

# THE NEW DIMENSION HFC 19

## IN HIGH-FEED MILLING

- ▲ Superior metal removal rates
- ▲ Four useable cutting edges
- ▲ Soft cutting positive geometry
- ▲ Cutting depth of up to .129"



CERATIZIT is a high-tech engineering group specialized in tooling and hard material technologies.



**Tooling the Future**

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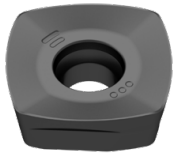
## A new dimension in high-feed milling

In order to meet the demand from our customers for ever higher feeds and reduced machining times, we have upgraded our existing HFC system with a size 19 indexable insert. The new HFC 19 system allows for cutting depths up to 83 % higher and feeds up to 150 % higher.

### Customer Benefits



- Irregular pitch for extremely quiet running
- Easy handling thanks to large indexable insert
- FEM-optimized base body
- Optimized chip gullets for excellent chip evacuation
- Coolant holes for emulsion/air/MMS
- Cutting forces are exerted primarily in the axial direction
- Minimal stress on the machine spindle



- Patented rectangular geometry, large radius
- Four useable cutting edges
- Soft cut with positive geometry
- Stable mating surfaces
- Cutting depth of up to .129"

### Success Story

Material: Ti6Al4V (3.7165)  
 Indexable insert: XOLX 190615ER-F40 CTC5240  
 Tool: AHFC.300.R.06-19

Cutting data	CERATIZIT	Competitor
$v_c$ in ft/min	3.00"	3.00"
$f_z$ inch	.028"	.010"
$a_p$ inch	.129"	.120"
$a_e$ inch	40	40
Coolant	Emulsion	Emulsion
Tool life/component	3	1

Machining time in min

