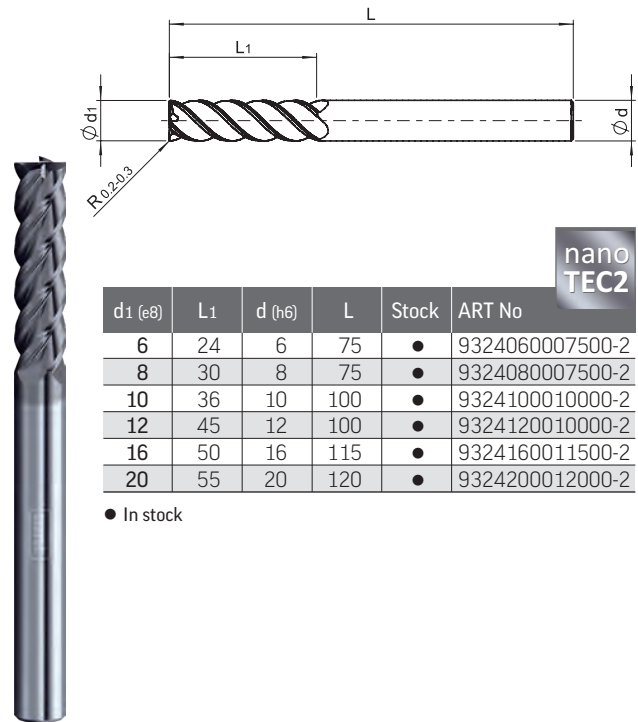
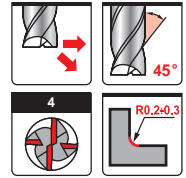


**UMT 9324 Z=4**  
Long end mills



d1 (e8)	L1	d (h6)	L	Stock	ART No
6	24	6	75	●	9324060007500-2
8	30	8	75	●	9324080007500-2
10	36	10	100	●	9324100010000-2
12	45	12	100	●	9324120010000-2
16	50	16	115	●	9324160011500-2
20	55	20	120	●	9324200012000-2

● In stock

Recommended cutting conditions for end mills 9324 - Shoulder milling

Work material			Cutting speed Vc (m/min)	d1 - diameter in mm					
	Ap	Ae		ø6	ø8	ø10	ø12	ø16	ø20
<b>P</b> Carbon steel and Alloy steel < 25 HRC	<2.5d1	<0.05d1	nanoTEC2 70-80	0.03-0.04	0.05-0.06	0.06-0.07	0.07-0.08	0.08-0.09	0.09-0.10
Alloy steel and Tool steel 25-45 HRC	<2d1	<0.05d1	40-50	0.025-0.035	0.045-0.055	0.05-0.06	0.06-0.07	0.07-0.08	0.08-0.09
<b>M</b> Stainless steel	<2d1	<0.02d1	40-50	0.025-0.035	0.045-0.055	0.05-0.06	0.06-0.065	0.065-0.07	0.07-0.08
<b>K</b> Cast iron GG	<2.5d1	<0.05d1	90-110	0.03-0.04	0.05-0.06	0.06-0.07	0.07-0.08	0.08-0.09	0.09-0.10
Nodular cast iron GGG	<2.5d1	<0.05d1	80-100	0.03-0.04	0.05-0.06	0.06-0.07	0.07-0.08	0.08-0.09	0.09-0.10
<b>S</b> Titanium alloy	<2d1	<0.02d1	40-50	0.025-0.035	0.045-0.055	0.05-0.06	0.06-0.065	0.065-0.07	0.07-0.08

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