SAD11E

P M K N S H

PRAMET

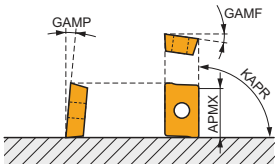
S

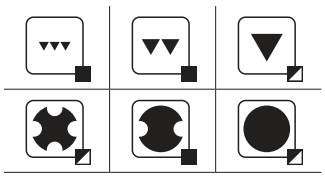
FORCE AD11 Square Shoulder Mill with Internal Coolant

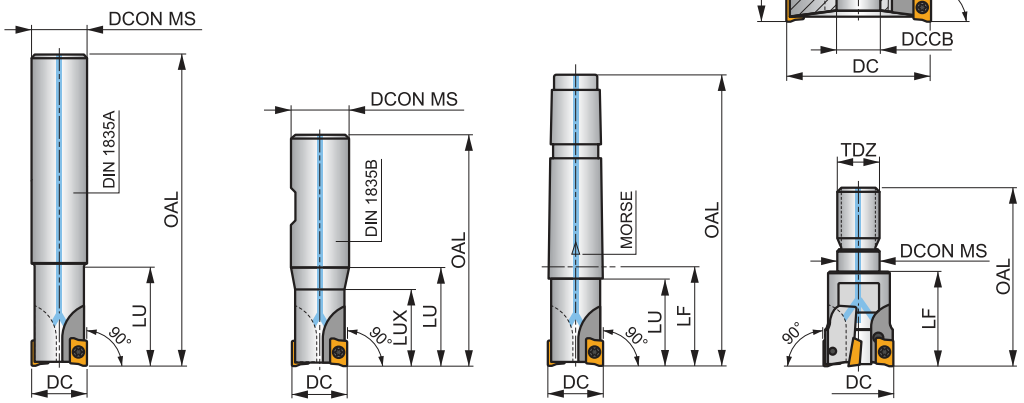
90° end and shell mills utilising positive AD.. 11 style insert with APMX of 9 mm. Suitable for face, shoulder, slot, helical, trochoidal, ramping and plunge milling. Available in cylindrical, Weldon, Morse taper, modular and arbor (with differential tooth pitch) style, in Ø16 up to Ø125 mm. Body treated for longer tool life.

