Tool table for DC 500-tools Aluminium

Schüco	Cutter Ø		Shaft Ø	Cutting lenght	max. cutting step	Feed milling	Feed intrusion (Z) drilling	Speed
Art.-Nr.	[mm]		[mm]	[mm]	[mm]	[mm/min]	[mm/min]	[U/min]
solid carbide milling tools								
296 589	4		6	8	4	610	150-400	12600
296 590	5		6	8	5	610	150-400	12200
296 591	6		6	10	6	600	150-450	11000
296 592	8		8	10	8	1600	150-400	18000
296 593	10		10	12	10	1200	150-600	14000
282 421	10		10	12	10	1100	500	12000
289 281	10		12	15	6	800	150-350	14000
solid carbide milling tools 2 edged								
283 367	4		6	8	3	800	200	15000
283 368	5		6	8	3	800	200	15000
283 369	6		6	10	3	2000	300	8000
283 370	8		8	10	5	2500	300	8000
283 371	10		10	12	8	3000	300	8000
289 670/-671	16		16	8.5	7.5	1500	150-500	7500
283 312	20		20	35	12	2000	500	12500
289 012	20		20	35	12	2000	400	12500
280 272	20		20	35	16	2000	150-500	12000
special contour milling cutter								
282 296	RL-Fräser		20	1,5 x 30°	0	750	0	15000
282 297	RL-Fräser		20	5,0 x 30°	0	750	0	15000
282 486	SL-Fräser		20	R = 10	0	1000	0	13500
289 516	T-Nutenfräser		10	Ø 28,5 x 8	0	1100	0	6000
Disc milling cutter / Saw								
280 857	120		-	5,7	-	1000	-	11000
283 768	330		-	3,5	-	2800	-	3000
283 717	500		-	4,4	-	2500	-	2500
282 771	500		-	4,6	-	2500	-	2500
283 867	500		-	4,8	-		-	
283 868	500		-	4,8	-		-	
Drill								
283 780	2,2		6	20	18	-	800	15000
283 781	2,5		6	20	18	-	800	14000
283 782	3,0		6	20	18	-	750	10000
283 783	3,2		6	20	18	-	700	9500
289 456	3,5		6	20	18	-	700	9500
283 784	4,2		6	20	18	-	700	9000
289 457	4,7		6	20	18	-	650	8700
283 785	5,0		6	20	18	-	600	8500
283 786	6,8		8	20	18	-	570	7500
289 458	7,1		8	20	18	-	550	6000
283 787	8,0		8	20	18	-	500	3500
283 788	8,2		10	20	18	-	500	3000
283 789	8,5		10	21	18	-	500	2500
289 017	10,0		10	21	18	-	450	2000
	Pitch m [mm]		Tap					
	Ø	m						
283 794	M4	0,7	4,5	12	12	-	420	600
283 795	M5	0,8	6	13	13	-	480	600
283 796	M6	1	6	15	15	-	600	600
283 798	M8	1,25	8	18	18	-	750	600
283 790	M10	1,5	10	20	20	-	900	600
289 018	M12	1,75	12	23	23			

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)

* 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.

Tool table for DC 500-tools Steel

Schüco	Cutter Ø		Shaft Ø	Cutting lenght	max. cutting step	Feed milling	Feed intrusion (Z) drilling	Speed
Art.-Nr.	[mm]		[mm]	[mm]	[mm]	[mm/min]	[mm/min]	[U/min]
solid carbide milling tools								
280 723*	6		6	10	3	1000	100	11000
280 724*	8		8	16	4	1200	100	9000
280 725*	10		10	19	6	700	150	7000
289 137**	16		16	30	8	1800	600	6600
Drill								
283 780	2,2		6	20	18	-	800	15000
283 781	2,5		6	20	18	-	800	14000
283 782	3,0		6	20	18	-	750	10000
283 783	3,2		6	20	18	-	700	9500
289 456	3,5		6	20	18	-	700	9500
283 784	4,2		6	20	18	-	700	9000
289 457	4,7		6	20	18	-	650	8700
283 785	5,0		6	20	18	-	600	8500
283 786	6,8		8	20	18	-	570	7500
289 458	7,1		8	20	18	-	550	6000
283 787	8,0		8	20	18	-	500	3500
283 788	8,2		10	20	18	-	500	3000
283 789	8,5		10	21	18	-	500	2500
289 017	10,0		10	21	18	-	450	2000
Disc milling cutter / Saw								
280 857	355,0		-	2,4	-	90-150	-	400
	Pitch m [mm]		Tap					
	Ø	m						
283 794	M4	0,70	4,5	12	12	-	420	600
283 795	M5	0,80	6	13	13	-	480	600
283 796	M6	1,00	6	15	15	-	600	600
283 798	M8	1,25	8	18	18	-	750	600
283 790	M10	1,50	10	20	20	-	900	600
289 018	M12	1,75	12	23	23	-		

Tool table for AF 500-tools Stainless steel

Schüco	Cutter Ø	Shaft Ø	Cutting lenght	max. cutting step	Feed milling	Feed intrusion (Z) drilling	Speed
Art.-Nr.	[mm]	[mm]	[mm]	[mm]	[mm/min]	[mm/min]	[U/min]
solid carbide milling tools							
289 135*	8,0	8	16	4	600	50	4000
289 136*	10,0	10	19	4	600	50	4000
289 137**	16,0	16	30	15	400	100	1800

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)

* 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).