

VARIO HELIX 2015



80% increased production

60% more feed

**roughing + finishing
with one tool**

no vibration

more productivity

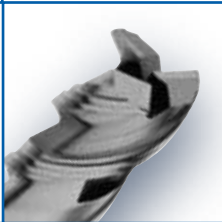
more quality

more precision

VARIO-HELIX



VARIO-HELIX - ROUGHING MILLS



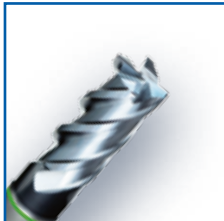
VARIO-HELIX - UNIVERSAL MILLS



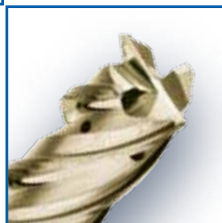
VARIO-HELIX - INOX MILLS



VARIO HELIX - FINISHING MILLS



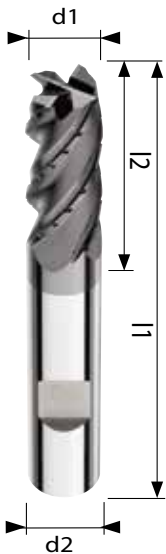
VARIO-HELIX - VARATECH



VARIO-HELIX - NON FERROUS

VARIO-HELIX - ROUGING MILL - SHORT

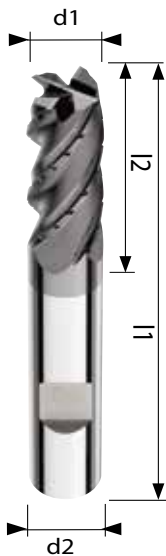
M322



Ø d1 Schnei- den- durchm.	Ø d2 Schaft- durchm.	l2 Schnei- den- länge	l1 Gesamt- länge	Schutz- fase	Schnei- den	Artikel- nummer
Mill diameter	Shank diameter	Lenght of cut	Overall Lenght	Corner of chamfer	No of Flute	Article No.
4,0	6	8	54	0,13	4	M322.040
5,0	6	6	54	0,18	4	M322.050
6,0	6	10	54	0,20	4	M322.060
8,0	8	12	58	0,20	4	M322.080
10,0	10	14	66	0,30	4	M322.100
12,0	12	16	73	0,30	4	M322.120
14,0	14	18	75	0,30	4	M322.140
16,0	16	22	82	0,40	4	M322.160
20,0	20	26	92	0,50	4	M322.200

VARIO-HELIX - ROUGING MILL - LONG

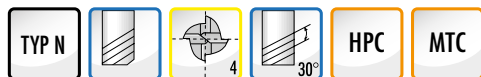
M327



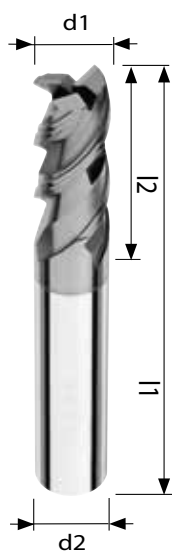
Ø d1 Schnei- den- durchm.	Ø d2 Schaft- durchm.	l2 Schnei- den- länge	l1 Gesamt- länge	Schutz- fase	Schnei- den	Artikel- nummer
Mill diameter	Shank diameter	Lenght of cut	Overall Lenght	Corner of chamfer	No of Flute	Article No.
4,0	6	11	57	0,13	4	M327.040
5,0	6	13	57	0,18	4	M327.050
6,0	6	13	57	0,20	4	M327.060
8,0	8	19	63	0,20	4	M327.080
10,0	10	22	72	0,30	4	M327.100
12,0	12	26	83	0,30	4	M327.120
14,0	14	26	83	0,30	4	M327.140
16,0	16	32	92	0,40	4	M327.160
20,0	20	38	104	0,50	4	M327.200

