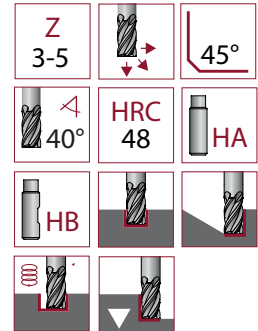
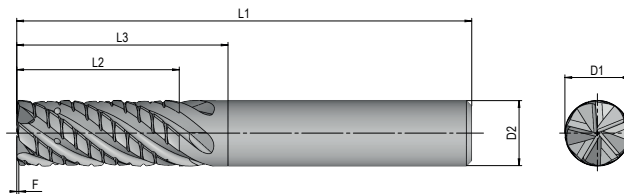


# SHANK END MILL CORD TOOTHED

## SC UW90



### SC UW90

Article	D1	D2	L1	L2	L3	F	Z <sub>eff</sub>	Center cutting	ic	Shaft form	Kg
22W.0614.001	6	6	58	14	22	0,20x45°	3	yes	yes	HA	0,02
22W.0614.002	6	6	58	14	22	0,20x45°	3	yes	yes	HB	0,02
22W.0816.001	8	8	64	16	28	0,20x45°	3	yes	yes	HA	0,04
22W.0816.002	8	8	64	16	28	0,20x45°	3	yes	yes	HB	0,04
22W.1024.001	10	10	73	24	33	0,20x45°	4	yes	yes	HA	0,07
22W.1024.002	10	10	73	24	33	0,20x45°	4	yes	yes	HB	0,07
22W.1230.001	12	12	84	30	38	0,25x45°	5	yes	yes	HA	0,12
22W.1230.002	12	12	84	30	38	0,25x45°	5	yes	yes	HB	0,12
22W.1432.001	14	14	84	32	38	0,25x45°	5	yes	yes	HA	0,17
22W.1432.002	14	14	84	32	38	0,25x45°	5	yes	yes	HB	0,17
22W.1632.001	16	16	93	32	45	0,30x45°	5	yes	yes	HA	0,24
22W.1632.002	16	16	93	32	45	0,30x45°	5	yes	yes	HB	0,24
22W.1836.001	18	18	93	36	45	0,40x45°	5	yes	yes	HA	0,30
22W.1836.002	18	18	93	36	45	0,40x45°	5	yes	yes	HB	0,30

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



Cutting data			Shoulder	
Material	N/mm <sup>2</sup>	v <sub>c</sub> m/min	d1	fz mm
<b>M</b> stainless steels 1.4301   1.4305   1.4034 stainless steels 1.4435   1.4571	< 750	120-140	6	0,050
	< 850	80-120	8	0,060
<b>S</b> titanium alloys 3.7164   3.7165 nickel alloys inconel	-	50	10	0,080
	-	50	12	0,090
<b>H</b> hardened steel HRC 45-50 hardened steel HRC 51-58 hardened steel HRC 59-65	-	250	14	0,100
	-	210	16	0,120
	-	170	18	0,140

Shoulder	
d1	fz mm
6	0,050
8	0,060
10	0,080
12	0,090
14	0,100
16	0,120
18	0,140