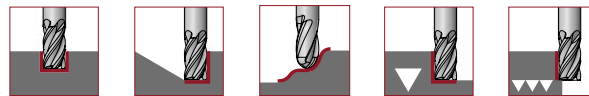


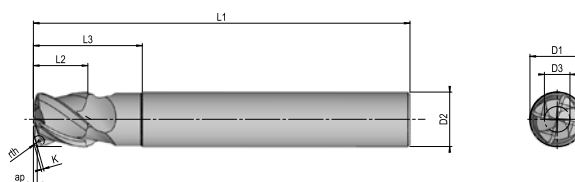
SOLID CARBIDE MILLS

SC UD90



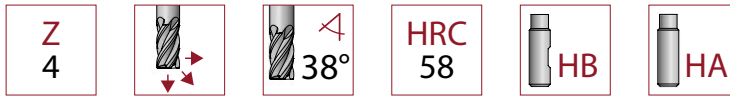
NEWTool

Highly dynamic high feed milling cutter
for extreme feed rates
Especially suitable for difficult-to-cut materials



SC UD90

Article	D ₁	D ₂	D ₃	L ₁	L ₂	L ₃	z	r _{th}	a _p	K	lc	Shank	kg
22U.0606.001	6	6	2.0	58	6	12	4	0.9	0.40	0.22	no	HA	0.02
22U.0606.002	6	6	2.0	58	6	12	4	0.9	0.40	0.22	no	HB	0.02
22U.0808.001	8	8	3.5	64	8	16	4	1.0	0.50	0.26	no	HA	0.04
22U.0808.002	8	8	3.5	64	8	16	4	1.0	0.50	0.26	no	HB	0.04
22U.1010.001	10	10	4.8	73	10	20	4	1.1	0.60	0.33	no	HA	0.08
22U.1010.002	10	10	4.8	73	10	20	4	1.1	0.60	0.33	no	HB	0.08
22U.1212.001	12	12	5.6	84	12	24	4	1.2	0.75	0.45	no	HA	0.13
22U.1212.002	12	12	5.6	84	12	24	4	1.2	0.75	0.45	no	HB	0.13
22U.1414.001	14	14	6.5	84	14	28	4	1.4	0.90	0.56	no	HA	0.17
22U.1414.002	14	14	6.5	84	14	28	4	1.4	0.90	0.56	no	HB	0.17
22U.1616.001	16	16	7.0	93	16	32	4	1.6	1.10	0.71	no	HA	0.25
22U.1616.002	16	16	7.0	93	16	32	4	1.6	1.10	0.71	no	HB	0.25



Shoulder milling

$$a_p \times a_e = 0.04d \times 0.65d$$

Shoulder	
D ₁	fz mm
6	0.250
8	0.320
10	0.350
12	0.400
14	0.480
16	0.550



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	200
	Tool/ tempering steels 1.2367 1.2379 1.7225	< 1100	180
	Alloyed/ cold work steels 1.2312 1.2767 1.3505 1.7707	< 1400	120
M	Stainless steels 1.4301 1.4305 1.4034	< 750	120
	Stainless steels 1.4435 1.4571	< 850	90
H	Hardened steel HRC 45–50	–	180
	Hardened steel HRC 51–58	–	120
	Hardened steel HRC 59–65	–	90

All cutting values are for guidance only. Feed rates in prehardened and stainless materials must be reduced by 25%.