



NUT- UND TRENNFRÄSSYSTEM M475
SCHNEIDBREITE 3 UND 4 MM

**GROOVE AND CUT-OFF
MILLING SYSTEM M475**
CUTTING WIDTH 3 AND 4 MM



ph HORN ph

R

DER UNTERSCHIED: MEHR MÖGLICHKEITEN

THE DIFFERENCE:
MORE POSSIBILITIES

- **Höhere Wirtschaftlichkeit durch größere Anzahl effektiver Schneiden**
Higher efficiency due to larger number of effective cutting edges
- **Positive Wendeschneidplatten-Geometrie mit neuer Schneidstoffsorte**
Positive insert geometry with new grade
- **Neutrale Schneidplatten zur einfachen Handhabung**
Neutral inserts for easy handling

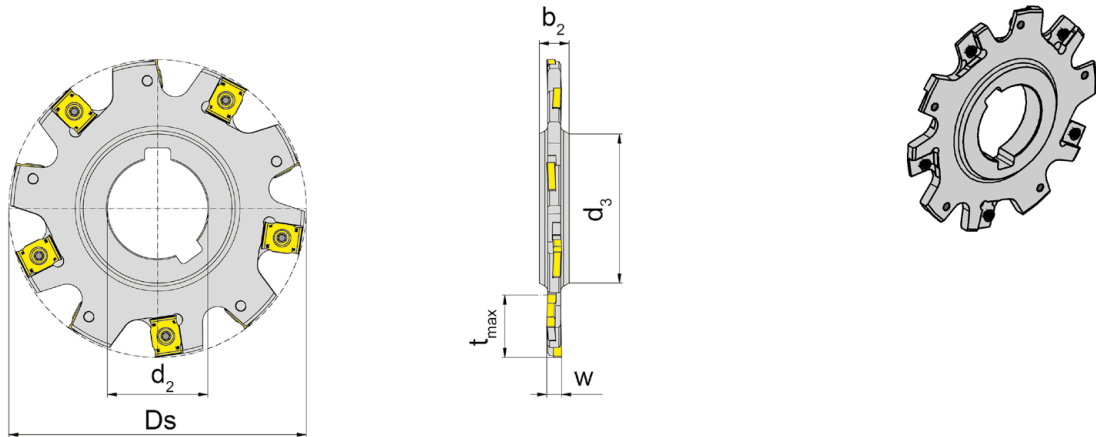
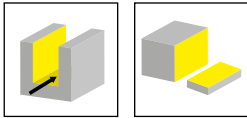


Abbildung = rechtsschneidend
Picture = right hand cutting version

Bestellnummer Part number	Z	Ds	t _{max}	d ₂	b ₂	d ₃	w	n _{max}	HWS
M475.0080.27.03	10	80	18	27	8	40	3	20000	475016N
M475.0100.32.03	12	100	25	32	8	46	3	17000	475016N
M475.0125.40.03	16	125	32	40	10	54	3	15000	475016N
M475.0160.40.03	20	160	50	40	10	54	3	12000	475016N
M475.0080.27.04	10	80	18	27	8	40	4	21000	475022N
M475.0100.32.04	12	100	25	32	8	46	4	18000	475022N
M475.0125.40.04	16	125	32	40	10	54	4	15000	475022N
M475.0160.40.04	20	160	50	40	10	54	4	13000	475022N
M475.0200.40.04	26	200	70	40	10	54	4	11000	475022N

Bohrung (d2) mit Längsnut nach DIN 138
Bore (d2) with longitudinal keyway to DIN 138

Ersatzteile

Spare Parts

Scheibenfräser Disc Milling Cutter	Spannschraube Clamping Screw	TORX PLUS®-Schlüssel TORX PLUS® Wrench
M475...03	030.2523.T6P	T6PL
M475...04	030.0330.1217	T7PL