FORCE AD

KAPR	90°
APMX	9.0 mm







h_m 0.08 - 0.16

h_m 0.06 - 0.13

	Product	DC	OAL	DCON MS	DCCB	LU	LUX	LF	TDZ	CZC MS	KWW	KWD	GAMF	GAMP			max.		kg			
		[mm]	[mm]	[mm]	[mm]	[mm]	[mm]	[mm]			[mm]	[mm]	[°]	[°]								
	16A2R024A14-SAD11E-C	16	160	14	–	24	–	–	–	–	–	–	-12.8	4	2	–	30100	✓	0.21	GI169	SQ025	–
	16A2R024A16-SAD11E-C	16	135	16	–	24	–	–	–	–	–	–	-12.8	4	2	–	30100	✓	0.19	GI169	SQ025	–
	16A2R050A16-SAD11E-C	16	135	16	–	50	–	–	–	–	–	–	-12.8	4	2	–	30100	✓	0.20	GI169	SQ025	–
	18A2R029A20-SAD11E-C	18	150	20	–	29	–	–	–	–	–	–	-12	4.5	2	–	28400	✓	0.35	GI169	SQ025	–
	20A2R029A20-SAD11E-C	20	150	20	–	29	–	–	–	–	–	–	-11.5	5	2	–	27000	✓	0.33	GI169	SQ020	–
	20A2R070A20-SAD11E-C	20	150	20	–	70	–	–	–	–	–	–	-11.5	5	2	–	27000	✓	0.32	GI169	SQ020	–
	20A3R029A18-SAD11E-C	20	200	18	–	29	–	–	–	–	–	–	-11.5	5	3	–	27000	✓	0.38	GI169	SQ025	–
	20A3R029A20-SAD11E-C	20	150	20	–	29	–	–	–	–	–	–	-11.5	5	3	–	27000	✓	0.33	GI169	SQ025	–
DIN 1835A	22A3R029A20-SAD11E-C	22	200	20	–	29	–	–	–	–	–	–	-11.5	5	3	–	25600	✓	0.49	GI169	SQ025	–
	25A3R034A25-SAD11E-C	25	170	25	–	34	–	–	–	–	–	–	-10.2	5	3	–	24100	✓	0.42	GI169	SQ020	–
	25A3R080A25-SAD11E-C	25	170	25	–	80	–	–	–	–	–	–	-10.2	5	3	–	24100	✓	0.55	GI169	SQ020	–
	25A4R034A25-SAD11E-C	25	170	25	–	34	–	–	–	–	–	–	-10.2	5	4	–	24100	✓	0.42	GI169	SQ025	–
	25A4R040A25-SAD11E-C	25	250	25	–	40	–	–	–	–	–	–	-10.2	5	4	–	24100	✓	0.86	GI169	SQ025	–
	30A3R080A32-SAD11E-C	30	200	32	–	80	–	–	–	–	–	–	-9.3	7	3	–	22000	✓	1.02	GI169	SQ020	–
	32A3R090A32-SAD11E-C	32	195	32	–	90	–	–	–	–	–	–	-9	5	3	–	21300	✓	1.01	GI169	SQ020	–
	32A5R034A32-SAD11E-C	32	195	32	–	34	–	–	–	–	–	–	-9	8	5	–	21300	✓	1.03	GI169	SQ025	–
	35A5R025A32-SAD11E-C	35	200	32	–	25	–	–	–	–	–	–	-9	8	5	–	20300	✓	1.16	GI169	SQ020	–
	16A2R027B16-SAD11E-C	16	75	16	–	–	27	–	–	–	–	–	-12.8	4	2	–	30100	✓	0.09	GI169	SQ025	–
	20A2R032B20-SAD11E-C	20	82	20	–	–	32	–	–	–	–	–	-11.5	5	2	–	27000	✓	0.13	GI169	SQ020	–
	20A3R032B20-SAD11E-C	20	82	20	–	–	32	–	–	–	–	–	-11.5	5	3	–	27000	✓	0.13	GI169	SQ025	–
DIN 1835B	25A3R042B25-SAD11E-C	25	98	25	–	–	42	–	–	–	–	–	-10.2	5	3	–	24100	✓	0.29	GI169	SQ020	–
	25A4R042B25-SAD11E-C	25	98	25	–	–	42	–	–	–	–	–	-10.2	5	4	–	24100	✓	0.31	GI169	SQ025	–
	32A4R042B32-SAD11E-C	32	102	32	–	–	42	–	–	–	–	–	-9	8	4	–	21300	✓	0.27	GI169	SQ020	–
	32A5R042B32-SAD11E-C	32	102	32	–	–	42	–	–	–	–	–	-9	8	5	–	21300	✓	0.52	GI169	SQ025	–
	16A2R030E02-SAD11E-C	16	94	–	–	25	–	30	–	2	–	–	-12.8	4	2	–	30100	✓	0.15	GI169	SQ025	–
DIN 228A	20A3R035E03-SAD11E-C	20	116	–	–	30	–	35	–	3	–	–	-11.5	5	3	–	27000	✓	0.28	GI169	SQ025	–
	25A4R043E03-SAD11E-C	25	124	–	–	38	–	43	–	3	–	–	-10.2	5	4	–	24100	✓	0.32	GI169	SQ025	–

	Product	DC [mm]	OAL [mm]	DCON MS [mm]	DCCB [mm]	LU [mm]	LUX [mm]	LF [mm]	TDZ	CZC MS	KWW [mm]	KWD [mm]	GAMF [°]	GAMP [°]			max.		kg			
MODULAR	**16A2R024M08-SAD11E-C**	16	38	8.5	–	–	–	24	M8	–	–	–	-12.8	4	2	–	–	✓	0.04	GI169	SQ025	–
	20A2R026M10-SAD11E-C	20	45	11	–	–	–	26	M10	–	–	–	-11.5	5	2	–	–	✓	0.09	GI169	SQ020	–
	20A3R026M10-SAD11E-C	20	45	10.5	–	–	–	26	M10	–	–	–	-11.5	5	3	–	–	✓	0.06	GI169	SQ025	–
	25A3R033M12-SAD11E-C	25	55	12.5	–	–	–	33	M12	–	–	–	-10.2	5	3	–	–	✓	0.15	GI169	SQ020	–
	25A4R033M12-SAD11E-C	25	55	12.5	–	–	–	33	M12	–	–	–	-10.2	5	4	–	–	✓	0.09	GI169	SQ025	–
	32A4R043M16-SAD11E-C	32	66	17	–	–	–	43	M16	–	–	–	-9	8	4	–	–	✓	0.21	GI169	SQ020	–
	32A5R043M16-SAD11E-C	32	66	17	–	–	–	43	M16	–	–	–	-9	8	5	–	–	✓	0.19	GI169	SQ025	–
	40A4R043M16-SAD11E-C	40	66	17	–	–	–	43	M16	–	–	–	-8.1	11	4	–	–	✓	0.27	GI169	SQ020	–
	40A6R043M16-SAD11E-C	40	66	17	–	–	–	43	M16	–	–	–	-8.1	11	6	–	–	✓	0.21	GI169	SQ020	–
ISO 6462 DIN 8030	**40A04R-S90AD11E-C**	40	–	16	14	–	–	40	–	–	8.4	5.6	-8.1	11	4	✓	19100	✓	0.16	GI169	SQ022	–
	40A05R-S90AD11E-C	40	–	16	14	–	–	40	–	–	8.4	5.6	-8.1	11	5	✓	19000	✓	0.32	GI169	SQ022	–
	40A06R-S90AD11E-C	40	–	16	14	–	–	40	–	–	8.4	5.6	-8.1	11	6	✓	19100	✓	0.16	GI169	SQ022	–
	50A05R-S90AD11E-C	50	–	22	18	–	–	40	–	–	10.4	6.3	-7.2	12	5	✓	17000	✓	0.31	GI169	SQ023	–
	50A07R-S90AD11E-C	50	–	22	18	–	–	40	–	–	10.4	6.3	-7.2	12	7	✓	17000	✓	0.45	GI169	SQ023	–
	63A06R-S90AD11E-C	63	–	22	18	–	–	40	–	–	10.4	6.3	-6.5	12	6	✓	15200	✓	0.54	GI169	SQ023	–
	63A09R-S90AD11E-C	63	–	22	18	–	–	40	–	–	10.4	6.3	-6.5	12	9	✓	15200	✓	0.63	GI169	SQ023	–
	80A10R-S90AD11E-C	80	–	27	38	–	–	50	–	–	12.4	7	-6	12	10	✓	13500	✓	1.05	GI169	SQ021	AC001
	100A11R-S90AD11E-C	100	–	32	45	–	–	50	–	–	14.4	8	-5.5	12	11	✓	12100	✓	1.89	GI169	SQ021	AC002
	125A12R-S90AD11E-C	125	–	40	56	–	–	63	–	–	16.4	9	-5.2	12	12	✓	10800	✓	2.97	GI169	SQ021	AC003

