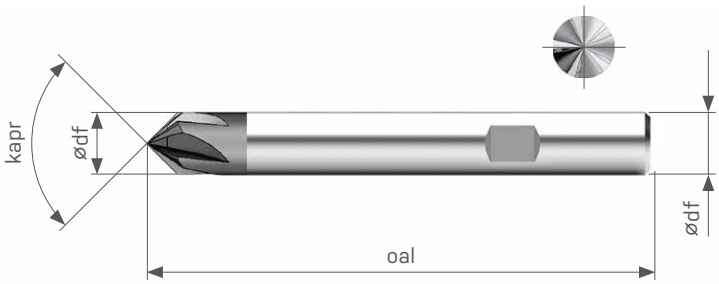
THE TOOL MANAGEMENT COMPANY

TCM

SOLID CARBIDE CHAMFER CUTTER

The new TCM *SIMPLY CLEVER* Solid Carbide Chamfer Cutter 90° delivers clean and accurate chamfers, supported by the digital data set according to DIN 4000 and ISO 13399, including 2D and 3D models as well as high-quality image material for seamless integration into your system.



SOLID CARBIDE CHAMFER CUTTER 90° SIMPLY CLEVER BASIC EDITION

Item Number	SAP No	dc	z	oal	df	Price per Piece*
SCDM 2025-040-90	668225	4	4	57	4	€ 9,40
SCDM 2025-060-90HB	668226	6	4	59	6	€ 12,20
SCDM 2025-080-90HB	668227	8	5	65	8	€ 16,50
SCDM 2025-100-90HB	668228	10	6	75	10	€ 25,40
SCDM 2025-120-90HB	668229	12	6	87	12	€ 35,80

* All prices excl. VAT. While stocks last.

SHOP ↓

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SOLID CARBIDE CHAMFER CUTTER 90°:
Recommended cutting data

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Cutter Diameter dc						
Material Group		4	6	8	10	12
Steel < 800 N/mm²	vc [m/min]	135	135	135	135	135
	fz [mm]	0,050	0,060	0,070	0,080	0,080
	n [U/min]	10,740	7,160	5,370	4,300	3,580
	vf [mm/min]	2,150	1,720	1,880	2,060	1,720
Steel < 1200 N/mm²	vc [m/min]	110	110	110	110	110
	fz [mm]	0,030	0,040	0,050	0,060	0,060
	n [U/min]	8,750	5,840	4,380	3,500	2,920
	vf [mm/min]	1,050	930	1,100	1,260	1,050
Steel < 1600 N/mm²	vc [m/min]	100	100	100	100	100
	fz [mm]	0,025	0,030	0,040	0,050	0,050
	n [U/min]	7,960	5,310	3,980	3,180	2,650
	vf [mm/min]	800	640	800	950	800
Stainless Steel < 800 N/mm²	vc [m/min]	80	80	80	80	80
	fz [mm]	0,020	0,025	0,030	0,040	0,050
	n [U/min]	6,370	4,240	3,180	2,550	2,120
	vf [mm/min]	510	420	480	610	640
Stainless Steel > 800 N/mm²	vc [m/min]	60	60	60	60	60
	fz [mm]	0,015	0,020	0,025	0,030	0,040
	n [U/min]	4,770	3,180	2,390	1,910	1,590
	vf [mm/min]	290	250	300	340	380
Gray Cast Iron GIL	vc [m/min]	130	130	130	130	130
	fz [mm]	0,040	0,050	0,060	0,070	0,080
	n [U/min]	10,350	6,900	5,170	4,140	3,450
	vf [mm/min]	1,660	1,380	1,550	1,740	1,660
Ductile Iron GJS	vc [m/min]	110	110	110	110	110
	fz [mm]	0,030	0,040	0,050	0,060	0,060
	n [U/min]	8,750	5,840	4,380	3,500	2,920
	vf [mm/min]	1,050	930	1,100	1,260	1,050
Aluminium Alloys < 8% Si	vc [m/min]	300	300	300	300	300
	fz [mm]	0,060	0,070	0,080	0,100	0,120
	n [U/min]	23,870	15,920	11,940	9,550	7,960
	vf [mm/min]	5,730	4,460	4,780	5,730	5,730
Aluminium Alloys > 8% Si	vc [m/min]	250	250	250	250	250
	fz [mm]	0,048	0,056	0,065	0,080	0,100
	n [U/min]	19,890	13,260	9,950	7,960	6,630
	vf [mm/min]	3,820	2,970	3,230	3,820	3,980
Copper Alloys	vc [m/min]	200	200	200	200	200
	fz [mm]	0,036	0,042	0,048	0,060	0,075
	n [U/min]	15,920	10,610	7,960	6,370	5,310
	vf [mm/min]	2,290	1,780	1,910	2,290	2,390
Titanium Alloys	vc [m/min]	70	70	70	70	70
	fz [mm]	0,015	0,020	0,025	0,030	0,040
	n [U/min]	5,570	3,710	2,790	2,230	1,860
	vf [mm/min]	330	300	350	400	450
Heat-Resistant Alloys	vc [m/min]	50	50	50	50	50
	fz [mm]	0,015	0,020	0,025	0,030	0,040
	n [U/min]	3,980	2,650	1,990	1,590	1,330
	vf [mm/min]	240	210	250	290	320