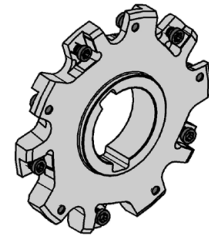
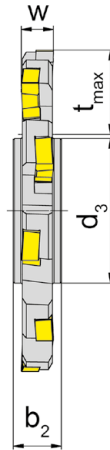
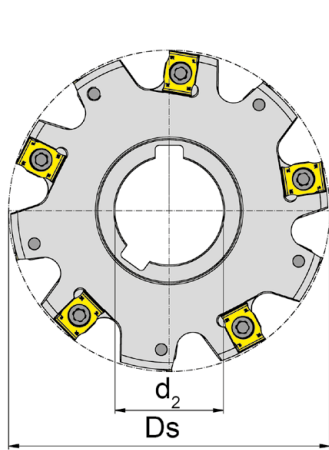
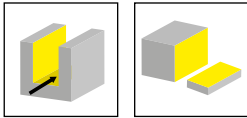


Abbildung = rechtsschneidend
Picture = right hand cutting version

Bestellnummer Part number	Z	Ds	t _{max}	d ₂	b ₂	d ₃	w	n _{max}	HWS
M475.0080.27.05	10	80	18	27	8	40	5	22000	475027N
M475.0100.32.05	12	100	25	32	8	46	5	19000	475027N
M475.0125.40.05	16	125	32	40	10	54	5	17000	475027N
M475.0160.40.05	20	160	50	40	10	54	5	14000	475027N
M475.0200.40.05	26	200	70	40	10	54	5	12000	475027N
M475.0080.27.06	10	80	21	27	10	36	6	21000	475032N
M475.0100.32.06	12	100	25,5	32	10	47	6	18000	475032N
M475.0125.40.06	16	125	32,5	40	10	58	6	15000	475032N
M475.0160.40.06	20	160	50	40	10	58	6	13000	475032N
M475.0200.50.06	26	200	63,5	50	10	71	6	11000	475032N
M475.0080.27.08	10	80	21	27	12	36	8	17000	475043N
M475.0100.32.08	12	100	25,5	32	12	47	8	15000	475043N
M475.0125.40.08	16	125	32,5	40	12	58	8	12000	475043N
M475.0160.40.08	20	160	50	40	12	58	8	10000	475043N
M475.0200.50.08	26	200	63,5	50	12	71	8	8000	475043N

Bohrung (d2) mit Längsnut nach DIN 138
Bore (d2) with longitudinal keyway to DIN 138

Ersatzteile

Spare Parts

Scheibenfräser Disc Milling Cutter	Spannschraube Clamping Screw	TORX PLUS®-Schlüssel TORX PLUS® Wrench
M475...05	030.3541.T8P	T8PL
M475...06	030.3550.T10P	T10PL
M475...08	030.350P.1110	T15PQ

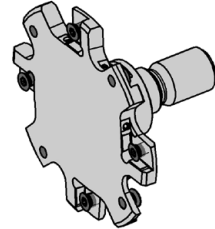
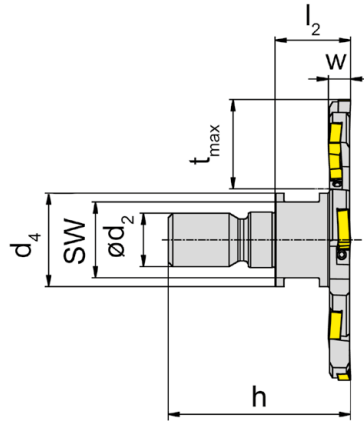
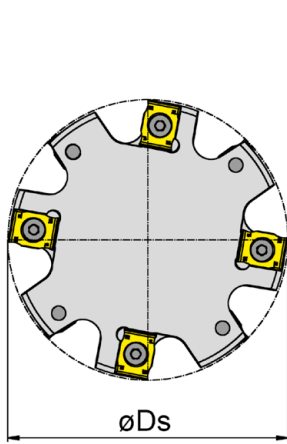
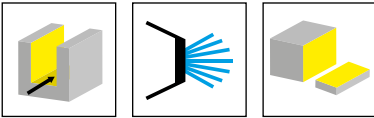


