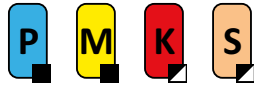




SS009



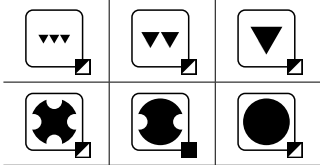
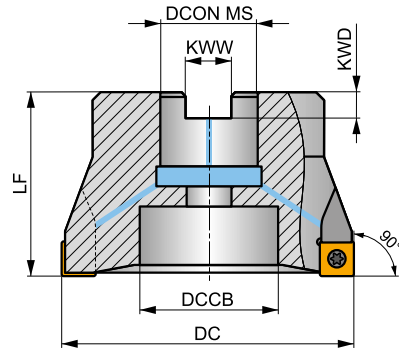
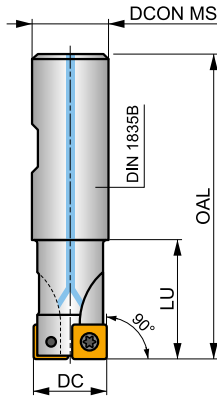
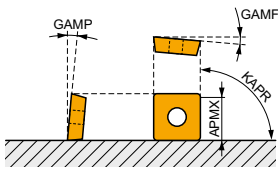
PRAMET



90° Square Shoulder Mill for SOMT 09 Insert with Internal Coolant

90° end and shell mills utilising positive SOMT 09 inserts with APMX of 8 mm. Suitable for face, shoulder, slot and plunge milling. Available in Weldon and arbor style, in Ø20 up to Ø125 mm. Differential tooth pitch available. Body treated for longer tool life.

KAPR	90°
APMX	8.0 mm



	0.07 - 0.22
	0.07 - 0.18



Product	DC	OAL	DCON MS	DCCB	LU	LF	KWW	KWD	GAMF	GAMP	Coolant		kg	G146	SQ400	SQ401	SQ402	SQ403	
	[mm]	[mm]	[mm]	[mm]	[mm]	[mm]	[mm]	[mm]	[°]	[°]	max.	Flag							
20A2R032B20-SS009-C	20	82	20	-	32	-	-	-	-12	6	2	-	23800	✓	0.21	G146	SQ400	-	-
25A3R042B25-SS009-C	25	98	25	-	42	-	-	-	-12	6	3	-	21300	✓	0.31	G146	SQ400	-	-
32A4R042B32-SS009-C	32	102	32	-	42	-	-	-	-10	10	4	✓	18800	✓	0.55	G146	SQ400	-	-
40A05R-S90S009-C	40	-	16	14	-	40	8.4	5.6	-9.1	10	5	-	16800	✓	0.29	G146	SQ402	-	-
50A06R-S90S009-C	50	-	22	18	-	40	10.4	6.4	-8.8	10	6	-	15100	✓	0.33	G146	SQ403	-	-
63A07R-S90S009-C	63	-	22	18	-	40	10.4	6.4	-8.6	10	7	-	13400	✓	0.86	G146	SQ403	-	-
80A09R-S90S009-C	80	-	27	38	-	50	12.4	7	-8.1	10	9	-	11900	✓	1.03	G146	SQ401	AC001	-
100A10R-S90S009-C	100	-	32	45	-	50	14.4	8	-8.1	10	10	-	10700	✓	1.79	G146	SQ401	AC002	-
125A12R-S90S009-C	125	-	40	56	-	63	16.4	9	-8.1	10	12	-	9500	✓	3.62	G146	SQ401	AC003	-

	G146		SOMT 09T3..
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Tool	Part	Nm	Thread	Length	Material	Material	Material
SQ400	US 3006-T09P	2.0	M 3	6	-	-	Flag T09P
SQ401	US 3006-T09P	2.0	M 3	6	D-T07P/T09P	FG-15	-
SQ402	US 3006-T09P	2.0	M 3	6	D-T07P/T09P	FG-15	HS 0830C
SQ403	US 3006-T09P	2.0	M 3	6	D-T07P/T09P	FG-15	HS 1030C

	AC001		KS 1230		K.FMH27
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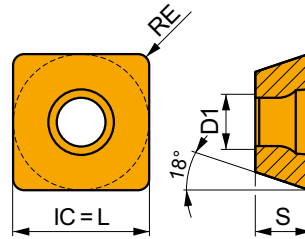


AC002	KS 1635	K.FMH32
AC003	KS 2040	K.FMH40

SOMT 09

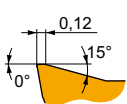
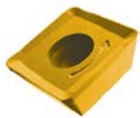


	IC	D1	L	S
	[mm]	[mm]	[mm]	[mm]
09T3	9.550	3.50	9.55	3.97



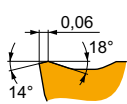
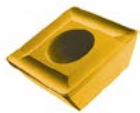
Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Conditions are valid for setting angle 90°. Refer to our Machining Calculator app for further calculations.

