



OFMW-FF Available in New Grades

Following the successful introduction of the OFMW 0706R10-FF IC908 revolutionary insert which has expanded the FEEDMILL family, we are adding two additional grades: **IC910 and IC928**. These two grades, together with the already available IC908 grade, will enable us to cover most face milling material and application ranges.

The round OFMW 0706R10-FF insert has **eight FEEDMILL** large radii segmented cutting edges. The insert does not require any new tools. It can be clamped on the standard HELIOCTO HOF tools after removing their seats.

This is another option for the HELIOCTO milling cutters which already use the octagonal OF.. 0706/07T3 and the round RF.. 19... inserts.

The HOF cutters, when used with OFMW 0706R10-FF inserts at small depths of cut, can run at extremely high table feeds.

For example: **at .020 inch DOC, a .118 inch feed per tooth can be applied.**

The tool life under these cutting parameters is remarkably high (see attached DOC vs. feed application range data).

As with the other FEEDMILL tools, the resultant force exerted on the tool is directed axially towards the spindle. This feature enables using the tools also on small to medium machines, less rigidly clamped parts and yet to attain very high metal removal rates.

We take this opportunity to provide detailed machining recommendations for this insert.

With the addition of these new grades, we are certain that their sales will increase substantially.

Availability

In stock.

Prices

Your price list will be sent to you by the pricing department and it is available in the **GAL** system.

Sincerely,

David Feldman
Chief Technical Officer,
ROTATING TOOLS
Iscar Headquarters

Sincerely,

Rafi Rabouach
Product Manager,
DIE & MOLD
Iscar Headquarters

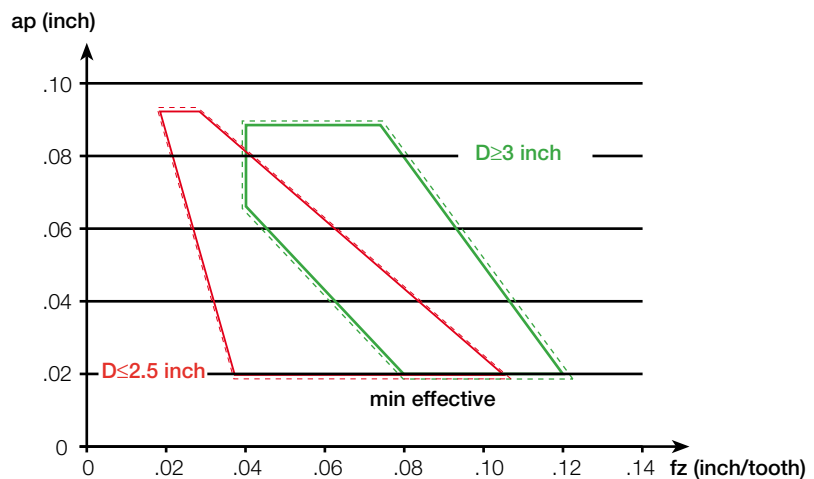


OFMW 0706...-FF fast Feed

- Eight FEEDMILL large radii segmented cutting edges.
- Can run at extremely high table feeds at small depths of cut.

Designation	ap	d	S	Tool Types	Type of Machining	Hard ← Tough →			
						IC908	IC910 <i>NEW</i>	IC928 <i>NEW</i>	
OFMW 0706R10-FF	.087	.803	.315	1	Medium-Heavy	●	●	●	
To be used without a seat.						P Steel	✓	✓	✓
						M Stainless Steel	✓		✓
						K Cast Iron	✓	✓	✓
						N Aluminum	✓		
						S High Temp. Alloys	✓		✓
						H Hardened Steel	✓		

Depth of cut and feed range (Depending on tool diameter: D)



Tool Types

1 HOF



Workpiece Materials ⁽¹⁾			Insert	Carbide Grade	Cutter ⁽²⁾ Overhang [inch]	Coolant	Cutting Conditions			
Material	SAE/AISI (DIN) ⁽³⁾	Hardness					D.O.C. Ap max [inch]	W.O.C. ⁽²⁾ Ae max [inch]	Vc [SFM]	fz [IPT]
Non-Alloy Steel	SAE 1060 (DIN 1.0601)	180-200 HB								
Alloy Steel	SAE 4340 (DIN 1.6582)	24-30 HRc	OFMW 07...-FF	IC908	2+D	Air	.059	0.7+D	330-460	.031-.055
							.087		330-460	.031-.055
Mold Steel	P20 (DIN 1.2311)	30-36 HRc	OFMW 07...-FF	IC908	2+D	Air	.059	0.7+D	330-460	.031-.047
							.087		330-460	.031-.047
0.5-1.0 Tool & Die Steel	H13 (DIN 1.2344)	200-220 HB	OFMW 07...-FF	IC908	2+D	Air	.059	0.7+D	330-490	.031-.055
				IC928			.087		330-490	.020-.039
Stainless Steel (Austenitic)	AISI 304L (DIN 1.4306)	200 HB	OFMW 07...-FF	IC908	2+D	Air	.059	0.7+D	260-330	.031-.047
	AISI 316L (DIN 1.4304)	140 HB		IC928			.087		260-330	.020-.031
Stainless Steel (Martensitic)	AISI 420 (DIN 1.4021)	200 HB	OFMW 07...-FF	IC908	2+D	Air	.059	0.7+D	260-430	.031-.055
				IC928			.087		260-430	.020-.039
Cast Iron	Grey GG25 (DIN 06025)	250 HB	OFMW 07...-FF	IC910	2+D	Air	.059	0.7+D	180-230	.039-.059
				IC908					130-180	
				IC910			.087		150-200	.031-.047
				IC908					130-180	
Nodular	GGG50 (DIN 0.705)	200 HB	OFMW 07...-FF	IC910	2+D	Air	.059	0.7+D	330-490	.047-.071
				IC908					330-460	
				IC910			.087		330-490	.031-.055
				IC908					330-460	
High Temp. Alloys	Titanium Ti6Al4V	35-45 HRc								
	Inconel 718 (DIN 1.6582)	200 HB								
Hardened Mold Steel	SAE 4340 (DIN 1.6582)	35-45 HRc	OFMW 07...-FF	IC908	2+D	Air	.059	0.7+D	260-330	.024-.035
							.087		260-330	.016-.028

⁽¹⁾ Example of typical material.

⁽²⁾ D-Cutter diameter (mm).

⁽³⁾ Equivalent or similar grade.