

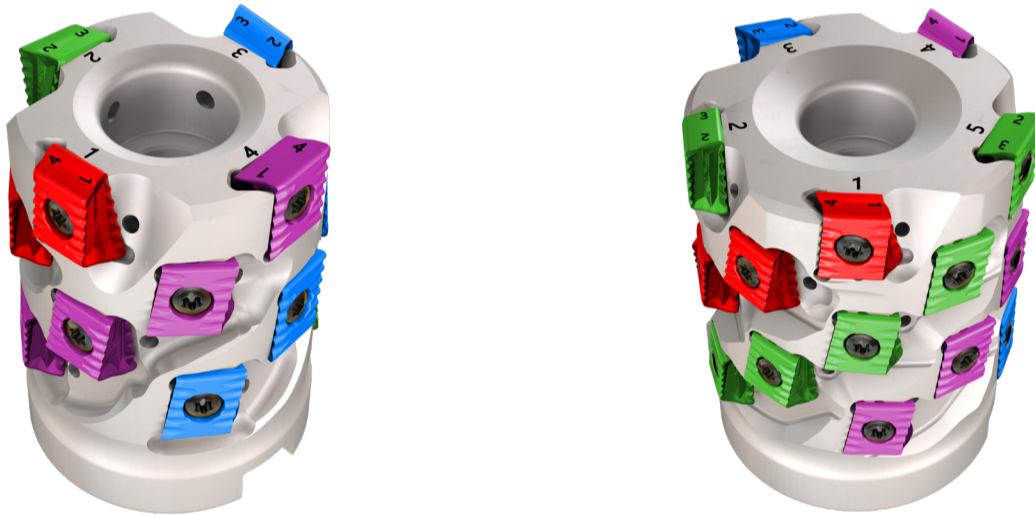
A serrated cutting edge provides an ideal solution for machining very deep cavities as the chips can easily be removed from the machining zone and consequently deliver effective chatter dampening abilities, even when positioned at more than 3×D long overhang positions. The serrated cutting edges are designed to ensure overlapping effect between all adjacent tool pockets, every 4 inserts providing a “fully effective” cutter configuration. In order to provide an overlapping effect and achieve optimal chip crushing, it is recommended to mount the inserts in alternating edge configuration on adjacent flute of a cutter.

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

Fig 1. Example of face mill cutters with 5 and 6 effective teeth



Fig 2. Example of extended flute shell mills with 4 and 5 effective teeth (flutes)



Z	Initial positioning	First indexing	Second indexing	Third indexing
	Corner No.	Corner No.	Corner No.	Corner No.
3	1, 2, 3	2, 3, 4	3, 4, 1	4, 1, 2
4	1, 2, 3, 4	2, 3, 4, 1	3, 4, 1, 2	4, 1, 2, 3
5	1, 2, 3, 4, 2	2, 3, 4, 1, 3	3, 4, 1, 2, 4	4, 1, 2, 3, 1
6	1, 2, 3, 4, 2, 3	2, 3, 4, 1, 3, 4	3, 4, 1, 2, 4, 1	4, 1, 2, 3, 1, 2
7	1, 2, 3, 4, 2, 3, 4	2, 3, 4, 1, 3, 4, 1	3, 4, 1, 2, 4, 1, 2	4, 1, 2, 3, 1, 2, 3

Z: Number of effective teeth (flutes)

Note 1: mounting the inserts not according to the instructions may shorten the inserts' tool life.

Note 2: in case of extended flute cutters, it important to mount the inserts in the same edge configuration along all the flute.

T490 LNMT1306PNR-RDPFW840

Tool Diameter		α° - Ramp Down	
mm	inch	mm	inch
40	1.25	0.9	0.9
50	2.0	0.7	0.7
63	2.5	0.5	0.5