



**CUT MORE,
EARN MORE!**

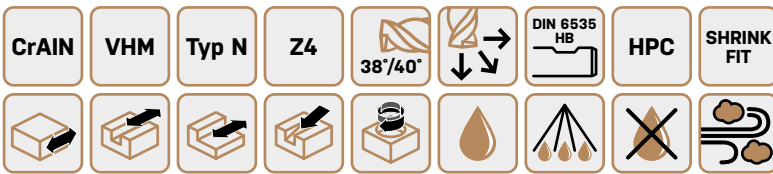
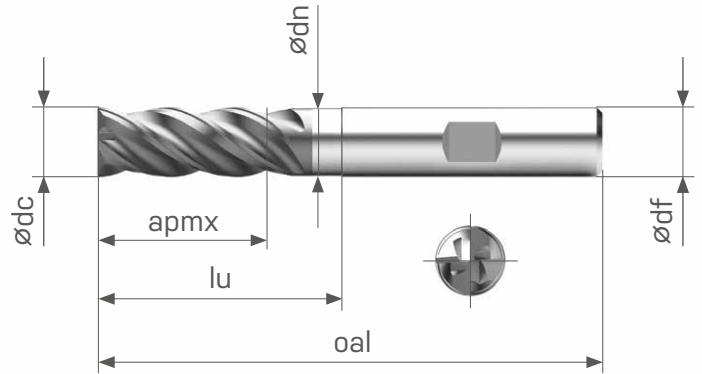
**SIMPLY CLEVER
BASIC EDITION**

**THE TOOL
MANAGEMENT
COMPANY**



MILLING CUTTERS

With the new *SIMPLY CLEVER* milling cutters from TCM, you get top milling performance at an unbeatable price. In addition, we provide you with the digital data set according to DIN 4000 and ISO 13399, including 2D and 3D models as well as images.



MILLING CUTTERS <small>SIMPLY CLEVER BASIC EDITION</small>									
Item Number	SAP No	dc	apmx	lu	dn	oal	df	Corner Chamfer	Price per Piece*
SCBE 2025-030HB	664924	3	9	14	2,9	57	6	0,06	€ 12,90
SCBE 2025-040HB	664925	4	11	18	3,9	57	6	0,06	€ 12,90
SCBE 2025-050HB	664926	5	13	20	4,9	57	6	0,08	€ 12,90
SCBE 2025-060HB	664927	6	14	23	5,8	59	6	0,12	€ 13,50
SCBE 2025-080HB	664928	8	20	29	7,7	65	8	0,16	€ 19,60
SCBE 2025-100HB	664929	10	23	35	9,7	75	10	0,20	€ 28,90
SCBE 2025-120HB	664930	12	28	42	11,7	87	12	0,24	€ 45,40
SCBE 2025-160HB	664931	16	35	48	15,6	96	16	0,30	€ 82,50
SCBE 2025-200HB	664932	20	42	57	19,5	108	20	0,40	€ 129,50

* All prices excl. VAT. While stocks last.

SHOP ↓



**THE TOOL
MANAGEMENT
COMPANY**

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MILLING CUTTERS: Recommended cutting data



