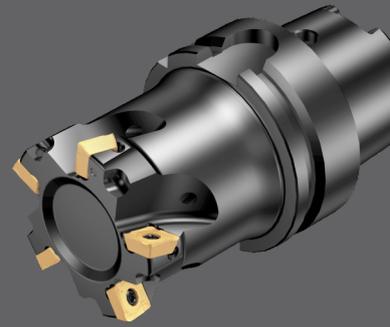


CoroMill® 490



First choice for general and repeated shoulder milling.

CoroMill® 490 is a light-cutting, positive concept with 4 cutting edges. Precise cutter bodies and insert location along with a low-vibration machining process provide accurate shoulders without mismatch. Covers roughing to finishing.

Features & benefits:

- Great flexibility, high precision and good tolerances
- Light and quiet cutting with low cutting forces
- High productivity with outstanding insert geometry and grades
- Sharp edge lines and burr-free, smooth profiles
- Component feature finished in one pass
- True 90-degree cut without sharp steps



Recommendations:

●	◐	○
Difficult conditions	Average conditions	Good conditions
Coarse Pitch (L)	Close Pitch (M)	Extra close pitch (H)
Limited stability and power Deep full-slotting operations Lowest cutting forces	General purpose	Short chipping materials Heat resistant materials Edging operations

CoroMill® 490 insert:

Light, medium and heavy operations

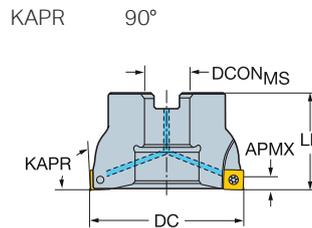
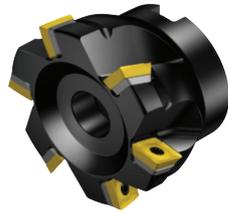


		Good conditions ○				Average conditions ◐				Difficult conditions ●			
ISO/ANSI	Ordering code	Geometry	Grade	v_c m/min	f_z mm/tooth	Geometry	Grade	v_c m/min	f_z mm/tooth	Geometry	Grade	v_c m/min	f_z mm/tooth
P	490R-140408	M-PL	1130	280	0.10	M-PL	1130	280	0.10	M-PL	4340	280	0.10
	490R-140408	M-PM	4330	320	0.17	M-PM	1130	270	0.17	M-PM	4340	270	0.17
	490R-140408	M-PH	4330	305	0.28	M-PH	1130	260	0.28	M-PH	4340	260	0.28
M	490R-140408	E-ML	1040	190	0.14	E-ML	1040	190	0.14	E-ML	1040	190	0.14
	490R-140408	E-MM	1040	190	0.17	E-MM	1040	190	0.17	E-MM	2040	230	0.17
	490R-140408	M-MM	1040	190	0.16	M-MM	1040	190	0.16	M-MM	2040	235	0.16
K	490R-140408	M-PL	1020	205	0.12	M-PL	1020	205	0.12	M-PL	1020	205	0.12
	490R-140408	M-PM	3330	255	0.17	M-PM	3330	255	0.17	M-PM	3330	255	0.17
	490R-140408	M-PM	3330	255	0.17	M-PM	3330	255	0.17	M-PM	3330	255	0.17
S	490R-140408	E-ML	S30T	65	0.14	E-ML	S30T	65	0.14	E-ML	S40T	50	0.14
	490R-140408	M-MM	S30T	65	0.17	M-MM	S30T	65	0.17	M-MM	S40T	45	0.17
	490R-140408	M-MM	S30T	65	0.17	M-PM	S30T	65	0.17	M-MM	S40T	45	0.17

*Cutting data valid for ISO S Titanium alloys(S4.3.ZAG)

