



**Carmex**  
*Precision Tools Ltd.*

**New**

## Multi-Function Milling Tool (MF)

### Advantages

- Performs multiple operations with one tool.
- Eliminates tool changes.
- Reduces programming and setup times.
- Reduces tool inventories.
- Ideal for machines with a limited number of tool stations.

### Applications

- Spotting and Drilling
- Side milling
- Chamfering
- Slotting
- Grooving
- Engraving



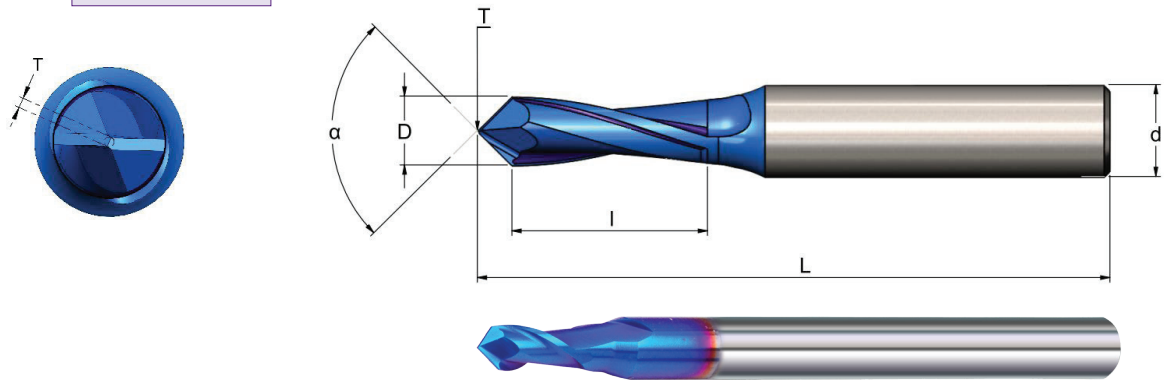
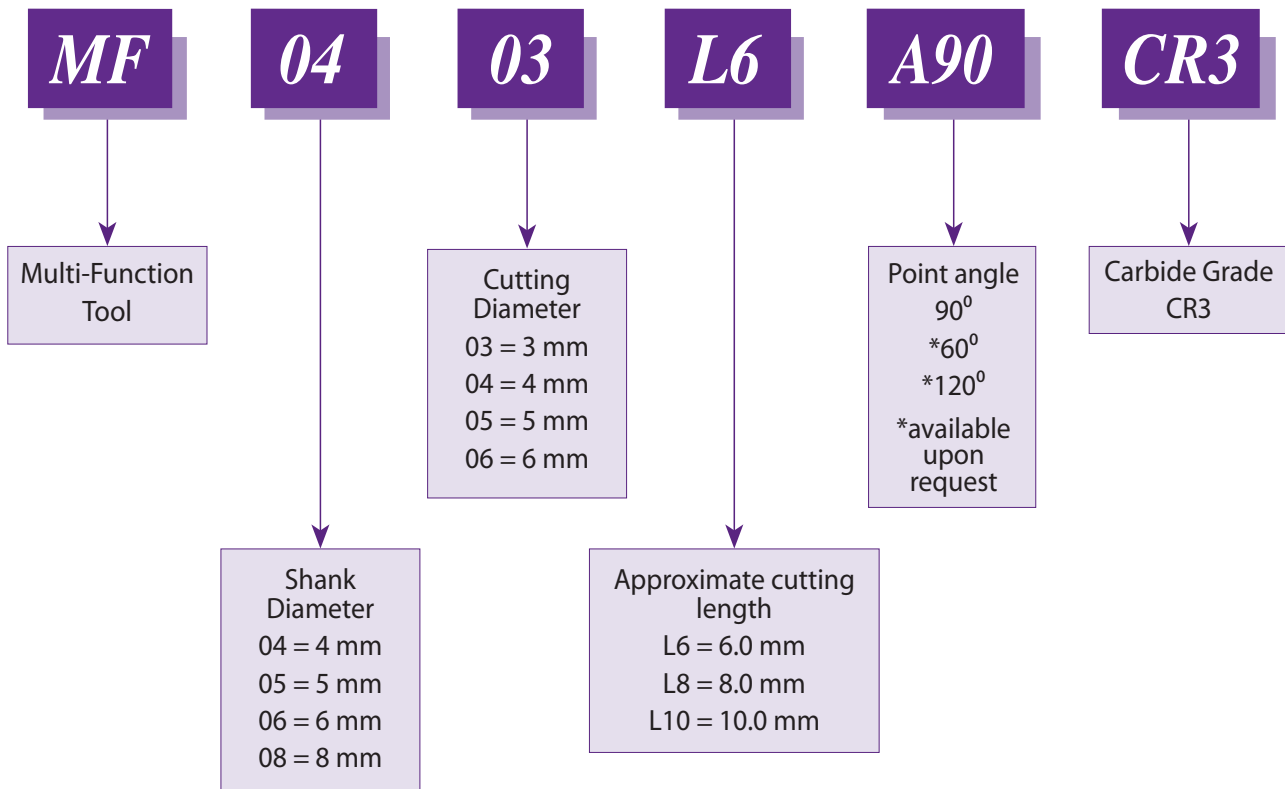
### Carbide grade: CR3

Ultra-Fine carbide grade with high hardness and toughness provides high cutting edge stability and wear resistance.

