

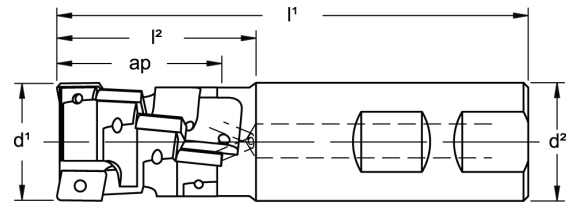
THX90

Helical Square Shoulder Milling Cutters

The Extended Program:

In addition to the proven helical end mills in the 1" to 2" diameter range, helical shell mills are also available from 2" to 3" diameters with coarse tooth pitches, for low-powered machine tools and slot milling, as well as trimming and shoulder milling.

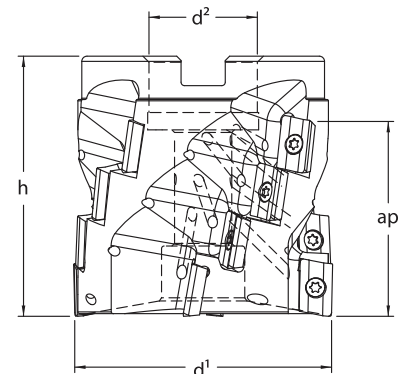
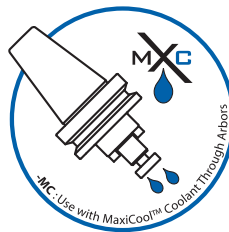
Our THX90 helical cutters are ideal for rough-milling large grooves and shoulders. Large overall cutting-edge lengths, and the efficient use of each flute, guarantees a wide range of applications and high performance.



Helical End Mills with Coolant Through for Profiling & Milling

Designation	d ¹	d ²	l ¹	l ²	Max. ap	flutes	No. of inserts	Insert	Insert Screw	Wrench
THXD90-1000	1.000	1.000	4.00	1.72	1.30	2	8	222.79.600 222.79.610	214.80.800	214.80.866 (S/D) 214.80.011 (F/T)
THXD90-1250	1.250	1.250	4.49	2.21	1.30	3	12			
THXD90-1500	1.500	1.250	4.84	2.56	1.61	3	15			
THXP90-1250	1.250	1.250	4.63	2.35	1.15	2	4	222.79.400 222.79.500 222.79.510 222.79.550 222.79.564 222.79.572 222.79.574	214.80.558	214.80.824 (S/D) 214.80.012 (F/T)
THXP90-1250L	1.250	1.250	4.84	2.56	1.70	2	6			
THXP90-1500	1.500	1.250	5.01	2.73	1.17	3	6			
THXP90-1500L	1.500	1.250	5.01	2.73	1.70	3	9			
THXP90-1750	1.750	1.250	5.01	2.73	1.17	3	6			
THXP90-2000EM	2.000	1.250	5.25	2.97	2.25	3	12			

Remember to use COPASLIP® anti-seize compound on all insert screws



Helical Shell Mills with Coolant Through for Profiling & Milling

Designation	d ¹	d ²	h	Max. ap	flutes	No. of inserts	Insert	Insert Screw	Wrench
THXP90-2000-MC	2.000	.750	2.00	1.17	3	6	222.79.400 222.79.500 222.79.510 222.79.550 222.79.564 222.79.572 222.79.574	214.80.558	214.80.824 (S/D) 214.80.012 (F/T)
THXP90-2000L-MC	2.000	.750	2.50	1.65	3	9			
THXP90-2500-MC	2.500	1.000	2.50	1.65	3	9			
THXP90-2500L-MC	2.500	1.000	3.00	2.13	3	12			
THXP90-3000-MC	3.000	1.250	3.00	2.25	4	16			

Remember to use COPASLIP® anti-seize compound on all insert screws

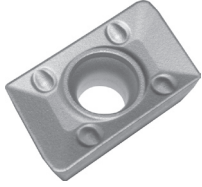
Inserts

for High Shear Square Shoulder Milling Cutters - TX90 / THX90

Inserts with optimized geometries and large selection of radii from 1/32" - 5/32" for steel, cast steel and aluminum alloys.

Very effective with high metal removal rates in medium and heavy duty milling.