Abbildung = rechtsschneidend
Picture = right hand cutting version

Bestellnummer Part number	Z	Ds	h	l_2	d_4	d_2	SW	w	t_{max}	n_{max}	HWS
M475.0040.M8.03.IK	4	40	33	15	13	M8	10	3	13	32000	475016N
M475.0050.M10.03.IK	6	50	35	15	18	M10	15	3	15	28000	475016N
M475.0063.M12.03.IK	8	63	41	17	21	M12	17	3	20	24000	475016N
M475.0040.M8.04.IK	4	40	33	15	13	M8	10	4	13	33000	475022N
M475.0050.M10.04.IK	6	50	35	15	18	M10	15	4	15	28000	475022N
M475.0063.M12.04.IK	8	63	41	17	21	M12	17	4	20	25000	475022N
M475.0040.M8.05.IK	4	40	33	15	13	M8	10	5	13	35000	475027N
M475.0050.M10.05.IK	6	50	35	15	18	M10	15	5	15	30000	475027N
M475.0063.M12.05.IK	8	63	41	17	21	M12	17	5	20	26000	475027N

Ersatzteile

Spare Parts

Einschraubfräser Screw-in cutter	Spannschraube Clamping Screw	TORX PLUS®-Schlüssel TORX PLUS® Wrench
M475.0...03	030.2523.T6P	T6PL
M475.0...04	030.0330.1217	T7PL
M475.0...05	030.3541.T8P	T8PL

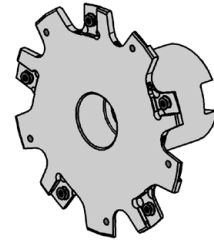
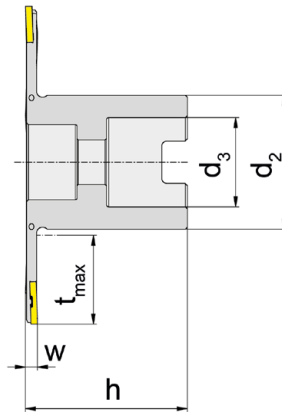
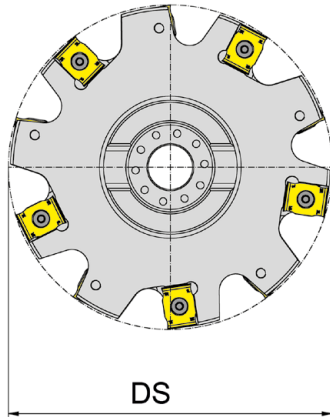
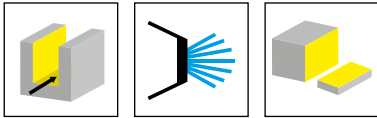


Abbildung = rechtsschneidend
Picture = right hand cutting version

Bestellnummer Part number	Z	Ds	t _{max}	h	d ₃	d ₂	n _{max}	w	HWS
M475.0063.16.03.IK	8	63	17,5	35	16	32	24000	3	475016N
M475.0080.16.03.IK	10	80	25	40	16	28	20000	3	475016N
M475.0080.22.03.IK	10	80	23	40	22	33	20000	3	475016N
M475.0100.27.03.IK	12	100	25	50	27	48	17000	3	475016N
M475.0125.27.03.IK	16	125	37,5	50	27	48	15000	3	475016N
M475.0125.32.03.IK	16	125	32,5	50	32	56	15000	3	475016N
M475.0125.40.03.IK	16	125	26,5	50	40	70	15000	3	475016N
M475.0160.40.03.IK	20	160	44	50	40	70	12000	3	475016N
M475.0063.16.04.IK	8	63	17,5	35	16	32	25000	4	475022N
M475.0080.16.04.IK	10	80	25	40	16	28	21000	4	475022N
M475.0080.22.04.IK	10	80	23	40	22	33	21000	4	475022N
M475.0100.27.04.IK	12	100	25	50	27	48	18000	4	475022N
M475.0125.27.04.IK	16	125	37,5	50	27	48	15000	4	475022N
M475.0125.32.04.IK	16	125	23,5	50	32	56	15000	4	475022N
M475.0125.40.04.IK	16	125	26,5	50	40	70	15000	4	475022N
M475.0160.40.04.IK	20	160	44	50	40	70	13000	4	475022N
M475.0200.40.04.IK	26	200	64	50	40	70	11000	4	475022N

