

Helical Mills



M390 SD1204...

Max depth of cut: 17mm

Lead angle: 90°

Indexes per insert: 4

Diameter: 50–80mm

Pages: K4–K9



Maximum cutting depth (Ap1) and contact width (ae) ratios based on application type

Slot Milling

$ae = 1 \times D1$
 $Ap1 \text{ max} = 0,6 \times D1$



**Not recommended in ISO "H" materials.*

Contouring

$ae = 0,25-0,4 \times D1$
 $Ap1 \text{ max} = 1 \times D1$
 $ae = >0,4 \times D1$
 $Ap1 \text{ max} = 0,6 \times D1$



**Not recommended in ISO "H" materials.*

Profiling

$ae = <0,25 \times D1$
 $Ap1 \text{ max} = Ap1 \text{ max}$