CoroMill® 490 square shoulder milling cutter

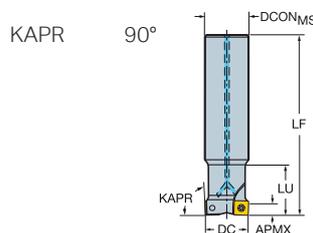
Arbor - Internal coolant supply



DC	CZC _{MS}	APMX _{FFW}	CNSC	Ordering code	Dimensions, mm					RPMX	CICT	MIID		
					DCON _{MS}	DBC	LF	NM	KG					
50.0	14	22	10.00	1	4	490-050Q22-14M	22.0	40.0	3.0	0.62	13700	4	490R-1404	
	14	22	10.00	1	5	490-050Q22-14H	22.0	40.0	3.0	0.59	22400	5	490R-1404	
54.0	14	22	10.00	1	4	490-054Q22-14M	22.0	40.0	3.0	0.67	13000	4	490R-1404	
	63.0	14	22	10.00	1	5	490-063Q22-14M	22.0	40.0	3.0	0.73	11700	5	490R-1404
14		22	10.00	1	6	490-063Q22-14H	22.0	40.0	3.0	0.71	11700	6	490R-1404	
66.0	14	22	10.00	1	5	490-066Q22-14M	22.0	40.0	3.0	0.76	11400	5	490R-1404	
80.0	14	27	10.00	1	6	490-080Q27-14M	27.0	50.0	3.0	1.26	10100	6	490R-1404	
	14	27	10.00	1	8	490-080Q27-14H	27.0	50.0	3.0	1.28	10100	8	490R-1404	
84.0	14	27	10.00	1	6	490-084Q27-14M	27.0	50.0	3.0	1.61	9800	6	490R-1404	
100.0	14	32	10.00	1	5	490-100Q32-14L	32.0	50.0	3.0	2.07	8900	5	490R-1404	
	14	32	10.00	1	7	490-100Q32-14M	32.0	50.0	3.0	1.99	8900	7	490R-1404	
	14	32	10.00	1	10	490-100Q32-14H	32.0	50.0	3.0	2.00	8900	10	490R-1404	
125.0	14	40	10.00	1	6	490-125Q40-14L	40.0	63.0	3.0	3.37	7800	6	490R-1404	
	14	40	10.00	1	8	490-125Q40-14M	40.0	63.0	3.0	3.05	7800	8	490R-1404	
	14	40	10.00	1	12	490-125Q40-14H	40.0	63.0	3.0	3.29	7800	12	490R-1404	
160.0	14	40S	10.00	0	8	490-160Q40-14L	40.0	66.7	63.0	3.0	5.05	6800	8	490R-1404
	14	40S	10.00	0	12	490-160Q40-14M	40.0	66.7	63.0	3.0	5.01	6800	12	490R-1404
	14	40S	10.00	0	15	490-160Q40-14H	40.0	66.7	63.0	3.0	5.06	6800	15	490R-1404
200.0	14	60	10.00	0	10	490-200Q60-14L	60.0	101.6	63.0	3.0	13.11	6000	10	490R-1404
	14	60	10.00	0	16	490-200Q60-14M	60.0	101.6	63.0	3.0	11.79	6000	16	490R-1404
250.0	14	60	10.00	0	12	490-250Q60-14L	60.0	101.6	63.0	3.0	15.50	5300	12	490R-1404
	14	60	10.00	0	18	490-250Q60-14M	60.0	101.6	63.0	3.0	17.52	5300	18	490R-1404

CoroMill® 490 square shoulder milling cutter

Cylindrical shank - Internal coolant supply



DC	CZC _{MS}	APMX _{FFW}	CNSC	Ordering code	Dimensions, mm					RPMX	CICT	MIID	
					DCON _{MS}	LF	NM	KG					
40.0	14	32	10.00	1	3	490-040A32-14M	32.0	170.0	3.0	1.12	26400	3	490R-1404
	14	32	10.00	1	3	490-040A32L-14M	32.0	250.0	3.0	1.77	7600	3	490R-1404
	14	32	10.00	1	4	490-040A32-14H	32.0	170.0	3.0	1.13	26400	4	490R-1404
50.0	14	32	10.00	1	3	490-050A32-14L	32.0	120.0	3.0	1.07	13700	3	490R-1404
	14	32	10.00	1	4	490-050A32-14M	32.0	120.0	3.0	1.09	13700	4	490R-1404
63.0	14	32	10.00	1	4	490-063A32-14L	32.0	120.0	3.0	1.43	11700	4	490R-1404
	14	32	10.00	1	5	490-063A32-14M	32.0	120.0	3.0	1.43	11700	5	490R-1404