

# SHANK END MILLS

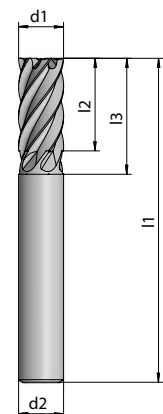
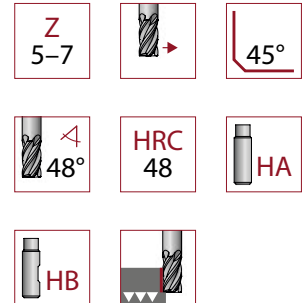
## FINISHING END MILLS | S 1040

Short version   Number of teeth 5						
Article no.	d1	d2	l1	l2	l3	Euro
10400601	6	6	56	12	20	28,00
10400801	8	8	62	16	26	29,00
10401001	10	10	85	20	40	56,00
10401201	12	12	86	24	40	77,00

Long version   Number of teeth 5						
Article no.	d1	d2	l1	l2	l3	Euro
10400600	6	6	62	18	26	30,00
10400800	8	8	70	24	34	31,00
10401000	10	10	98	30	50	70,00
10401200	12	12	98	36	52	92,00

Short version   Number of teeth 7						
Article no.	d1	d2	l1	l2	l3	Euro
10401601	16	16	86	32	38	135,00
10401801	18	18	90	36	42	164,00
10402001	20	20	98	40	48	177,00
10402501	25	25	117	50	61	323,00

Long version   Number of teeth 7						
Article no.	d1	d2	l1	l2	l3	Euro
10401600	16	16	102	48	54	154,00
10401800	18	18	108	54	60	178,00
10402000	20	20	118	60	68	191,00
10402500	25	25	142	75	86	338,00



For Weldon add abbreviation HB.  
Example 10400601 becomes 10400601HB

Shoulder milling  $a_p \times a_e = 2.5d \times 0.4d$



Cutting data for short version			Shoulder	
Material	N/mm <sup>2</sup>	v <sub>c</sub> m/min	d1	fz mm
<b>P</b> Gen. structural/ case hard. steels 1.0037   1.0570   1.0503   1.7131 Tool/ tempering steels 1.2367   1.2379   1.7225 Alloyed/ cold work steels 1.2312   1.2767   1.3505   1.7707	< 800	120	6	0.020
	< 1100	100	8	0.025
	< 1400	70	10	0.030
<b>M</b> Stainless steels 1.4301   1.4305   1.4034	< 750	70	12	0.040
<b>N</b> Copper/ brass/ bronze 2.0321   2.1030 Medium hard/ soft plastics	-	230	16	0.055
	-	200-300	18	0.065
			20	0.075
			25	0.080

Shoulder	
d1	fz mm
6	0.020
8	0.025
10	0.030
12	0.040
16	0.055
18	0.065
20	0.075
25	0.080