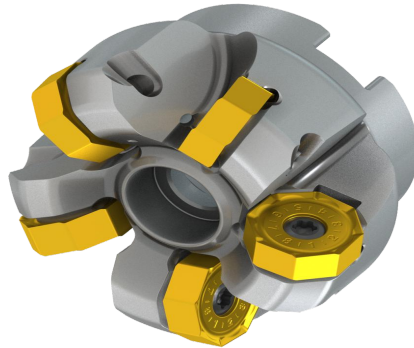


SON06C FACE MILL TECHNICAL DATA



Highly economical and productive face mill utilising two types of double-sided negative inserts. Economical octagonal ON..06 inserts with 16 cutting edges and APMX of 4 mm, and productive square SN.. 17 inserts with 8 cutting edges and APMX of 7 mm. Arbor style available with differential tooth pitch. Body treated for longer tool life.

Product Feature



Finishing – very good surface quality - Primary use



Medium machining – good surface quality - Primary use



Roughing – unlimited surface roughness - Possible use



Suitable for very unstable working conditions - Possible use



Suitable for unstable working conditions - Primary use



Suitable for stable working conditions - Primary use



S – Screw clamp



Shell mill DIN 8030



Through Tool Coolant

Product Operation



Face Milling - Primary use



Plunge Milling - Possible use



Chamfer Milling - Primary use



Ramping - Possible use



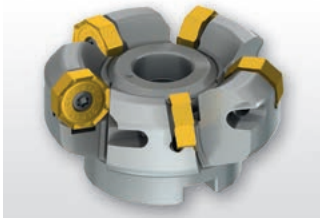
Helical Interpolation - Possible use

SON06C



PRAMET

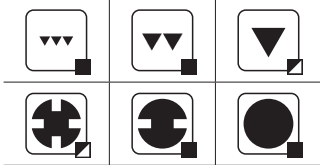
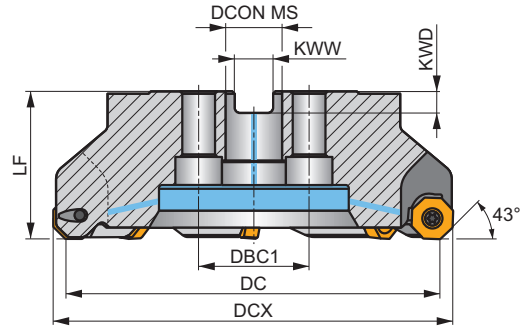
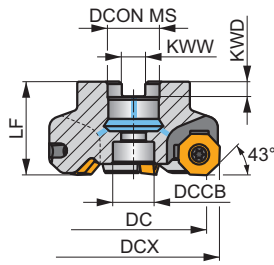
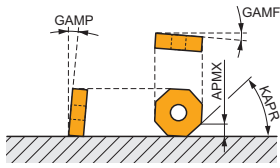
S



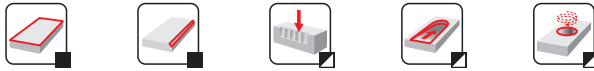
ECON ON06 43° Face Mill with Double Negative Design and Internal Coolant

Highly economical and productive face mill utilising two types of double-sided negative inserts. Economical octagonal ON..06 inserts with 16 cutting edges and APMX of 4 mm, and productive square SN..17 inserts with 8 cutting edges and APMX of 7 mm. Arbor style available with differential tooth pitch. Body treated for longer tool life.

