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.

INCH

Product Identification

Ordering Codes

MF → Multi-Function Tool

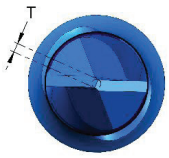
04 → Shank Diameter
04 = 4 mm
05 = 5 mm
06 = 6 mm
08 = 8 mm

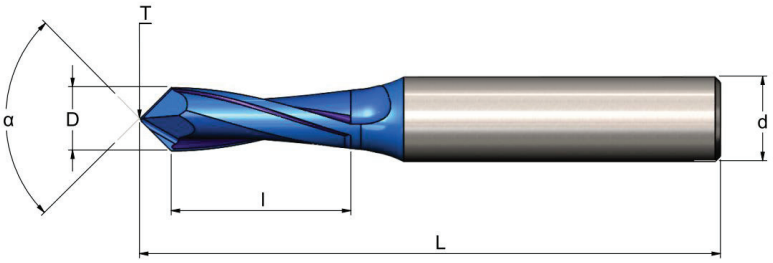
03 → Cutting Diameter
03 = .118
04 = .157
05 = .197
06 = .236

L6 → Approximate cutting length
L6 = .24
L8 = .31
L10 = .39

A90 → Point angle 90°

CR3 → Carbide Grade CR3





Ordering Code	d mm	D	α	*T	l	L
MF 0403 L6 A90	4	.118	90°	.012	.24	2.0
MF 0504 L8 A90	5	.157	90°	.016	.31	2.0
MF 0605 L10 A90	6	.197	90°	.020	.39	2.3
MF 0806 L12 A90	8	.236	90°	.024	.47	2.5
MF 1008 L16 A90	10	.315	90°	.031	.63	2.9
MF 1210 L18 A90	12	.394	90°	.039	.71	3.3
MF 1212 L20 A90	12	.472	90°	.047	.79	3.3

ISO	CR3
P	●
M	●
K	●
N	●
S	●
H	○

* T = Web thickness No. of Flutes: 2

● First choice ○ Alternative

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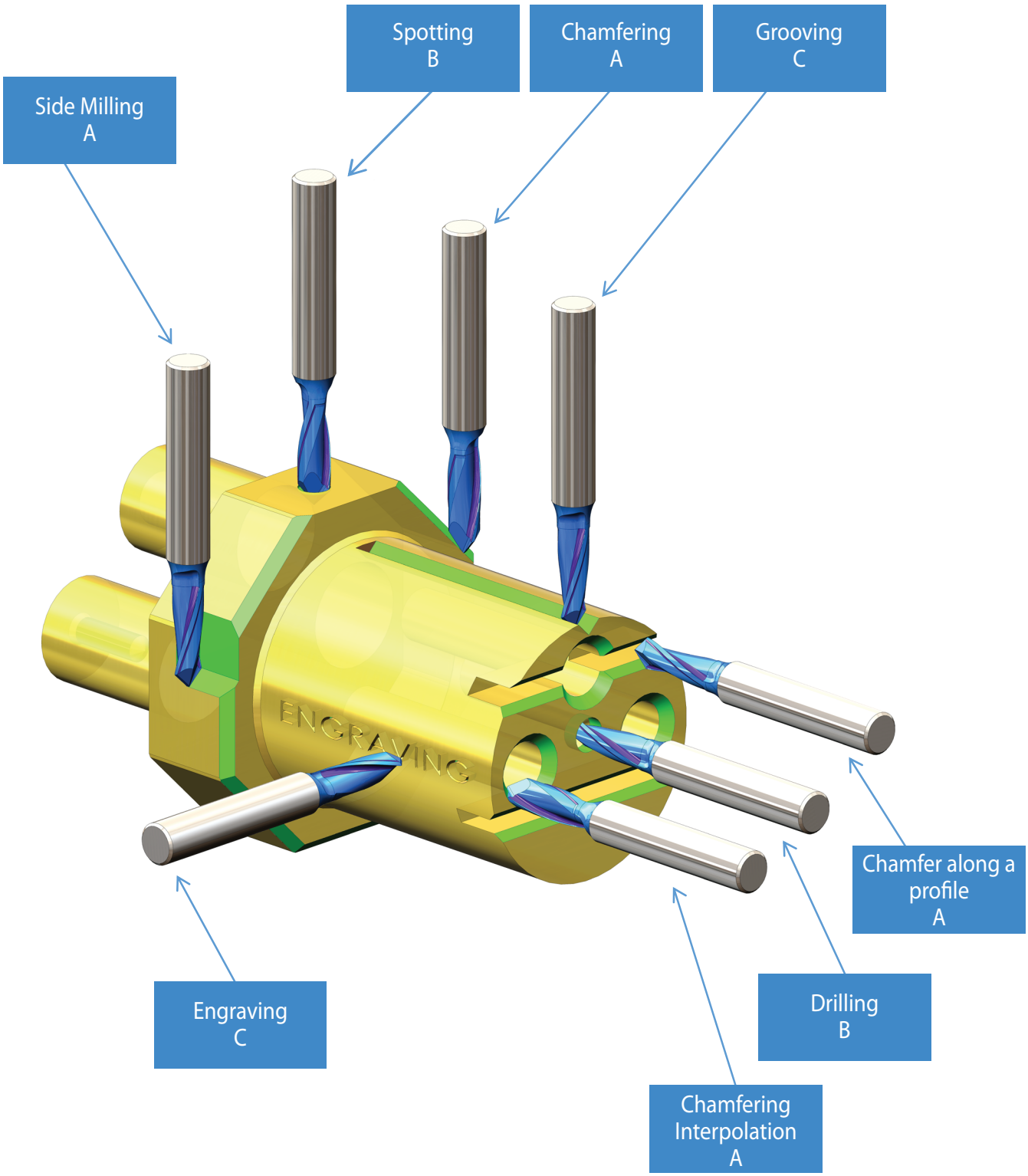
Working Methods



