

TWO TIMES MORE



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NEW LINE OF CUTTERS WITH SETTING ANGLE 90°
FOR ECONOMICAL MILLING WITH INSERTS

LNGX12 and LNGU16

AVAILABLE ALSO IN NEW GRADES WITH MTCVD COATING

TEMMAK
Türkiye Yetkili Distribütörü

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PRAMET

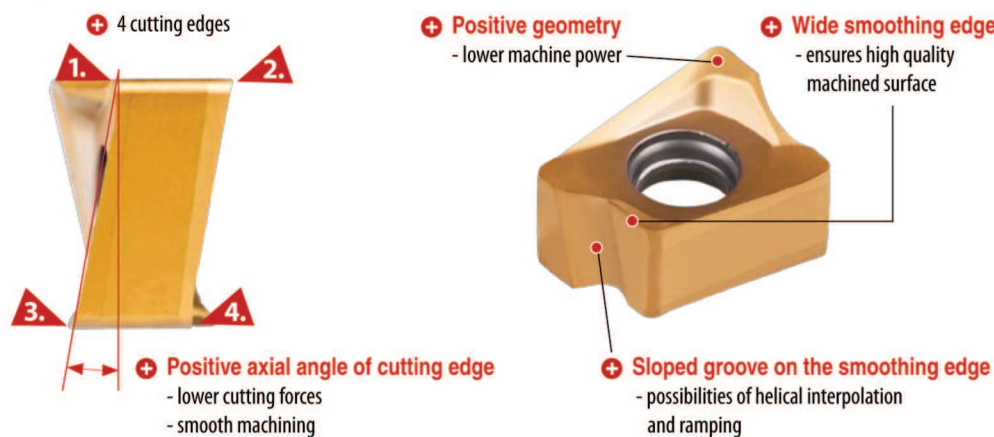
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CUTTING TOOLS WITH LNGX 12 AND LNGU 16 INSERTS

