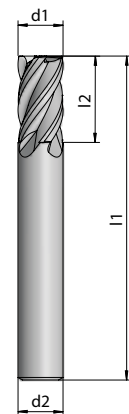
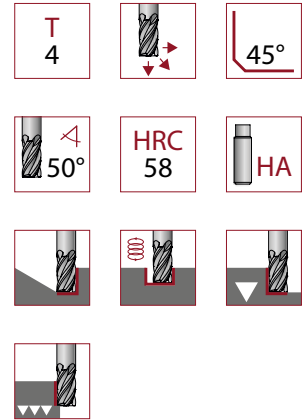


# SHANK END MILLS

## HPC | S 1130

Short version				
Article no.	d1	d2	l1	l2
11300400	4	4	48	8
11300500	5	6	48	10
11300600	6	6	50	12
11300800	8	8	57	16
11301000	10	10	66	20
11301200	12	12	76	24
11301600	16	16	90	32
11301800	18	18	94	36
11302000	20	20	98	40
11302500	25	25	120	50



Shoulder milling	$a_p \times a_e = 2d \times 0,5d$
Slot milling	$a_p \times a_e = 0,65d \times 1d$



Cutting data for short version		Shoulder	Slot	
Material	N/mm <sup>2</sup>	v <sub>c</sub> m/min		
<b>P</b>	Gen. structural/ case hard. steels 1.0037   1.0570   1.0503   1.7131	< 800	210	150
	Tool/ tempering steels 1.2367   1.2379   1.7225	< 1100	160	100
	Alloyed/ cold work steels 1.2312   1.2767   1.3505   1.7707	< 1400	100	–
<b>M</b>	Stainless steels 1.4301   1.4305   1.4034	< 750	120	–
	Stainless steels 1.4435   1.4571	< 850	90	–
<b>K</b>	Cast iron GG25   GG40   GGG40	< 450	200	130
	Spherical cast iron GGG50   GGG60   GGG70	< 650	150	100
<b>H</b>	Hardened steel HRC 45–50	–	60–80	50–70
	Hardened steel HRC 51–58	–	50–70	40–60

d1	Shoulder	Slot
	fz mm	
4	0,035	0,010
5	0,040	0,015
6	0,050	0,025
8	0,060	0,030
10	0,070	0,040
12	0,100	0,060
16	0,110	0,070
18	0,120	0,090
20	0,150	0,100
25	0,160	0,110