

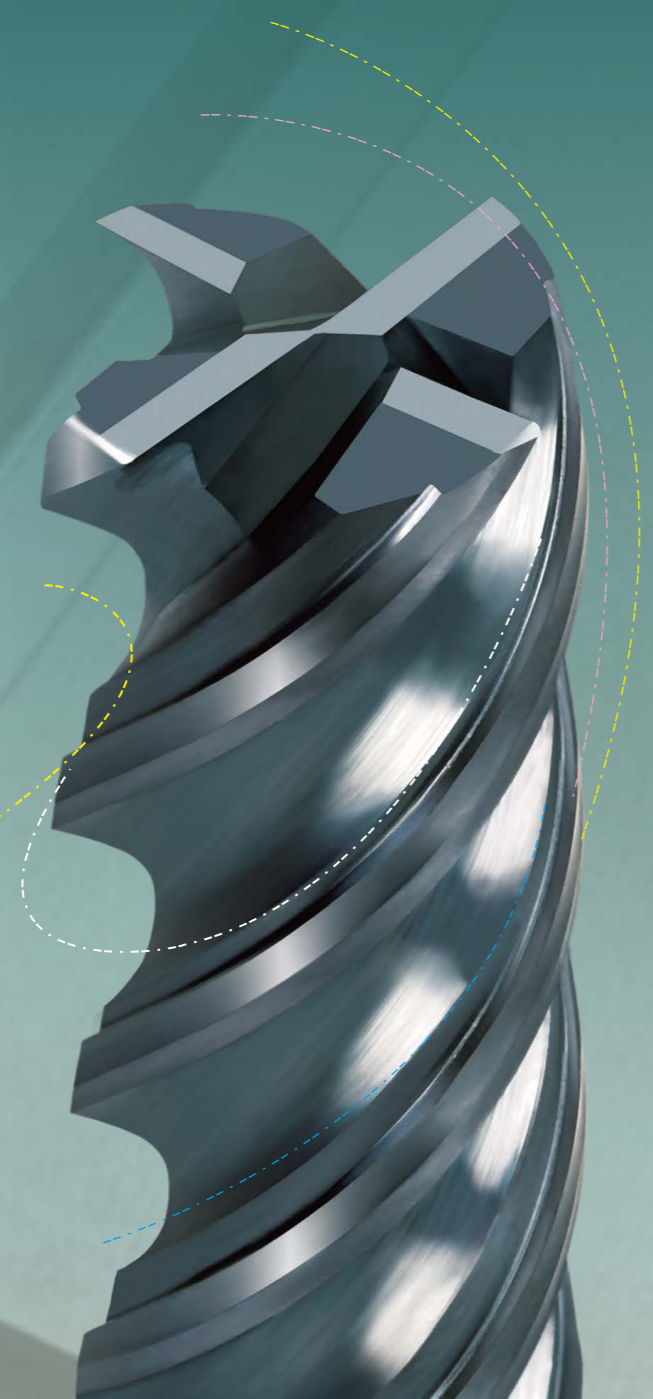
HI-EFFICIENCY END MILLS FOR NI-BASED STAINLESS STEEL

镍基不锈钢 高效加工铣刀

Multi-Function: Integrate the slotting/side milling, the functions of roughing/finishing as one unit.

Hi-Efficiency: Distinctive Geometry makes the chip removal optimized. Unequal Index eliminates the Harmonic Vibration in operation, which enables the increase of cutting depth, cutting width and feed significantly. Thusly, the slotting efficiency can be increased in 3-4 times and side milling in more than 50%.

Ultra-Precision: The High Helix & Anti-Vibration Geometry makes the machining stable and smooth, improves the workpiece's finish and precision ultra better.



