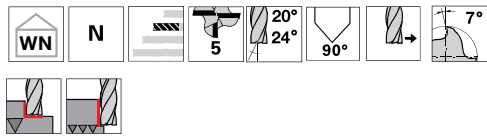


SpyroTec

**THE SPIRAL-FLUTED 90° CHAMFERING MILLING CUTTER,
5 CUTTING EDGES**



90° Chamfer mill, spiral-flute Series **6992** **6993**



Tool material	Solid Carbide	
Coating	nano-A™	
Type	N	
Shank	HA HB	
Internal cooling	X	
	NEW	

Material	Suitability
P Steel	●
M Stainless steel	●
K Cast iron	○
N Aluminum	●
S Ni / Ti alloys	●
H Hardened steel	

●=Optimal ○=Secondary

- face cutting
- without center cutting



d1 js9	d2 h6	d3	l1	l2	Z	Code no.	EDP Number	EDP Number
mm	mm	mm	mm	m	no. flutes			
6.000	6.000	1.500	57.000	2.250	5	6.000	9069920060000	9069930060000
8.000	8.000	2.000	63.000	3.000	5	8.000	9069920080000	9069930080000
10.000	10.000	2.500	72.000	3.750	5	10.000	9069920100000	9069930100000
12.000	12.000	3.000	83.000	4.500	5	12.000	9069920120000	9069930120000
16.000	16.000	4.000	92.000	6.000	5	16.000	9069920160000	9069930160000
20.000	20.000	5.000	104.000	7.500	5	20.000	9069920200000	9069930200000

Speeds & Feeds - Chamfering milling cutters

ISO	Hardness
P	Up to 25 HRC Over 25 HRC
M	Up to 20 HRC 20-30 HRC
K	< 240 HB
N	< 7% Si
S	Ti alloys ≤ 42 HRC Hi Temp ≤ 42 HRC
H	Up to 55 HRC 55 - 63 HRC

SFM	Feed Rate IPT per Ø							
	3	6	8	10	12	16	20	
	Chamfering ap/ae max = 0.25 x D							
630	0.0007	0.0014	0.0019	0.0024	0.0031	0.0039	0.0051	
460	0.0006	0.0012	0.0016	0.0024	0.0028	0.0035	0.0047	
390	0.0005	0.0010	0.0013	0.0018	0.0020	0.0028	0.0035	
260	0.0004	0.0007	0.0010	0.0014	0.0016	0.0024	0.0028	
560	0.0006	0.0012	0.0016	0.0024	0.0028	0.0035	0.0047	
820	0.0009	0.0019	0.0024	0.0031	0.0039	0.0051	0.0067	
260	0.0003	0.0007	0.0009	0.0012	0.0016	0.0020	0.0023	
130	0.0004	0.0006	0.0008	0.0009	0.0013	0.0016	0.0019	
160	0.0005	0.0010	0.0013	0.0020	0.0020	0.0027	0.0035	
130	0.0004	0.0008	0.0010	0.0015	0.0016	0.0023	0.0027	

SFM	Feed Rate IPT per Ø							
	3	6	8	10	12	16	20	
	Deburring ap/ae max = 0.05 x D							
820	0.0010	0.0023	0.0031	0.0040	0.0051	0.0067	0.0083	
590	0.0010	0.0020	0.0028	0.0039	0.0047	0.0063	0.0079	
525	0.0008	0.0017	0.0022	0.0031	0.0035	0.0047	0.0059	
325	0.0006	0.0013	0.0017	0.0024	0.0028	0.0039	0.0047	
755	0.0010	0.0020	0.0028	0.0039	0.0047	0.0063	0.0079	
1080	0.0015	0.0031	0.0041	0.0055	0.0067	0.0087	0.0110	
325	0.0005	0.0011	0.0014	0.0018	0.0024	0.0030	0.0035	
190	0.0006	0.0009	0.0012	0.0014	0.0020	0.0024	0.0029	
230	0.0008	0.0016	0.0022	0.0031	0.0035	0.0047	0.0059	
200	0.0007	0.0013	0.0017	0.0023	0.0027	0.0039	0.0047	