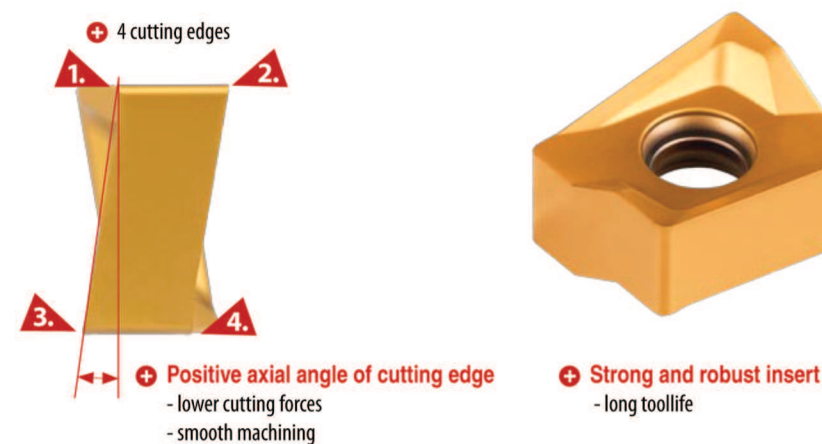
PRAMET
AGE **MILL**

Both-side inserts with 4 cutting edges

LNGX 120508ER-M



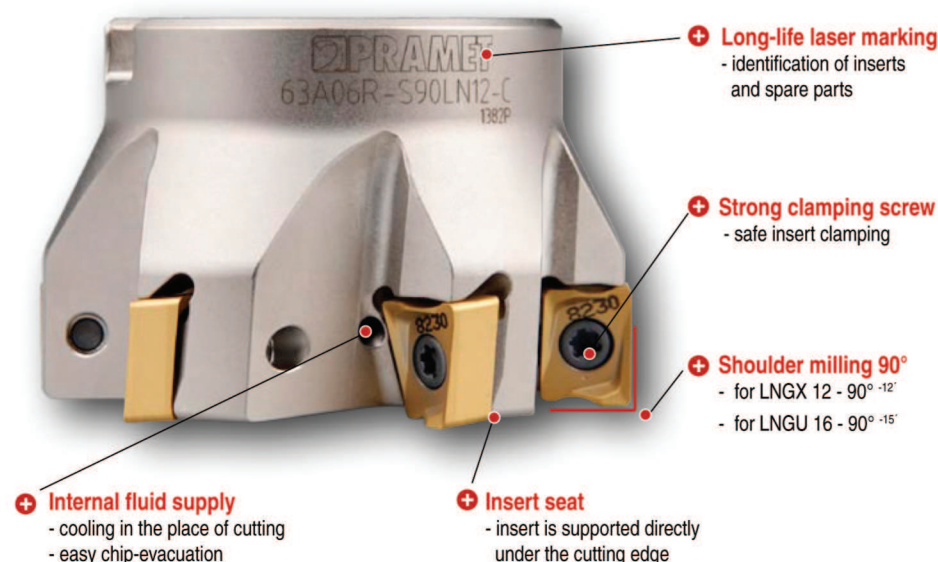
LNGU 160708SR-M



90° cutters for economical machining with LNGX12 and LNGU 16 inserts

Universal use:
face milling,
shoulder milling,
slotting
and grooving

PLUS
for LNGX 12
milling by helical
interpolation
ramping
progressive
plunging



both-side inserts
LNGX 12 and LNGU
16 with 4 cutting
edges

periphery grinded
inserts for precise
milling

ramping and helical
interpolation
for LNGX 12

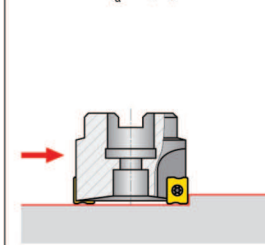
high quality
of machined
surface

wide cutter
assortment

Wide area of applications of new milling cutters with inserts LNGX 12 and LNGU 16

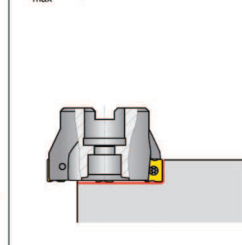
FACE MILLING

LNGX 12 $R_a \leq 0,7 \mu m$
LNGU 16 $R_a \leq 0,7 \mu m$



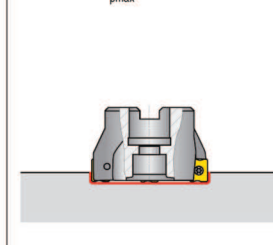
SHOULDER MILLING

areas link-up
 $x_{max} \leq 0,03 mm$



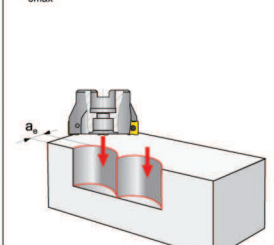
SLOT MILLING

LNGX 12 $a_{pmax} = 9 mm$
LNGU 16 $a_{pmax} = 13 mm$



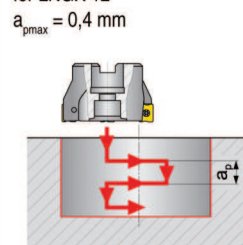
PLUNGE MILLING

$a_{emax} = 3,5 mm$ for LNGX 12
 $a_{emax} = 7 mm$ for LNGU 16

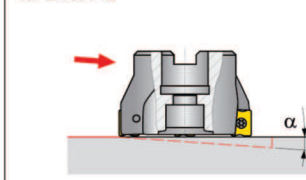


PROGRESSIVE PLUNGING

for LNGX 12
 $a_{pmax} = 0,4 mm$

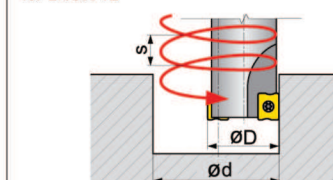


RAMPING for LNGX 12



cutter Ø	$\alpha_{max} [^\circ]$
25	2,20
32	1,20
40	0,85
50	0,65
63	0,45
80	0,35
100	0,25
110	0,2

