

## Tool table for AF 300-tools Aluminium

Schüco	Cutter Ø	Shaft Ø	Cutting length	max. cutting step	Feed milling	Feed intrusion (Z) drilling	Speed	milling direction
Art.-Nr.	[mm]	[mm]	[mm]	[mm]	[mm/min]	[mm/min]	[U/min]	um/dm*
Cutter								
289 830	3	6	7	2	1500	150-500	18000	dm
296 589	4	6	8	3	1200	150-400	15000	dm
296 590	5	6	8	4	850	150-400	10000	dm
296 591	6	6	10	6	600	150-450	13000	dm
296 592	8	8	10	8	1600	150-400	18000	dm
296 593	10	10	12	10	2000	150-600	11000	dm
282 421	10	10	12	8	600	150-500	7500	dm
289 281	10	12	15	6	800	150-350	14000	dm
Cutter with 2 edge								
289 811	8	8	45	3	800	150-400	6000	dm
289 670/-671	16	16	8.5	7.5	1500	150-500	7500	dm
280 272	20	20	35	16	2000	150-500	12000	dm
special contour milling cutter								
282 296	RL-Cutter	20	1,5 x 30°	0	750	0	15000	dm
282 297	RL-Cutter	20	5,0 x 30°	0	750	0	15000	dm
282 486	SL-Cutter	20	R = 10	0	1000	0	13500	dm
264 767	T-slot cutter	10	Ø 19,5 x 5	0	1000	0	10000	dm
289 516	T-slot cutter	10	Ø 28,5 x 8	0	1100	0	6000	dm
Disc milling cutter / Saw								
264 230	120	-	4	0	1000	0	11000	um
280 857	120	-	5.7	0	1000	0	11000	um
289 295	120	-	18.5	0	1000	0	7000	um
Drill								
283 780	2.2	6	20	18	--	800	15000	--
283 781	2.5	6	20	18	--	800	14000	--
283 782	3	6	20	18	--	750	10000	--
283 783	3.2	6	20	18	--	700	9500	--
289 456	3.5	6	20	18	--	700	9300	--
264 335	3.5	6	20	18	--	700	9300	--
283 784	4.2	6	20	18	--	700	9000	--
289 498	4.2	6	20	18	--	700	9000	--
289 852	4.5	6	20	18	--	680	8800	--
289 457	4.7	6	20	18	--	650	8700	--
283 785	5	6	20	18	--	600	8500	--
264 308	5.5	6	20	18	--	600	8500	--
264 354	6.5	8	20	18	--	580	8000	--
283 786	6.8	8	20	18	--	570	7500	--
289 458	7.1	8	20	18	--	550	7200	--
264 295	7.5	8	20	18	--	520	7000	--
283 787	8	8	20	18	--	500	3500	--
283 788	8.2	10	20	18	--	500	3000	--
283 789	8.5	10	21	18	--	500	2500	--
264 319	9	10	21	18	--	480	2400	--
288 017	10	10	21	18	--	450	2000	--

These figures are guidelines only for Schüco tools (commercial HSS drill different), which may vary depending on the depth of cut and / or clamping situation. The cutting data must therefore be adjusted by the operator to the situation (for example by readjusting means of the feed potentiometer on the terminal or changing the tool parameters in Schüco CAM)


\*dm: downmilling 


um: upmilling 

## Tool table for AF 300-tools Aluminium

Schüco	Cutter Ø		Shaft Ø	Cutting length	max. cutting step	Feed milling	Feed intrusion (Z) drilling	Speed	milling direction
Art.-Nr.	[mm]		[mm]	[mm]	[mm]	[mm/min]	[mm/min]	[U/min]	um/dm*
	Pitch		Tap						
	[mm]								
	Ø	m							
283 794	M4	0.7	4.5	12	12	420	420	600	
283 795	M5	0.8	6	13	13	480	480	600	
283 796	M6	1	6	15	15	600	600	600	
283 798	M8	1.25	8	18	18	750	750	600	
283 790	M10	1.5	10	20	20	900	900	600	
289 018	M12	1.75	9	23	23	1050	1050	600	

These figures are guidelines only for Schüco tools (commercial HSS drill different), which may vary depending on the depth of cut and / or clamping situation. The cutting data must therefore be adjusted by the operator to the situation (for example by readjusting means of the feed potentiometer on the terminal or changing the tool parameters in Schüco CAM)

