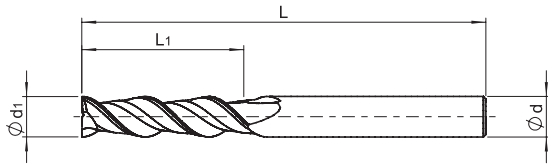
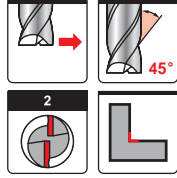


UMT 9422 Z=2

Long end mills for aluminium



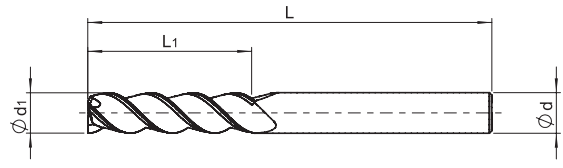
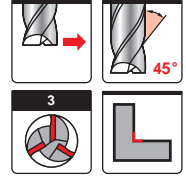
d1 (e8)	L1	d (h6)	L	Stock	ART No
3	18	3	60	●	9422030006000-0
4	24	4	60	●	9422040006000-0
5	26	5	75	●	9422050007500-0
6	30	6	75	●	9422060007500-0
8	30	8	75	●	9422080007500-0
10	40	10	100	●	9422100010000-0
12	45	12	100	●	9422120010000-0
16	45	16	100	●	9422160010000-0

● In stock

HM

UMT 9423 Z=3

Long end mills for aluminium



d1 (e8)	L1	d (h6)	L	Stock	ART No
3	18	3	60	●	9423030006000-0
4	24	4	60	●	9423040006000-0
5	26	5	75	●	9423050007500-0
6	30	6	75	●	9423060007500-0
8	30	8	75	●	9423080007500-0
10	40	10	100	●	9423100010000-0
12	45	12	100	●	9423120010000-0
16	45	16	100	●	9423160010000-0

● In stock

HM

Recommended cutting conditions for end mills 9422, 9423 - Shoulder milling

Work material			Cutting speed Vc (m/min)	d1 - diameter in mm					fz - feed per tooth in mm				
	Ap	Ae		HM	Ø3 - Ø6	Ø6 - Ø8	Ø8 - Ø10	Ø10 - Ø12	Ø12 - Ø16				
N Aluminium alloy Si<8%	<1.5d1	<0.15d1	170-180	0.03-0.05	0.06-0.08	0.085-0.10	0.10-0.125	0.125-0.15					
Cast aluminium Si>8%	<1.5d1	<0.15d1	140-150	0.025-0.05	0.06-0.08	0.08-0.10	0.10-0.125	0.125-0.15					
Copper alloy	<1.5d1	<0.15d1	90-100	0.025-0.05	0.06-0.08	0.08-0.09	0.09-0.12	0.12-0.15					