MILLING BY HELICAL INTERPOLATION for LNGX 12



cutter Ø	d_{min}	s_{max}	d_{max}	s_{min}
25	43	2,20	48	2,80
32	57	1,65	62	2,00
40	73	1,55	78	1,75
50	93	1,50	98	1,70
63	119	1,40	124	1,50

Assortment of inserts LNGX 12/LNGU 16

Basic shape of insert		Cutting condition		Initial cutting conditions					
				P	M	K	N	S	H
	LNGX 120508ER-M M9315	feed	[mm.teeth ⁻¹]	0,05 - 0,15	-	0,05 - 0,15	-	-	0,1 - 0,2
		depth of cut	[mm]	1 - 9	-	1 - 9	-	-	0,3 - 1,5
		cutting speed	[m.min ⁻¹]	255 - 475	-	240 - 450	-	-	50 - 95
	LNGX 120508ER-M M9325	feed	[mm.teeth ⁻¹]	0,05 - 0,15	0,05 - 0,11	-	-	0,05 - 0,09	-
		depth of cut	[mm]	1 - 9	1 - 6,75	-	-	1 - 5,4	-
		cutting speed	[m.min ⁻¹]	250 - 420	150 - 250	-	-	50 - 125	-
	LNGX 120508ER-M 8215	feed	[mm.teeth ⁻¹]	0,05 - 0,25	0,05 - 0,19	0,05 - 0,25	-	0,05 - 0,15	0,1 - 0,2
		depth of cut	[mm]	1 - 9	1 - 6,75	1 - 9	-	1 - 5,4	0,3 - 1,5
		cutting speed	[m.min ⁻¹]	185 - 255	110 - 150	175 - 240	-	35 - 75	35 - 50
	LNGX 120508ER-M 8230	feed	[mm.teeth ⁻¹]	0,05 - 0,25	0,05 - 0,19	0,05 - 0,25	-	0,05 - 0,15	0,1 - 0,2
		depth of cut	[mm]	1 - 9	1 - 6,75	1 - 9	-	1 - 5,4	0,3 - 1,5
		cutting speed	[m.min ⁻¹]	160 - 245	95 - 145	150 - 235	-	30 - 75	30 - 50
	LNGX 120508ER-M 8240	feed	[mm.teeth ⁻¹]	0,05 - 0,25	0,05 - 0,19	0,05 - 0,25	-	0,05 - 0,15	-
		depth of cut	[mm]	1 - 9	1 - 6,75	1 - 9	-	1 - 5,4	-
		cutting speed	[m.min ⁻¹]	145 - 205	85 - 120	135 - 190	-	25 - 60	-
	LNGU 160708SR-M M9315	feed	[mm.teeth ⁻¹]	0,1 - 0,25	-	0,1 - 0,25	-	-	0,1 - 0,2
		depth of cut	[mm]	1 - 13	-	1 - 13	-	-	0,3 - 1,5
		cutting speed	[m.min ⁻¹]	205 - 375	-	190 - 355	-	-	40 - 75
	LNGU 160708SR-M M9325	feed	[mm.teeth ⁻¹]	0,1 - 0,25	0,1 - 0,19	-	-	0,1 - 0,15	-
		depth of cut	[mm]	1 - 13	1 - 9,75	-	-	1 - 7,8	-
		cutting speed	[m.min ⁻¹]	215 - 355	125 - 210	-	-	40 - 105	-
	LNGU 160708SR-M 8215	feed	[mm.teeth ⁻¹]	0,1 - 0,3	0,1 - 0,23	0,1 - 0,3	-	0,1 - 0,18	0,1 - 0,2
		depth of cut	[mm]	1 - 13	1 - 9,75	1 - 13	-	1 - 7,8	0,3 - 1,5
		cutting speed	[m.min ⁻¹]	175 - 245	105 - 145	165 - 230	-	35 - 70	35 - 45
	LNGU 160708SR-M 8230	feed	[mm.teeth ⁻¹]	0,1 - 0,3	0,1 - 0,23	0,1 - 0,3	-	0,1 - 0,18	0,1 - 0,2
		depth of cut	[mm]	1 - 13	1 - 9,75	1 - 13	-	1 - 7,8	0,3 - 1,5
		cutting speed	[m.min ⁻¹]	150 - 240	90 - 140	140 - 225	-	30 - 70	30 - 45
	LNGU 160708SR-M 8240	feed	[mm.teeth ⁻¹]	0,1 - 0,3	0,1 - 0,23	0,1 - 0,3	-	0,1 - 0,18	-
		depth of cut	[mm]	1 - 13	1 - 9,75	1 - 13	-	1 - 7,8	-
		cutting speed	[m.min ⁻¹]	140 - 200	80 - 120	130 - 190	-	25 - 60	-

