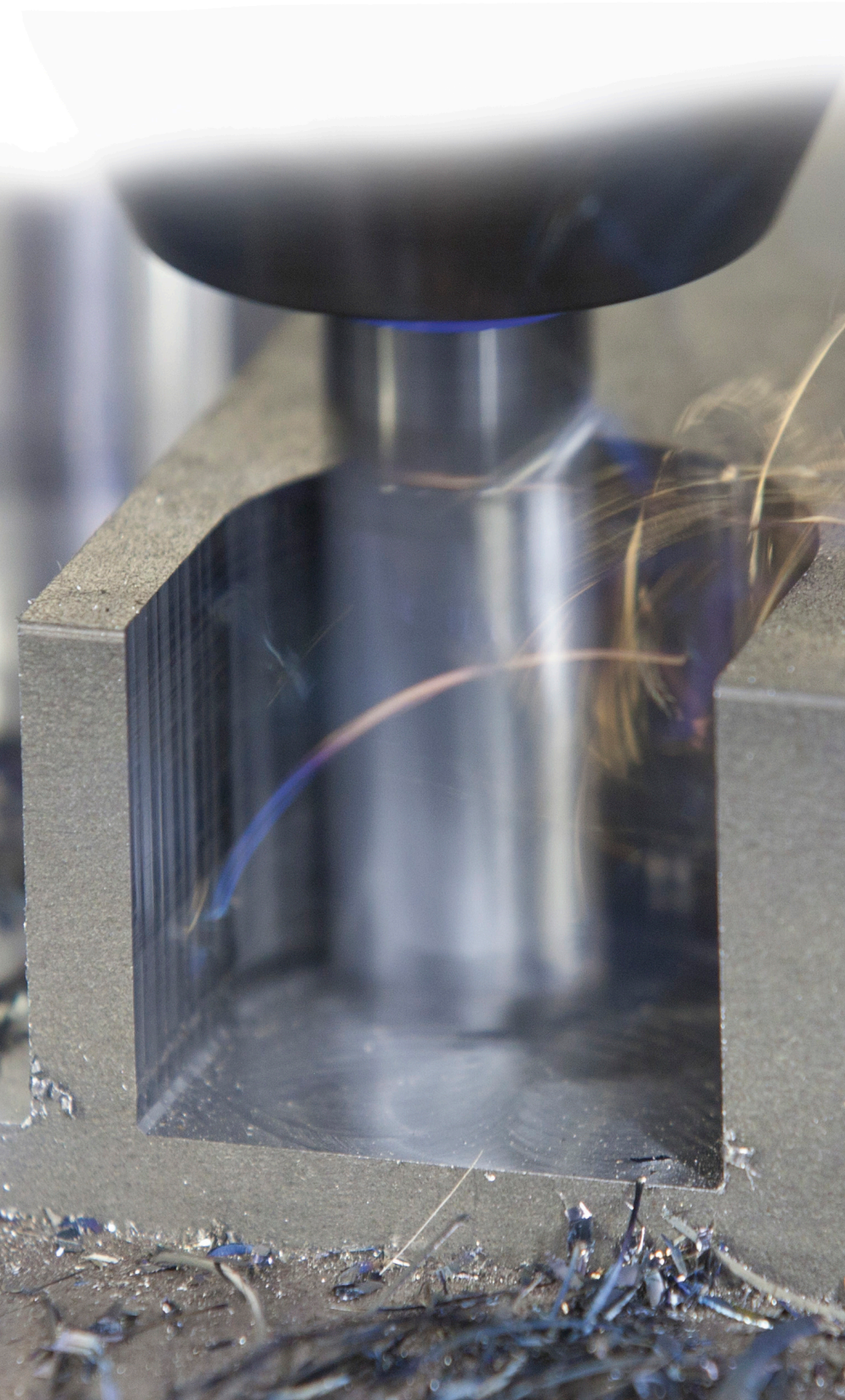




HEIDENHAIN



NC-Solutions

Tool table

**English (en)
2/2017**

Tool table

T	NAME	L	R	R2	TYP	LCUTS	ANGLE	CUT	T-ANGLE
0	NULLWERKZEUG	+0	+0	+0	99	+0	+0	0	+0
1	MILL_D1_ROUGH	+30	+0.5	+0	9	+20	+6	2	+0
2	MILL_D2_ROUGH	+30	+1	+0	9	+20	+6	2	+0
3	MILL_D3_ROUGH	+40	+1.5	+0	9	+20	+6	3	+0
4	MILL_D4_ROUGH	+40	+2	+0	9	+20	+6	3	+0
5	MILL_D5_ROUGH	+50	+2.5	+0	9	+30	+6	3	+0
6	MILL_D6_ROUGH	+50	+3	+0	9	+30	+6	4	+0
7	MILL_D8_ROUGH	+50	+4	+0	9	+30	+6	4	+0
8	MILL_D10_ROUGH	+60	+5	+0	9	+60	+6	4	+0
9	MILL_D12_ROUGH	+60	+6	+0	9	+40	+6	4	+0
10	MILL_D14_ROUGH	+70	+7	+0	9	+40	+6	4	+0
11	MILL_D16_ROUGH	+80	+8	+0	9	+40	+6	4	+0
12	MILL_D18_ROUGH	+90	+9	+0	9	+40	+6	4	+0
13	MILL_D20_ROUGH	+90	+10	+0	9	+50	+6	4	+0
14	MILL_D22_ROUGH	+90	+11	+0	9	+50	+6	4	+0
15	MILL_D25_ROUGH	+90	+12.5	+0	9	+50	+6	4	+0
