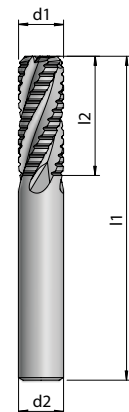
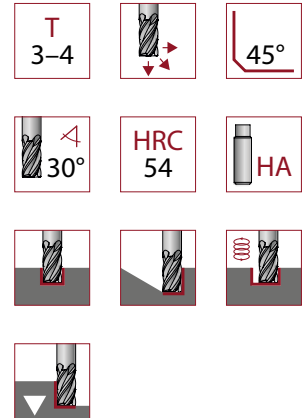


SHANK END MILLS

UNIVERSAL ROUGHING END MILLS | S 1030

Short version Number of teeth 3				
Article no.	d1	d2	l1	l2
10300600	6	6	57	10
10300800	8	8	63	16

Short version Number of teeth 4				
Article no.	d1	d2	l1	l2
10301000	10	10	72	22
10301200	12	12	83	26
10301400	14	14	83	26
10301600	16	16	92	32
10301800	18	18	92	34
10302000	20	20	104	38
10302500	25	25	125	48



Shoulder milling	$a_p \times a_e = 1d \times 0,4d$
Slot milling	$a_p \times a_e = 0,65d \times 1d$



Cutting data for short version		Shoulder	Slot	
Material	N/mm ²	v _c m/min		
P	Gen. structural/ case hard. steels 1.0037 1.0570 1.0503 1.7131	< 800	170	120
	Tool/ tempering steels 1.2367 1.2379 1.7225	< 1100	130	90
	Alloyed/ cold work steels 1.2312 1.2767 1.3505 1.7707	< 1400	80	-
	Cast steel 1.0619 1.0446	-	130-170	110-140
M	Stainless steels 1.4301 1.4305 1.4034	< 750	120-140	80-130
	Stainless steels 1.4435 1.4571	< 850	80-120	60-90
K	Cast iron GG25 GG40 GGG40	< 450	230	150
	Spherical cast iron GGG50 GGG60 GGG70	< 650	140-180	100-150
S	Titanium alloys 3.7164 3.7165	-	50	40
	Nickel alloys Inconel 713	-	50	40

d1	Shoulder	Slot
	fz mm	
6	0,050	0,035
8	0,060	0,040
10	0,080	0,055
12	0,090	0,065
14	0,100	0,080
16	0,120	0,090
18	0,140	0,100
20	0,150	0,110
25	0,160	0,120