[illegible]

LNx 12

- Stock Assortment
- Non-stock Assortment

[illegible]

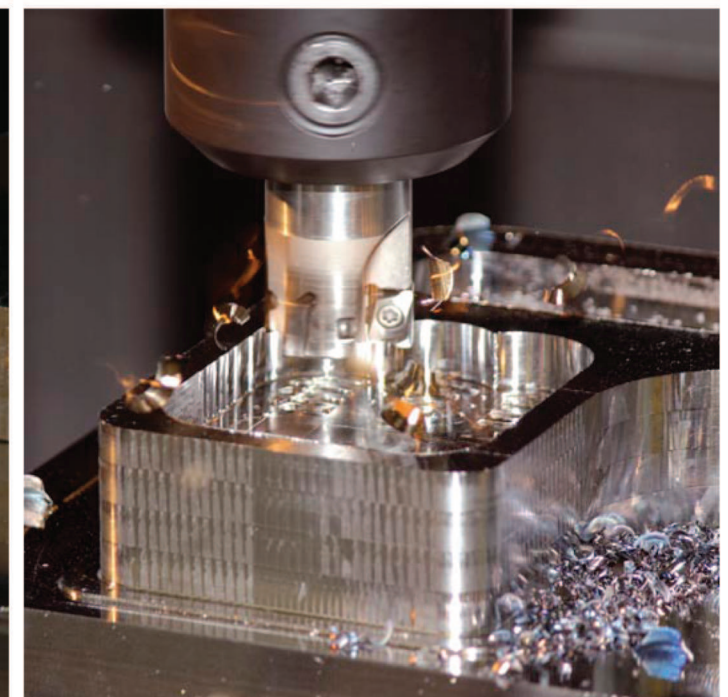
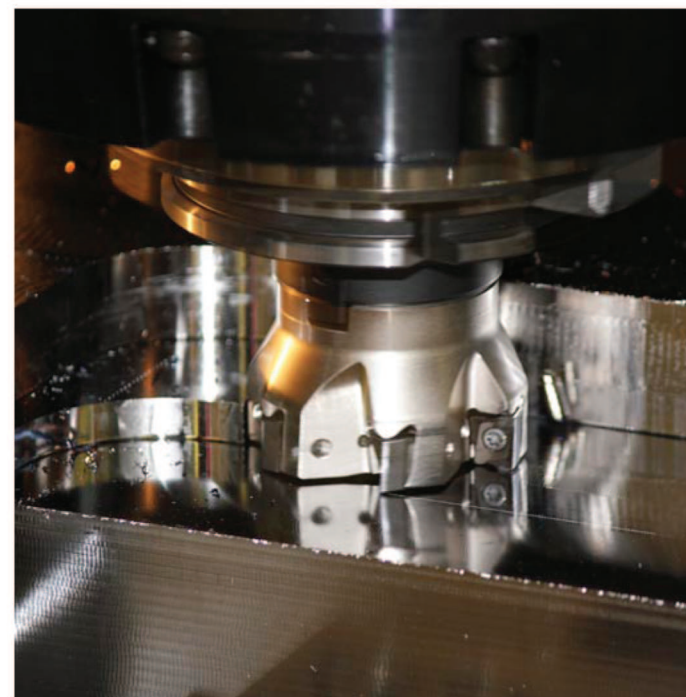
All dimensions in [mm]