16	MILL_D30_ROUGH	+90	+15	+0	9	+50	+6	4	+0
17	MILL_D32_ROUGH	+100	+16	+0	9	+60	+6	4	+0
21	MILL_D1_FINISH	+30	+0.5	+0	10	+20	+6	2	+0
22	MILL_D2_FINISH	+30	+1	+0	10	+20	+6	2	+0
23	MILL_D3_FINISH	+40	+1.5	+0	10	+20	+6	3	+0
24	MILL_D4_FINISH	+40	+2	+0	10	+20	+6	3	+0
25	MILL_D5_FINISH	+50	+2.5	+0	10	+30	+6	3	+0
26	MILL_D6_FINISH	+50	+3	+0	10	+30	+6	3	+0
27	MILL_D8_FINISH	+50	+4	+0	10	+30	+6	3	+0
28	MILL_D10_FINISH	+60	+5	+0	10	+30	+6	3	+0
29	MILL_D12_FINISH	+60	+6	+0	10	+40	+6	3	+0
30	MILL_D14_FINISH	+70	+7	+0	10	+40	+6	3	+0
31	MILL_D16_FINISH	+80	+8	+0	10	+40	+6	3	+0
32	MILL_D18_FINISH	+90	+9	+0	10	+40	+6	3	+0
33	MILL_D20_FINISH	+90	+10	+0	10	+50	+6	3	+0
34	MILL_D22_FINISH	+90	+11	+0	10	+50	+6	4	+0
35	MILL_D25_FINISH	+90	+12.5	+0	10	+50	+6	4	+0
36	MILL_D30_FINISH	+90	+15	+0	10	+50	+6	4	+0
37	MILL_D32_FINISH	+100	+16	+0	10	+60	+6	4	+0

