**EMO, Milan**

**Hall 10, Stand B10**

**Expanded 406 tangential milling system**

The patented 406 tangential milling system has been expanded twice over, now offering side milling cutters and screw-in milling cutters.

Available with diameters of 100 mm (3.9370") and 125 mm (4.9213") as well as cutting widths of 10 mm (0.3937") or 12 mm (0.4724"), the side milling cutters achieve slot depths of 26 mm (1.0236") or 34.5 mm (1.3583"). The bore and driver slot are compliant with DIN 138. Featuring cutting edge diameters of 16, 20, 25, 32 and 40 mm (0.6299"; 0.7874"; 0.9843"; 1.2598" and 1.5748") the screw-in milling cutters are equipped with a metric thread that has cylindrical level support, plus internal cooling. Like the previous version, which included a DIN 1835-B holder, these milling cutters come with two to six AS4B-grade rhombic indexable inserts of type 406, which are precision-ground and achieve a high level of precision with very good surface quality. Positive cutting and axial angles enable a soft cut. The secondary cutting edge with integrated trailing chamfer produces outstanding surfaces. An additional free-formed surface chamfer provides a stable wedge angle and a smooth milling process.

The cutting inserts with a corner radius of 0.4 mm or 0.8 mm (0.0157" or 0.0315") achieve cutting depths of up to 6.3 mm (0.2480") and are suitable for milling exact 90 ° shoulders. The entire cutting length can be used during this process. The side milling cutter is equipped with identical R406 inserts, but also requires the left version (L406).

*1,485 characters incl. spaces*

**Image captions:**

**Image 1:** Side milling cutters and screw-in milling cutters are new additions to the 406 system.

**Image credits:** Paul Horn GmbH, Nico Sauermann

Text and further information:

Hartmetall-Werkzeugfabrik Paul Horn GmbH, Mr Christian Thiele

Unter dem Holz 33-35, 72072 Tübingen, Germany

Tel.: +49 7071 7004-1602, Fax: +49 7071 72893

E-mail: [christian.thiele@phorn.de](mailto:christian.thiele@phorn.de), [www.phorn.de](http://www.phorn.de/)