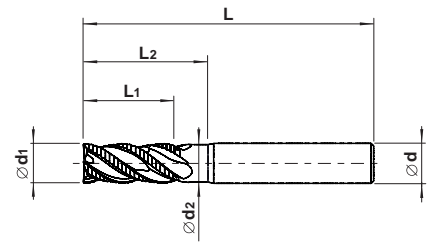
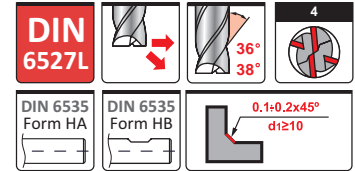


UMT 9764 Z-4 NEW

HPC Roughing end mills with different helix angles and irregular teeth for machining different types of steel



d1 (h10)	L1	L2	d2	d (h6)	L	nanoTEC1		nanoTEC1	
						Stock	ART No	Stock	ART No
						Shank Style DIN 6535 HA		Shank Style DIN 6535 HB	
6	13	21	5.5	6	57	●	9764060005700-1	○	9764060005700-1-HB
8	19	27	7.5	8	63	●	9764080006300-1	○	9764080006300-1-HB
10	22	32	9.3	10	72	○	9764100007200-1	●	9764100007200-1-HB
12	26	38	11.2	12	83	○	9764120008300-1	●	9764120008300-1-HB
14	26	38	13.2	14	83	○	9764140008300-1	○	9764140008300-1-HB
16	32	44	15.2	16	92	○	9764160009200-1	●	9764160009200-1-HB
18	32	44	17.2	18	92	○	9764180009200-1	○	9764180009200-1-HB
20	38	54	19.2	20	104	○	9764200010400-1	●	9764200010400-1-HB

- In stock
- Produced to order only

Recommended cutting conditions for end mills 9764 - 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 Ae	Vc (m/min)	ø6	ø8	ø10	ø12	ø14	ø16	ø18	ø20	
P Carbon steel and Alloy steel < 25 HRC	<1.8d1	<0.5d1	130-140	<1d1 max 12mm	100-120	0.03	0.04	0.047	0.052	0.058	0.061	0.063	0.067
Alloy steel and Tool steel 25-45 HRC	<1.8d1	<0.4d1	70-80	<0.7d1 max 12mm	55-75	0.025	0.035	0.042	0.047	0.052	0.055	0.06	0.065
M Stainless steel	<1.8d1	<0.3d1	50-60	<0.5d1	40-50	0.022	0.033	0.04	0.045	0.048	0.052	0.057	0.062
K Cast iron GG	<1.8d1	<0.5d1	110-140	<1d1 max 12mm	80-100	0.03	0.04	0.047	0.052	0.058	0.061	0.063	0.067
Nodular cast iron GGG	<1.8d1	<0.4d1	90-120	<0.7d1 max 12mm	60-80	0.025	0.035	0.042	0.047	0.052	0.055	0.06	0.065

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