*** 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 ft/min	Fz inch/tooth Cutting Diameter		
			Ø.12- Ø.16	Ø.20- Ø.24	Ø.31- Ø.47
P	Low & Medium Carbon Steels <0.55%C	165-380	A: .0001-.0004 B: .0001-.0003 C: .0002-.0006	A: .0002-.0008 B: .0002-.0004 C: .0002-.0010	A: .0005-.0015 B: .0003-.0006 C: .0006-.0015
	High Carbon Steels ≥0.55%C	130-330	A: .0001-.0005 B: .0001-.0003 C: .0002-.0007	A: .0002-.0007 B: .0002-.0004 C: .0004-.0011	A: .0004-.0012 B: .0004-.0007 C: .0006-.0019
	Alloy Steels, Treated Steels	130-330	A: .0001-.0003 B: .0001-.0002 C: .0002-.0006	A: .0002-.0006 B: .0002-.0004 C: .0002-.0007	A: .0005-.0012 B: .0002-.0006 C: .0006-.0012
M	Stainless Steel-Free Cutting	100-280	A: .0002-.0005 B: .0001-.0003 C: .0002-.0007	A: .0003-.0007 B: .0002-.0006 C: .0002-.0007	A: .0001-.0019 B: .0001-.0009 C: .0006-.0019
	Stainless Steel-Austenitic	80-230	A: .0002-.0004 B: .0001-.0002 C: .0002-.0006	A: .0002-.0006 B: .0002-.0006 C: .0002-.0007	A: .0005-.0016 B: .0005-.0008 C: .0007-.0014
	Cast Steels	130-295	A: .0002-.0005 B: .0001-.0003 C: .0002-.0007	A: .0003-.0007 B: .0002-.0006 C: .0002-.0007	A: .0006-.0019 B: .0001-.0009 C: .0006-.0019
K	Cast Iron	100-390	A: .0001-.0004 B: .0001-.0003 C: .0002-.0006	A: .0002-.0008 B: .0002-.0004 C: .0002-.0010	A: .0005-.0015 B: .0003-.0006 C: .0006-.0015
N	Aluminum ≤12%Si, Copper	295-390	A: .0002-.0003 B: .0002-.0003 C: .0002-.0003	A: .0004-.0008 B: .0003-.0006 C: .0004-.0008	A: .0010-.0018 B: .0008-.0016 C: .0010-.0018
	Aluminum >12%Si	245-330	A: .0001-.0002 B: .0001-.0002 C: .0001-.0003	A: .0002-.0006 B: .0002-.0004 C: .0002-.0006	A: .0008-.0013 B: .0006-.0014 C: .0008-.0013
	Synthetics, Duroplastics, Thermoplastics	295-390	A: .0002-.0003 B: .0002-.0003 C: .0002-.0003	A: .0004-.0008 B: .0003-.0006 C: .0004-.0008	A: .0010-.0018 B: .0008-.0016 C: .0010-.0018
S	Nickel alloys, Titanium alloys	65-195	A: .0002-.0003 B: .0001-.0003 C: .0001-.0002	A: .0003-.0004 B: .0002-.0003 C: .0002-.0003	A: .0007-.0010 B: .0001-.0008 C: .0005-.0006
H	Hardened Steel 45-50 HRc	65-195	A: .0002-.0004 B: .0002-.0003 C: .0001-.0002	A: .0003-.0006 B: .0003-.0004 C: .0002-.0003	A: .0006-.0012 B: .0003-.0010 C: .0003-.0008

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