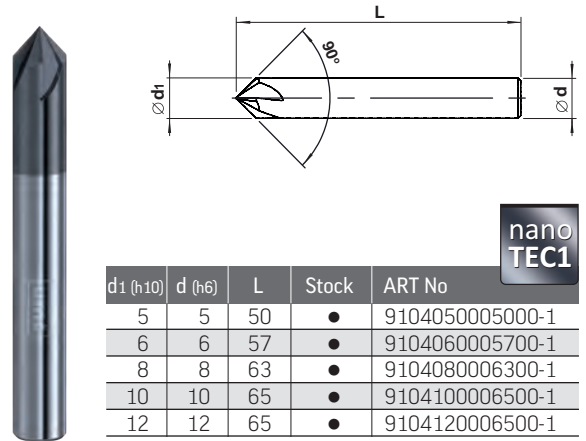


UMT 9104 Z=4 NEW

Chamfer end mill 90°



d1 (h10)	d (h6)	L	Stock	ART No
5	5	50	●	9104050005000-1
6	6	57	●	9104060005700-1
8	8	63	●	9104080006300-1
10	10	65	●	9104100006500-1
12	12	65	●	9104120006500-1

● In stock

Recommended cutting conditions for end mills 9104 - Chamfer milling

Work material	Cutting speed V _c (m/min)	d1 - diameter in mm			f _z - feed per tooth in mm	
		Ø5	Ø6	Ø8	Ø10	Ø12
P Carbon steel and Alloy steel < 25 HRC	110-150	0.025-0.035	0.035-0.045	0.045-0.05	0.05-0.06	0.06-0.07
	80-110	0.02-0.03	0.03-0.04	0.04-0.045	0.045-0.055	0.055-0.065
M Alloy steel and Tool steel 25-45 HRC	40-60	0.02-0.03	0.03-0.04	0.04-0.045	0.045-0.055	0.055-0.065
K Cast iron GG Nodular cast iron GGG	70-90	0.025-0.035	0.035-0.045	0.045-0.05	0.05-0.06	0.06-0.07
S Titanium alloy	60-80	0.02-0.03	0.03-0.04	0.04-0.045	0.045-0.055	0.055-0.065
40-50	0.02-0.03	0.03-0.04	0.04-0.045	0.045-0.055	0.055-0.065	

For high alloyed steels (> 12 Cr), INOX, titanium alloys, cutting speed must be reduced by 20-30% when used emulsion