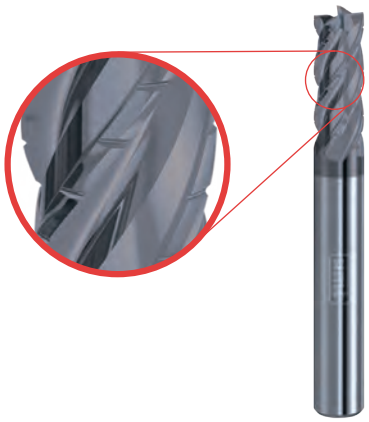
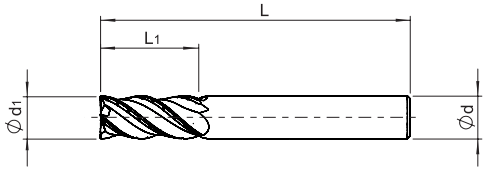
UMT 9744 Z=4 NEW

HPC Roughing end mills with different helix angles and irregular teeth for difficult to cut materials





nanoTEC2

d1 (e10)	L1	d (h6)	L	Stock	ART No
6	13	6	57	●	9744060005700-2
8	19	8	63	●	9744080006300-2
10	22	10	72	●	9744100007200-2
12	26	12	83	●	9744120008300-2
16	32	16	92	●	9744160009200-2
20	38	20	104	●	9744200010400-2

● In stock

Recommended cutting conditions for end mills 9744 - 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	<1.8d1	<0.4d1	80-140	<1d1 max 12mm	70-110	0.034	0.044	0.052	0.054	0.064	0.075
P	Alloy steel and Tool steel 25-45 HRC	<1.8d1	<0.3d1	60-90	<0.7d1 max 12mm	50-80	0.022	0.028	0.034	0.04	0.052	0.064
M	Stainless steel	<1.8d1	<0.25d1	50-90	<0.5d1	40-70	0.02	0.025	0.028	0.032	0.038	0.05
S	Titanium alloy	<1.8d1	<0.3d1	45-70	<1d1 max 12mm	30-50	0.025	0.034	0.04	0.05	0.065	0.074
S	Titanium	<1.8d1	<0.3d1	50-75	<0.8d1 max 12mm	35-55	0.025	0.034	0.04	0.05	0.065	0.074
S	Heat resistant alloy	<1.8d1	<0.15d1	20-40	<0.3d1	20-25	0.02	0.025	0.028	0.032	0.038	0.05

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