KAPR	43°
APMX	4.0 (7.0) mm



0.04 - 0.25



Product	DC (mm)	DCX (mm)	DCON MS (mm)	DCCB (mm)	DBC1 (mm)	LF (mm)	KWW (mm)	KWD (mm)	GAME (°)	GAMP (°)									
50A04R-S450N06-C	50	60.8	22	16.5	-	40	10.4	6.3	-10	-5	4	✓	9400	✓	0.42	GI342	C0621	-	-
50A05R-S450N06-C	50	60.8	22	16.5	-	40	10.4	6.3	-10	-5	5	-	9400	✓	0.39	GI342	C0621	-	-
63A05R-S450N06-C	63	73.8	22	18.1	-	40	10.4	6.3	-10	-5	5	✓	8400	✓	0.71	GI342	C0621	-	-
63A06R-S450N06-C	63	73.8	22	18.1	-	40	10.4	6.3	-10	-5	6	✓	8400	✓	0.55	GI342	C0621	-	-
80A06R-S450N06-C	80	90.8	27	22.1	-	50	12.4	7	-10	-5	6	✓	7500	✓	1.27	GI342	C0622	-	-
80A08R-S450N06-C	80	90.8	27	22.1	-	50	12.4	7	-10	-5	8	-	7500	✓	1.19	GI342	C0622	-	-
100A08R-S450N06-C	100	110.8	32	30.1	-	50	14.4	8	-10	-5	8	✓	6700	✓	1.88	GI342	C0620	AC002	-
100A10R-S450N06-C	100	110.8	32	30.1	-	50	14.4	8	-10	-5	10	-	6700	✓	1.81	GI342	C0620	AC002	-
125A08R-S450N06-C	125	135.8	40	56.1	-	63	16.4	9	-10	-5	8	✓	6000	✓	3.80	GI342	C0620	AC003	-
125A10R-S450N06-C	125	135.8	40	56.1	-	63	16.4	9	-10	-5	10	✓	6000	✓	3.65	GI342	C0620	AC003	-
125A12R-S450N06-C	125	135.8	40	56.1	-	63	16.4	9	-11	-5	12	-	6000	✓	3.70	GI342	C0620	AC003	-
160C08R-S450N06-C	160	170.8	40	-	66.7	63	16.4	9.25	-10	-5	8	✓	5700	✓	6.48	GI342	C0623	-	-
160C12R-S450N06-C	160	170.8	40	-	66.7	63	16.4	9.25	-10	-5	12	✓	5700	✓	5.74	GI342	C0623	-	-
160C14R-S450N06-C	160	170.8	40	-	66.7	63	16.4	9.25	-11	-5	14	-	5700	✓	5.65	GI342	C0623	-	-
200C12R-S450N06-C	200	210.8	60	-	101.6	63	25.8	14.25	-10	-5	12	✓	4700	✓	9.06	GI342	C0624	-	-
200C16R-S450N06-C	200	210.8	60	-	101.6	63	25.8	14.25	-10	-5	16	-	4700	✓	9.02	GI342	C0624	-	-
250C14R-S450N06-C	250	260.8	60	-	101.6	63	25.8	14.25	-10	-5	14	✓	4300	✓	15.71	GI342	C0625	-	-
250C18R-S450N06-C	250	260.8	60	-	101.6	63	25.8	14.25	-10	-5	18	-	4300	✓	15.51	GI342	C0625	-	-

GI342	ONMX 0605..	ONMX 0605..-W..	SNMX 1705..

C0620	US 45013A-T20P	5.0	M 5	13	SDR T20P-T	-	-	-	-

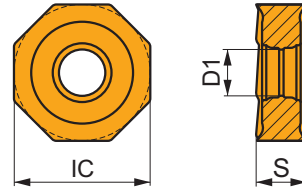
CO621	US 45013A-T20P	5.0	M 5	13	SDR T20P-T	HS 1030C	-	-	-
CO622	US 45013A-T20P	5.0	M 5	13	SDR T20P-T	HS 1230C	-	-	-
CO623	US 45013A-T20P	5.0	M 5	13	SDR T20P-T	HS 1240C	CAC 160C	HSD 0825C	HXK 5
CO624	US 45013A-T20P	5.0	M 5	13	SDR T20P-T	HS 1655C	CAC 200C	HSD 1025C	HXK 7
CO625	US 45013A-T20P	5.0	M 5	13	SDR T20P-T	HS 1655C	CAC 250C	HSD 1025C	HXK 7

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

ONMX 06

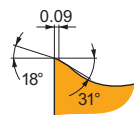
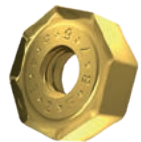


	IC	D1	S
	(mm)	(mm)	(mm)
0605	17.000	5.70	7.08



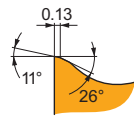
Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

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)



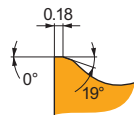
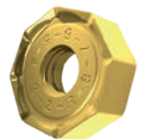
F geometry is sharp and used for finishing, suitable for large overhang or thin walled and slim workpiece applications. Designed with highly positive rake, narrow T-land and rounding of cutting edge for light machining.

ONMX 060508SR-F:8215	0.8	275	0.10	2.0	165	0.09	2.0	-	-	-	-	-	65	0.07	1.6	-	-	-
ONMX 060508SR-F:M6330	0.8	230	0.10	2.0	165	0.09	2.0	-	-	-	-	-	65	0.07	1.6	-	-	-
ONMX 060508SR-F:M8330	0.8	270	0.10	2.0	160	0.09	2.0	-	-	-	-	-	65	0.07	1.6	-	-	-
ONMX 060508SR-F:M8340	0.8	245	0.10	2.0	145	0.09	2.0	-	-	-	-	-	60	0.07	1.6	-	-	-
ONMX 060508SR-F:M9340	0.8	320	0.10	2.0	190	0.09	2.0	-	-	-	-	-	80	0.07	1.6	-	-	-



M geometry is versatile and the first choice for a wide range of working conditions. Designed with positive rake, medium T-land and rounding of cutting edge for medium machining.