\*dm: downmilling 

um: upmilling 

## Tool table for AF 300-tools Steel


Schüco	Cutter Ø	Schaft Ø	Cutting length	max. cutting step	Feed milling	Feed intrusion (Z) drilling	Speed	milling direction	
Art.-Nr.	[mm]	[mm]	[mm]	[mm]	[mm/min]	[mm/min]	[U/Min]	[um/dm*]	
Milling Cutter									
280 723**	6	6	10	9	1000	100	11000	dm	
280 724**	8	8	16	15	1200	100	9000	dm	
280 725**	10	10	19	18	700	150	7000	dm	
289 137***	16	16	30	29	800	600	6600	dm	
Drill									
283 780	2.2	6	20	8	--	700	15000	--	
283 781	2.5	6	20	6	--	680	14000	--	
283 782	3	6	20	18	--	650	10000	--	
283 783	3.2	6	20	18	--	630	9500	--	
289 456	3.5	6	20	18	--	600	9300	--	
264 335	3.5	6	20	18	--	600	9300	--	
283 784	4.2	6	20	18	--	550	9000	--	
289 498	4.2	6	20	18	--	550	9000	--	
289 852	4.5	6	20	18	--	530	8800	--	
289 457	4.7	6	20	18	--	520	8700	--	
283 785	5	6	20	18	--	500	8500	--	
264 308	5.5	6	20	18	--	480	8500	--	
264 354	6.5	8	20	18	--	450	7800	--	
283 786	6.8	8	20	18	--	430	7500	--	
289 458	7.1	8	20	18	--	410	7200	--	
264 295	7.5	8	20	18	--	400	6000	--	
283 787	8	8	20	18	--	370	3500	--	
283 788	8.2	10	20	18	--	350	3000	--	
283 789	8.5	10	21	18	--	330	2500	--	
264 319	9	10	21	18	--	300	2300	--	
289 017	10	10	21	18	--	200	1800	--	
	pitch		Tap						
	[mm]								
	Ø	m							
283 794	M4	0.7	4.5	12	12	420	420	600	
283 795	M5	0.8	6	13	13	480	480	600	
283 796	M6	1	6	15	15	600	600	600	
283 798	M8	1.25	8	18	18	750	750	600	
283 790	M10	1.5	10	20	20	900	900	600	
289 018	M12	1.75	9	23	23	1050	1050	600	


These figures are guidelines only for the machining of Schüco Jansen Steel profiles with Schüco tools (commercial HSS drill different), which may vary depending on the depth of cut and / or clamping situation. The cutting data must therefore be adjusted by the operator to the situation (for example by readjusting means of the feed potentiometer on the terminal or changing the tool parameters in Schüco CAM)

\*\* it must be pre-drilled (maximum spray cooling in stainless steel).

\*\*\* only use for Lock- and Strikeplate operation with insulated profiles and C4, this drill requires the application with the appropriate collet (289 144) and tool holder (282 394).

Furthermore, it must be pre-drilled at this router (maximum spray cooling in stainless steel).

\*dm: downmilling 

um: upmilling 

## Tool table for AF300-tools Stainless steel

Schüco	Cutter Ø	Schaft Ø	Cutting length	max. cutting step	Feed milling	Feed intrusion (Z) drilling	Speed	milling direction
Art.-Nr.	[mm]	[mm]	[mm]	[mm]	[mm/min]	[mm/min]	[U/Min]	[um/dm*]
milling cutter								
289 135**	8	8	16	15	600	50	4000	dm
289 136**	10	10	19	18	600	50	4000	dm
289 137***	16	16	30	29	400	100	1800	dm

These figures are guidelines only for the machining of Schüco Jansen Steel profiles with Schüco tools (commercial HSS drill different), which may vary depending on the depth of cut and / or clamping situation. The cutting data must therefore be adjusted by the operator to the situation (for example by readjusting means of the feed potentiometer on the terminal or changing the tool parameters in Schüco CAM)

\*\* it must be pre-drilled (maximum spray cooling in stainless steel).

\*\*\* only use for Lock- and Strikeplate operation with insulated profiles and C4, this drill requires the application with the appropriate collet (289 144) and tool holder (282 394).

Furthermore, it must be pre-drilled at this router (maximum spray cooling in stainless steel).

\*dm: downmilling



um: upmilling