VARIO-HELIX - ROUGING MILL - EXTRA LONG

M323



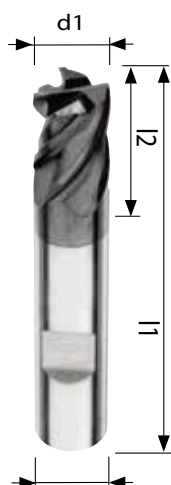
Ø d1 Schnei- den- durchm.	Ø d2 Schaft- durchm.	l2 Schnei- den- länge	l1 Gesamt- länge	Schutz- fase	Schnei- den	Artikel- nummer
Mill diameter	Shank diameter	Lenght of cut	Overall Lenght	Corner of chamfer	No of Flute	Article No.
6,0	6	24	68	0,20	4	M329.060
8,0	8	38	88	0,20	4	M329.080
10,0	10	45	95	0,30	4	M329.100
12,0	12	53	110	0,30	4	M329.120
16,0	16	63	123	0,40	4	M329.160
20,0	20	75	141	0,50	4	M329.200



Ø d1 Schneiden- durchm.	Ø d2 Schaft- durchm.	l2 Schneiden- länge	l1 Gesamt- länge	Schutz- fase	Schnei- den	Artikel- nummer
Mill diameter	Shank diameter	Lenght of cut	Overall Lenght	Corner of chamfer	No of Flute	Article No.
3,0	6	8	57	0,05	3	M139.030
4,0	6	11	57	0,05	3	M139.040
5,0	6	13	57	0,08	3	M139.050
6,0	6	13	57	0,08	3	M139.060
7,0	8	16	63	0,08	3	M139.070
8,0	8	19	63	0,10	3	M139.080
9,0	10	19	72	0,10	3	M139.090
10,0	10	22	72	0,10	3	M139.100
12,0	12	26	83	0,15	3	M139.120
16,0	16	32	92	0,20	3	M139.160
20,0	20	38	104	0,20	3	M139.200

VARIO-HELIX - UNIVERSAL - SHORT

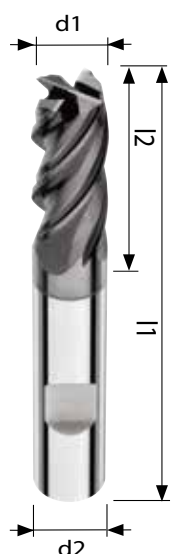
M301



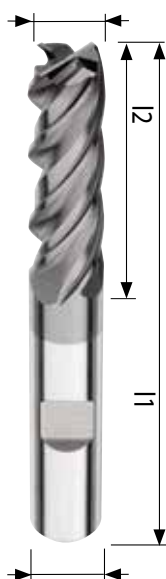
Ø d1 Schneiden- durchm.	Ø d2 Schaft- durchm.	l2 Schneiden- länge	l1 Gesamt- länge	Schutz- fase	Schnei- den	Artikel- nummer
Mill diameter	Shank diameter	Lenght of cut	Overall Lenght	Corner of chamfer	No of Flute	Article No.
3,0	6	6	54	0,10	4	M301.030
4,0	6	8	54	0,13	4	M301.040
5,0	6	9	54	0,18	4	M301.050
6,0	6	10	54	0,20	4	M301.060
7,0	8	12	58	0,20	4	M301.070
8,0	8	12	58	0,20	4	M301.080
9,0	10	14	66	0,30	4	M301.090
10,0	10	14	66	0,30	4	M301.100
11,0	12	16	73	0,30	4	M301.110
12,0	12	16	73	0,30	4	M301.120
13,0	14	18	75	0,30	4	M301.130
14,0	14	18	75	0,30	4	M301.140
16,0	16	22	82	0,40	4	M301.160
18,0	18	24	84	0,40	4	M301.180
20,0	20	26	92	0,50	4	M301.200
25,0	25	32	92	0,50	4	M301.250

