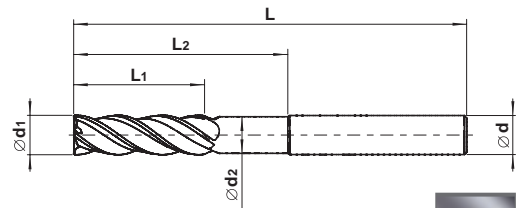
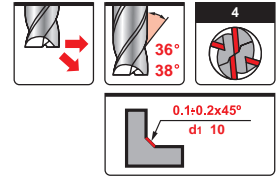


**UMT 9364 Z=4**

Long 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	19	29	5.5	6	63	●	9364060006300-2
8	26	42	7.5	8	80	●	9364080008000-2
10	33	54	9.5	10	100	●	9364100010000-2
12	38	54	11.5	12	100	●	9364120010000-2
16	53	69	15.5	16	150	●	9364160015000-2
20	68	84	19.5	20	150	●	9364200015000-2

● In stock

Recommended cutting conditions for end mills 9364 - Shoulder

Work material	Ap Ae		Cutting speed Vc (m/min)	d1 - diameter in mm				fz - feed per tooth in mm	
	Ap	Ae		ø6	ø8	ø10	ø12	ø16	ø20
<b>P</b> Carbon steel and Alloy steel < 25 HRC	<2d1	<0.4d1	nanoTEC2 130-170	0.02-0.035	0.035-0.045	0.045-0.06	0.06-0.075	0.07-0.09	0.08-0.10
Alloy steel and Tool steel 25-45 HRC	<2d1	<0.3d1	100-130	0.02-0.035	0.035-0.045	0.045-0.06	0.06-0.075	0.07-0.09	0.08-0.10
<b>M</b> Stainless steel	<1.5d1	<0.2d1	35-45	0.015-0.03	0.03-0.04	0.04-0.055	0.055-0.07	0.065-0.08	0.075-0.09
<b>K</b> Cast iron GG	<2d1	<0.4d1	90-110	0.02-0.035	0.035-0.045	0.045-0.06	0.06-0.075	0.07-0.09	0.08-0.10
Nodular cast iron GGG	<2d1	<0.3d1	80-100	0.02-0.035	0.035-0.045	0.045-0.06	0.06-0.075	0.07-0.09	0.08-0.10

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