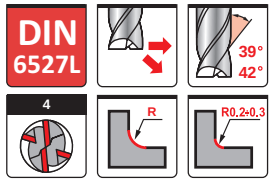
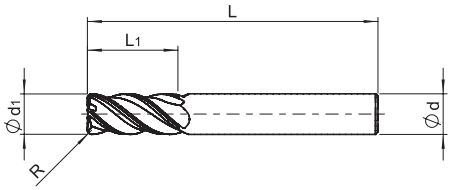
UMT 9544 Z=4

End mills with different helix angles and irregular teeth for difficult to cut materials





nano TEC2

d1 (e8)	L1	d (h6)	L	R(±0.02)	Stock	ART No
6	13	6	57		●	9544060005700-2
6	13	6	57	0.5	○	9544060005705-2
6	13	6	57	1.0	○	9544060005710-2
8	19	8	63		●	9544080006300-2
8	19	8	63	0.5	○	9544080006305-2
8	19	8	63	1.0	○	9544080006310-2
10	22	10	72		●	9544100007200-2
10	22	10	72	0.5	○	9544100007205-2
10	22	10	72	1.0	○	9544100007210-2
10	22	10	72	2.0	○	9544100007220-2
12	26	12	83		●	9544120008300-2
12	26	12	83	0.5	○	9544120008305-2
12	26	12	83	1.0	○	9544120008310-2
12	26	12	83	2.0	○	9544120008320-2
16	32	16	92		●	9544160009200-2
16	32	16	92	1.0	○	9544160009210-2
16	32	16	92	2.0	○	9544160009220-2
16	32	16	92	3.0	○	9544160009230-2
20	38	20	104		●	9544200010400-2
20	38	20	104	1.0	○	9544200010410-2
20	38	20	104	2.0	○	9544200010420-2
20	38	20	104	3.0	○	9544200010430-2

● In stock
○ Produced to order only

Recommended cutting conditions for end mills 9544 - 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)						
		Ap	Ae	nanoTEC2	Ap	nanoTEC2	∅6	∅8	∅10	∅12	∅16	∅20
P	Carbon steel and Alloy steel < 25 HRC	<2d1	<0.4d1	120-150	<1d1 max 12mm	90-120	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	<0.3d1	60-80	<0.7d1 max 12mm	50-70	0.025-0.035	0.045-0.055	0.05-0.06	0.06-0.07	0.07-0.08	0.08-0.09
M	Stainless steel	<1.5d1	<0.3d1	70-80	<0.5d1	50-70	0.025-0.035	0.035-0.055	0.055-0.06	0.06-0.065	0.065-0.07	0.07-0.08
S	Titanium alloy	<1.5d1	<0.2d1	40-50	<0.5d1	30-40	0.015-0.035	0.045-0.055	0.05-0.06	0.06-0.065	0.065-0.07	0.07-0.08
	Titanium	<1.5d1	<0.1d1	45-60	<0.3d1	35-45	0.012	0.015	0.019	0.025	0.034	0.042
	Heat resistant alloy	<1.5d1	0.05d1	30-40	<0.3d1	20-25	0.015	0.018	0.023	0.028	0.037	0.043

1. Cutting conditions to be adjusted according to cutting style, rigidity of machine and work clamping
2. For high alloyed steel (> 12% Cr), INOX, titanium alloy, cutting speed must be reduced by 20-30% when used emulsion