VARIO-HELIX - UNIVERSAL - LONG

M302



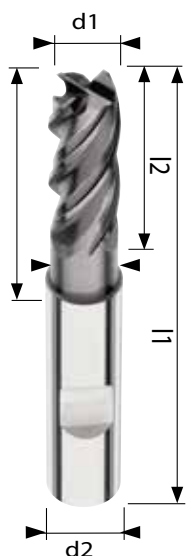
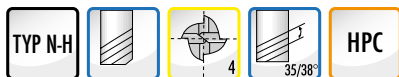
Ø d1 Schneiden- durchm.	Ø d2 Schaft- durchm.	l2 Schneiden- länge	l1 Gesamt- länge	Schutz- fase	Schnei- den	Artikel- nummer
Mill diameter	Shank diameter	Lenght of cut	Overall Lenght	Corner of chamfer	No of Flute	Article No.
3,0	6	8	57	0,10	4	M302.030
4,0	6	11	57	0,13	4	M302.040
5,0	6	13	57	0,18	4	M302.050
6,0	6	13	57	0,20	4	M302.060
7,0	8	19	63	0,20	4	M302.070
8,0	8	19	63	0,20	4	M302.080
9,0	10	22	72	0,30	4	M302.090
10,0	10	22	72	0,30	4	M302.100
11,0	12	26	83	0,30	4	M302.110
12,0	12	26	83	0,30	4	M302.120
13,0	14	26	83	0,30	4	M302.130
14,0	14	26	83	0,30	4	M302.140
16,0	16	32	92	0,40	4	M302.160
18,0	18	32	92	0,40	4	M302.180
20,0	20	38	104	0,50	4	M302.200
25,0	25	38	104	0,50	4	M302.250



Ø d1 Schnei- den- durchm.	Ø d2 Schaft- durchm.	l2 Schnei- den- länge	l1 Gesamt- länge	Schutz- fase	Schnei- den	Art-Nr.
Mill diameter	Shank diame- ter	Lenght of cut	Overall Lenght	Corner of chamfer	No of Flute	Article No.
5	6	21	63	0,18	4	M308.050
6	6	22	63	0,20	4	M308.060
8	8	28	80	0,20	4	M308.080
10	10	33	100	0,30	4	M308.100
12	12	42	100	0,30	4	M308.120
14	14	48	100	0,30	4	M308.140
16	16	53	150	0,40	4	M308.160

VARIO-HELIX - UNIVERSAL - REDUCED SHANK

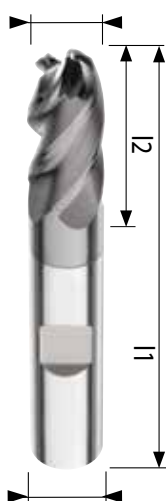
M303



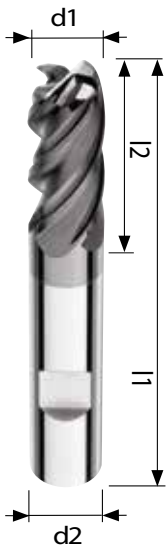
Ø d1 Schneiden- durchm.	Ø d2 Schaft- durchm.	l2 Schneiden- länge	l1 Gesamt- länge	Ø d3 Schutz- fase	-0,1	AP	Schnei- den	Artikel- nummer
Mill diameter	Shank diameter	Lenght of cut	Overall Lenght	Corner of cham- fere	Clearance shark	AP	No of Flute	Article No.
3,0	6	8	57	0,13	2,8	18	4	M303.030
4,0	6	11	57	0,18	3,6	21	4	M303.040
5,0	6	13	57	0,20	4,6	21	4	M303.050
6,0	6	13	57	0,20	5,5	21	4	M303.060
7,0	8	19	63	0,20	6,5	27	4	M303.070
8,0	8	19	63	0,20	7,5	27	4	M303.080
9,0	10	22	72	0,30	8,5	32	4	M303.090
10,0	10	22	72	0,30	9,5	32	4	M303.100
11,0	12	26	83	0,30	10,5	38	4	M303.110
12,0	12	26	83	0,30	11,5	38	4	M303.120
13,0	14	26	83	0,30	12,5	42	4	M303.130
14,0	14	26	83	0,30	13,5	42	4	M303.140
16,0	16	32	92	0,40	15,5	44	4	M303.160
18,0	18	32	100	0,40	17,5	50	4	M303.180
20,0	20	38	104	0,50	19,5	54	4	M303.200
25,0	25	42	121	0.50	24	65	4	M303.250