**A New Generation** of PVD Coating for High-Performance Cutting Applications.

## Product Identification

### Ordering Codes



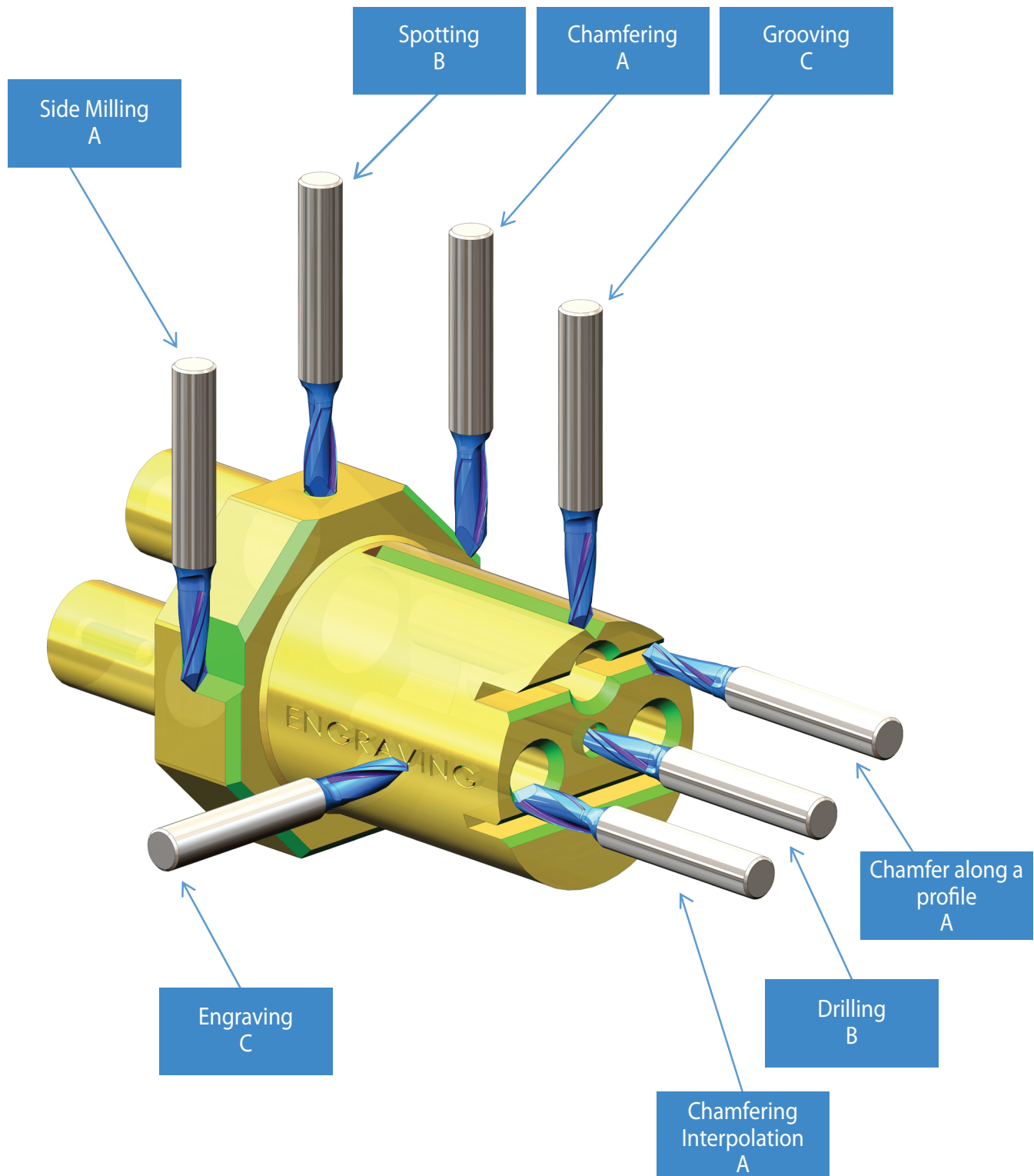
Ordering Code	d	D	α	*T	l	L
<b>MF 0403 L6 A90</b>	4	3.0	90°	0.3	6.0	51
<b>MF 0504 L8 A90</b>	5	4.0	90°	0.4	8.0	51
<b>MF 0605 L10 A90</b>	6	5.0	90°	0.5	10.0	58
<b>MF 0806 L12 A90</b>	8	6.0	90°	0.6	12.0	64
<b>MF 1008 L16 A90</b>	10	8.0	90°	0.8	16.0	73
<b>MF 1210 L18 A90</b>	12	10.0	90°	1.0	18.0	84
<b>MF 1212 L20 A90</b>	12	12.0	90°	1.2	20.0	84

