

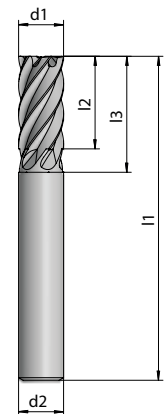
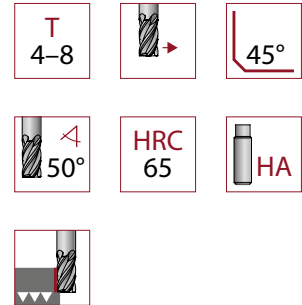
# SHANK END MILLS

## HPC FINISHING END MILLS | S 1170

Short version   Number of teeth 4					
Article no.	d1	d2	l1	l2	l3
11700300	3	6	50	9	-
11700350	3,5	6	50	10	-
11700400	4	6	52	12	-
11700450	4,5	6	54	14	-
11700500	5	6	56	15	-

Short version   Number of teeth 6					
Article no.	d1	d2	l1	l2	l3
11700600	6	6	58	18	22
11700800	8	8	65	24	29
11701000	10	10	76	30	36
11701200	12	12	88	36	43

Short version   Number of teeth 8					
Article no.	d1	d2	l1	l2	l3
11701600	16	16	105	48	56
11701800	18	18	114	54	62
11702000	20	20	118	60	68
11702500	25	25	145	75	87



Shoulder milling  $a_p \times a_e = 2d \times 0,04d$



Cutting data for short version		Shoulder	
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 Tool/ tempering steels 1.2367   1.2379   1.7225 Alloyed/ cold work steels 1.2312   1.2767   1.3505   1.7707	< 800	170	
	< 1100	120	
	< 1400	90	
<b>M</b> Stainless steels 1.4301   1.4305   1.4034 Stainless steels 1.4435   1.4571	< 750	100	
	< 850	80	
<b>K</b> Cast iron GG25   GG40   GGG40 Spherical cast iron GGG50   GGG60   GGG70	< 450	230	
	< 650	160	

Shoulder	
d1	fz mm
3	0,020
3,5	0,020
4	0,025
4,5	0,025
5	0,030
6	0,040
8	0,050
10	0,060
12	0,070
16	0,075
18	0,080
20	0,085
25	0,090