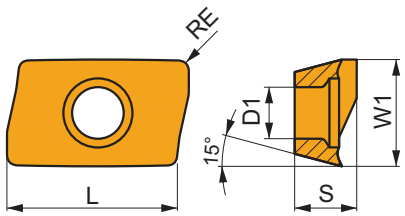
GI169	ADMX 11T3..	ADEX 11T3..

		Nm						
SQ020	US 62506-T07P	1.2	M 2.5	6	–	–	Flag T07P	–
SQ021	US 62506-T07P	1.2	M 2.5	6	D-T07P/T09P	FG-15	–	–
SQ022	US 62506-T07P	1.2	M 2.5	6	D-T07P/T09P	FG-15	–	HS 0830C
SQ023	US 62506-T07P	1.2	M 2.5	6	D-T07P/T09P	FG-15	–	HS 1030C
SQ025	US 62505-T07P	1.2	M 2.5	5	–	–	Flag T07P	–

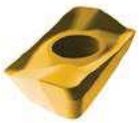
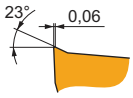
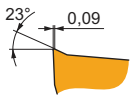
AC001	KS 1230	K.FMH27
AC002	KS 1635	K.FMH32
AC003	KS 2040	K.FMH40

ADMX 11

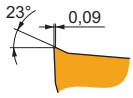
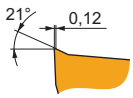
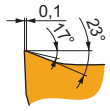
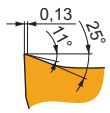
	W1	D1	L	S
	[mm]	[mm]	[mm]	[mm]
11T3	6.530	2.90	11.00	3.97



Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

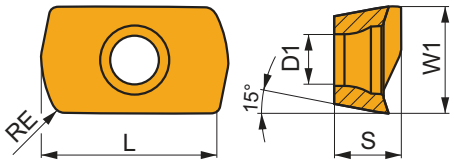
Product		RE	P			M			K			N			S			H		
			vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
		[mm]	[m/min]	[mm/tooth]	[mm]	[m/min]	[mm/tooth]	[mm]	[m/min]	[mm/tooth]	[mm]	[m/min]	[mm/tooth]	[mm]	[m/min]	[mm/tooth]	[mm]	[m/min]	[mm/tooth]	[mm]
																				
			F geometry with very sharp positive design for light machining.																	
ADMX 11T304SR-F	**8215**	0.4	245	0.10	2.0	145	0.09	2.0	230	0.10	2.0	735	0.12	2.0	60	0.08	1.6	–	–	–
	M8310	0.4	270	0.10	2.0	135	0.09	2.0	255	0.10	2.0	–	–	–	–	–	–	–	–	–
	M8330	0.4	240	0.10	2.0	140	0.09	2.0	225	0.10	2.0	720	0.12	2.0	60	0.08	1.6	–	–	–
	M8340	0.4	220	0.10	2.0	130	0.09	2.0	205	0.10	2.0	–	–	–	55	0.08	1.6	–	–	–
	M9340	0.4	285	0.10	2.0	170	0.09	2.0	–	–	–	–	–	–	70	0.08	1.6	–	–	–
ADMX 11T308SR-F	**8215**	0.8	290	0.10	2.0	170	0.09	2.0	275	0.10	2.0	870	0.12	2.0	70	0.08	1.6	–	–	–
	M8330	0.8	285	0.10	2.0	170	0.09	2.0	270	0.10	2.0	855	0.12	2.0	70	0.08	1.6	–	–	–
	M8340	0.8	260	0.10	2.0	155	0.09	2.0	245	0.10	2.0	–	–	–	65	0.08	1.6	–	–	–
	M9340	0.8	340	0.10	2.0	200	0.09	2.0	–	–	–	–	–	–	85	0.08	1.6	–	–	–
																				
