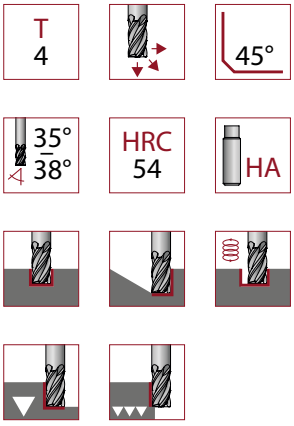
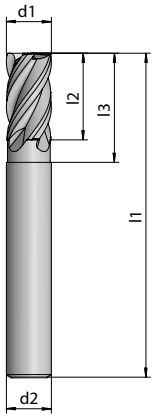
SHANK END MILLS
HPC | S 1025

BOGERBENZ

Short version					
Article no.	d1	d2	l1	l2	l3
10250400	4	6	57	11	19
10250500	5	6	57	13	21
10250600	6	6	57	13	21
10250800	8	8	63	19	27
10251000	10	10	72	24	32
10251200	12	12	83	28	36
10251400	14	14	83	29	37
10251600	16	16	92	35	43
10252000	20	20	104	44	54
10252500	25	25	125	52	65





Shoulder milling	a_p x a_e = 1d x 0.3d
Slot milling	a_p x a_e = 0.65d x 1d

Cutting data for short version			Shoulder	Slot
Material		N/mm²	v_c m/min	
P	Gen. structural/ case hard. steels 1.0037 | 1.0570 | 1.0503 | 1.7131	< 800	150	130
	Tool/ tempering steels 1.2367 | 1.2379 | 1.7225	< 1100	130	100
	Alloyed/ cold work steels 1.2312 | 1.2767 | 1.3505 | 1.7707	< 1400	100	–
M	Stainless steels 1.4301 | 1.4305 | 1.4034	< 750	100	–
	Stainless steels 1.4435 | 1.4571	< 850	75	–
K	Cast iron GG25 | GG40 | GGG40	< 450	160	130
	Spherical cast iron GGG50 | GGG60 | GGG70	< 650	120	100

	Shoulder	Slot
d1	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	0.080	0.060
14	0.080	0.060
16	0.090	0.070
20	0.100	0.080
25	0.100	0.080