US44012-T15P

- clamping screw
- head cone angle (4=40°)
- thread diameter (40=M4)
- screw length (12mm)
- Torx 15P

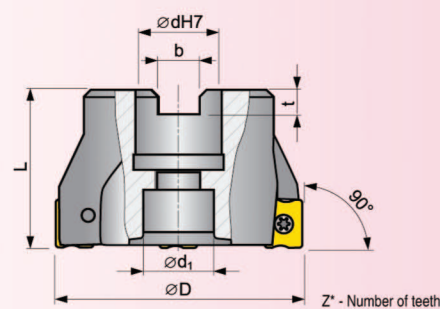
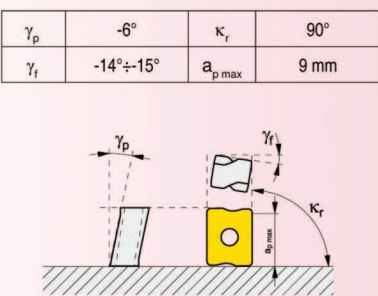
US45012-T20P

- clamping screw
- head cone angle (4~40°)
- thread diameter (50=M5)
- screw length (12mm)
- Torx 20P



S90LN12

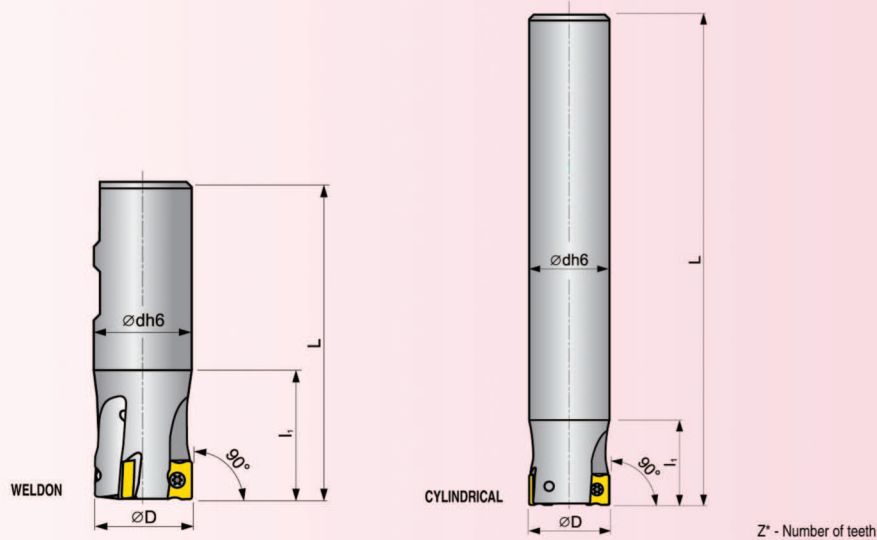
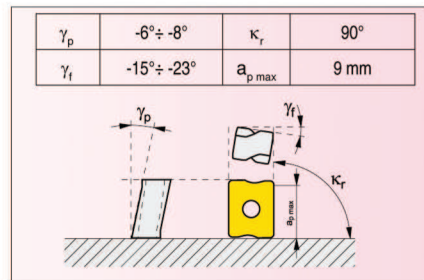
Shoulder milling cutters with inserts LNGX 12