			M geometry with positive design for light to medium machining.																	
ADMX 11T302SR-M	**M8330**	0.2	190	0.15	4.0	110	0.14	4.0	180	0.15	4.0	–	–	–	45	0.12	3.2	–	–	–
	M8340	0.2	170	0.15	4.0	100	0.14	4.0	160	0.15	4.0	–	–	–	40	0.12	3.2	–	–	–
ADMX 11T304SR-M	**8215**	0.4	205	0.15	4.0	120	0.14	4.0	190	0.15	4.0	–	–	–	50	0.12	3.2	–	–	–
	M8310	0.4	220	0.15	4.0	110	0.14	4.0	205	0.15	4.0	–	–	–	–	–	–	–	–	–
	M8330	0.4	205	0.15	4.0	120	0.14	4.0	190	0.15	4.0	–	–	–	50	0.12	3.2	–	–	–
	M8340	0.4	185	0.15	4.0	110	0.14	4.0	175	0.15	4.0	–	–	–	45	0.12	3.2	–	–	–
	M9325	0.4	255	0.15	4.0	–	–	–	240	0.15	4.0	–	–	–	–	–	–	–	–	–
	M9340	0.4	235	0.15	4.0	140	0.14	4.0	–	–	–	–	–	–	55	0.12	3.2	–	–	–
ADMX 11T308SR-M	**8215**	0.8	245	0.15	4.0	145	0.14	4.0	230	0.15	4.0	–	–	–	60	0.12	3.2	–	–	–
	M5315	0.8	335	0.15	4.0	–	–	–	315	0.15	4.0	–	–	–	–	–	–	–	–	–
	M8310	0.8	265	0.15	4.0	135	0.14	4.0	250	0.15	4.0	–	–	–	–	–	–	–	–	–
	M8330	0.8	245	0.15	4.0	145	0.14	4.0	230	0.15	4.0	–	–	–	60	0.12	3.2	–	–	–
	M8340	0.8	220	0.15	4.0	130	0.14	4.0	205	0.15	4.0	–	–	–	55	0.12	3.2	–	–	–
	M9315	0.8	330	0.15	4.0	–	–	–	310	0.15	4.0	–	–	–	–	–	–	–	–	–
	M9325	0.8	305	0.15	4.0	–	–	–	285	0.15	4.0	–	–	–	–	–	–	–	–	–
	M9340	0.8	275	0.15	4.0	165	0.14	4.0	–	–	–	–	–	–	65	0.12	3.2	–	–	–
ADMX 11T310SR-M	**M8330**	1.0	255	0.15	4.0	150	0.14	4.0	240	0.15	4.0	–	–	–	60	0.12	3.2	–	–	–
	M8340	1.0	230	0.15	4.0	135	0.14	4.0	215	0.15	4.0	–	–	–	55	0.12	3.2	–	–	–
ADMX 11T312SR-M	**8215**	1.2	255	0.15	4.0	150	0.14	4.0	240	0.15	4.0	–	–	–	60	0.12	3.2	–	–	–
	M8330	1.2	255	0.15	4.0	150	0.14	4.0	240	0.15	4.0	–	–	–	60	0.12	3.2	–	–	–
	M8340	1.2	230	0.15	4.0	135	0.14	4.0	215	0.15	4.0	–	–	–	55	0.12	3.2	–	–	–
ADMX 11T316SR-M	**8215**	1.6	270	0.15	4.0	160	0.14	4.0	255	0.15	4.0	–	–	–	65	0.12	3.2	–	–	–
	M6330	1.6	230	0.15	4.0	165	0.14	4.0	–	–	–	–	–	–	65	0.12	3.2	–	–	–
	M8310	1.6	295	0.15	4.0	150	0.14	4.0	280	0.15	4.0	–	–	–	–	–	–	–	–	–
	M8330	1.6	270	0.15	4.0	160	0.14	4.0	255	0.15	4.0	–	–	–	65	0.12	3.2	–	–	–
	M8340	1.6	240	0.15	4.0	140	0.14	4.0	225	0.15	4.0	–	–	–	60	0.12	3.2	–	–	–

Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

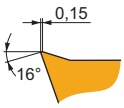
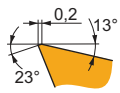
Product		RE	P			M			K			N			S			H		
			vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
		[mm]	[m/min]	[mm/tooth]	[mm]	[m/min]	[mm/tooth]	[mm]	[m/min]	[mm/tooth]	[mm]	[m/min]	[mm/tooth]	[mm]	[m/min]	[mm/tooth]	[mm]	[m/min]	[mm/tooth]	[mm]
																				
