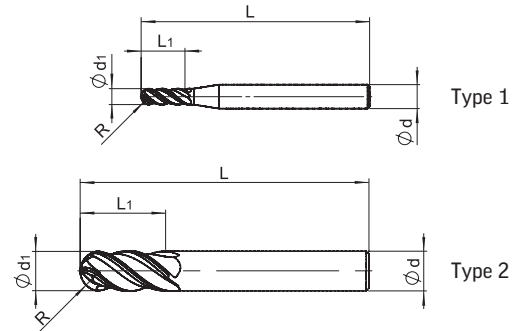
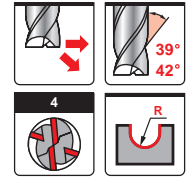


UMT 9644 Z=4

Ball nose end mills with different helix angles and irregular teeth for difficult to cut materials



nano
TEC2

d1 (e8)	L1	d (h6)	L	R (d1/2)	Stock	Type	ART No
3	8	6	57	1.5	●	1	9644030005700-2
4	11	6	57	2.0	●	1	9644040005700-2
5	13	6	57	2.5	●	1	9644050005700-2
6	13	6	57	3.0	●	2	9644060005700-2
8	19	8	63	4.0	●	2	9644080006300-2
10	22	10	72	5.0	●	2	9644100007200-2
12	26	12	83	6.0	●	2	9644120008300-2
16	32	16	92	8.0	○	2	9644160009200-2
20	38	20	104	10.0	○	2	9644200010400-2

- In stock
- Produced to order only

Recommended cutting conditions for end mills 9644

Work material			Cutting speed V _c (m/min)	d1 - diameter in mm						f _z - feed per tooth in mm		
	Ap	Ae		ø3	ø4	ø5	ø6	ø8	ø10	ø12	ø16	ø20
P Carbon steel and Alloy steel < 25 HRC	<0.2d ₁	<0.3d ₁	nanoTEC2 110-130	0.02	0.025	0.03	0.035	0.05	0.06	0.065	0.075	0.09
	Alloy steel and Tool steel 25-45 HRC	<0.2d ₁		<0.3d ₁	60-80	0.015	0.02	0.025	0.028	0.04	0.048	0.052
M Stainless steel	<0.15d ₁	<0.2d ₁	55-75	0.015	0.02	0.025	0.028	0.04	0.048	0.052	0.06	0.07
S Titanium alloy	<0.15d ₁	<0.2d ₁	55-75	0.015	0.02	0.025	0.028	0.04	0.048	0.052	0.06	0.07
	Titanium	<0.1d ₁	<0.2d ₁	40-60	0.012	0.015	0.018	0.02	0.03	0.035	0.04	0.05
Heat resistant alloy	<0.1d ₁	<0.1d ₁	25-35	0.01	0.012	0.015	0.018	0.025	0.032	0.038	0.046	0.055

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