Bohrung (d3) mit Quernut nach DIN 138
Bore (d3) with cross keyway to DIN 138

Ersatzteile

Spare Parts

Aufsteckfräser Arbour Mounted Cutter	Spannschraube Clamping Screw	TORX PLUS®-Schlüssel TORX PLUS® Wrench
M475...03	030.2523.T6P	T6PL
M475...04	030.0330.1217	T7PL

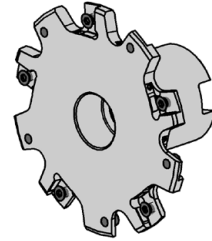
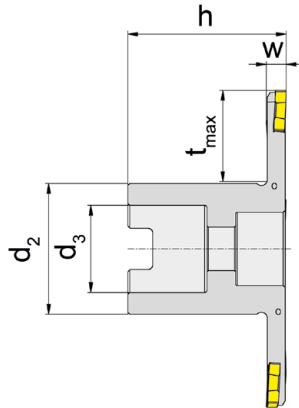
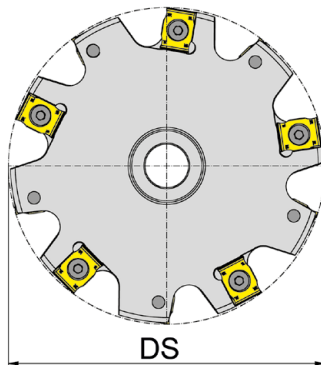
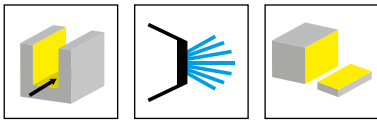


Abbildung = rechtsschneidend
Picture = right hand cutting version

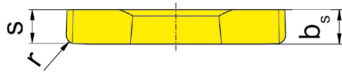
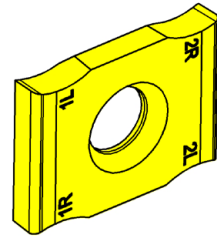
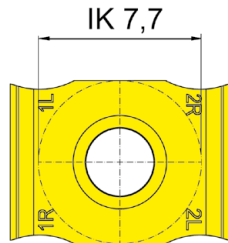
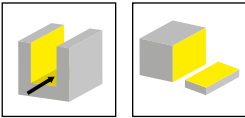
Bestellnummer Part number	Z	Ds	t _{max}	h	d ₃	d ₂	n _{max}	w	HWS
M475.0063.16.05.IK	8	63	17,5	35	16	32	26000	5	475027N
M475.0080.16.05.IK	10	80	25	40	16	28	22000	5	475027N
M475.0080.22.05.IK	10	80	23	40	22	33	22000	5	475027N
M475.0100.27.05.IK	12	100	25	50	27	48	19000	5	475027N
M475.0125.27.05.IK	16	125	37,5	50	27	48	17000	5	475027N
M475.0125.32.05.IK	16	125	32,5	50	32	56	17000	5	475027N
M475.0125.40.05.IK	16	125	26,5	50	40	70	17000	5	475027N
M475.0160.40.05.IK	20	160	44	50	40	70	14000	5	475027N
M475.0200.40.05.IK	26	200	64	50	40	70	12000	5	475027N
M475.0100.27.06.IK	12	100	25	50	27	48	18000	6	475032N
M475.0125.32.06.IK	16	125	32	50	32	56	15000	6	475032N
M475.0160.40.06.IK	20	160	44	60	40	70	13000	6	475032N
M475.0200.40.06.IK	26	200	54	50	40	90	11000	6	475032N
M475.0100.27.08.IK	12	100	25	50	27	48	15000	8	475043N
M475.0125.32.08.IK	16	125	32	50	32	56	12000	8	475043N
M475.0160.40.08.IK	20	160	44	60	40	70	10000	8	475043N
M475.0200.40.08.IK	26	200	54	50	40	90	8000	8	475043N