Cutter Diameter dc									
Material Group		3 - 4	5	6	8	10	12	16	20
Steel < 800 N/mm ²	vc [m/min]	120	120	120	120	120	120	120	120
	fz [mm]	0,026	0,031	0,035	0,049	0,062	0,079	0,114	0,158
	n [U/min]	9,554	7,643	6,369	4,777	3,822	3,185	2,389	1,911
	vf [mm/min]	1,009	954	897	932	942	1,009	1,093	1,211
Steel < 1200 N/mm ²	vc [m/min]	100	100	100	100	100	100	100	100
	fz [mm]	0,024	0,028	0,032	0,044	0,056	0,072	0,104	0,144
	n [U/min]	7,962	6,369	5,308	3,981	3,185	2,654	1,990	1,592
	vf [mm/min]	764	713	679	701	713	764	828	917
Steel < 1600 N/mm ²	vc [m/min]	80	80	80	80	80	80	80	80
	fz [mm]	0,021	0,024	0,027	0,038	0,048	0,062	0,089	0,122
	n [U/min]	6,369	5,096	4,246	3,185	2,548	2,123	1,592	1,274
	vf [mm/min]	530	489	462	479	489	523	566	624
Stainless Steel < 800 N/mm ²	vc [m/min]	70	70	70	70	70	70	70	70
	fz [mm]	0,019	0,022	0,026	0,035	0,045	0,058	0,083	0,115
	n [U/min]	5,573	4,459	3,715	2,787	2,229	1,858	1,393	1,115
	vf [mm/min]	428	399	380	392	399	428	464	514
Stainless Steel > 800 N/mm ²	vc [m/min]	60	60	60	60	60	60	60	60
	fz [mm]	0,016	0,018	0,022	0,030	0,038	0,048	0,070	0,097
	n [U/min]	4,777	3,822	3,185	2,389	1,911	1,592	1,194	955
	vf [mm/min]	306	281	275	283	287	306	332	370
Gray Cast Iron GIL	vc [m/min]	120	120	120	120	120	120	120	120
	fz [mm]	0,026	0,031	0,035	0,049	0,062	0,079	0,114	0,158
	n [U/min]	9,554	7,643	6,369	4,777	3,822	3,185	2,389	1,911
	vf [mm/min]	1,009	954	897	932	942	1,009	1,093	1,211
Ductile Iron GJS	vc [m/min]	100	100	100	100	100	100	100	100
	fz [mm]	0,024	0,028	0,032	0,044	0,056	0,072	0,104	0,144
	n [U/min]	7,962	6,369	5,308	3,981	3,185	2,654	1,990	1,592
	vf [mm/min]	764	713	679	701	713	764	828	917
Aluminium Alloys < 8% Si	vc [m/min]	320	320	320	320	320	320	320	320
	fz [mm]	0,048	0,056	0,064	0,088	0,112	0,144	0,208	0,288
	n [U/min]	25,478	20,382	16,985	12,739	10,191	8,493	6,369	5,096
	vf [mm/min]	4,892	4,566	4,348	4,484	4,566	4,892	5,299	5,870
Aluminium Alloys > 8% Si	vc [m/min]	250	250	250	250	250	250	250	250
	fz [mm]	0,041	0,048	0,054	0,075	0,095	0,122	0,177	0,245
	n [U/min]	19,904	15,924	13,270	9,952	7,962	6,635	4,976	3,981
	vf [mm/min]	3,248	3,057	2,887	2,994	3,032	3,248	3,519	3,898
Copper Alloys	vc [m/min]	220	220	220	220	220	220	220	220
	fz [mm]	0,048	0,056	0,064	0,088	0,112	0,144	0,208	0,288
	n [U/min]	17,516	14,013	11,677	8,758	7,006	5,839	4,379	3,503
	vf [mm/min]	3,363	3,139	2,989	3,083	3,139	3,363	3,643	4,036
Titanium Alloys	vc [m/min]	50	50	50	50	50	50	50	50
	fz [mm]	0,016	0,018	0,022	0,030	0,038	0,048	0,070	0,097
	n [U/min]	3,981	3,185	2,654	1,990	1,592	1,327	995	796
	vf [mm/min]	255	234	229	236	239	255	277	308
Heat-Resistant Alloys	vc [m/min]	35	35	35	35	35	35	35	35
	fz [mm]	0,016	0,018	0,021	0,029	0,037	0,047	0,068	0,094
	n [U/min]	2,787	2,229	1,858	1,393	1,115	929	697	557
	vf [mm/min]	178	164	155	161	164	175	189	209

Side Milling / Trimming				Full Slot Milling			
		vc	fz			vc	fz
	ap = 1xd ae = 0,2xd	x 1	x 1		ap = 0,5xd ae = 1xd	x 1	x 1
	ap = 1,5xd ae = 0,5xd	x 0,8	x 0,5		ap = 1xd ae = 1xd	x 0,8	x 0,5