**Intec, Leipzig**

Hall 3 / Stand F04/G05

Hall 2 / Stand B01

**409 tangential milling cutter system - main body with wide tooth pitch**

HORN has enhanced its proven 409 tangential milling cutter system to include additional 90-degree milling shanks as well as cutter heads with a wide tooth pitch. The new end mills are available with cutting edge diameters of 32 and 40 mm in accordance with DIN 1835-B. Arbor milling cutter bodies in accordance with DIN 8030-A are available in diameters 40, 50, 63 and 80 mm.

The 90-degree milling shank and the cutter head with wide tooth pitch provide users with greater feed rates per tooth and increased infeeds. These new products from HORN also demonstrate their strengths when machining long-chipping materials.

The 409 tangential milling cutter system is equipped with indexable rhombic inserts. They are precision-ground and achieve a high level of precision with very good surface quality levels. The system with new, additional holders also has 45 and 60-degree milling cutters as well as indexable insert end mills and side milling cutters.

The 45-degree variant achieves cutting depths of ap = 6.2 mm and the 60-degree version cutting depths of ap = 7.7 mm. Each can be used with the same R409 indexable inserts. Both milling cutter models are available as arbor milling cutters with DIN 8030-A holders in cutting edge diameters of 40, 50 and 63 mm. The 90-degree milling cutter from the 409 system is available in cutting edge diameters of 32, 40, 50, 63 and 80 mm. The milling cutters have an internal coolant supply which provides efficient cooling and optimises chip flow. The 45 and 60-degree versions are available with five, seven or eight teeth.

HORN is also introducing five-row indexable insert end mills with a cutting depth of ap = 43.2 mm and DIN 8030-A holders into its range. These also use the R409 indexable inserts. These holders have internal cooling and are available in diameters of 40, 50 and 63 mm. Side/slot milling cutters with DIN 138 driver slots also form part of the 409 system. The milling cutters are available with cutting edge diameters of 100 and 125 mm and have cutting widths of 14 and 18 mm.

HORN's 409 tangential milling cutter system is particularly suitable for general steel machining. With alloy steel, the tools achieve a cutting speed of vc = 150 m/min, and with high-alloy steel a speed of vc = 70 m/min.

*2,327 characters incl. spaces*

**Image captions:**

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**Image 1:** HORN has enhanced its proven 409 tangential milling cutter system to include cutter heads with a wide tooth pitch.

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**Image 2:** The rhombic indexable inserts are precision-ground and achieve a high level of precision with very good surface quality levels.

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

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