

forster

tool catalogue

forster

UNIVERSAL DSC end-mill cutter for steel and stainless steel Z = 3

Design	According to DIN 6527 L
Type	Centre cutting, 3 cutting edges, reinforced core Ø
Helix angle	30°, TiALN-X coating
Cylinder shaft	DIN 6535-HA without clamping surface and without clearance between cutting edge and shaft
Special feature	Submersible drilling possible up to 2.0 mm material thickness, optimal submersion via arc. Can also be used for fire protection fillings such as Promat or similar, specially designed for T 3 Star, FORSTER STEEL TEC and similar machining centres for machining steel



Forster art. no.	Ø mm	Cutting length mm	Shaft Ø mm	Total length mm	Max. projection	Steel	Stainless steel	Total feed	Drill feed
						Speed	Speed		
909.530F	4	10	4	50	30	7500	5500	3-5	80
909.531F	5	10	5	50	35	6500	4500	6-8	60
909.532F	6	10	6	57	40	5300	3750	6-12	60
909.533F	8	16	8	63	40	4000	2800	9-12	50
									VA -25%

Info:

For steel machining, this coating is optimal for DRY MILLS! For VA machining, care must be taken to ensure very adequate lubrication Ø 3.0 - 5.0 spray stroke 40-50, Ø 6.0 - 8.0 spray stroke 50-60, for larger dimensions please enquire. The total feed depends on the material thickness (table here up to 2.5 mm) and small clamping distances. Reduce speed by -20% when machining profiles with plaster.

HSS PMX end-mill cutter, short version

Fine-toothed roughing (semi-finishing) cutter, helix angle: 30°, cylinder shaft: DIN 6535 HB (with clamping surface)

End-mill cutter in HSS-E-Co powder steel, specially for machining steel and stainless steel, with TiALN coating; steel = dry machining, stainless steel with a lot of minimal lubrication = 60 cycle



Forster art. no.	Ø mm	Cutting length mm	Working length mm	Total length mm	Shaft Ø mm	Teeth	Steel		Stainless steel	
							Speed	Total feed	Speed	Total feed
909.535F	16	32	42	92	16	5	rpm	f = mm/rev	rpm	f = mm/rev
							800	16-26	600	22-30

ATTENTION:

The plunge speed is (only with the starting hole min. 50 % of the cutter Ø) **60-90 mm/min.**

Info:

We recommend from tool-Ø 12 mm the spindle power should be min. 10 KW. **Do not** plunge into full, start hole min. 50 % of cutter Ø.

For DIAMANT and SATELITE XT or XT-E we also recommend Weldon chucks. Very good for milling welding edges, especially on the SATELITE XT.

Spiral bit DIN 1897 (short)

HSS-Co with TiALN coating

For applications in steel (dry machining) and stainless steel (with a lot of minimal lubrication) as an optimal alternative, under unstable conditions such as vibrations or instability in profile, if the use of DSC bits (Black-Multi) is not economical. The shaft Ø is identical to the bit Ø; only clamp in ER collet chucks, for optimal concentric running clamp the collet additionally with max. 0.4 mm.



Forster art. no.	Bit Ø mm	Total length mm	Spiral length mm	Steel		Stainless steel	
				Speed N max.	Forward feed mm/min	Speed N max.	Forward feed mm/min
909.536F	3.3	49	18	4000	240	2000	80
909.537F	4.2	55	22	3000	240	1350	85
909.538F	4.6	58	24	2800	230	1380	85
909.539F	5.5	66	28	2300	230	1100	90

Thread former

Tool used after the flow punch former

ATTENTION: With spray cycle 30–60 !!! The submersion feed for thread formers is calculated as follows:

Pitch x 100, e.g. M5 pitch 0.8 x 100 = 80 mm, with feed reduction = 10–20 %, this activates the length compensation of the tap collet chuck CET 25 + 32 GB.

When flow punch formers are not used, thread formers can also offer an interesting alternative to taps in aluminium and steel = significantly improved pull-out strength on the thread and non-cutting machining, especially on deep threads and blind-hole threads.

HOWEVER: Pay attention to the larger core hole!