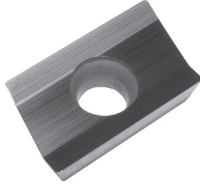
222.79.400



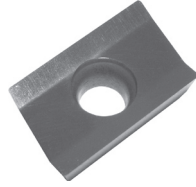
222.79.500 / 600



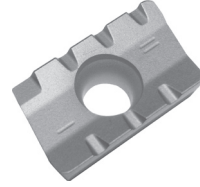
222.79.510 / 610



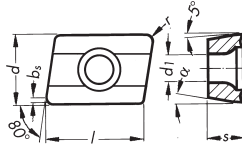
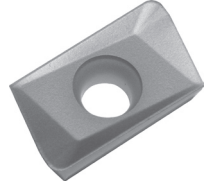
222.79.550



222.79.564

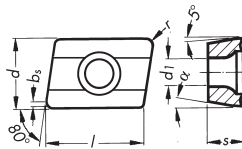


222.79.572 / 574



TX90 / THX90 Inserts

Designation	l	s	r	d	d ¹	bs	a	Coated								Uncoated			Cermet				
								TN7525	TN6525	TN7535	TN6540	TN450	TN5515	TN6510	TN6520	TN2510	TTM	TTR	THM	THR	THM-U	TTI-25	
222.79.400	.635	3/16	3/64	3/8	.173	.047	11°	●	●	●	●	●	●	●	●	●	●	●					
222.79.600	.381	1/8	1/32	1/4	.110	.039	15°	●	●	●	●	●	●	●	●	●	●	●	●	●	●		●
222.79.530	.635	3/16	1/32	3/8	.173	.071	11°	●	●	●	●	●	●	●	●	●	●	●					
222.79.500			3/64				.059	11°	●	●	●	●	●	●	●	●	●	●	●	●	●		●
222.79.532			1/16				.031	11°	●	●	●	●	●	●	●	●	●	●	●	●	●		
222.79.534 ⁽²⁾			5/64				.020	11°	●	●	●	●	●	●	●	●	●	●	●	●	●		
222.79.536 ⁽²⁾			3/32				--	11°	●	●	●	●	●	●	●	●	●	●	●	●	●		
222.79.538 ⁽²⁾			1/8				--	11°	●	●	●	●	●	●	●	●	●	●	●	●	●		
222.79.540 ⁽²⁾			5/32				--	11°	●	●	●	●	●	●	●	●	●	●	●	●	●		
222.79.564 ⁽³⁾			.635	3/16	3/64	3/8	.173	.067	11°	●	●	●	●	●	●	●	●	●	●	●	●		
222.79.572	.634	3/16	.031	.386	.173	.071	11°	●	●	●	●	●	●	●	●	●	●	●	●			●	
222.79.574	.634	3/16	.047	.375	.173	.059	11°	●	●	●	●	●	●	●	●	●	●	●	●			●	



TX90 / THX90 Alu. Inserts

Designation	l	s	r	d	d ¹	bs	a	Coated								Uncoated			Cermet				
								TN7525	TN6525	TN7535	TN6540	TN450	TN5515	TN2510	TN6501	TN6502	TTM	TTR	THM	THR	THM-U	TTI-25	
222.79.610 ^{(1)*}	.381	1/8	1/32	.264	.110	.039	15°															●	
222.79.510 ^{(1)*}	.635	.183	1/32	.386	.173	.067	11°								●								
222.79.512 ^{(1)*}			3/64				.055	11°								●							
222.79.514 ^{(1)*}			1/16				.035	11°								●							
222.79.516 ^{(1,2)*}			5/64				.016	11°								●							
222.79.518 ^{(1,2)*}			3/32				---	11°								●							
222.79.520 ^{(1,2)*}			1/8				---	11°								●							
222.79.522 ^{(1,2)*}			5/32				---	11°								●							
222.79.550 ^{(1)*}	.635	.183	1/64	.386	.173	.078	11°															●	
222.79.552 ^{(1)*}			1/32				.067	11°															●
222.79.554 ^{(1)*}			3/64				.055	11°															●

Note 1: Due to the higher side rake angles, 222.79.510 - 522, 222.79.550 - 222.79.552 & 222.79.610 inserts are wider and will cut oversize.
 Note 2: To provide necessary clearance for the inserts with radii over 5/64", the cutter body must be relieved.
 Note 3: Cutting edges are serrated and marked I & II, are to be mounted alternating edge I & II, and can only be used with a minimum of 2 teeth.
 Best results achieved when used in cutters with an even number of flutes.
 * Optimized for aluminum.