ISO	Assortment	Dimensions							[kg]	Cooling	Spare parts			Inserts
		D	dH7	d ₁	L	b	t	Z*						
40A04R-S90LN12-C	●	40	16	14	40	8,4	5,6	4	0,2	+	US44012-T15P	D-T08PT15P	FG-15	LNGX 120508ER-M
50A04R-S90LN12-C	●	50	22	18	40	10,4	6,3	4	0,3	+				
50A05R-S90LN12-C	●	50	22	18	40	10,4	6,3	5	0,3	+				
63A04R-S90LN12-C	●	63	22	18	40	10,4	6,3	4	0,5	+				
63A06R-S90LN12-C	●	63	22	18	40	10,4	6,3	6	0,5	+				
80A05R-S90LN12-C	●	80	27	38	50	12,4	7,0	5	1,0	+				
80A07R-S90LN12-C	●	80	27	38	50	12,4	7,0	7	1,0	+				
100A06R-S90LN12-C	●	100	32	45	50	14,4	8,0	6	1,7	+				
100A08R-S90LN12-C	●	100	32	45	50	14,4	8,0	8	1,7	+				
110A06R-S90LN12-C	●	110	32	45	50	14,4	8,0	6	2,3	+				

SLN12

Shoulder end milling cutters with inserts LNGX 12

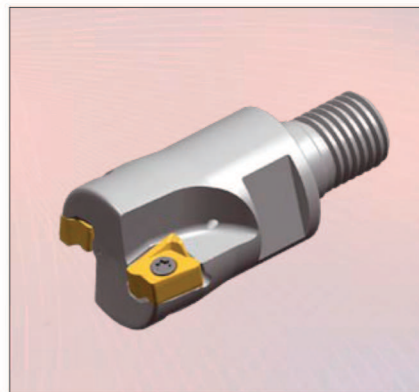


ISO	Assortment	Dimensions					[kg]	Cooling	Spare parts			Inserts
		D	L	l ₁	dh6	Z*						
WELDON	25A2R042B25-SLN12-C	●	25	99	42	25	2	0,1	+	US44012-T15P	FLAG T15P	LNGX 120508ER-M
	32A3R042B32-SLN12-C	●	32	103	42	32	3	0,5	+			
	40A4R050B32-SLN12-C	●	40	111	50	32	4	0,6	+			
CYLINDRICAL	25A2R034A25-SLN12-C	●	25	170	34	25	2	0,5	+			
	25A2R080A25-SLN12-C	●	25	170	80	25	2	0,5	+			
	32A2R034A32-SLN12-C	●	32	195	34	32	2	0,9	+			
	32A2R090A32-SLN12-C	●	32	195	90	32	2	0,9	+			

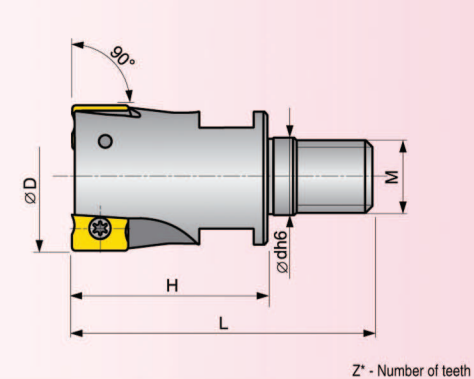
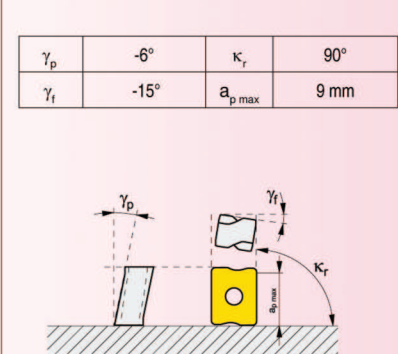
● Stock Assortment ○ Non-stock Assortment

All dimensions in [mm]