Bohrung (d3) mit Quernut nach DIN 138
Bore (d3) with cross keyway to DIN 138

Ersatzteile

Spare Parts

Aufsteckfräser Arbour Mounted Cutter	Spannschraube Clamping Screw	TORX PLUS®-Schlüssel TORX PLUS® Wrench
M475...05	030.3541.T8P	T8PL
M475...06	030.3550.T10P	T10PL
M475...08	030.350P.1110	T15PQ



HM-Sorten
Carbide grades

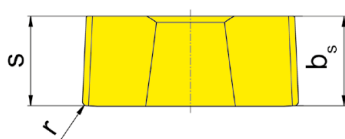
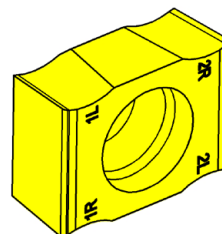
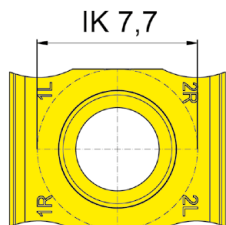
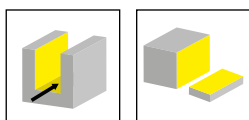
▲ ab Lager
on stock

Δ 4 Wochen
4 weeks

Bestellnummer Part number	b_s	r	s	HIS	RC4G
S475.0162.10.02	1,6	0,2	1,62	475016N	▲
S475.0163.10.04	1,61	0,4	1,63	475016N	Δ
S475.0163.10.05	1,61	0,5	1,63	475016N	Δ
S475.0222.10.02	2,2	0,2	2,22	475022N	▲
S475.0223.10.04	2,21	0,4	2,23	475022N	Δ
S475.0223.10.05	2,21	0,5	2,23	475022N	Δ
S475.0222.10.08	2,22	0,8	2,22	475022N	Δ

mittlere Spandicke h_m medium thickness of chip			
sehr stabil very rigid	0,05	stabil rigid	0,03
		nicht stabil not rigid	0,01

P	●
M	●
K	●
N	-
S	-
H	-



HM-Sorten
Carbide grades

▲ ab Lager
on stock

Δ 4 Wochen
4 weeks

Bestellnummer Part number	b_s	r	s	HIS	RC4G
S475.0273.10.02	2,7	0,2	2,73	475027N	▲
S475.0274.10.04	2,71	0,4	2,74	475027N	Δ
S475.0275.10.05	2,72	0,5	2,75	475027N	Δ
S475.0275.10.08	2,74	0,8	2,74	475027N	Δ
S475.0275.10.10	2,75	1	2,75	475027N	Δ
S475.0276.10.12	2,76	1,2	2,76	475027N	Δ
S475.0323.10.02	3,2	0,2	3,23	475032N	▲
S475.0324.10.04	3,21	0,4	3,24	475032N	Δ
S475.0325.10.05	3,22	0,5	3,25	475032N	Δ
S475.0325.10.08	3,24	0,8	3,24	475032N	Δ
S475.0325.10.10	3,25	1	3,25	475032N	Δ
S475.0326.10.12	3,26	1,2	3,26	475032N	Δ
S475.0327.10.15	3,27	1,5	3,27	475032N	Δ
S475.0433.10.02	4,3	0,2	4,33	475043N	▲
S475.0434.10.04	4,31	0,4	4,34	475043N	Δ
S475.0435.10.05	4,32	0,5	4,35	475043N	Δ
S475.0435.10.08	4,34	0,8	4,34	475043N	Δ
S475.0435.10.10	4,35	1	4,35	475043N	Δ
S475.0436.10.12	4,36	1,2	4,36	475043N	Δ
S475.0437.10.15	4,37	1,5	4,37	475043N	Δ
S475.0439.10.20	4,39	2	4,39	475043N	Δ