T	NAME	L	R	R2	TYP	LCUTS	ANGLE	CUT	T-ANGLE
50	FACE_MILL_D40	+120	+20	+0	0	+40	+3	4	+0
51	FACE_MILL_D50	+120	+25	+0	0	+40	+3	4	+0
52	FACE_MILL_D63	+120	+31.5	+0	0	+40	+3	6	+0
53	FACE_MILL_D80	+120	+40	+0	0	+50	+3	6	+0
54	FACE_MILL_D100	+120	+50	+0	0	+50	+3	7	+0
55	FACE_MILL_D125	+120	+62.5	+0	0	+60	+3	8	+0
56	FACE_MILL_D160	+120	+80	+0	0	+60	+3	8	+0
57	FACE_MILL_D200	+120	+100	+0	0	+60	+3	8	+0
58	FACE_MILL_D250	+120	+125	+0	0	+60	+3	8	+0
59	FACE_MILL_D315	+120	+157.5	+0	0	+60	+3	8	+0
60	FACE_MILL_D400	+120	+200	+0	0	+60	+3	8	+0
61	FACE_MILL_D500	+120	+250	+0	0	+60	+3	8	+0
62	FACE_MILL_D630	+120	+315	+0	0	+60	+3	8	+0
63	FACE_MILL_D800	+120	+400	+0	0	+60	+3	8	+0
64	FACE_MILL_D1000	+120	+500	+0	0	+60	+3	8	+0
65	FACE_MILL_D1250	+120	+625	+0	0	+60	+3	8	+0
66	FACE_MILL_D1600	+120	+800	+0	0	+60	+3	8	+0
67	FACE_MILL_D2000	+120	+1000	+0	0	+60	+3	8	+0
68	FACE_MILL_D2500	+120	+1250	+0	0	+60	+3	8	+0
69	FACE_MILL_D3150	+120	+1575	+0	0	+60	+3	8	+0
70	FACE_MILL_D4000	+120	+2000	+0	0	+60	+3	8	+0
71	FACE_MILL_D5000	+120	+2500	+0	0	+60	+3	8	+0
72	FACE_MILL_D6300	+120	+3150	+0	0	+60	+3	8	+0
73	FACE_MILL_D8000	+120	+4000	+0	0	+60	+3	8	+0
74	FACE_MILL_D10000	+120	+5000	+0	0	+60	+3	8	+0
75	FACE_MILL_D12500	+120	+6250	+0	0	+60	+3	8	+0
76	FACE_MILL_D16000	+120	+8000	+0	0	+60	+3	8	+0
77	FACE_MILL_D20000	+120	+10000	+0	0	+60	+3	8	+0
78	FACE_MILL_D25000	+120	+12500	+0	0	+60	+3	8	+0
79	FACE_MILL_D31500	+120	+15750	+0	0	+60	+3	8	+0
80	FACE_MILL_D40000	+120	+20000	+0	0	+60	+3	8	+0
81	FACE_MILL_D50000	+120	+25000	+0	0	+60	+3	8	+0
82	FACE_MILL_D63000	+120	+31500	+0	0	+60	+3	8	+0
83	FACE_MILL_D80000	+120	+40000	+0	0	+60	+3	8	+0
84	FACE_MILL_D100000	+120	+50000	+0	0	+60	+3	8	+0
85	FACE_MILL_D125000	+120	+62500	+0	0	+60	+3	8	+0
86	FACE_MILL_D160000	+120	+80000	+0	0	+60	+3	8	+0
87	TORUS_MILL_D2_05	+60	+1	+0.5	0	+40	+6	2	+0
88	TORUS_MILL_D3_05	+60	+1.5	+0.5	0	+40	+6	2	+0
89	TORUS_MILL_D3_1	+60	+1.5	+1	0	+40	+6	2	+0
90	TORUS_MILL_D4_05	+60	+2	+0.5	0	+40	+6	2	+0
91	TORUS_MILL_D4_1	+60	+2	+1	0	+40	+6	2	+0
92	TORUS_MILL_D5_05	+60	+2.5	+0.5	0	+40	+6	2	+0
93	TORUS_MILL_D5_1	+60	+2.5	+1	0	+40	+6	2	+0
94	TORUS_MILL_D6_1	+60	+3	+1	0	+40	+6	2	+0
95	TORUS_MILL_D6_15	+60	+3	+1.5	0	+40	+6	2	+0
96	TORUS_MILL_D8_1	+60	+4	+1	0	+40	+6	4	+0
97	TORUS_MILL_D8_15	+60	+4	+1.5	0	+40	+6	4	+0
98	TORUS_MILL_D8_2	+60	+4	+2	0	+40	+6	4	+0
99	TORUS_MILL_D8_3	+60	+4	+1.5	0	+40	+6	4	+0
100	TORUS_MILL_D10_1	+80	+5	+1	0	+40	+6	4	+0
101	TORUS_MILL_D10_15	+80	+5	+1.5	0	+40	+6	4	+0
102	TORUS_MILL_D10_2	+80	+5	+2	0	+40	+6	4	+0
103	TORUS_MILL_D10_3	+80	+5	+3	0	+40	+6	4	+0
104	TORUS_MILL_D10_4	+80	+5	+4	0	+40	+6	4	+0
105	TORUS_MILL_D12_1	+100	+6	+1	0	+40	+6	4	+0
106	TORUS_MILL_D12_15	+100	+6	+1.5	0	+40	+6	4	+0
107	TORUS_MILL_D12_2	+100	+6	+2	0	+40	+6	4	+0
108	TORUS_MILL_D12_3	+100	+6	+3	0	+40	+6	4	+0
109	TORUS_MILL_D12_4	+100	+6	+4	0	+40	+6	4	+0
110	TORUS_MILL_D16_1	+100	+8	+1	0	+40	+6	4	+0
111	TORUS_MILL_D16_2	+100	+8	+2	0	+40	+6	4	+0
112	TORUS_MILL_D16_3	+100	+8	+3	0	+40	+6	4	+0
113	TORUS_MILL_D16_35	+100	+8	+3.5	0	+40	+6	4	+0
114	TORUS_MILL_D16_4	+100	+8	+4	0	+40	+6	4	+0
115	TORUS_MILL_D16_5	+100	+8	+5	0	+40	+6	4	+0
116	TORUS_MILL_D20_1	+100	+10	+1	0	+40	+6	4	+0