Forster art. no.	Thread	Pitch	Core hole Ø mm	Overall length mm	Thread length	Shaft Ø mm	Speed rpm
909.540F	M4	0.7	3.7	63	12	4.5	2400
909.541F	M5	0.8	4.7	70	13	6	1900
909.542F	M6	1.0	5.6	80	15	6	1550

NEW: For Twin Ferro double-mitring saw

Specially for steel and stainless steel profiles

Metal circular saw blades 350 mm with NBL for EMMEGI and FORSTER, Z = 140

With low-tolerance lateral run-out, surface finish and RedFire coating



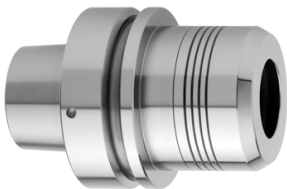
Forster art. no.	Diameter	Working length	Slot width	Speed	Forward feed
909.534F	350	40	3.0	5-8	3-4

CENTROJP collet chuck DIN 69893 HSK-F 63

Cone: HSK F 63, A = 65 mm, D = 50 mm

Clamping range 2 to 20 mm, compatible clamping nut HPC 32

Designation: CP 32 HSK F 63



Forster art. no.
909.543F

CP clamping nut HPC 32

Not suitable for QUADRA and similar direct spindle drives!



Forster art. no.
909.544F

Collet chuck acc. to DIN 69893, design HSK-F-63

For ER 32 and CET 32, A = 70 mm
 Price incl. clamping nut STM (without grooves)
 Use roller wrench RO



Forster art. no.

909.545F

Collet GER.C 32 B

For ER 32 and CET 32, A = 70 mm
Caution: The collets for spiral bits should be max. 0.4 mm more than the nominal dimension (e.g.: bit Ø 7.1 mm = collet Ø 7.5 mm)!

Accuracy = 0.005
 Surface: Protect = long-term corrosion protection



Forster art. no.	Ø mm
909.555F	3.5
909.556F	4.5
909.557F	5.5
909.558F	6.5
909.559F	7.5
909.560F	8.5
909.561F	9.5
909.562F	3
909.563F	4
909.564F	5
909.565F	6
909.566F	7
909.567F	8
909.568F	9
909.569F	10
909.570F	11
909.571F	12
909.572F	13
909.573F	14
909.574F	15
909.575F	16
909.576F	17
909.577F	18
909.578F	19
909.579F	20

Collet chuck acc. to DIN 69893 HSK F 63

Long version, for milling
 Nut Ø = 28 mm, ER 20, A = 76



Forster art. no.

909.546F

Special chuck key ER 20-MS

Forster art. no.

909.547F

Roller chuck key RO 50

For CP 32 + ER 32



Forster art. no.

909.550F

Mounting block TBRS 63

For HSK F63



Forster art. no.

909.549F

Cooling lubricant for minimal lubrication "NEBOL SNF 2000"

5 litre canister
Suitable for aluminium and stainless steel, surface neutral

Forster art. no.

909.552F

Tool length setting

Incl. grub screw for setting the fixed length



Forster art. no.

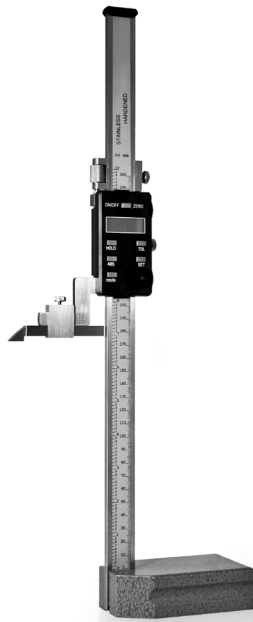
909.551F

Height gauge DIGIT

IMPORTANT INFORMATION: When not in use, preserve the tool holders and measuring plate with BRUNOX care spray. Regular care and maintenance of the tool holder and spindle cone is ESSENTIAL!

Forster art. no.

909.553F



Steel is our nature.

For us, steel is a matter of the heart. We develop long-lasting systems for attractive and energy-efficient architecture.

Forster Profile Systems develops and manufactures safe, energy-efficient solutions in steel and stainless steel for doors, windows and facades in Switzerland. Forster works with its own branches in over 20 countries – and exclusive sales partners in around 10 more. In-house consultants are on hand to assist our customers at sites ranging from Europe and the Middle East to Asia and North America. Forster systems are used for building shells and interiors. This includes market-leading solutions

that meet the strictest requirements and standards in terms of thermal insulation, plus safety applications such as fire protection, burglar resistance and bullet resistance. The product range is rounded off by matching accessories. Our customers and business partners in architecture, planning and construction can also count on comprehensive services for their respective industry.

Forster Profilsysteme AG | CH-8590 Romanshorn
info@forstersystems.com | www.forstersystems.com

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