			M geometry with positive design for light to medium machining.																	
ADMX 11T320SR-M	**M6330**	2.0	240	0.15	4.0	170	0.14	4.0	–	–	–	–	–	–	70	0.12	3.2	–	–	–
	M8330	2.0	280	0.15	4.0	165	0.14	4.0	265	0.15	4.0	–	–	–	70	0.12	3.2	–	–	–
	M8340	2.0	255	0.15	4.0	150	0.14	4.0	240	0.15	4.0	–	–	–	60	0.12	3.2	–	–	–
ADMX 11T325SR-M	**M6330**	2.5	240	0.15	4.0	170	0.14	4.0	–	–	–	–	–	–	70	0.12	3.2	–	–	–
	M8340	2.5	255	0.15	4.0	150	0.14	4.0	240	0.15	4.0	–	–	–	60	0.12	3.2	–	–	–
ADMX 11T330SR-M	**M6330**	3.0	240	0.15	4.0	170	0.14	4.0	–	–	–	–	–	–	70	0.12	3.2	–	–	–
	M8330	3.0	280	0.15	4.0	165	0.14	4.0	265	0.15	4.0	–	–	–	70	0.12	3.2	–	–	–
	M8340	3.0	255	0.15	4.0	150	0.14	4.0	240	0.15	4.0	–	–	–	60	0.12	3.2	–	–	–
																				
			R geometry with positive design for machining conditions in less stable conditions.																	
ADMX 11T308PR-R	**8215**	0.8	230	0.18	4.0	135	0.16	4.0	215	0.18	4.0	–	–	–	55	0.16	3.2	45	0.15	1.0
	M5315	0.8	310	0.18	4.0	–	–	–	290	0.18	4.0	–	–	–	–	–	–	60	0.15	1.0
	M8310	0.8	250	0.18	4.0	125	0.16	4.0	235	0.18	4.0	–	–	–	–	–	–	50	0.15	1.0
	M8330	0.8	230	0.18	4.0	135	0.16	4.0	215	0.18	4.0	–	–	–	55	0.16	3.2	45	0.15	1.0
	M8340	0.8	210	0.18	4.0	125	0.16	4.0	195	0.18	4.0	–	–	–	50	0.16	3.2	–	–	–
	M9315	0.8	310	0.18	4.0	–	–	–	290	0.18	4.0	–	–	–	–	–	–	60	0.15	1.0
	M9325	0.8	290	0.18	4.0	–	–	–	275	0.18	4.0	–	–	–	–	–	–	55	0.15	1.0
ADMX 11T316PR-R	**8215**	1.6	255	0.18	4.0	150	0.16	4.0	240	0.18	4.0	–	–	–	60	0.16	3.2	50	0.15	1.0
	M8330	1.6	255	0.18	4.0	150	0.16	4.0	240	0.18	4.0	–	–	–	60	0.16	3.2	50	0.15	1.0
	M9325	1.6	320	0.18	4.0	–	–	–	300	0.18	4.0	–	–	–	–	–	–	60	0.15	1.0
																				
			MF geometry with highly positive design for light to finish machining.																	
ADMX 11T304SR-MF	**M6330**	0.4	215	0.08	2.5	150	0.07	2.5	–	–	–	–	–	–	60	0.06	2.0	–	–	–
	M8340	0.4	220	0.08	2.5	130	0.07	2.5	–	–	–	–	–	–	55	0.06	2.0	–	–	–
ADMX 11T308SR-MF	**M6330**	0.8	255	0.08	2.5	180	0.07	2.5	–	–	–	–	–	–	75	0.06	2.0	–	–	–
	M8340	0.8	265	0.08	2.5	155	0.07	2.5	–	–	–	–	–	–	65	0.06	2.0	–	–	–
	M9340	0.8	360	0.08	2.5	215	0.07	2.5	–	–	–	–	–	–	90	0.06	2.0	–	–	–
																				
			MM geometry with highly positive design for light to medium and finish to semi-rough machining.																	
ADMX 11T304SR-MM	**M6330**	0.4	185	0.14	2.5	130	0.13	2.5	–	–	–	–	–	–	55	0.11	2.0	–	–	–
	M8340	0.4	195	0.14	2.5	115	0.13	2.5	–	–	–	–	–	–	45	0.11	2.0	–	–	–
	M9340	0.4	250	0.14	2.5	150	0.13	2.5	–	–	–	–	–	–	60	0.11	2.0	–	–	–
ADMX 11T308SR-MM	**M6330**	0.8	225	0.14	2.5	155	0.13	2.5	–	–	–	–	–	–	65	0.11	2.0	–	–	–
	M8340	0.8	235	0.14	2.5	140	0.13	2.5	–	–	–	–	–	–	55	0.11	2.0	–	–	–
	M8345	0.8	190	0.14	2.5	110	0.13	2.5	–	–	–	–	–	–	45	0.11	2.0	–	–	–
	M9340	0.8	300	0.14	2.5	180	0.13	2.5	–	–	–	–	–	–	75	0.11	2.0	–	–	–
ADMX 11T312SR-MM	**M6330**	1.2	235	0.14	2.5	165	0.13	2.5	–	–	–	–	–	–	70	0.11	2.0	–	–	–
	M8340	1.2	245	0.14	2.5	145	0.13	2.5	–	–	–	–	–	–	60	0.11	2.0	–	–	–
	M9340	1.2	315	0.14	2.5	185	0.13	2.5	–	–	–	–	–	–	75	0.11	2.0	–	–	–

