



Tool table for AF 510-tools Aluminium

Schüco	Cutter Ø	Shaft Ø	Cutting length	Feed milling	Feed intrusion (Z) drilling	Speed	milling direction	
Art.-Nr.	[mm]	[mm]	[mm]	[mm/min]	[mm/min]	[U/min]	um/dm*	
Cutter								
289 830	3.0	6	2	1.50	0.25	18000	dm	
296 589	4.0	6	3	1.20	0.25	15000	dm	
296 590	5.0	6	4	0.80	0.30	9500	dm	
296 591	6.0	6	6	1.40	0.30	11000	dm	
296 592	8.0	8	8	1.60	0.30	18000	dm	
296 593	10.0	10	10	2.00	0.30	12500	dm	
282 421	10.0	10	8	0.60	0.30	6500	dm	
289 281	10.0	12	15	0.50	0.30	14000	dm	
Cutter with 2 edge								
283 367	4.0	6	3	0.80	0.20	15000	dm	
283 368	5.0	6	4	0.80	0.20	15000	dm	
283 369	6.0	6	5	2.00	0.30	8000	dm	
283 370	8.0	8	7	2.00	0.30	8000	dm	
283 371	10.0	10	7	2.00	0.30	8000	dm	
289 670/-671	16.0	16	7.5	2.00	0.30	7500	dm	
283 312	20.0	20	10	2.00	0.40	12500	dm	
289 012	20.0	20	10	2.00	0.40	12500	dm	
280 272	20.0	20	16	2.00	0.30	12000	dm	
special contour milling cutter								
282 296	RL-cutter	20	1,5 x 30°	0.75	0.00	15000		
282 297	RL-cutter	20	5,0 x 30°	0.75	0.00	15000		
282 486	SL-cutter	20	R = 10	1.00	0.00	13500		
289 516	T-slot cutter	10	Ø 28,5 x 8	1.10	0.00	6000		
264 767	T-slot cutter	10	Ø 19,5 x 5	1.00	0.00	10000		
		no. of teeht	Disc milling cutter / Saw					
		*Bombastic						
280 857	120.0	30	5.7	1.00	--	11000		
289 295	120.0	4 x 15	18.5	1.00	--	6000		
283 768	330.0	102	3.5	2.80	--	3400		
283 717	500.0	120*	4.4	1.50	--	2500		
282 771	500.0	120	4.6	1.50	--	2500		
283 867	500.0	96	4.8	1.50	--	2500		
283 868	500.0	96*	4.8	1.50	--	2500		


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 

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Art.-Nr.	[mm]	[mm]	[mm]	[mm/min]	[mm/min]	[U/min]	um/dm*
Drill							
283 780	2.2	6	18	--	0.70	15000	
283 781	2.5	6	18	--	0.70	14000	
283 782	3.0	6	18	--	0.70	10000	
283 783	3.2	6	18	--	0.70	9500	
289 456	3.5	6	18	--	0.70	9300	
264 335	3.5	6	18	--	0.70	9300	
283 784	4.2	6	18	--	0.70	9000	
289 498	4.2	6	18	--	0.70	9000	
289 852	4.5	6	18	--	0.65	8800	
289 457	4.7	6	18	--	0.65	8700	
283 785	5.0	6	18	--	0.60	8500	
264 308	5.5	6	18	--	0.60	8500	
264 430	6.0	6	18	--	0.60	8300	
264 354	6.5	8	18	--	0.60	8000	
283 786	6.8	8	18	--	0.57	7500	
289 458	7.1	8	18	--	0.55	7200	
264 295	7.5	8	18	--	0.53	7000	
283 787	8.0	8	18	--	0.50	3500	
283 788	8.2	10	18	--	0.50	3000	
283 789	8.5	10	18	--	0.50	2500	
264 319	9.0	10	18	--	0.48	2400	
289 017	10.0	10	18	--	0.45	2000	

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Art.-Nr.	[mm]		[mm]	[mm]	[mm/min]	[mm/min]	[U/min]	um/dm*
	Pitch (m)		screw tap					
	[mm]							
	Ø	m						
283 794	M4	0.70		12	-	0.42	600	
283 795	M5	0.80		13	-	0.48	600	
283 796	M6	1.00		15	-	0.60	600	
283 798	M8	1.25		18	-	0.75	600	
283 790	M10	1.50		20	-	0.90	600	
289 018	M12	1.75		23	-	1.05	600	

Note:

These guideline values refer to the use of the tool holder 283 603 (tap drill)

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