



Archon Standart Series (Z9) - HPC / Normal Cutting Edge

S	Order Code	Code	d1h9	d2h6	ØxD	l1	l2	Corner	W.Order No
	82100	161.9.0800.0640.R0030.0160.0000.0000.00.S08B1T01.01	8	8	2xD	64	16	R 0.30	82101
	82102	161.9.0800.0640.R0050.0200.0000.0000.00.S08B1T01.01	8	8	2.5xD	64	20	R 0.50	82103
	82104	161.9.0800.0640.R0050.0160.0000.0000.00.S08B1T01.01	8	8	2xD	64	16	R 0.50	82105
	82106	161.9.0800.0640.R0030.0200.0000.0000.00.S08B1T01.01	8	8	2.5xD	64	20	R 0.30	82107
	82108	161.9.1000.0730.R0050.0200.0000.0000.00.S10B1T01.01	10	10	2xD	73	20	R 0.50	82109
	82110	161.9.1000.0730.R0100.0250.0000.0000.00.S10B1T01.01	10	10	2.5xD	73	25	R 1.00	82111
	82112	161.9.1000.0730.R0100.0200.0000.0000.00.S10B1T01.01	10	10	2xD	73	20	R 1.00	82113
	82114	161.9.1000.0730.R0050.0250.0000.0000.00.S10B1T01.01	10	10	2.5xD	73	25	R 0.50	82115
	82116	161.9.1200.0830.R0050.0240.0000.0000.00.S12B1T01.01	12	12	2xD	83	24	R 0.50	82117
	82118	161.9.1200.0830.R0100.0300.0000.0000.00.S12B1T01.01	12	12	2.5xD	83	30	R 1.00	82119
	82120	161.9.1200.0830.R0100.0240.0000.0000.00.S12B1T01.01	12	12	2xD	83	24	R 1.00	82121
	82122	161.9.1200.0830.R0050.0300.0000.0000.00.S12B1T01.01	12	12	2.5xD	83	30	R 0.50	82123
	82124	161.9.1600.0930.R0050.0320.0000.0000.00.S16B1T01.01	16	16	2xD	93	32	R 0.50	82125
	82126	161.9.1600.0930.R0100.0400.0000.0000.00.S16B1T01.01	16	16	2.5xD	93	40	R 1.00	82127
	82128	161.9.1600.0930.R0100.0320.0000.0000.00.S16B1T01.01	16	16	2xD	93	32	R 1.00	82129
	82130	161.9.1600.0930.R0050.0400.0000.0000.00.S16B1T01.01	16	16	2.5xD	93	40	R 0.50	82131

Archon Standart Series (Z9) - HPC / Chip Splitter

S	Order Code	Code	d1h9	d2h6	ØxD	l1	l2	Corner	W.Order No
	82132	161CS.9.0800.0640.R0030.0240.0000.0000.00.S08B1T01.01	8	8	3xD	64	24	R 0.30	82133
	82134	161CS.9.0800.0640.R0050.0240.0000.0000.00.S08B1T01.01	8	8	3xD	64	24	R 0.50	82135
	82136	161CS.9.1000.0730.R0050.0300.0000.0000.00.S10B1T01.01	10	10	3xD	73	30	R 0.50	82137
	82138	161CS.9.1000.0730.R0100.0300.0000.0000.00.S10B1T01.01	10	10	3xD	73	30	R 1.00	82139
	82140	161CS.9.1200.0830.R0050.0360.0000.0000.00.S12B1T01.01	12	12	3xD	83	36	R 0.50	82141
	82142	161CS.9.1200.0830.R0100.0360.0000.0000.00.S12B1T01.01	12	12	3xD	83	36	R 1.00	82143
	82144	161CS.9.1600.1000.R0050.0480.0000.0000.00.S16B1T01.01	16	16	3xD	100	48	R 0.50	82145
	82146	161CS.9.1600.1000.R0100.0480.0000.0000.00.S16B1T01.01	16	16	3xD	100	48	R 1.00	82147

Cutting Parameters - Trochoidal

Material	Trochoidal & HPC	Trochoidal & HPC
	ap=2xØ - 2,5xØ / ae=0.03 - 0.06 x Ø Vc (m/min)	ap=3xØ / ae=0.03 - 0.06 x Ø Vc (m/min)



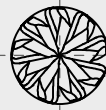
Steel	Unalloyed Steel	130-160	130-150
	Steel	125-145	125-140
	Tempered Steel	120-140	120-135
	Cold Work Tool Steel	110-130	110-125
	Hot Work Tool Steel	100-120	100-115
Stainless Steel	AISI 304 - 416 - 420	130-150	130-145
	AISI 316 - 440	130-150	130-145
	17-4 PH 15-5 PH	110-140	110-130
	Chrome-Cobalt alloy	110-135	110-130
	Duplex F51	110-130	110-125
Cast Iron	Super Duplex F55	110-130	110-125
	Gray cast	110-130	110-125
	Alloyed cast	110-130	110-125
	Precision cast	100-120	95-115
	54 HRC	60-90	60-80
Titanium	HRSA Hastelloy	60-90	60-80
	HRSA Inconel 625	60-90	60-80
	HRSA Inconel 718	60-90	60-80
	HRSA Nimonic	110-130	100-120
	Titanium	110-120	100-120
	Titanium Alloys	60-80	60-80

Feed Per Tooth (mm/tooth)

Ø	ae=0.06 x Ø	ae=0.03 x Ø	ae=0.015 x Ø
8	0,071-0,11	0,08-0,12	0,045-0,08
10	0,081-0,14	0,091-0,15	0,055-0,1
12	0,098-0,16	0,1-0,18	0,065-0,12
16	0,135-0,21	0,15-0,23	0,08-0,16

Gen-Z
Archon 161
High Performance
Machining

Z9



Steel	●
Stainless Steel	●
Hardened Steel ≤54 HRC	○
Hardened Steel >54 HRC	○
Cast Iron	●
Graphite	○
Non Ferrous Material	○
HRSA	●
Titanium	●

● Recommended ○ Acceptable ○ Not Recommended

*Marked products can be delivered
quickly from stock.