ONMX 060508SR-M:8215	0.8	230	0.20	2.0	135	0.18	2.0	-	-	-	-	-	55	0.14	1.6	45	0.14	1.0
ONMX 060508SR-M:M6330	0.8	195	0.20	2.0	140	0.18	2.0	-	-	-	-	-	55	0.14	1.6	-	-	-
ONMX 060508SR-M:M8330	0.8	230	0.20	2.0	135	0.18	2.0	-	-	-	-	-	55	0.14	1.6	45	0.14	1.0
ONMX 060508SR-M:M8340	0.8	210	0.20	2.0	125	0.18	2.0	-	-	-	-	-	50	0.14	1.6	-	-	-
ONMX 060508SR-M:M9325	0.8	285	0.20	2.0	-	-	-	-	-	-	-	-	-	-	-	55	0.14	1.0
ONMX 060508SR-M:M9340	0.8	255	0.20	2.0	150	0.18	2.0	-	-	-	-	-	60	0.14	1.6	-	-	-

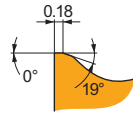


R geometry is strong and used for roughing and heavy working conditions. Designed with slightly positive rake, wide T-land and rounding of cutting edge for rough machining.

ONMX 060508SR-R:8215	0.8	210	0.30	2.0	-	-	-	195	0.30	2.0	-	-	-	-	-	-	40	0.21	1.0
ONMX 060508SR-R:M5315	0.8	255	0.30	2.0	-	-	-	240	0.30	2.0	-	-	-	-	-	-	50	0.21	1.0
ONMX 060508SR-R:M8330	0.8	210	0.30	2.0	-	-	-	195	0.30	2.0	-	-	-	-	-	-	40	0.21	1.0

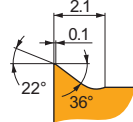
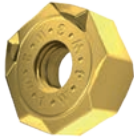
Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

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)



R geometry is strong and used for roughing and heavy working conditions. Designed with slightly positive rake, wide T-land and rounding of cutting edge for rough machining.

ONMX 060508SR-R:M8340	0.8	190	0.30	2.0	–	–	–	180	0.30	2.0	–	–	–	–	–	–	–	–	–
ONMX 060508SR-R:M9325	0.8	250	0.30	2.0	–	–	–	235	0.30	2.0	–	–	–	–	–	–	50	0.21	1.0



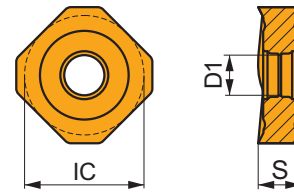
Wiper design for improved surface finish when machining with large cutters and high feed rate.

ONMX 060508SR-W:8215	0.8	340	0.10	0.3	200	0.09	0.3	–	–	–	–	–	–	–	–	–	–	–	–
ONMX 060508SR-W:M8330	0.8	325	0.10	0.3	195	0.09	0.3	–	–	–	–	–	–	–	–	–	–	–	–

SNMX 17

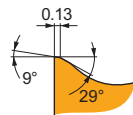
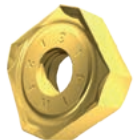


	IC (mm)	D1 (mm)	S (mm)
1705	17.000	5.70	5.56



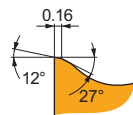
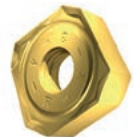
Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

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 is versatile and the first choice for a wide range of working conditions. Designed with positive rake, medium T-land and rounding of cutting edge for medium machining.

SNMX 170508SR-M:8215	0.8	265	0.20	4.0	155	0.18	4.0	–	–	–	65	0.14	3.2	50	0.14	1.0	–	–	–
SNMX 170508SR-M:M6330	0.8	225	0.20	4.0	160	0.18	4.0	–	–	–	65	0.14	3.2	–	–	–	–	–	–
SNMX 170508SR-M:M8330	0.8	265	0.20	4.0	155	0.18	4.0	–	–	–	65	0.14	3.2	50	0.14	1.0	–	–	–
SNMX 170508SR-M:M8340	0.8	240	0.20	4.0	140	0.18	4.0	–	–	–	60	0.14	3.2	–	–	–	–	–	–
SNMX 170508SR-M:M9325	0.8	325	0.20	4.0	–	–	–	–	–	–	–	–	–	65	0.14	1.0	–	–	–
SNMX 170508SR-M:M9340	0.8	295	0.20	4.0	175	0.18	4.0	–	–	–	70	0.14	3.2	–	–	–	–	–	–



