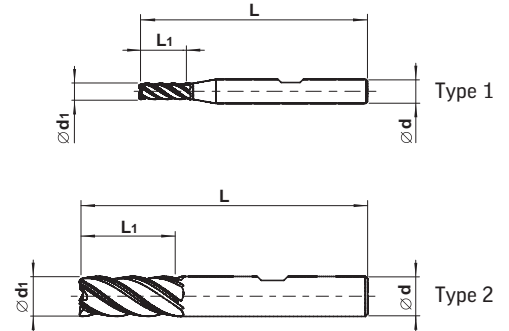
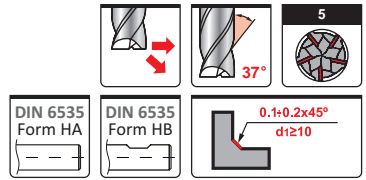


UMT 9265 Z-5

HPC end mills with irregular teeth for machining different types of steel



d1 (h10)	L1	d (h6)	L	Type	nano TEC2		nano TEC2	
					Stock	ART No	Stock	ART No
					Shank Style DIN 6535 HA		Shank Style DIN 6535 HB	
3	8	6	57	1	●	9265030005700-2	○	9265030005700-2-HB
4	11	6	57	1	●	9265040005700-2	○	9265040005700-2-HB
5	13	6	57	1	●	9265050005700-2	○	9265050005700-2-HB
6	13	6	57	2	●	9265060005700-2	○	9265060005700-2-HB
8	19	8	63	2	●	9265080006300-2	○	9265080006300-2-HB
10	22	10	72	2	○	9265100007200-2	●	9265100007200-2-HB
12	26	12	83	2	○	9265120008300-2	●	9265120008300-2-HB
16	32	16	92	2	○	9265160009200-2	●	9265160009200-2-HB
20	38	20	104	2	○	9265200010400-2	●	9265200010400-2-HB

- In stock
- Produced to order only

Recommended cutting conditions for end mills 9265 - Shoulder milling and slotting

Work material	Cutting speed		Cutting speed		d1 - diameter in mm					fz - feed per tooth in mm				
	Ap	Ae	Vc (m/min)	Ap	Vc (m/min)	Ø3	Ø4	Ø5	Ø6	Ø8	Ø10	Ø12	Ø16	Ø20
P Carbon steel and Alloy steel < 25 HRC	<1.5d1	<0.5d1	160-190	<1d1 max 12mm	130-150	0.012	0.018	0.022	0.029	0.049	0.06	0.074	0.087	0.095
Alloy steel and Tool steel 25-45 HRC	<1.5d1	<0.4d1	90-110	<0.7d1 max 12mm	70-90	0.01	0.015	0.018	0.022	0.036	0.045	0.055	0.067	0.075
M Stainless steel	<1.5d1	<0.3d1	80-100	<0.5d1	60-80	0.008	0.01	0.014	0.017	0.03	0.037	0.043	0.05	0.058
K Cast iron GG	<1.5d1	<0.5d1	130-160	<1d1 max 12mm	100-120	0.01	0.015	0.018	0.026	0.045	0.056	0.067	0.079	0.09
Nodular cast iron GGG	<1.5d1	<0.4d1	110-140	<0.7d1 max 12mm	80-100	0.009	0.012	0.015	0.02	0.034	0.043	0.05	0.059	0.067

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