VARIO-HELIX - UNIVERSAL - BALL NOSE

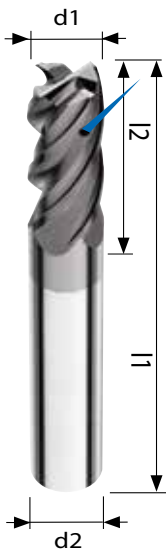
M339



Ø d1 Schnei- den- durchm.	Ø d2 Schaft- durchm.	l2 Schnei- den- länge	l1 Gesamt- länge	Radius	Schnei- den	Artikel- nummer
Mill diameter	Shank diameter	Lenght of cut	Overall Lenght	Radius	No of Flute	Article No.
3	6	8	57	1,5	4	M339.030
4	6	10	57	2	4	M339.040
5	6	13	57	2,5	4	M339.050
6	6	13	57	3	4	M339.060
8	8	16	63	4	4	M339.080
10	10	22	72	5	4	M339.100
12	12	26	83	6	4	M339.120
14	14	26	83	7	4	M339.140
16	16	32	92	8	4	M339.160
20	20	38	104	10	4	M339.200



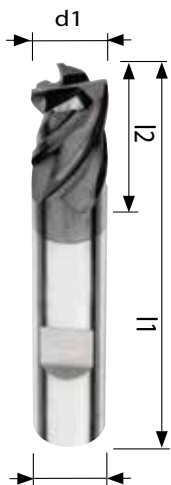
Ø d1 Schneiden- durchm.	Ø d2 Schaft- durchm.	l2 Schneiden- länge	l1 Gesamt- länge	Schnei- den	Ecken- radius	Artikel- nummer
Mill diameter	Shank diameter	Lenght of cut	Overall Lenght	No of Flute	Corner radius	Article No.
4,0	6	11	57	4	0,25	M304.040
4,0	6	11	57	4	0,50	M304.041
4,0	6	11	57	4	1,00	M304.042
5,0	6	13	57	4	0,50	M304.050
5,0	6	13	57	4	1,00	M304.051
5,0	6	13	57	4	1,50	M304.052
6,0	6	13	57	4	0,50	M304.060
6,0	6	13	57	4	1,00	M304.061
6,0	6	13	57	4	1,50	M304.062
6,0	6	13	57	4	2,00	M304.063
8,0	8	19	63	4	0,50	M304.080
8,0	8	19	63	4	1,00	M304.081
8,0	8	19	63	4	1,50	M304.082
8,0	8	19	63	4	2,00	M304.083
10	10	22	72	4	0,50	M304.100
10	10	22	72	4	1,00	M304.101
10	10	22	72	4	1,50	M304.102
10	10	22	72	4	2,00	M304.103
12	12	26	83	4	0,50	M304.120
12	12	26	83	4	1,00	M304.121
12	12	26	83	4	1,50	M304.122
12	12	26	83	4	2,00	M304.123
14	14	26	83	4	1,00	M304.140
14	14	26	83	4	2,00	M304.141
16	16	32	92	4	1,00	M304.160
16	16	32	92	4	1,50	M304.161
16	16	32	92	4	2,00	M304.162
16	16	32	92	4	2,50	M304.163
18	18	32	92	4	1,50	M304.180
18	18	32	92	4	2,50	M304.181
20	20	38	104	4	1,00	M304.200
20	20	38	104	4	1,50	M304.201
20	20	38	104	4	2,00	M304.202
20	20	38	104	4	2,50	M304.203
20	20	38	104	4	3,00	M304.204
20	20	38	104	4	4,00	M304.205
20	20	38	104	4	5,00	M304.206



Ø d1 Schnei- den- durchm.	Ø d2 Schaft- durchm.	l2 Schnei- den- länge	l1 Gesamt- länge	Schutz- fase	Schnei- den	Artikel- nummer
Mill diameter	Shank diameter	Lenght of cut	Overall Lenght	Corner of chamfer	No of Flute	Article No.
6	6	13	57	0,20	4	M329.060
8	8	19	63	0,20	4	M329.080
10	10	22	72	0,30	4	M329.100
12	12	26	83	0,30	4	M329.120
16	16	32	92	0,40	4	M329.160
20	20	38	104	0,50	4	M329.200