SLN12



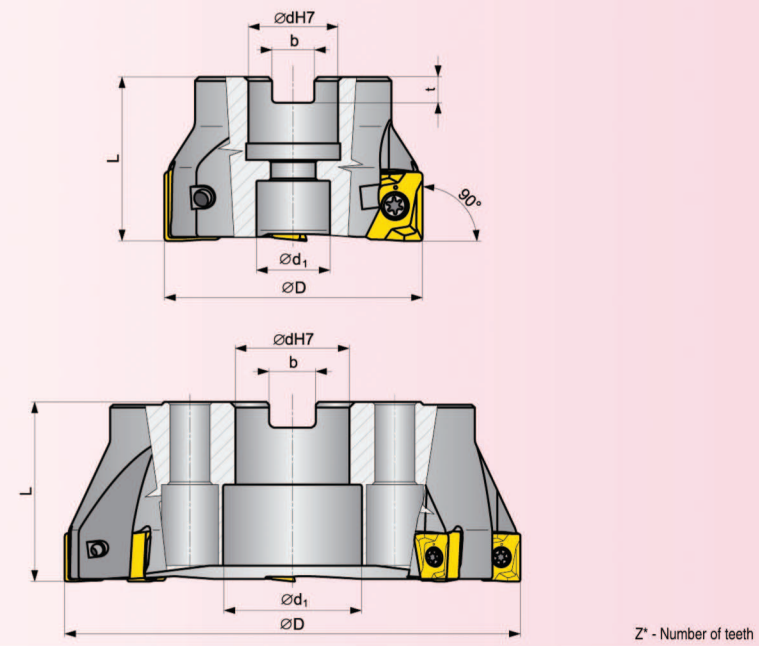
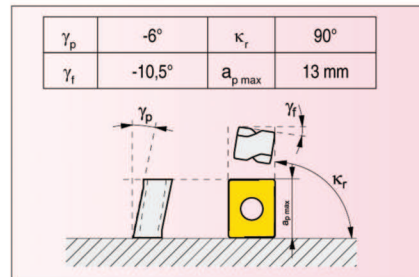
Exchangeable heads for modular system with inserts LNGX12



ISO	Assortment	Dimensions					[kg]	Cooling	Spare parts			Inserts
		D	L	H	dh6	Z*						
32A2R043M16-SLN12-C	●	32	66	43	17	2	0,2	+	US44012-T15P	FLAG T15P	LNGX 120508ER-M	
40A3R043M16-SLN12-C	●	40	66	43	17	3	0,2	+				

S90LN16

Shoulder milling cutters with inserts LNGU 16



ISO	Assortment	Dimensions							[kg]	Cooling	Spare parts			Inserts
		D	dH7	d ₁	L	b	t	Z*						
63A04R-S90LN16-C	●	63	22	18	40	10,4	6,3	4	0,5	+	US45012-T20P	SDR T20P-T	LNGU 16	
63A05R-S90LN16-C	●	63	22	18	40	10,4	6,3	5	0,5	+				
80A04R-S90LN16-C	●	80	27	38	50	12,4	7,0	4	1,0	+				
80A06R-S90LN16-C	●	80	27	38	50	12,4	7,0	6	1,0	+				
100A05R-S90LN16-C	●	100	32	45	50	14,4	8,0	5	1,8	+				
100A07R-S90LN16-C	●	100	32	45	50	14,4	8,0	7	1,7	+				
125A06R-S90LN16-C	●	125	40	56	63	16,4	9,0	6	3,5	+				
125A08R-S90LN16-C	●	125	40	56	63	16,4	9,0	8	3,3	+				
140A06R-S90LN16-C	●	140	40	56	63	16,4	9,0	6	4,5	+				
160C08R-S90LN16	●	160	40	66,7	63	16,4	9,0	8	5,7					
175C08R-S90LN16	●	175	40	66,7	63	16,4	9,0	8	6,7					

● Stock Assortment ○ Non-stock Assortment

All dimensions in [mm]