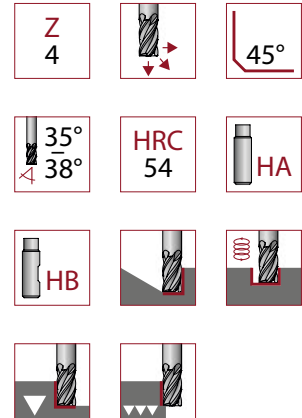


SHANK END MILLS

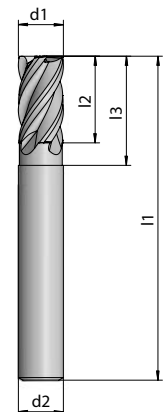
HPC | S 1025

Short version						
Article no.	d1	d2	l1	l2	l3	Euro
10250400	4	6	57	11	19	24,00
10250500	5	6	57	13	21	24,00
10250600	6	6	57	13	21	24,00
10250800	8	8	63	19	27	33,00
10251000	10	10	72	24	32	43,00
10251200	12	12	83	28	36	68,00
10251400	14	14	83	29	37	91,00
10251600	16	16	92	35	43	123,00
10252000	20	20	104	44	54	163,00
10252500	25	25	125	52	65	282,00



For Weldon add abbreviation HB.

Example 10250400 becomes 10250400HB



Shoulder milling $a_p \times a_e = 1d \times 0.3d$



Cutting data for short version		Shoulder	
Material	N/mm ²	v _c m/min	
P	Gen. structural/ case hard. steels 1.0037 1.0570 1.0503 1.7131	< 800	150
	Tool/ tempering steels 1.2367 1.2379 1.7225	< 1100	130
	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
	Spherical cast iron GGG50 GGG60 GGG70	< 650	120

Shoulder	
d1	fz mm
4	0.035
5	0.040
6	0.050
8	0.060
10	0.070
12	0.080
14	0.080
16	0.090
20	0.100
25	0.100