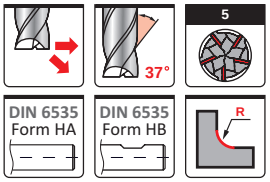
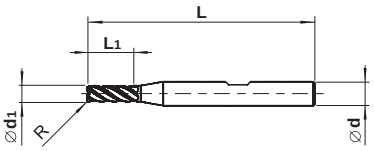
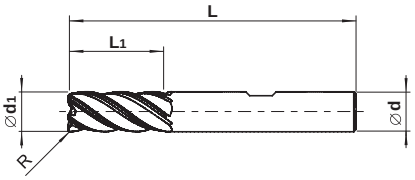
UMT 9545 Z=5

HPC end mills with irregular teeth for stainless steel and difficult to cut materials





Type 1



Type 2

d1 (h10)	L1	d (h6)	L	R(±0.02)	Type	Stock	ART No Shank Style DIN 6535 HA (nanoTEC2)	Stock	ART No Shank Style DIN 6535 HB (nanoTEC2)
3	8	6	57	0.2	1	●	9545030005702-2	○	9545030005702-2-HB
4	11	6	57	0.2	1	●	9545040005702-2	○	9545040005702-2-HB
5	13	6	57	0.3	1	●	9545050005703-2	○	9545050005703-2-HB
6	13	6	57	0.3	2	●	9545060005703-2	○	9545060005703-2-HB
8	19	8	63	0.4	2	●	9545080006304-2	○	9545080006304-2-HB
10	22	10	72	0.5	2	○	9545100007205-2	●	9545100007205-2-HB
12	26	12	83	0.5	2	○	9545120008305-2	●	9545120008305-2-HB
16	32	16	92	0.5	2	○	9545160009205-2	●	9545160009205-2-HB
20	38	20	104	0.5	2	○	9545200010405-2	●	9545200010405-2-HB

● In stock

○ Produced to order only

Recommended cutting conditions for end mills 9545 - 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	∅3	∅4	∅5	∅6	∅8	∅10	∅12	∅16	∅20
P	Carbon steel and Alloy steel < 25 HRC	<1.5d1	<0.4d1	150-180	<1d1 max 12mm	120-140	0.012	0.018	0.022	0.029	0.049	0.06	0.074	0.087	0.095
	Alloy steel and Tool steel 25-45 HRC	<1.5d1	<0.4d1	80-100	<0.7d1 max 12mm	70-90	0.01	0.015	0.018	0.022	0.036	0.045	0.055	0.067	0.075
M	Stainless steel	<1.5d1	<0.4d1	90-110	<0.5d1	70-90	0.008	0.01	0.014	0.017	0.03	0.037	0.043	0.05	0.058
S	Titanium alloy	<1d1	<0.3d1	60-70	<0.4d1	40-50	0.009	0.011	0.015	0.019	0.032	0.04	0.048	0.056	0.064
	Titanium	<1d1	<0.3d1	60-70	<0.4d1	40-50	0.007	0.009	0.013	0.016	0.025	0.034	0.04	0.046	0.052
	Heat resistant alloy	<1d1	<0.2d1	30-40	<0.4d1	20-25	0.006	0.008	0.01	0.012	0.02	0.024	0.028	0.034	0.04

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