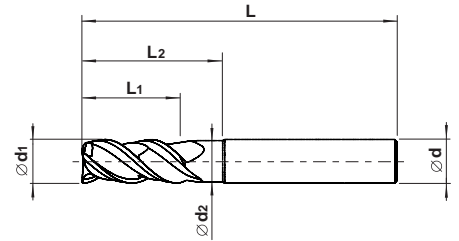
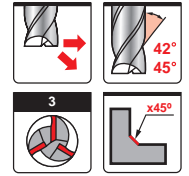


**UMT 9243 Z=3 NEW**

End mills with different helix angles, irregular teeth and relieved neck



nano  
TEC2

d1 (h10)	L1	L2	d2	d (h6)	L	Stock	ART No
6	13	21	5.5	6	57	●	9243060005700-2
8	19	27	7.5	8	63	●	9243080006300-2
10	22	32	9.5	10	72	●	9243100007200-2
12	26	38	11.5	12	83	●	9243120008300-2
14	26	38	13.5	14	83	○	9243140008300-2
16	32	44	15.5	16	92	●	9243160009200-2
18	32	44	17.5	18	92	○	9243180009200-2
20	38	54	19.5	20	104	●	9243200010400-2

- In stock
- Produced to order only

Recommended cutting conditions for end mills 9243 - Shoulder milling and slotting

Work material	Cutting speed		Cutting speed		d1 - diameter in mm				fz - feed per tooth in mm					
		Vc (m/min)		Vc (m/min)	Ø6	Ø8	Ø10	Ø12	Ø14	Ø16	Ø18	Ø20		
<b>P</b> Carbon steel and Alloy steel < 25 HRC	<1.5d1	<0.5d1	nanoTEC2	100-160	<1d1 max 12mm	90-130	0.029	0.049	0.061	0.074	0.086	0.10	0.103	0.107
Alloy steel and Tool steel 25-45 HRC	<1.5d1	<0.4d1	60-90	60-90	<0.7d1 max 12mm	50-80	0.022	0.036	0.045	0.055	0.063	0.074	0.077	0.08
<b>M</b> Stainless steel	<1.5d1	<0.3d1	60-90	60-90	<0.7d1 max 12mm	50-80	0.019	0.032	0.04	0.048	0.056	0.064	0.066	0.069
<b>K</b> Cast iron GG	<1.5d1	<0.5d1	90-120	90-120	<1d1 max 12mm	70-100	0.029	0.049	0.061	0.074	0.086	0.10	0.103	0.107
Nodular cast iron GGG	<1.5d1	<0.4d1	70-100	70-100	<0.7d1 max 12mm	50-80	0.022	0.036	0.045	0.055	0.063	0.074	0.077	0.08
<b>S</b> Titanium alloy	<1.5d1	<0.4d1	40-60	40-60	<0.7d1 max 12mm	35-50	0.019	0.032	0.04	0.048	0.056	0.064	0.066	0.069

1. The figures to be adjusted according to machining shape, rigidity of machine and work clamping  
 2. For high alloyed steels (>12% Cr), INOX, cutting speed must be reduced by 20-30% when used emulsion