ISO	CR3
<b>P</b>	●
<b>M</b>	●
<b>K</b>	●
<b>N</b>	●
<b>S</b>	●
<b>H</b>	○

\*T = Web thickness

● First choice    ○ Alternative

## Working Methods



\* A, B, C refers to cutting data on next page.



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## Cutting Data

A: Side milling, Chamfering

B: Spotting, Drilling

C: Grooving, Engraving

ISO Standard	Materials Class	Vc m/min	Fz mm/tooth Cutting Diameter		
			Ø3 - Ø4	Ø5 - Ø6	Ø8 - Ø12
<b>P</b>	Low & Medium Carbon Steels <0.55%C	50-115	A: 0.003-0.01 B: 0.003-0.007 C: 0.005-0.015	A: 0.005-0.02 B: 0.004-0.009 C: 0.006-0.025	A: 0.013-0.038 B: 0.007-0.015 C: 0.015-0.038
	High Carbon Steels ≥0.55%C	40-100	A: 0.002-0.012 B: 0.003-0.007 C: 0.005-0.018	A: 0.005-0.018 B: 0.006-0.01 C: 0.01-0.028	A: 0.009-0.03 B: 0.009-0.018 C: 0.016-0.047
	Alloy Steels, Treated Steels	40-100	A: 0.002-0.008 B: 0.003-0.006 C: 0.005-0.015	A: 0.005-0.015 B: 0.004-0.009 C: 0.005-0.018	A: 0.013-0.031 B: 0.006-0.015 C: 0.015-0.031
<b>M</b>	Stainless Steel-Free Cutting	30-85	A: 0.004-0.012 B: 0.003-0.007 C: 0.004-0.018	A: 0.007-0.018 B: 0.004-0.016 C: 0.006-0.018	A: 0.018-0.047 B: 0.008-0.024 C: 0.012-0.047
	Stainless Steel-Austenitic	25-70	A: 0.005-0.010 B: 0.003-0.006 C: 0.004-0.015	A: 0.006-0.015 B: 0.004-0.015 C: 0.005-0.017	A: 0.017-0.04 B: 0.007-0.02 C: 0.01-0.035
	Cast Steels	40-90	A: 0.004-0.012 B: 0.003-0.007 C: 0.004-0.018	A: 0.007-0.018 B: 0.004-0.016 C: 0.006-0.018	A: 0.018-0.047 B: 0.008-0.024 C: 0.012-0.047
<b>K</b>	Cast Iron	30-120	A: 0.003-0.01 B: 0.003-0.007 C: 0.005-0.015	A: 0.005-0.02 B: 0.004-0.009 C: 0.006-0.025	A: 0.013-0.038 B: 0.007-0.015 C: 0.015-0.038
<b>N</b>	Aluminum ≤12%Si, Copper	90-120	A: 0.005-0.008 B: 0.004-0.007 C: 0.005-0.008	A: 0.01-0.02 B: 0.008-0.015 C: 0.01-0.02	A: 0.025-0.045 B: 0.02-0.04 C: 0.025-0.045
	Aluminum >12%Si	75-100	A: 0.003-0.006 B: 0.003-0.005 C: 0.003-0.008	A: 0.005-0.015 B: 0.006-0.01 C: 0.005-0.015	A: 0.02-0.032 B: 0.015-0.035 C: 0.02-0.032
	Synthetics, Duroplastics, Thermoplastics	90-120	A: 0.005-0.008 B: 0.004-0.007 C: 0.005-0.008	A: 0.01-0.02 B: 0.008-0.015 C: 0.01-0.02	0.025-0.045 B: 0.02-0.04 C: 0.025-0.045
<b>S</b>	Nickel alloys, Titanium alloys	20-60	A: 0.004-0.008 B: 0.003-0.007 C: 0.002-0.005	A: 0.007-0.01 B: 0.006-0.008 C: 0.005-0.007	A: 0.01-0.025 B: 0.008-0.02 C: 0.007-0.015
<b>H</b>	Hardened Steel 45-50 HRc	20-60	A: 0.005-0.009 B: 0.004-0.008 C: 0.003-0.006	A: 0.008-0.015 B: 0.007-0.009 C: 0.006-0.008	A: 0.015-0.03 B: 0.009-0.025 C: 0.008-0.02