VARIO-HELIX - INOX - SHORT

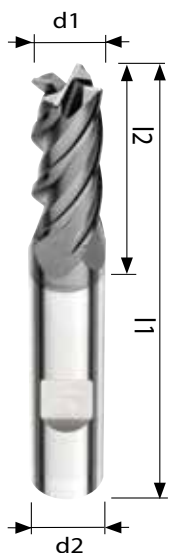
M307



Ø d1 Schneiden- durchm.	Ø d2 Schaft- durchm.	l2 Schneiden- länge	l1 Gesamt- länge	Schutz- fasse	Schnei- den	Artikel- nummer
Mill diameter	Shank diameter	Lenght of cut	Overall Lenght	Corner of chamfer	No of Flute	Article No.
3,0	6	6	54	0,10	4	M307.030
4,0	6	8	54	0,13	4	M307.040
5,0	6	9	54	0,18	4	M307.050
6,0	6	10	54	0,20	4	M307.060
7,0	8	12	58	0,20	4	M307.070
8,0	8	12	58	0,20	4	M307.080
9,0	10	14	66	0,30	4	M307.090
10,0	10	14	66	0,30	4	M307.100
11,0	12	16	73	0,30	4	M307.110
12,0	12	16	73	0,30	4	M307.120
13,0	14	18	75	0,30	4	M307.130
14,0	14	18	75	0,30	4	M307.140
16,0	16	22	82	0,40	4	M307.160
18,0	18	24	84	0,40	4	M307.180
20,0	20	26	92	0,50	4	M307.200
25,0	25	32	92	0,50	4	M307.250

VARIO-HELIX - INOX - LONG

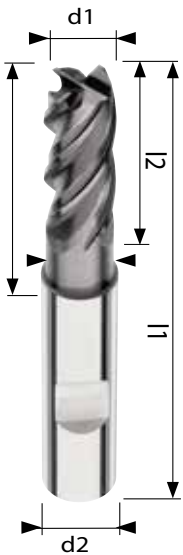
M305



Ø d1 Schnei- den- durchm.	Ø d2 Schaft- durchm.	l2 Schnei- den- länge	l1 Gesamt- länge	Schutz- fasse	Schnei- den	Art-Nr.
Mill diameter	Shank diame- ter	Lenght of cut	Overall Lenght	Corner of chamfer	No of Flute	Article No.
4,0	6	11	57	0,13	4	M305.040
5,0	6	13	57	0,18	4	M305.050
6,0	6	13	57	0,20	4	M305.060
8,0	8	19	63	0,20	4	M305.080
10,0	10	22	72	0,30	4	M305.100
12,0	12	26	83	0,30	4	M305.120
16,0	16	32	92	0,40	4	M305.160
20,0	20	38	104	0,50	4	M305.200
25,0	25	42	104	0,50	4	M305.250

VARIO-HELIX - INOX - REDUCED SHANK

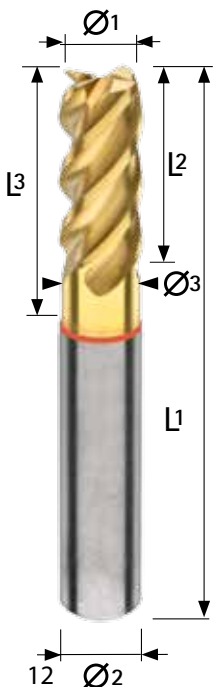
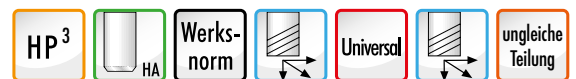
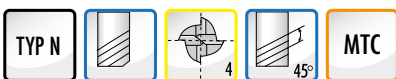
M306



