

SKS Extreme

INCH

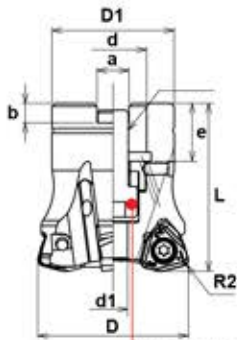
METRIC

FACE MILL

High Feed cutter with double sided insert
EXSKS type



Fig. 1
Coolant thru



Set bolt built into the cutter body

Fig. 2
Coolant thru

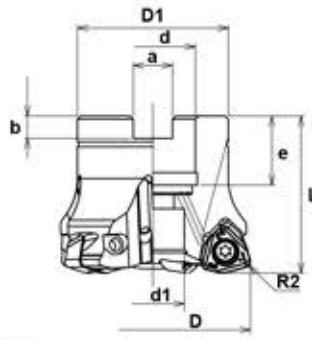
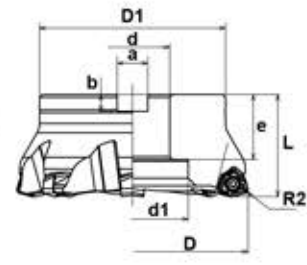


Fig. 3
Not Coolant thru



Specifications - Metric

CATALOG NUMBER	STK	DIMENSIONS								FIG.	INSERT	Q	PARTS	
		D	L	d	D1	a	b	e	d1				Screw	Wrench
EXSKS-4050R	•	50	55	22.225	40	8.4	5	19	9.6	1	WNMU090720ZER-PM	4	CSW-513H	A-20
EXSKS-4050R-22	•	50	55	22	40	10.4	6.3	19	9.6	1		4		
EXSKS-4052R-22	◦	52	50	22	40	10.4	6.3	20	17	2		4		
EXSKS-5063R	•	63	50	22.225	48	8.4	5	20	17	2		5		
EXSKS-5063R-22	•	63	50	22	48	10.4	6.3	20	17	2		5		
EXSKS-5063R-27	•	63	50	27	48	12.4	7	22	20	2		5		
EXSKS-5066R-27	◦	66	50	27	48	12.4	7	22	20	2		5		
EXSKS-6080R	•	60	70	31.75	65	12.7	8	32	26	2		6		
EXSKS-6080R-27	•	80	55	27	65	12.4	7	22	37	3		6		
EXSKS-7100R	•	100	70	31.75	70	12.7	8	32	26	3		7		
EXSKS-7100R-32	•	100	55	32	85	14.4	8	32	45	3		7		
EXSKS-8125R	•	125	63	37.1	100	15.9	10	35	60	3		8		
EXSKS-8125R-40	•	125	55	40	100	16.4	9	35	60	3		8		
EXSKS-9160R	•	160	63	50.8	100	19	11	43	75	3		9		
EXSKS-9160R-40	•	160	55	40	100	16.4	9	35	85	3		9		

◦ - longer delivery may apply.

Note: All cutters are supplied without inserts.

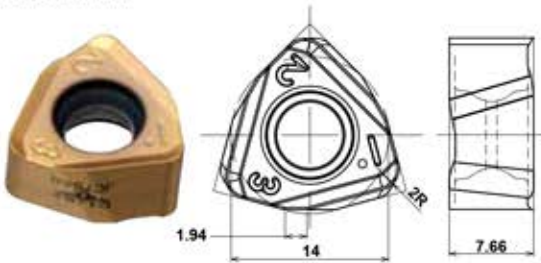


INCH

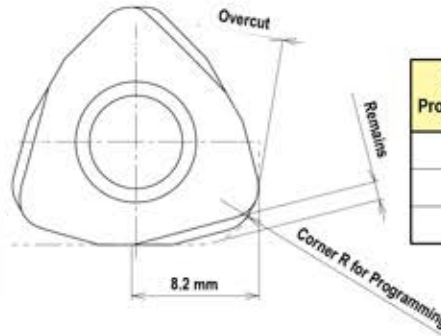
METRIC

SKS Extreme

INSERT



Definition of Corner Shape for Programming

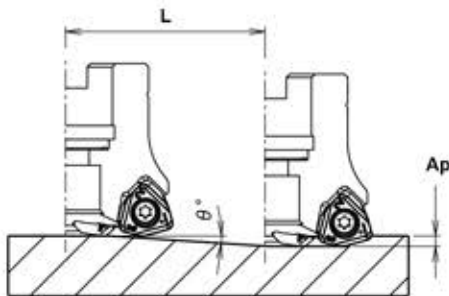


Corner R for Programming (mm)	Over cut (mm)	Remains (mm)
R3.0	0	1.41
R3.5	0	1.30
R4.0	0.025	1.19

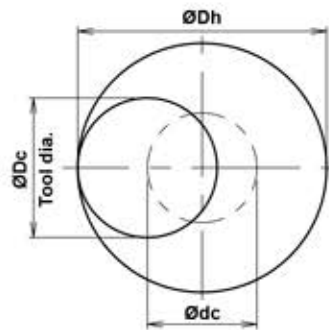
Catalog Number	Tolerance	PVD Coated		
		JC7560	JC8118	JC8050
WNMU090720ZER-PM	M	•	•	•

Recommended Data for Profile Milling

- Ramping



- Helical interpolation



- Calculation of tool pass dia.

$$\text{Tool pass dia. } \varnothing D_c = \text{Bore dia. } \varnothing D_h - \text{Tool Dia. } \varnothing D_c$$

- Depth of cut per one circuit should not exceed max. depth of cut Ap
- Down cutting is recommended, so tool pass rotation should be counterclockwise

- In case of ramping and helical interpolation, apply 70% or less feed speed from standard cutting table.
- In case of drilling, apply 50% or less Z axis feed from standard cutting condition table.
- Long consecutive chips may come out in case of drilling, confirm safe operating conditions.

CATALOG NUMBER	TOOL DIA.	EFFECTIVE CUTTING DIA.	MAX. DEPTH OF CUT: AP	RAMPING		HELICAL INTERPOLATION		MAX. DRILLING DEPTH: Z	
				MAX. ANGLE	TOTAL CUTTING LENGTH AT MAX. AP: L	MIN BORE DIA.: Dh	MAX BORE DIA.: Dh		
METRIC	EXSKS-*050	50	33.7	3	2°24'	71.6	68	96	2
	EXSKS-*052	52	35.7	3	2°24'	71.6	72	100	2
	EXSKS-*063	63	46.7	3	3°	57.3	94	122	2
	EXSKS-*066	66	49.7	3	2°42'	63.7	100	128	2
	EXSKS-*080	80	63.6	3	2°18'	74.7	128	156	2
	EXSKS-*100	100	83.6	3	1°42'	101.1	168	196	2
	EXSKS-*125	125	108.5	3	1°18'	132.2	218	246	2
	EXSKS-*160	160	143.5	3	1°	171.9	288	316	2
INCH	EXSKS-*200	2"	1.36"	.12"	2°24'	2.82"	2.74"	3.84"	.08"
	EXSKS-*250	2.5"	1.86"	.12"	3°	2.26"	3.74"	4.84"	.08"
	EXSKS-*300	3"	2.36"	.12"	2°18'	2.94"	4.74"	5.84"	.08"
	EXSKS-*400	4"	3.35"	.12"	1°42'	3.98"	6.74"	7.84"	.08"
	EXSKS-*500	5"	4.35"	.12"	1°18'	5.20"	8.74"	9.84"	.08"
	EXSKS-*600	6"	5.35"	.12"	1°	6.77"	10.74"	11.84"	.08"