mittlere Spandicke h_m
medium thickness of chip

sehr stabil very rigid	0,05	stabil rigid	0,03	nicht stabil not rigid	0,01
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P	●
M	●
K	●
N	-
S	-
H	-

Werkstoff Material		Material- gruppe Material group	Härte (HB) Hardness Brinell	Zug- festigkeit R_m [N/mm ²] Tensile Strength	Beispiel Werkstoff Example Material	Schnittgeschwindigkeit Cutting speed vc (m/min) RC4G	
P	unlegierter Stahl Carbon steel	~ 0,2 % C	P1.1	125	430	CK15	160-240
		~ 0,4% C geglüht annealed	P1.2	190	610	19Mn6	160-240
		~ 0,4% C vergütet quenched	P1.3	210	640	36Mn5	160-240
		~ 0,6% C geglüht annealed	P1.4	190	610	C55	160-240
		~ 0,6% C vergütet quenched	P1.5	300	1000	CK60	160-240
		Automatenstahl Free cutting steel	P1.6	220	750	9SMn28	160-240
	niedrig legierter Stahl (<5%) Alloyed steel	geglüht annealed	P2.1	180	590	100Cr6	180-220
		vergütet quenched	P2.2	280	960	14NiCr10	180-220
		vergütet quenched	P2.3	350	1250	34CrMo4	180-220
		vergütet quenched	P2.4	430	1450	55Cr3	180-220
	hochlegierter Stahl (>5%) high alloyed steel	geglüht annealed	P3.1	200	680	X10CrAl18	80-120
		gehärtet hardened	P3.2	350	1200	X210Cr2	80-100
	Stahlguss Cast steel	unlegiert unalloyed	P4.1	180	590	GE200	160-220
		legiert alloyed	P4.2	220	750	GX40CrSi28	80-140
	Sinterstahl Sintered steel	weich soft	P5.1	220	570	Sint-D39	
M	Rostfreier Stahl Stainless steel	martensitisch ferritisch martensitic ferritic	M1.1	200	680	X16Cr13	80-140
		austenitisch austenitic ferritic	M1.2	300	1000	X6CrNiMo- Ti17-12-2	70-120
		austenitisch ferritisch austenitic	M1.3	230	780	X2CrNi- Mo-N17-13-3	70-120
K	Grauguss Grey cast iron	niedrige Festigkeit low tensile strength	K1.1	180	250	GG-25	180-250
		hohe Festigkeit high tensile strength	K1.2	250	350	GG-40	120-180
	Kugelgraphit- guss Spheroidal graphite cast iron	ferritisch ferritic	K2.1	160	400	GGG-40	120-160
		perlitisch perlitic	K2.1	260	700	GGG-60	120-160
	Temperguss Malleable cast iron	ferritisch ferritic	K3.1	200	400	GTW-45	60-120
		perlitisch perlitic	K3.2	260	700	GTS-55-04	80-140



**FINDEN SIE JETZT IHRE
PASSENDE WERKZEUGLÖSUNG.**

FIND YOUR RIGHT
TOOLING SOLUTION NOW.

horn-group.com

DEUTSCHLAND, STAMMSITZ

GERMANY, HEADQUARTERS

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