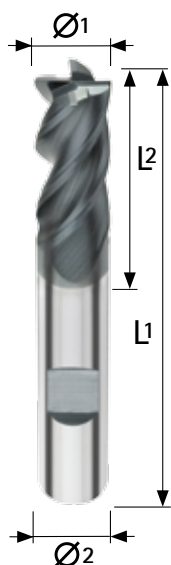
Ø d1 Schneiden- durchm.	Ø d2 Schaft- durchm.	l2 Schneiden- länge	l1 Gesamt- länge	Ø d3 Schutz- fase	-0,1	AP	Schnei- den	Artikel- nummer
Mill diameter	Shank diameter	Lenght of cut	Overall Lenght	Corner of cham- fer	Clearance shark	AP	No of Flute	Article No.
3,0	6	8	57	0,13	2,8	18	4	M306.030
4,0	6	11	57	0,18	3,6	21	4	M306.040
5,0	6	13	57	0,20	4,6	21	4	M306.050
6,0	6	13	57	0,20	5,5	21	4	M306.060
7,0	8	19	63	0,20	6,5	27	4	M306.070
8,0	8	19	63	0,20	7,5	27	4	M306.080
9,0	10	22	72	0,30	8,5	32	4	M306.090
10,0	10	22	72	0,30	9,5	32	4	M306.100
11,0	12	26	83	0,30	10,5	38	4	M306.110
12,0	12	26	83	0,30	11,5	38	4	M306.120
13,0	14	26	83	0,30	12,5	42	4	M306.130
14,0	14	26	83	0,30	13,5	42	4	M306.140
16,0	16	32	92	0,40	15,5	44	4	M306.160
18,0	18	32	100	0,40	17,5	50	4	M306.180
20,0	20	38	104	0,50	19,5	54	4	M306.200
25,0	25	42	121	0.50	24	65	4	M306.250

VARIO-HELIX - HP³

M388



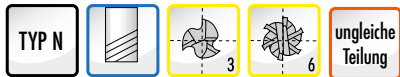
Ø d1 Schneiden- durchm.	Ø d2 Schaft- durchm.	l2 Schneiden- länge	l1 Gesamt- länge	Ø d3 Schutz- fase		AP	Schnei- den	Artikel- nummer
Mill diameter	Shank diameter	Lenght of cut	Overall Lenght	Corner of chamfer	Clearance shark	AP	No of Flute	Article No.
6,0	6	13	57	0,20	5,50	21	4	M388.060
8,0	8	19	63	0,20	7,50	27	4	M388.080
10,0	10	22	72	0,30	9,50	32	4	M388.100
12,0	12	26	83	0,30	11,50	38	4	M388.120
16,0	16	32	92	0,40	15,00	44	4	M388.160
20,0	20	38	104	0,40	19,00	52	4	M388.200



Ø d1 Schneiden- durchm.	Ø d2 Schaft- durchm.	l2 Schneiden- länge	l1 Gesamt- länge	Schutz- fase	Schnei- den	Artikel- nummer
Mill diameter	Shank diameter	Lenght of cut	Overall Lenght	Corner of chamfer	No of Flute	Article No.
4,0	6	12	55	0,13	4	M315.040
5,0	6	13	57	0,18	4	M315.050
6,0	6	13	57	0,20	4	M315.060
8,0	8	16	63	0,20	4	M315.080
10,0	10	22	72	0,20	4	M315.100
12,0	12	26	83	0,30	4	M315.120
14,0	14	26	83	0,40	4	M315.140
16,0	16	32	92	0,40	4	M315.160
18,0	18	32	92	0,50	4	M315.180
20,0	20	38	104	0,50	4	M315.200
25,0	25	45	121	0,50	4	M315.250

VARIO-HELIX - FINISHING - MULTICUT

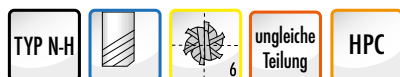
M309



Ø d1 Schnei- den- durchm.	Ø d2 Schaft- durchm.	l2 Schnei- den- länge	l1 Gesamt- länge	Schnei- den	Art-Nr.
Mill diameter	Shank diameter	Lenght of cut	Overall Lenght	No of Flute	Article No.
6	6	13	57	3/6	M309.060
8	8	19	63	3/6	M309.080
10	10	22	72	3/6	M309.100
12	12	26	83	3/6	M309.120
16	16	32	92	3/6	M309.160
20	20	38	104	3/6	M309.200
25	25	42	110	3/6	M309.250