T	NAME	L	R	R2	TYP	LCUTS	ANGLE	CUT	T-ANGLE
117	TORUS_MILL_D20_2	+100	+10	+2	0	+40	+6	4	+0
118	TORUS_MILL_D20_4	+100	+10	+4	0	+40	+6	4	+0
119	TORUS_MILL_D20_5	+100	+10	+5	0	+40	+6	4	+0
120	TORUS_MILL_D25_2	+100	+12.5	+2	0	+40	+6	4	+0
121	TORUS_MILL_D25_4	+100	+12.5	+4	0	+40	+6	4	+0
122	TORUS_MILL_D25_5	+100	+12.5	+5	0	+40	+6	4	+0
123	TORUS_MILL_D25_6	+100	+12.5	+6	0	+40	+6	4	+0
124	TORUS_MILL_D32_2	+120	+16	+2	0	+40	+6	6	+0
125	TORUS_MILL_D32_4	+120	+16	+4	0	+40	+6	6	+0
126	TORUS_MILL_D32_5	+120	+16	+5	0	+40	+6	6	+0
127	TORUS_MILL_D35_2	+120	+17.5	+2	0	+60	+6	6	+0
128	TORUS_MILL_D40_4	+120	+20	+4	0	+60	+6	6	+0
129	TORUS_MILL_D42_5	+120	+21	+5	0	+60	+6	6	+0
130	TORUS_MILL_D42_6	+120	+21	+6	0	+60	+6	6	+0
131	TORUS_MILL_D48_6	+120	+24	+6	0	+60	+6	6	+0
132	TORUS_MILL_D52_6	+120	+26	+6	0	+60	+12	6	+0
133	TORUS_MILL_D66_6	+120	+33	+6	0	+60	+6	8	+0
134	TORUS_MILL_D80_6	+120	+40	+6	0	+60	+6	8	+0
135	TORUS_MILL_D100_6	+120	+50	+6	0	+60	+6	8	+0
149	BALL_MILL_D1	+30	+0.5	+0.5	14	+30	+6	2	+0
150	BALL_MILL_D1.5	+30	+0.75	+0.75	14	+30	+6	2	+0
151	BALL_MILL_D2	+30	+1	+1	14	+30	+6	2	+0
152	BALL_MILL_D3	+40	+1.5	+1.5	14	+30	+6	2	+0
153	BALL_MILL_D4	+40	+2	+2	14	+30	+6	2	+0
154	BALL_MILL_D5	+50	+2.5	+2.5	14	+40	+6	2	+0
155	BALL_MILL_D6	+50	+3	+3	14	+40	+6	2	+0
156	BALL_MILL_D8	+60	+4	+4	14	+40	+6	2	+0
157	BALL_MILL_D10	+60	+5	+5	14	+50	+6	2	+0
158	BALL_MILL_D12	+70	+6	+6	14	+50	+6	2	+0
159	BALL_MILL_D16	+80	+8	+8	14	+50	+6	2	+0
160	BALL_MILL_D20	+90	+10	+10	14	+60	+6	2	+0
170	NC_DEBURRING_D6	+60	+3	+0	14	+30	+0	6	+90
171	NC_DEBURRING_D8	+60	+4	+0	14	+30	+0	6	+90
172	NC_DEBURRING_D10	+80	+5	+0	14	+40	+0	6	+90
173	NC_DEBURRING_D12	+80	+6	+0	14	+40	+0	6	+90
174	NC_DEBURRING_D16	+100	+8	+0	14	+60	+0	6	+90