Product	RE [mm]	P			M			K			N			S			H		
		vc [m/min]	f [mm/tooth]	ap [mm]	vc [m/min]	f [mm/tooth]	ap [mm]	vc [m/min]	f [mm/tooth]	ap [mm]	vc [m/min]	f [mm/tooth]	ap [mm]	vc [m/min]	f [mm/tooth]	ap [mm]	vc [m/min]	f [mm/tooth]	ap [mm]



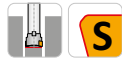
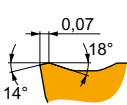
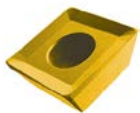
M geometry with positive design for medium machining.

SOMT 09T308-M	8215	0.8	275	0.14	2.5	165	0.13	2.5	260	0.14	2.5	65	0.13	2.0			
	M5315	0.8	390	0.14	2.5				370	0.14	2.5						
	M8330	0.8	270	0.14	2.5	160	0.13	2.5	255	0.14	2.5	65	0.13	2.0			
	M8340	0.8	250	0.14	2.5	150	0.13	2.5	235	0.14	2.5	60	0.13	2.0			
	M9315	0.8	380	0.14	2.5				360	0.14	2.5						



MI geometry with stable positive design for medium machining.

SOMT 09T304-MI	8215	0.4	230	0.14	2.5	135	0.13	2.5	215	0.14	2.5	55	0.10	2.0			
	M8310	0.4	255	0.14	2.5	130	0.13	2.5	240	0.14	2.5						
	M8330	0.4	230	0.14	2.5	135	0.13	2.5	215	0.14	2.5	55	0.10	2.0			
	M8340	0.4	210	0.14	2.5	125	0.13	2.5	195	0.14	2.5	50	0.10	2.0			
	M9315	0.4	320	0.14	2.5				300	0.14	2.5						
M9340	0.4	265	0.14	2.5	155	0.13	2.5				65	0.10	2.0				



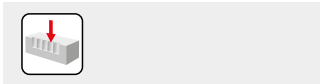
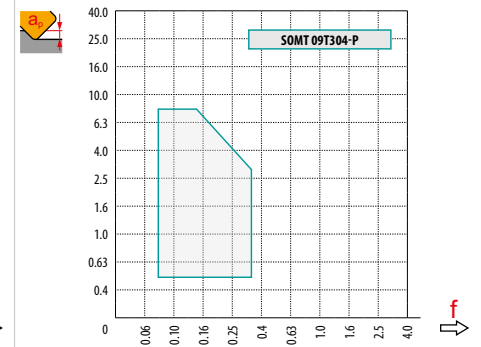
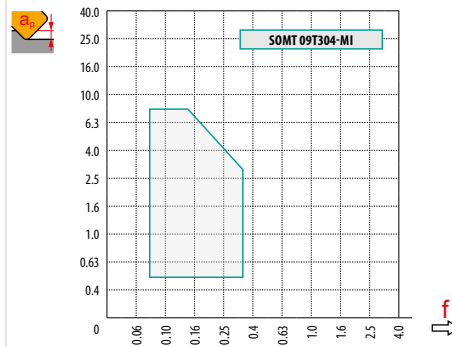
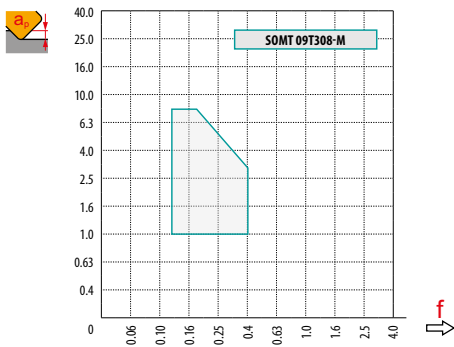
P geometry with highly positive design for medium machining.

SOMT 09T304-P	M8330	0.4	250	0.14	2.5	150	0.13	2.5	235	0.14	2.5	60	0.10	2.0			
	M8340	0.4	230	0.14	2.5	135	0.13	2.5	215	0.14	2.5	55	0.10	2.0			
	M9325	0.4	320	0.14	2.5				300	0.14	2.5						



a_e DC	5%	10%	15%	20%	25%	30%	40%	50%	60%	70%	75%	80%	90%	100%
	1.48	1.35	1.27	1.22	1.19	1.16	1.11	1.08	1.05	1.03	1.00	1.00	1.00	1.00
	2.20	1.60	1.35	1.20	1.10	0.95	0.85	0.75	0.85	0.95	1.00	1.00	1.00	1.00
	0.64	0.64	0.64	0.64	0.64	0.65	0.65	0.67	0.68	0.71	0.72	0.74	0.79	1.00

	SOMT 09-M	SOMT 09-MI	SOMT 09-P
	0.8	0.4	0.4
	0.90	1.30	1.30



max.
6.0



	1.0	4.0	8.0
	0.28	0.19	0.09