VARIO-HELIX - FINISHING - SUPER FINISH

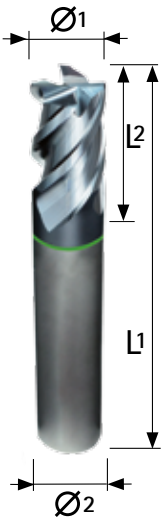
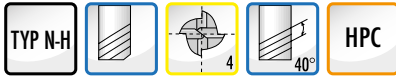
M336



Ø d1 Schnei- den- durchm.	Ø d2 Schaft- durchm.	l2 Schnei- den- länge	l1 Gesamt- länge	Schutz- fase	Schnei- den	Artikel- nummer
Mill diameter	Shank diameter	Lenght of cut	Overall Lenght	Corner of chamfer	No of Flute	Article No.
8,0	8	19	63	0,20	6	M336.080
10,0	10	22	72	0,30	6	M336.100
12,0	12	26	83	0,30	6	M336.120
16,0	16	32	92	0,40	6	M336.160
20,0	20	38	104	0,50	6	M336.200
25,0	25	42	110	0,50	6	M336.250

VARIO-HELIX - VARA-TECH - SHORT

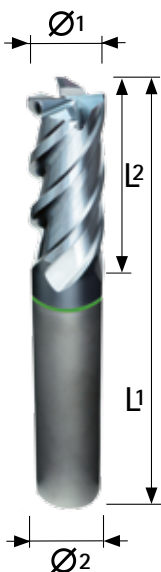
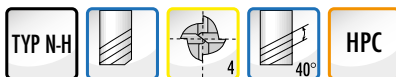
M381



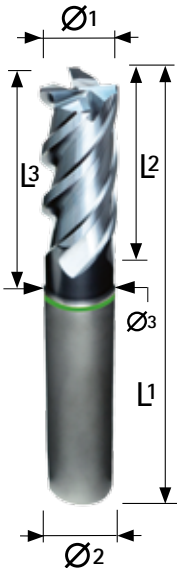
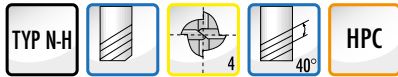
Ø d1 Schnei- den- durchm.	Ø d2 Schaft- durchm.	l2 Schnei- den- länge	l1 Gesamt- länge	Schutz- fasse	Schnei- den	Art-Nr.
Mill diameter	Shank diami- ter	Lenght of cut	Overall Lenght	Corner of chamfer	No of Flute	Article No.
3,0	6	6	54	0,10	4	M381.030
4,0	6	8	54	0,13	4	M381.040
5,0	6	9	54	0,18	4	M381.050
6,0	6	10	58	0,20	4	M381.060
7,0	8	12	58	0,20	4	M381.070
8,0	8	12	58	0,20	4	M381.080
9,0	10	14	66	0,30	4	M381.090
10,0	10	14	66	0,30	4	M381.100
11,0	12	16	73	0,30	4	M381.110
12,0	12	16	73	0,30	4	M381.120
13,0	14	18	75	0,30	4	M381.130
14,0	14	18	75	0,30	4	M381.140
16,0	16	22	82	0,40	4	M381.160
18,0	18	24	84	0,40	4	M381.180
20,0	20	26	92	0,50	4	M381.200
25,0	25	32	92	0,50	4	M381.250