ADEX 11-HF

	W1 [mm]	D1 [mm]	L [mm]	S [mm]
11T3	6.450	2.90	10.67	3.82

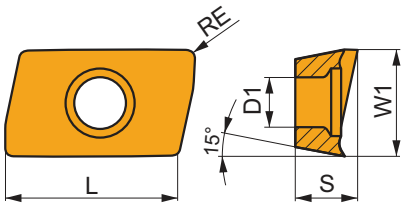


Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

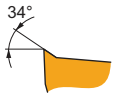
Product		RE [mm]	P vc [m/min]	P f [mm/tooth]	P ap [mm]	M vc [m/min]	M f [mm/tooth]	M ap [mm]	K vc [m/min]	K f [mm/tooth]	K ap [mm]	N vc [m/min]	N f [mm/tooth]	N ap [mm]	S vc [m/min]	S f [mm/tooth]	S ap [mm]	H vc [m/min]	H f [mm/tooth]	H ap [mm]
			HFC S																	
			HF geometry with highly positive design for high feed machining.																	
ADEX 11T308SR-HF	**8215**	0.8	215	0.68	0.4	125	0.61	0.4	–	–	–	–	–	–	–	–	–	–	–	–
	M6330	0.8	185	0.68	0.4	130	0.61	0.4	–	–	–	–	–	–	–	–	–	–	–	–
	M8310	0.8	220	0.68	0.4	110	0.52	0.4	–	–	–	–	–	–	–	–	–	–	–	–
	M8330	0.8	215	0.68	0.4	125	0.61	0.4	–	–	–	–	–	–	–	–	–	–	–	–
	M8340	0.8	200	0.68	0.4	120	0.61	0.4	–	–	–	–	–	–	–	–	–	–	–	–
	M9340	0.8	220	0.68	0.4	130	0.61	0.4	–	–	–	–	–	–	–	–	–	–	–	–
			HFC S																	
			HF2 geometry with positive design for high feed machining.																	
ADEX 11T308SR-HF2	**M8310**	0.8	220	0.68	0.4	110	0.61	0.4	205	0.68	0.4	–	–	–	–	–	–	40	0.15	1.0
	M8330	0.8	215	0.68	0.4	125	0.61	0.4	200	0.68	0.4	–	–	–	50	0.48	0.3	40	0.15	1.0
	M8340	0.8	200	0.68	0.4	120	0.61	0.4	190	0.68	0.4	–	–	–	50	0.48	0.3	–	–	–
	M9325	0.8	250	0.68	0.4	–	–	–	235	0.68	0.4	–	–	–	–	–	–	50	0.15	1.0
	M9340	0.8	220	0.68	0.4	130	0.61	0.4	–	–	–	–	–	–	55	0.48	0.3	–	–	–

