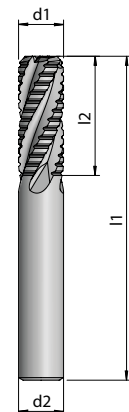
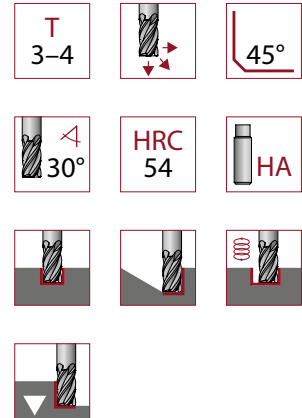


# SHANK END MILLS CORD TOOTHED

## 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 <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	140	110
	Tool/ tempering steels 1.2367   1.2379   1.7225	< 1100	110	80
	Alloyed/ cold work steels 1.2312   1.2767   1.3505   1.7707	< 1400	80	-
	Cast steel 1.0619   1.0446	-	130-170	80-130
<b>M</b>	Stainless steels 1.4301   1.4305   1.4034	< 750	70-100	50-85
	Stainless steels 1.4435   1.4571	< 850	70-100	50-85
<b>K</b>	Cast iron GG25   GG40   GGG40	< 450	100-150	80-130
	Spherical cast iron GGG50   GGG60   GGG70	< 650	100-150	80-130
<b>S</b>	Titanium alloys 3.7164   3.7165	-	50	35
	Nickel alloys Inconel 713	-	50	35

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