VARIO-HELIX - VARA-TECH - LONG

M382



Ø d1 Schnei- den- durchm.	Ø d2 Schaft- durchm.	l2 Schnei- den- länge	l1 Gesamt- länge	Schutz- fasse	Schnei- den	Art-Nr.
Mill diameter	Shank diami- ter	Lenght of cut	Overall Lenght	Corner of chamfer	No of Flute	Article No.
3,0	6	8	57	0,10	4	M382.030
4,0	6	11	57	0,13	4	M382.040
5,0	6	13	57	0,18	4	M382.050
6,0	6	13	57	0,20	4	M382.060
7,0	8	19	63	0,20	4	M382.070
8,0	8	19	63	0,20	4	M382.080
9,0	10	22	72	0,30	4	M382.090
10,0	10	22	72	0,30	4	M382.100
11,0	12	26	83	0,30	4	M382.110
12,0	12	26	83	0,30	4	M382.120
13,0	14	26	83	0,30	4	M382.130
14,0	14	26	83	0,30	4	M382.140
16,0	16	32	92	0,40	4	M382.160
18,0	18	32	92	0,40	4	M382.180
20,0	20	38	104	0,50	4	M382.200
25,0	25	38	104	0,50	4	M382.250



Ø d1 Schnei- den- durchm.	Ø d2 Schaft- durchm.	l2 Schnei- den- länge	l1 Gesamt- länge	Schutz- fasse	Ø d3	Ap	Schnei- den	Art-Nr.
Mill diameter	Shank diame- ter	Lenght of cut	Overall Lenght	Corner of chamfer	Ø d3	Ap	No of Flute	Article No.
3,0	6	8	57	0,13	2,8	18	4	M383.030
4,0	6	11	57	0,18	3,6	21	4	M383.040
5,0	6	13	57	0,20	4,6	21	4	M383.050
6,0	6	13	57	0,20	5,5	21	4	M383.060
7,0	8	19	63	0,20	6,5	27	4	M383.070
8,0	8	19	63	0,20	7,5	27	4	M383.080
9,0	10	22	72	0,30	8,5	32	4	M383.090
10,0	10	22	72	0,30	9,5	32	4	M383.100
11,0	12	26	83	0,30	10,5	38	4	M383.110
12,0	12	26	83	0,30	11,5	38	4	M383.120
13,0	14	26	83	0,30	12,5	42	4	M383.130
14,0	14	26	83	0,30	13,5	42	4	M383.140
16,0	16	32	92	0,40	15,5	44	4	M383.160
18,0	18	32	100	0,40	17,5	50	4	M383.180
20,0	20	38	104	0,50	19,5	54	4	M383.200
25,0	25	42	121	0,50	24,0	65	4	M383.250

VARIO-HELIX - NON FERROUS - INTERNAL COOLANT

M408

TYP N-W



ungleiche
Teilung



HPC

ZrN

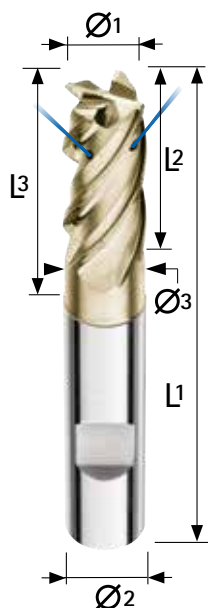
geläpft
polished



DIN 6527
lang

ALU
NE

INCONEL



Ø d1 Schnei- den- durchm.	Ø d2 Schaft- durchm.	l2 Schnei- den- länge	l1 Gesamt- länge	Schutz- fasse	Ø d3	Ap	Schnei- den	Art-Nr.
Mill diameter	Shank diameter	Lenght of cut	Overall Lenght	Corner of chamfer	Ø d3	Ap	No of Flute	Article No.
3,0	6	11	57	0,10	2,80	18	4	M408.030
4,0	6	12	57	0,15	3,60	21	4	M408.040
5,0	6	15	57	0,18	4,50	21	4	M408.050
6,0	6	15	57	0,20	5,50	21	4	M408.060
8,0	8	21	63	0,20	7,50	28	4	M408.080
10,0	10	22	72	0,20	9,50	32	4	M408.100
12,0	12	28	83	0,20	11,50	38	4	M408.120
14,0	14	30	83	0,20	13,50	42	4	M408.140
16,0	16	35	92	0,20	15,50	45	4	M408.160
20,0	20	41	104	0,20	19,50	55	4	M408.200
25,0	25	51	110	0,20	24,00	65	4	M408.250