ADEX 11-FA

	W1	D1	L	S
	[mm]	[mm]	[mm]	[mm]
11T3	6.450	2.90	9.70	3.91



Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

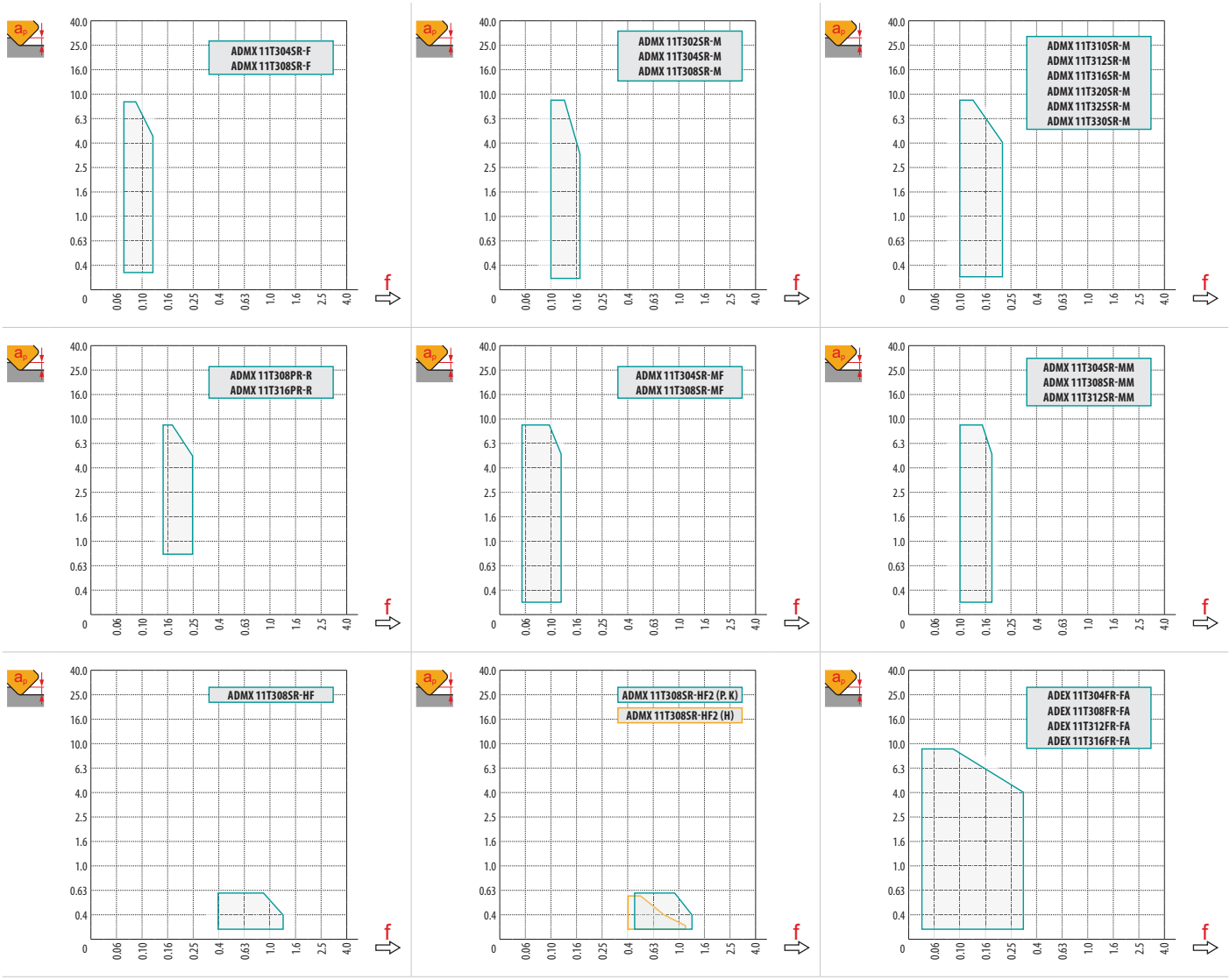
Product		RE	P			M			K			N			S			H		
			vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
		[mm]	[m/min]	[mm/tooth]	[mm]	[m/min]	[mm/tooth]	[mm]	[m/min]	[mm/tooth]	[mm]	[m/min]	[mm/tooth]	[mm]	[m/min]	[mm/tooth]	[mm]	[m/min]	[mm/tooth]	[mm]
																				
ADEX 11T304FR-FA	**HF7**	0.4	–	–	–	–	–	–	–	–	–	210	0.30	5.0	–	–	–	–	–	–
	M0315	0.4	–	–	–	–	–	–	–	–	–	480	0.30	5.0	–	–	–	–	–	–
ADEX 11T308FR-FA	**HF7**	0.8	–	–	–	–	–	–	–	–	–	240	0.30	5.0	–	–	–	–	–	–
	M0315	0.8	–	–	–	–	–	–	–	–	–	570	0.30	5.0	–	–	–	–	–	–
ADEX 11T312FR-FA	**HF7**	1.2	–	–	–	–	–	–	–	–	–	255	0.30	5.0	–	–	–	–	–	–
	M0315	1.2	–	–	–	–	–	–	–	–	–	600	0.30	5.0	–	–	–	–	–	–
ADEX 11T316FR-FA	**HF7**	1.6	–	–	–	–	–	–	–	–	–	270	0.18	5.0	–	–	–	–	–	–

FA geometry with highly positive design for fine-finish to medium machining.

a_e/DC	5 %	10 %	15 %	20 %	25 %	30 %	40 %	50 %	60 %	70 %	75 %	80 %	90 %	100 %
X.V	1.48	1.35	1.27	1.22	1.19	1.16	1.11	1.08	1.05	1.03	1.00	1.00	1.00	1.00
⇨x.f	2.20	1.60	1.35	1.20	1.10	0.95	0.85	0.75	0.85	0.95	1.00	1.00	1.00	1.00
⇨x.f	0.64	0.64	0.64	0.64	0.64	0.65	0.65	0.67	0.68	0.71	0.72	0.74	0.79	1.00

	ADMX 11-F		ADMX 11-M									ADMX 11-R		ADMX 11-MF	
RE	0.4	0.8	0.2	0.4	0.8	1.0	1.2	1.6	2.0	2.5	3.0	0.8	1.6	0.4	0.8
BS	1.89	1.48	2.09	1.89	1.48	1.27	1.08	0.68	1.61	1.13	0.66	1.48	0.68	1.89	1.48