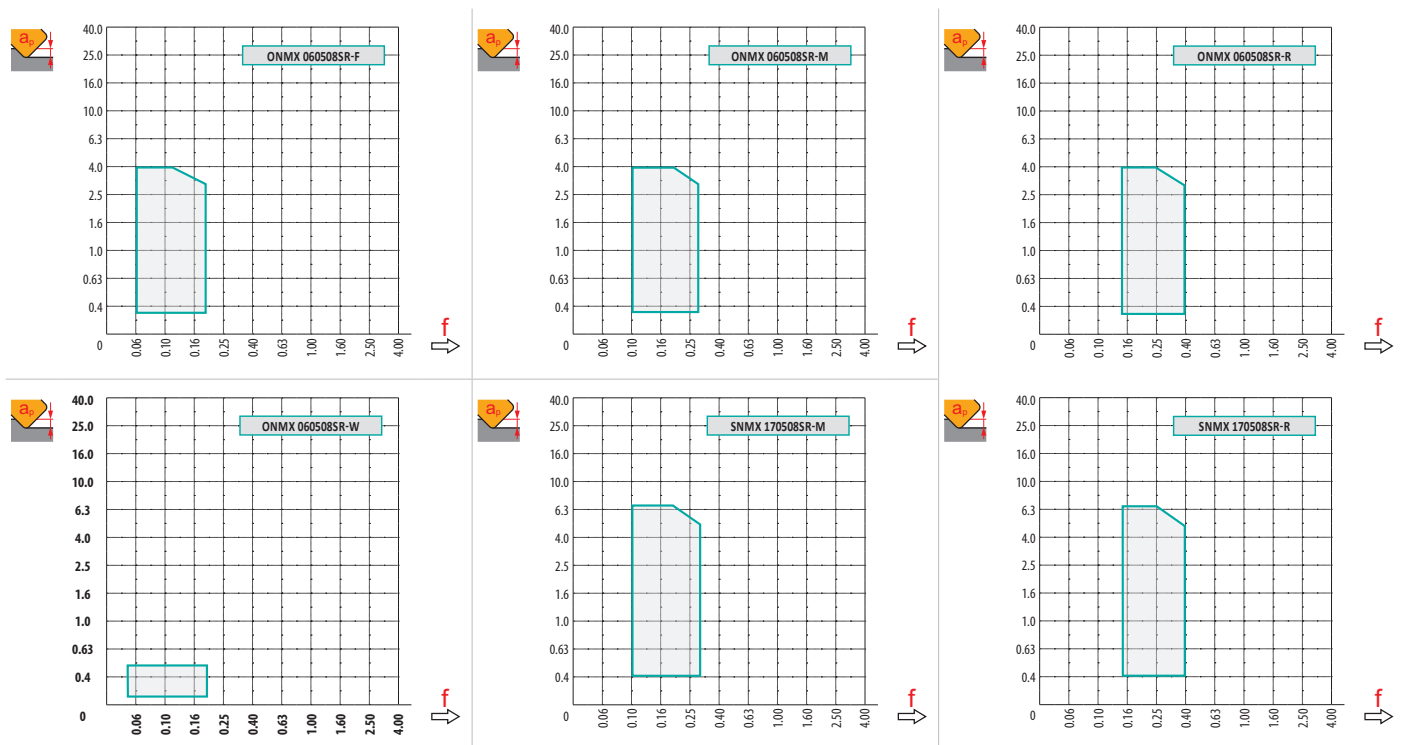
R geometry is strong and used for roughing and heavy working conditions. Designed with slightly positive rake, wide T-land and rounding of cutting edge for rough machining.

SNMX 170508SR-R:8215	0.8	240	0.30	4.0	–	–	–	225	0.30	4.0	–	–	–	45	0.21	1.0	–	–	–
SNMX 170508SR-R:M5315	0.8	300	0.30	4.0	–	–	–	285	0.30	4.0	–	–	–	60	0.21	1.0	–	–	–
SNMX 170508SR-R:M8330	0.8	240	0.30	4.0	–	–	–	225	0.30	4.0	–	–	–	45	0.21	1.0	–	–	–
SNMX 170508SR-R:M8340	0.8	220	0.30	4.0	–	–	–	205	0.30	4.0	–	–	–	–	–	–	–	–	–
SNMX 170508SR-R:M9325	0.8	290	0.30	4.0	–	–	–	275	0.30	4.0	–	–	–	55	0.21	1.0	–	–	–