T	NAME	L	R	R2	TYP	LCUTS	ANGLE	CUT	T-ANGLE
185	SIDE_MILLING_CUTTER_D63	+80	+31.5	+0	0	+1.5	+0	4	+0
186	SIDE_MILLING_CUTTER_D80	+100	+40	+0	0	+1.5	+0	5	+0
187	SIDE_MILLING_CUTTER_D100	+120	+50	+0	0	+1.5	+0	8	+0
188	SIDE_MILLING_CUTTER_D125	+140	+62.5	+0	0	+1.5	+0	10	+0
189	SIDE_MILLING_CUTTER_D160	+160	+80	+0	0	+2.2	+0	15	+0
200	NC_SPOT_DRILL_D5	+60	2.5	+0	4	+30	+0	2	+90
201	NC_SPOT_DRILL_D6	+60	3	+0	4	+30	+0	2	+90
202	NC_SPOT_DRILL_D8	+80	4	+0	4	+30	+0	2	+90
203	NC_SPOT_DRILL_D10	+80	5	+0	4	+30	+0	2	+90
204	NC_SPOT_DRILL_D12	+100	6	+0	4	+30	+0	2	+90
205	NC_SPOT_DRILL_D16	+100	+8	+0	4	+30	+0	2	+90
206	NC_SPOT_DRILL_D20	+120	+10	+0	4	+30	+0	2	+90
220	DRILL_D1	+30	+0.5	+0	1	+0	+0	0	+118
221	DRILL_D1.5	+30	+0.75	+0	1	+0	+0	0	+118
222	DRILL_D2	+30	+1	+0	1	+0	+0	0	+118
223	DRILL_D3	+40	+1.5	+0	1	+0	+0	0	+118
224	DRILL_D3.3	+40	+1.65	+0	1	+0	+0	0	+118
225	DRILL_D4	+40	+2	+0	1	+0	+0	0	+118
226	DRILL_D4.2	+50	+2.1	+0	1	+0	+0	0	+118
227	DRILL_D5	+50	+2.5	+0	1	+0	+0	0	+118
228	DRILL_D6	+50	+3	+0	1	+0	+0	0	+118
229	DRILL_D6.8	+80	+3.4	+0	1	+0	+0	0	+118
230	DRILL_D8	+80	+4	+0	1	+0	+0	0	+118
231	DRILL_D8.5	+80	+4.25	+0	1	+0	+0	0	+118
232	DRILL_D10	+100	+5	+0	1	+0	+0	0	+118
233	DRILL_D12	+100	+6	+0	1	+0	+0	0	+118
234	DRILL_D14	+100	+7	+0	1	+0	+0	0	+118
235	DRILL_D16	+100	+8	+0	1	+0	+0	0	+118
236	DRILL_D18	+100	+9	+0	1	+0	+0	0	+118
237	DRILL_D20	+100	+10	+0	1	+0	+0	0	+118
238	DRILL_D22	+120	+11	+0	1	+0	+0	0	+118
239	DRILL_D25	+120	+12.5	+0	1	+0	+0	0	+118
240	DRILL_D30	+150	+15	+0	1	+0	+0	0	+118
241	DRILL_D35	+150	+17.5	+0	1	+0	+0	0	+118
242	DRILL_D40	+150	+20	+0	1	+0	+0	0	+118
243	DRILL_D45	+200	+22.5	+0	1	+0	+0	0	+118

