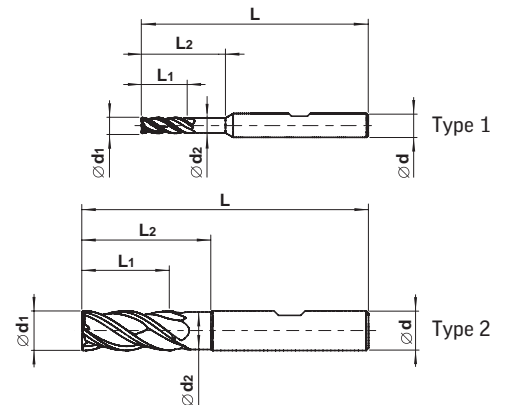
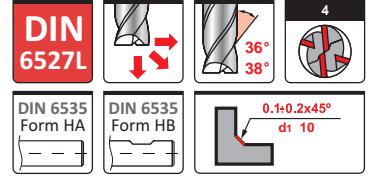


UMT 9264 Z=4 NEW Geometry

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



d1 (h10)	L1	L2	d2	d (h6)	L	Type	Stock	nano TEC2		
								ART No	Stock	ART No
							Shank Style DIN 6535 HA		Shank Style DIN 6535 HB	
3	8	18	2.8	6	57	1	●	9264030005700-2	○	9264030005700-2-HB
4	11	21	3.6	6	57	1	●	9264040005700-2	○	9264040005700-2-HB
5	13	21	4.6	6	57	1	●	9264050005700-2	○	9264050005700-2-HB
6	13	21	5.5	6	57	2	●	9264060005700-2	○	9264060005700-2-HB
8	19	27	7.5	8	63	2	●	9264080006300-2	○	9264080006300-2-HB
10	22	32	9.5	10	72	2	●	9264100007200-2	○	9264100007200-2-HB
12	26	38	11.5	12	83	2	●	9264120008300-2	○	9264120008300-2-HB
14	26	38	13.5	14	83	2	○	9264140008300-2	○	9264140008300-2-HB
16	32	44	15.5	16	92	2	●	9264160009200-2	○	9264160009200-2-HB
18	32	44	17.5	18	92	2	○	9264180009200-2	○	9264180009200-2-HB
20	38	54	19.5	20	104	2	●	9264200010400-2	○	9264200010400-2-HB

- In stock
- Produced to order only

Recommended cutting conditions for end mills 9264 - Shoulder milling and slotting

Work material	Cutting speed		Cutting speed		d1 - diameter in mm						
	Ap	Ae	Vc (m/min)	Ap	Vc (m/min)	03-06	06-08	08-10	10-14	14-16	16-20
P Carbon steel and Alloy steel < 25 HRC	<2d1	<0.5d1	140-180	<1d1 max 12mm	120-160	0.015-0.03	0.025-0.04	0.035-0.05	0.045-0.075	0.065-0.09	0.07-0.11
Alloy steel and Tool steel 25-45 HRC	<2d1	<0.4d1	110-140	<0.7d1 max 12mm	90-120	0.015-0.03	0.025-0.04	0.035-0.05	0.045-0.075	0.065-0.09	0.07-0.11
M Stainless steel	<1.5d1	<0.3d1	45-55	<0.5d1	35-45	0.01-0.025	0.02-0.035	0.03-0.045	0.04-0.07	0.045-0.08	0.055-0.10
K Cast iron GG	<2d1	<0.5d1	100-120	<1d1 max 12mm	90-110	0.015-0.03	0.025-0.04	0.035-0.05	0.045-0.075	0.065-0.09	0.07-0.11
Nodular cast iron GGG	<2d1	<0.4d1	90-110	<1d1 max 12mm	80-100	0.015-0.03	0.025-0.04	0.035-0.05	0.045-0.075	0.065-0.09	0.07-0.11

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