	ADMX 11-MM				ADEX 11-HF	ADEX 11-HF2	ADEX 11-FA			
RE	0.4	0.8	1.2	1.6	0.8	0.8	0.4	0.8	1.2	1.6
BS	1.89	1.48	1.08	0.61	0.17	0.17	1.77	1.39	1.0	0.62



4.5

	1.0	5.0	9.0
f	0.20	0.13	0.10

			HFC		
DC	RPMX	APMX/l	RPMX *	RPMX **	APMX/l
16	13.5	9.0/40	4.1	5.7	0.6/8
18	10.0	9.0/53	2.8	4.5	0.6/12
20	9.0	9.0/59	2.3	4.3	0.6/15
25	6.0	9.0/87	1.3	6.7	0.6/26
32	5.3	9.0/99	0.7	4.3	0.6/49
40	3.8	6.5/100	0.3	2.9	0.6/100
50	2.8	4.7/100	0.1	2.1	0.6/100
63	1.8	3.0/100	–	–	–
80	1.6	2.6/100	–	–	–

* HFC milling

** Conventional milling

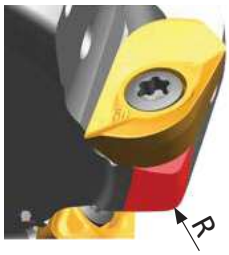
					HFC			
DC	DMIN	DMAX	SMAX DMIN	SMAX DMAX	DMIN	DMAX	SMAX DMIN	SMAX DMAX
16	27.0	32.0	8.3	9.0	21.0	32.0	0.6	0.6
18	32.0	36.0	7.5	9.0	29.0	36.0	0.6	0.6
20	35.0	40.0	7.5	9.0	29.0	40.0	0.6	0.6
25	45.0	50.0	6.5	7.5	39.0	50.0	0.6	0.6
32	59.0	64.0	4.0	4.5	53.0	64.0	0.6	0.6
40	75.0	80.0	1.5	2.0	68.5	80.0	0.6	0.6
50	–	–	–	–	88.5	100.0	0.6	0.6

a_p

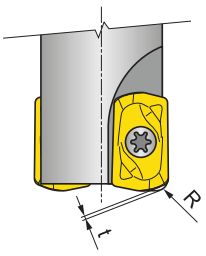
1.7

DC	µm	3	5	10	15	20	30	40	50	60	80	100
16	FE	0.438	0.566	0.800	0.980	1.131	1.386	1.600	1.789	1.960	2.263	2.530
18		0.465	0.600	0.849	1.039	1.200	1.470	1.697	1.897	2.078	2.400	2.683
20		0.490	0.632	0.894	1.095	1.265	1.549	1.789	2.000	2.191	2.530	2.828
20		0.490	0.632	0.894	1.095	1.265	1.549	1.789	2.000	2.191	2.530	2.828
25		0.548	0.707	1.000	1.225	1.414	1.732	2.000	2.236	2.449	2.828	3.162
32		0.620	0.800	1.131	1.386	1.600	1.960	2.263	2.530	2.771	3.200	3.578
40		0.693	0.894	1.265	1.549	1.789	2.191	2.530	2.828	3.098	3.578	4.000
50		0.775	1.000	1.414	1.732	2.000	2.449	2.828	3.162	3.464	4.000	4.472
63		0.869	1.122	1.587	1.944	2.245	2.750	3.175	3.550	3.888	4.490	5.020
80		0.980	1.265	1.789	2.191	2.530	3.098	3.578	4.000	4.382	5.060	5.657

RE	µm	3	5	10	15	20	30	40	50	60	80	100
1.0	FE	0.155	0.200	0.283	0.346	0.400	0.490	0.566	0.632	0.693	0.800	0.894
1.2		0.170	0.219	0.310	0.379	0.438	0.537	0.620	0.693	0.759	0.876	0.980
1.6		0.196	0.253	0.358	0.438	0.506	0.620	0.716	0.800	0.876	1.012	1.131
2.0		0.219	0.283	0.400	0.490	0.566	0.693	0.800	0.894	0.980	1.131	1.265
2.5		0.245	0.316	0.447	0.548	0.632	0.775	0.894	1.000	1.095	1.265	1.414
3.0		0.268	0.346	0.490	0.600	0.693	0.849	0.980	1.095	1.200	1.386	1.549



ADMX/ADEX 11	R
ADMX 11T320SR-M	1.0
ADMX 11T325SR-M	1.8
ADMX 11T330SR-M	1.8
ADEX 11T308SR-HF	1.4
ADEX 11T308SR-HF2	1.4



ADEX 11	R	t
ADEX 11T308SR-HF	1.42	0.35
ADEX 11T308SR-HF2	1.34	0.38