

T890HT ELN/FLN-13 milling cutters are intended mainly for rough face milling near square shoulder, due to their 90° cutting-edge angle.

The depth of cut should not exceed the maximum catalog depth of cut.

The deviation of a generated shoulder profile, which is a function of a cutter diameter and a depth of cut, may be estimated with the use of the following sketch and table:

Cutter Diameter, mm	$\Delta 1$ , mm	$\Delta 2$ , mm
<b>32</b>	0.04	0.09
<b>40</b>	0.06	0.12
<b>50</b>		
<b>63</b>		
<b>80</b>	0.08	0.16
<b>100</b>	0.09	0.18
<b>125</b>		
<b>160</b>		

The cutters in 32 and 40 mm diameters are not recommended for machining shoulders by stepdown milling.