T	NAME	L	R	R2	TYP	LCUTS	ANGLE	CUT	T-ANGLE
244	DRILL_D50	+200	+25	+0	1	+0	+0	0	+118
245	DRILL_D60	+200	+30	+0	1	+0	+0	0	+118
260	TAP_M3	+70	+1.5	+0	2	+10	+0	4	+0
261	TAP_M4	+70	+2	+0	2	+12	+0	4	+0
262	TAP_M5	+70	+2.5	+0	2	+14	+0	4	+0
263	TAP_M6	+80	+3	+0	2	+16	+0	4	+0
264	TAP_M8	+90	+4	+0	2	+20	+0	4	+0
265	TAP_M10	+100	+5	+0	2	+24	+0	4	+0
266	TAP_M12	+110	+6	+0	2	+30	+0	4	+0
267	TAP_M16	+110	+8	+0	2	+40	+0	4	+0
280	REAMER_3H7	+70	+0	+0	3	+10	+0	4	+0
281	REAMER_4H7	+70	+0	+0	3	+12	+0	4	+0
282	REAMER_5H7	+70	+0	+0	3	+14	+0	4	+0
283	REAMER_6H7	+80	+0	+0	3	+16	+0	6	+0
284	REAMER_8H7	+90	+0	+0	3	+20	+0	6	+0
285	REAMER_10H7	+100	+0	+0	3	+24	+0	6	+0
286	REAMER_12H7	+110	+0	+0	3	+30	+0	6	+0
287	REAMER_16H7	+110	+0	+0	3	+40	+0	6	+0
300	TURN_ROUGH	+0	+0	+0	29	+0	+0	0	+0
301	TURN_FINISH	+0	+0	+0	29	+0	+0	0	+0
302	TURN_INSIDE	+0	+0	+0	29	+0	+0	0	+0
303	TURN_THREAD	+0	+0	+0	29	+0	+0	0	+0
304	TURN_KONTUR	+0	+0	+0	29	+0	+0	0	+0
305	TURN_INSIDE_FINISH	+0	+0	+0	29	+0	+0	0	+0
306	TURN_REC_AX_43-60	+0	+0	+0	29	+0	+0	0	+0
307	TURN_REC_RAD	+0	+0	+0	29	+0	+0	0	+0
308	TURN_REC_AX_100-150	+0	+0	+0	29	+0	+0	0	+0
309	TURN_ROUGH_LONG	+0	+0	+0	29	+0	+0	0	+0
310	TURN_FINISH_LONG	+0	+0	+0	29	+0	+0	0	+0
311	TURN_BUTTON_R5	+0	+0	+0	29	+0	+0	0	+0
500	TOUCH_PROBE_D6	+200	+3	+0	21	+0	+0	0	+0
501	TOUCH_PROBE_D4	+150	+2	+0	21	+0	+0	0	+0

T	NAME	ZL	XL	DZL	DXL	RS	TO	ORI	PA.*	TA.*	CL.*	CW.*	TYPE
300	TURN_ROUGH	+75	+10	+0	+0	0.2	1	252	+80	+95	-	+0	11
301	TURN_FINISH	+75	+10	+0	+0	0.2	1	252	+57	+120	-	+0	12
302	TURN_INSIDE	+75	+10	+0	+0	0.2	1	0	+55	+105	-	+0	11
303	TURN_THREAD	+120	+10	+0	+0	0.2	1	70	+55	+105	-	+0	14
304	TURN_KONTUR	+65	+0	+0	+0	3	8	0	+0	+0	-	+0	21
305	TURN_INSIDE_FINISH	+100	+10	+0	+0	1	2	0	+45	+90	-	+0	12
306	TURN_REC_AX_43-60	+110	+11	+0	+0	0.2	8	0	+0	+0	+2	+6	15
307	TURN_REC_RAD	+100	+39	+0	+0	0.8	1	0	+0	+0	+4	+6	26
308	TURN_REC_AX_100-150	+110	+11	+0	+0	0.8	8	0	+0	+0	+2	+6	15
309	TURN_ROUGH_LONG	+120	+20	+0	+0	0	1	252	+80	+95	-	+0	11
310	TURN_FINISH_LONG	+120	+20	+0	+0	0	1	252	+57	+120	-	+0	12
311	TURN_BUTTON_R5	+0	+0	+0	+0	3	8	0	+50	+0	-	+0	11

PA) P-ANGLE

TA) T-ANGLE

CL) CUTLENGTH

CW) CUTWIDTH