



Chamfering milling cutters with spiral-fluted cutting edges

- fast, cost-effective production of large chamfers
- soft cutting action for tough materials
- outstanding surface finish in one pass

SpyroTec 90° Chamfering milling cutters

SpyroTec

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



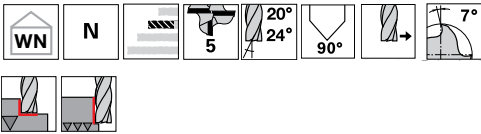


90° Chamfering milling cutters, spiral-fluted

Series

6992

6993



Tool material

Solid Carbide

Solid Carbide

Coating

nano-A™

nano-A™

Type

N

N

Shank



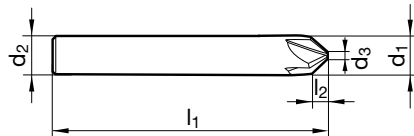
Internal cooling



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

●=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				
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	SFM	Feed Rate IPT per Ø in (mm)						
			3	6	8	10	12	16	20
P	Up to 25 HRc	630	0.0007	0.0014	0.0019	0.0024	0.0031	0.0039	0.0051
	Over 25 HRc		460	0.0006	0.0012	0.0016	0.0024	0.0028	0.0035
M	Up to 20 HRc	390	0.0005	0.0010	0.0013	0.0018	0.0020	0.0028	0.0035
	20-30 HRc		260	0.0004	0.0007	0.0010	0.0014	0.0016	0.0024
K	< 240 HB	560	0.0006	0.0012	0.0016	0.0024	0.0028	0.0035	0.0047
N	< 7% Si	820	0.0009	0.0019	0.0024	0.0031	0.0039	0.0051	0.0067
S	Ti alloys ≤ 42 HRc	260	0.0003	0.0007	0.0009	0.0012	0.0016	0.0020	0.0023
	Hi Temp ≤ 42 HRc		130	0.0004	0.0006	0.0008	0.0009	0.0013	0.0016

SFM	Feed Rate IPT per Ø in (mm)						
	3	6	8	10	12	16	20
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
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
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



Drilling

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GUHRING

Guhring, Inc. Main Office
1445 Commerce Avenue
Brookfield, WI 53045
Tel (262) 784-6730 (800) 776-6170
Fax (262) 784-9096

**Michigan Manufacturing and
Reconditioning Facility**
24975 Trans-X Road
Novi, MI 48375

Guhring Corp. (Canada)
20 Steckle Place, Unit #14
Kitchener, ON N2E 2C3
Tel (519) 748-9664 (800) 463-5555
Fax (519) 748-2954

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