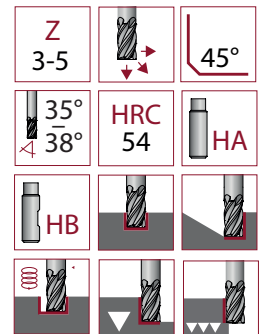
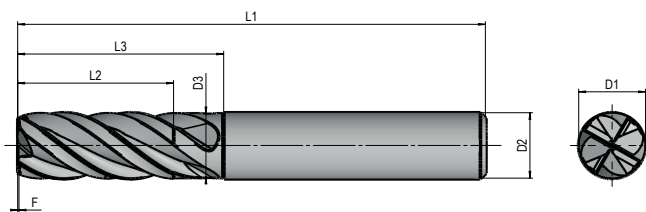


SHANK END MILL

SC CW90



SC CW90

Article	D ₁	D ₂	D ₃	L ₁	L ₂	L ₃	F	Z _{eff}	Center cutting	ic	Shank form	Kg
22T.0613.001	6	6	5,7	58	13	22	0,20x45°	4	yes	no	HA	0,02
22T.0613.002	6	6	5,7	58	13	22	0,20x45°	4	yes	no	HB	0,02
22T.0819.001	8	8	7,7	64	19	28	0,20x45°	4	yes	no	HA	0,04
22T.0819.002	8	8	7,7	64	19	28	0,20x45°	4	yes	no	HB	0,04
22T.1024.001	10	10	9,7	73	24	33	0,20x45°	4	yes	no	HA	0,07
22T.1024.002	10	10	9,7	73	24	33	0,20x45°	4	yes	no	HB	0,07
22T.1228.001	12	12	11,6	84	28	38	0,25x45°	4	yes	no	HA	0,12
22T.1228.002	12	12	11,6	84	28	38	0,25x45°	4	yes	no	HB	0,12
22T.1429.001	14	14	13,6	84	29	38	0,25x45°	4	yes	no	HA	0,17
22T.1429.002	14	14	13,6	84	29	38	0,25x45°	4	yes	no	HB	0,17
22T.1635.001	16	16	15,5	93	35	44	0,30x45°	4	yes	no	HA	0,24
22T.1635.002	16	16	15,5	93	35	44	0,30x45°	4	yes	no	HB	0,24

Shoulder milling $a_p \times a_e = 1d \times 0,3d$



Cutting data		Shoulder	
Material	N/mm ²	v _c m/min	
M stainless steels 1.4301 1.4305 1.4034 stainless steels 1.4435 1.4571	< 750	100	
	< 850	75	
S titanium alloys 3.7164 3.7165 nickel alloys inconel	–	50	
	–	50	
H hardened steel HRC 45–50	–	60-80	
hardened steel HRC 51–58	–	50-70	

Shoulder	
d1	fz mm
6	0,035
8	0,040
10	0,050
12	0,060
14	0,070
16	0,100