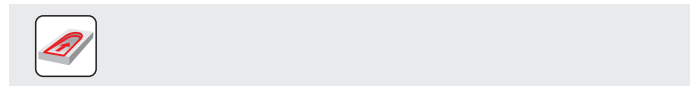
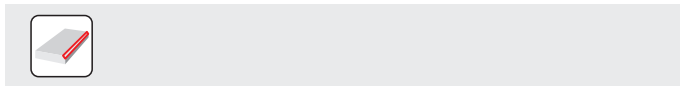
a_e / DC	5%	10%	15%	20%	25%	30%	40%	50%	60%	70%	75%	80%	90%	100%
	1.48	1.35	1.27	1.22	1.19	1.16	1.11	1.08	1.05	1.03	1.00	1.00	1.00	1.00
	2.20	1.60	1.35	1.20	1.10	0.95	0.85	0.75	0.85	0.95	1.00	1.00	1.00	1.00
	0.64	0.64	0.64	0.64	0.64	0.65	0.65	0.67	0.68	0.71	0.72	0.74	0.79	1.00

	ONMX 06-F	ONMX 06-M	ONMX 06-R	ONMX 06-W	SNMX 17-M	SNMX 17-R
	0.80	0.80	0.80	0.80	0.80	0.80
	0.75	0.75	0.75	4.30	0.70	0.70



		0.50	1.00	1.50	2.00	2.50	3.00	3.50	4.00
50		51.06	52.11	53.19	54.27	55.35	56.43	57.51	58.59
63		64.06	65.11	66.19	67.27	68.35	69.43	70.51	71.59
80		81.06	82.11	83.19	84.27	85.35	86.43	87.51	88.59
100		101.06	102.11	103.19	104.27	105.35	106.43	107.51	108.59
125		126.06	127.11	128.19	129.27	130.35	131.43	132.51	133.59
160		161.06	162.11	163.19	164.27	165.35	166.43	167.51	168.59
200		201.06	202.11	203.19	204.27	205.35	206.43	207.51	208.59
250		251.06	252.11	253.19	254.27	255.35	256.43	257.51	258.59

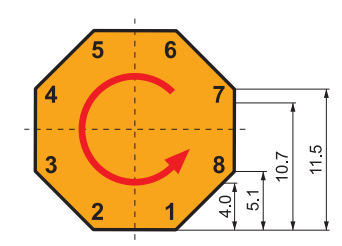
DC		S							
		0.00	1.00	2.00	3.00	4.00	5.00	6.00	7.00
50	DEF	47.24	49.40	51.56	53.73	55.90	58.06	60.23	62.40
63		60.24	62.40	64.56	66.73	68.90	71.06	73.23	75.40
80		77.24	79.40	81.56	83.73	85.90	88.06	90.23	92.40
100		97.24	99.40	101.56	103.73	105.90	108.06	110.23	112.40
125		122.24	124.40	126.56	128.73	130.90	133.06	135.23	137.40
160		157.24	159.40	161.56	163.73	165.90	168.06	170.23	172.40
200		197.24	199.40	201.56	203.73	205.90	208.06	210.23	212.40
250		247.24	249.40	251.56	253.73	255.90	258.06	260.23	262.40



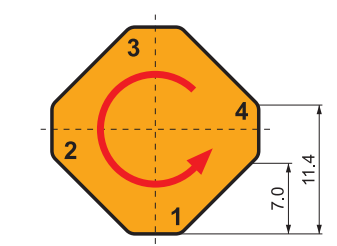
DC	X.V	f _{max}
50	1.35	0.36
63	1.39	0.40
80	1.44	0.45
100	1.48	0.51
125	1.53	0.57
160	1.58	0.64
200	1.63	0.72
250	1.68	0.80

DC	O	
	RPMX	APMX/I
50	0.3	0.4/100
63	0.2	0.25/100
80	0.2	0.2/100
100	0.1	0.1/100
125	0.1	0.05/100

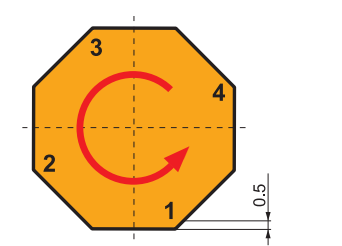
DC	S	
	RPMX	APMX/I
47.24	0.1	0.1/100
60.24	0.1	0.05/100
77.24	0.1	0.05/100



-> 4.0	16
-> 5.1	14
-> 10.7	8
-> 11.5	6



-> 7.0	8
-> 11.4	4



ONMX 06-W	
-> 0.5	8