1.4021)	12	M
0.1	0.13	0.16	0.22	Austenitic s.s.	316L (DIN 1.4404)	14	
0.2	0.25	0.3	0.35	Grey cast iron	Class 40 (DIN 0.6025) (GG25)	16	K
0.15	0.2	0.25	0.3	Nodular cast iron	Class 65-45-12 (DIN 0.7050) (GGG50)	17	
0.1	0.13	0.16	0.22	High temp. alloys	AMS R56400 (DIN 3.7165)	37	S

Basic feed fz0, mm/tooth

Description

AISI / SAE / ASTM (DIN W.-Nr.)

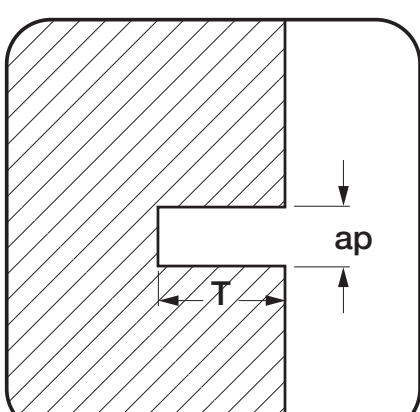
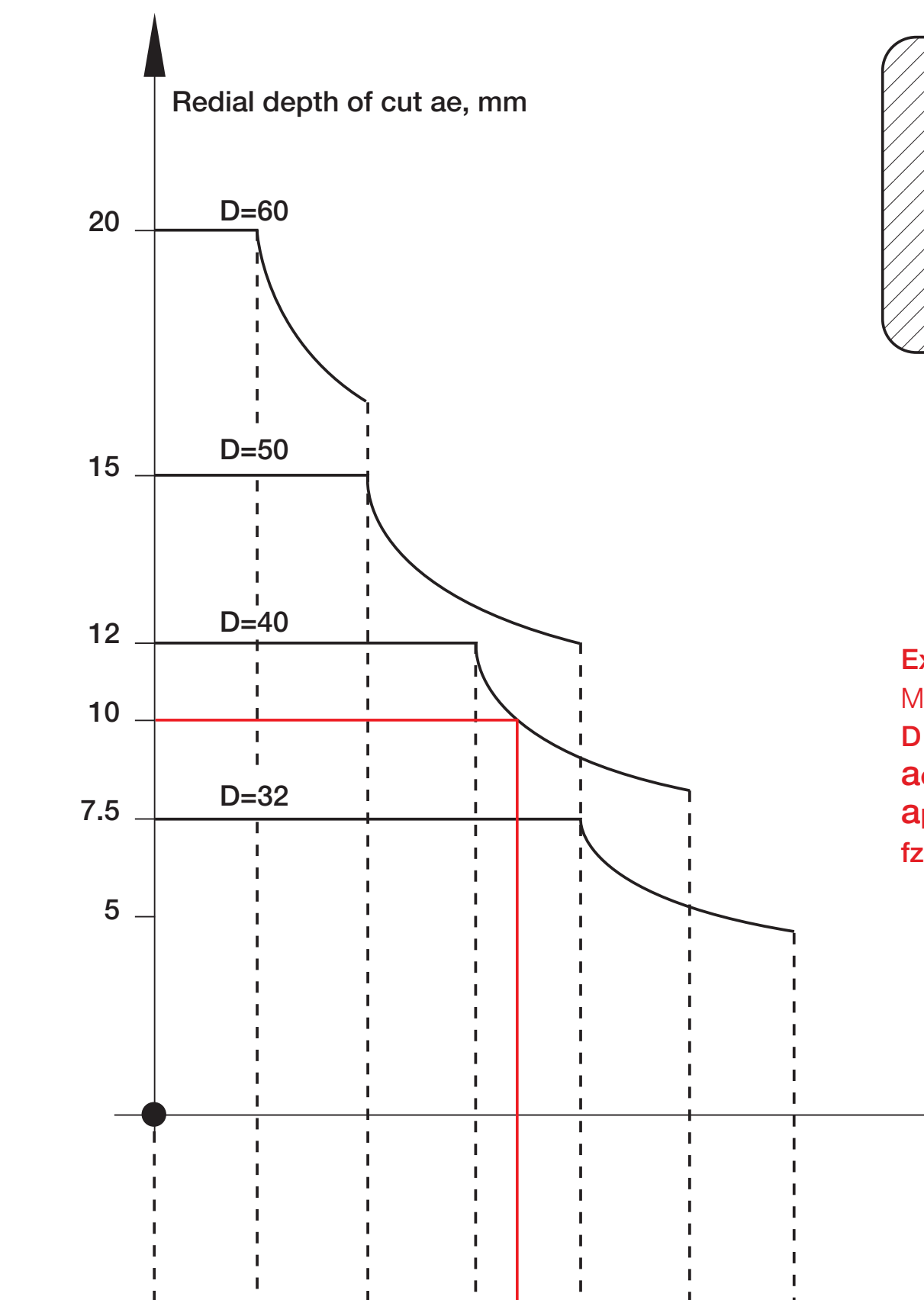
ISCAR Mat. Group

DIN/ISO

Workpiece Material

10 Recommended feed per tooth for MINI-TANGSLOT cutters

carrying LN..08... inserts for $a_p = 7-8 \text{ mm}$



Example

Material - Alloy steel DIN 40NiCrMo6, W.-Nr.16565

D = 40 mm

ae = 10 mm

ap = 8 mm

fz = 0.09x0.8=0.072 mm/tooth

0.045	0.060	0.090	0.105	0.120	0.135	Non-alloy steel	1020 (DIN 1.0402)	1	P
0.045	0.060	0.075	0.090	0.105	0.120	Alloy steel	4340 (DIN 1.6582)	8	
0.030	0.045	0.052	0.060	0.068	0.075	Alloy steel	3135 (DIN 1.5710)	9	
0.030	0.045	0.052	0.060	0.075	0.090	High alloy steel	H13 (DIN 1.2344)	10	
0.030	0.052	0.068	0.082	0.090	0.105	Martensitic s.s.	420 (DIN 1.4021)	12	M
0.030	0.045	0.052	0.068	0.075	0.090	Austenitic s.s.	316L (DIN 1.4404)	14	
0.068	0.090	0.105	0.120	0.135	0.150	Grey cast iron	Class 40 (DIN 0.6025) (GG25)	16	K
0.045	0.075	0.090	0.105	0.120	0.135	Nodular cast iron	Class 65-45-12 (DIN 0.7050) (GGG50)	17	
0.030	0.045	0.052	0.060	0.075	0.090	High temp. alloys	AMS R56400 (DIN 3.7165)	37	S

Basic feed fz0 mm/tooth

Description

AISI / SAE / ASTM / DIN

ISCAR mat. group

DIN/ISO

Workpiece material

fz= fz0xK

a_p mm	K
from 7 up to 7.5	1
over 7.5 up to 8	0.80