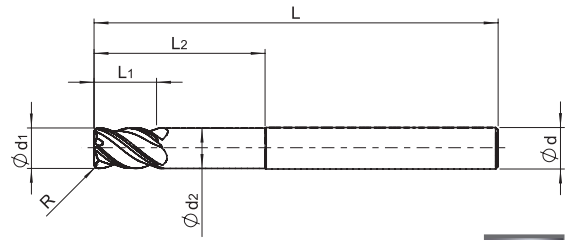
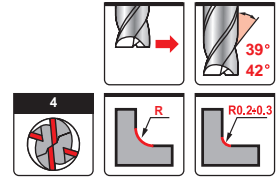


**UMT 9554 Z=4**

End mills with different helix angles, irregular teeth, short cutting length and relieved neck for difficult to cut materials



**nano  
TEC2**

d1 (e8)	L1	L2	d2	d (h6)	L	R(±0.02)	Stock	ART No
6	9	26	5.8	6	75		●	9554060007500-2
6	9	26	5.8	6	75	0.5	○	9554060007505-2
6	9	26	5.8	6	75	1.0	○	9554060007510-2
8	12	34	7.8	8	75		●	9554080007500-2
8	12	34	7.8	8	75	0.5	○	9554080007505-2
8	12	34	7.8	8	75	1.0	○	9554080007510-2
10	15	42	9.7	10	100		●	9554100010000-2
10	15	42	9.7	10	100	0.5	○	9554100010005-2
10	15	42	9.7	10	100	1.0	○	9554100010010-2
10	15	42	9.7	10	100	2.0	○	9554100010020-2
12	18	50	11.7	12	100		●	9554120010000-2
12	18	50	11.7	12	100	0.5	○	9554120010005-2
12	18	50	11.7	12	100	1.0	○	9554120010010-2
12	18	50	11.7	12	100	2.0	○	9554120010020-2
16	24	65	15.5	16	115		●	9554160011500-2
16	24	65	15.5	16	115	1.0	○	9554160011510-2
16	24	65	15.5	16	115	2.0	○	9554160011520-2
16	24	65	15.5	16	115	3.0	○	9554160011530-2
20	30	82	19.5	20	140		●	9554200014000-2
20	30	82	19.5	20	140	1.0	○	9554200014010-2
20	30	82	19.5	20	140	2.0	○	9554200014020-2
20	30	82	19.5	20	140	3.0	○	9554200014030-2

- In stock
- Produced to order only

**Recommended cutting conditions for end mills 9554 - Shoulder milling and slotting**

Work material	Cutting speed		Cutting speed		d1 - diameter in mm						
	Ap Ae	Vc (m/min)	Ap Ae	Vc (m/min)	nanoTEC2		fz - feed per tooth in mm				
	Ap	Ae	Ap	Ae	6	8	10	12	16	20	
<b>P</b> Carbon steel and Alloy steel < 25 HRC	<1d1	<0.4d1	100-130	<1d1 max 12mm	70-100	0.03-0.04	0.05-0.06	0.06-0.07	0.07-0.08	0.08-0.09	0.09-0.10
Alloy steel and Tool steel 25-45 HRC	<1d1	<0.3d1	50-70	<0.7d1 max 12mm	40-60	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	<1d1	<0.2d1	60-70	<0.5d1	40-60	0.025-0.035	0.035-0.055	0.055-0.06	0.06-0.065	0.065-0.07	0.07-0.08
<b>S</b> Titanium alloy	<1d1	<0.2d1	30-40	<0.5d1	25-35	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	<1d1	<0.1d1	35-50	<0.3d1	30-40	0.012	0.015	0.019	0.025	0.034	0.042
Heat resistant alloy	<1d1	<0.05d1	25-35	<0.3d1	15-20	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