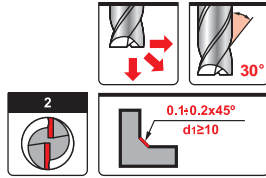
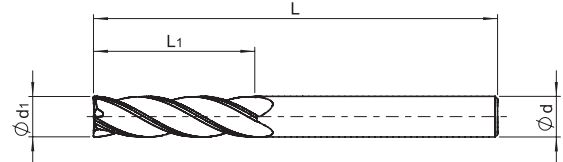
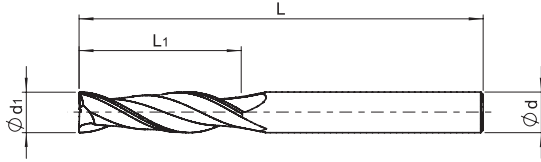
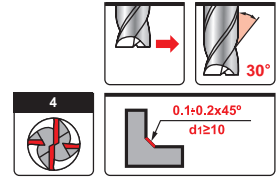


**UMT 9302 Z=2**  
Long end mills



**UMT 9304 Z=4**  
Long end mills



d1 (e8)	L1	d (h6)	L	Stock	ART No	nano TEC2
3	18	3	60	●	9302030006000-2	
4	24	4	60	●	9302040006000-2	
5	26	5	75	●	9302050007500-2	
6	30	6	75	●	9302060007500-2	
8	30	8	75	●	9302080007500-2	
10	40	10	100	●	9302100010000-2	
12	45	12	100	●	9302120010000-2	
16	45	16	100	●	9302160010000-2	

● In stock



d1 (e8)	L1	d (h6)	L	Stock	ART No	nano TEC2
3	18	3	60	●	9304030006000-2	
4	24	4	60	●	9304040006000-2	
5	26	5	75	●	9304050007500-2	
6	30	6	75	●	9304060007500-2	
8	30	8	75	●	9304080007500-2	
10	40	10	100	●	9304100010000-2	
12	45	12	100	●	9304120010000-2	
16	45	16	100	●	9304160010000-2	

● In stock

Recommended cutting conditions for end mills 9302, 9304 - Shoulder milling

Work material	Ap Ae		Cutting speed Vc (m/min)	d1 - diameter in mm					fz - feed per tooth in mm	
	Ap	Ae		nanoTEC2	Ø3 - Ø6	Ø6 - Ø8	Ø8 - Ø10	Ø10 - Ø12	Ø12 - Ø16	
<b>P</b> Carbon steel and Alloy steel < 25 HRC	<1d1	<0.1d1	50-60	0.005-0.01	0.01-0.02	0.02-0.03	0.02-0.04	0.03-0.06		
Alloy steel and Tool steel 25-45 HRC	<1d1	<0.1d1	30-50	0.005-0.01	0.005-0.01	0.01-0.02	0.01-0.03	0.02-0.05		
<b>M</b> Stainless steel	<1d1	<0.1d1	30-40	0.005-0.01	0.005-0.01	0.01-0.02	0.01-0.03	0.02-0.05		
<b>K</b> Cast iron GG	<1d1	<0.1d1	30-70	0.005-0.01	0.01-0.02	0.02-0.03	0.02-0.04	0.03-0.06		
Nodular cast iron GGG	<1d1	<0.1d1	30-40	0.005-0.01	0.005-0.01	0.01-0.02	0.01-0.03	0.02-0.05		