

TOOL DIA		$\alpha^\circ$ - Ramp Down	
mm	inch	mm	inch
40	1.5	0.9	0.9
50	2	0.7	0.7
63	2.5	0.5	0.5

## HELITANG

T490 LINE

A chip splitting insert is designed for general roughing applications, especially when using extended flute cutters. The insert is most efficient for deep shoulder milling providing better chip evacuation.

For optimal performance, it is recommended to mount the inserts in an alternating edge configuration on adjacent cutter flutes to achieve the most effective chip splitting effect.

Basically, the chip splitting inserts demonstrate maximum efficiency when they are mounted in milling cutters with even-number of teeth (flute).

The following figures and table illustrate the principle of insert mounting and their indexing.



Fig 1. A side view of insert T490 LNMT 1306PNTR-CS

Z	Initial positioning	First indexing
	Side	Side
3	A, B, A	B, A, B
4	A, B, A, B	B, A, B, A
5	A, B, A, B, A	B, A, B, A, B
6	A, B, A, B, A, B	B, A, B, A, B, A
7	A, B, A, B, A, B, A	B, A, B, A, B, A, B

Z: Number of inserts

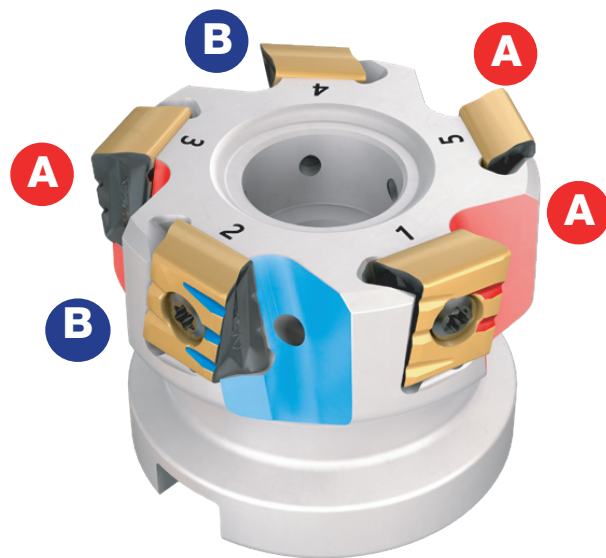


Fig 2. Example of facemill cutter with 5 effective teeth

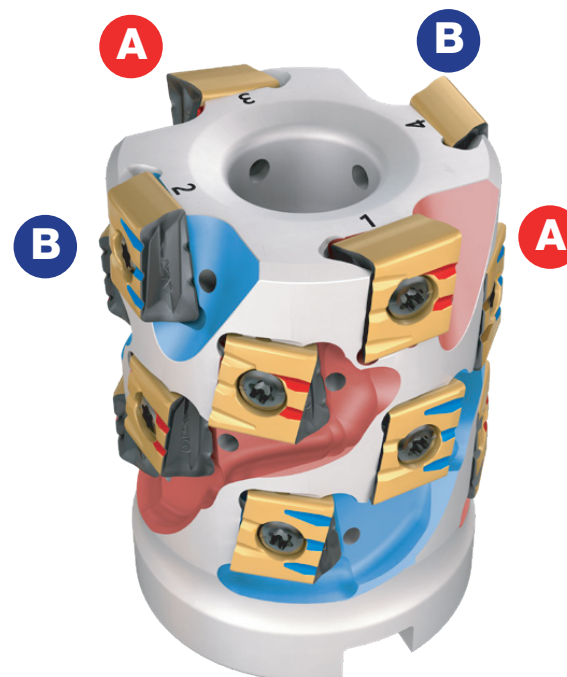


Fig 3. Example of extended flute shellmill with 4 effective teeth