Carbide End Mills

High Efficiency End Mills for Ni-Based Stainless Steel

Four Flute Standard 四齿标准型



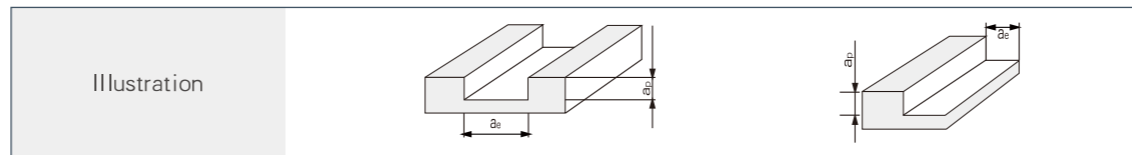
Type & Specifications/类型与规格

D1	D2	L2	L1	Corner Radius	Flute No.	Orde No.
	h6	js14	js14			
4	4	8	50	0.3	4	C4UHZA040004-03
5	6	10	50	0.3	4	C4UHZA050006-03
6	6	12	50	0.3	4	C4UHZA060006-03
8	8	16	60	0.3	4	C4UHZA080008-03
10	10	20	75	0.4	4	C4UHZA100010-04
12	12	25	75	0.5	4	C4UHZA120012-05
16	16	40	100	0.7	4	C4UHZA160016-07
20	20	40	100	1.0	4	C4UHZA200020-10

Recommendation/推荐切削条件

Slotting Diameter	Carbon Steel		Alloy Steel		Hardened Steel		Ni-Based Stainless Steel	
	Speed	Feed	Speed	Feed	Speed	Feed	Speed	Feed
D1 (mm)	n (R/min)	Vf (mm/min)	n (R/min)	Vf (mm/min)	n (R/min)	Vf (mm/min)	n (R/min)	Vf (mm/min)
4	9000	1000	6000	560	3900	400	4000	450
5	7200	1000	4800	620	3120	380	3250	420
6	6000	1000	4000	640	2600	370	2700	400
8	4600	1000	3000	580	1900	360	2030	330
10	3600	1000	2400	550	1400	300	1600	300
12	2860	830	2000	450	1150	270	1300	280
16	2100	530	1500	360	880	180	1000	210
20	1680	450	1200	310	715	160	800	160
ap (Depth)	ap=1.0D		ap=1.0D		ap=0.5D		ap=0.5D	
ae (Width)	ae=1.0D		ae=1.0D		ae=1.0D		ae=1.0D	

Side milling Diameter	Carbon Steel		Alloy Steel		Hardened Steel		Ni-Based Stainless Steel	
	Speed	Feed	Speed	Feed	Speed	Feed	Speed	Feed
D1 (mm)	n (R/min)	Vf (mm/min)	n (R/min)	Vf (mm/min)	n (R/min)	Vf (mm/min)	n (R/min)	Vf (mm/min)
4	9200	600	8700	1390	5025	300	5400	400
5	7500	610	6960	1390	4000	300	4400	400
6	6250	620	5800	1400	3350	300	3680	400
8	4680	630	4400	1300	2550	285	2760	360
10	3715	650	3500	1200	2150	285	2200	320
12	3150	570	3000	1100	1750	265	1850	280
16	2350	430	2250	810	1300	190	1380	230
20	1900	350	1750	630	1050	170	1050	190
ap (Depth)	ap=2.0D		ap=2.0D		ap=2.0D		ap=2.0D	
ae (Width)	ae=0.3D		ae=0.3D		ae=0.15D		ae=0.15D	



- ⊙ Please optimize the over-hang
- ⊙ Be in climb milling. Please lower the recommendations simultaneously in case cutting tools shake badly
- ⊙ Please use suitable coolants

Work Materials/被加工材质

Steels			Cast Iron	Aluminium Alloys	Copper Alloys	Stainless Steel	Titanium Alloys	Graphite
<HRC45	<HRC60	<HRC65						
○						⊙	○	
⊙ Preferential ○ Suitable								

High Efficiency End Mills for Ni-Based Stainless Steel

Four Flute Long Length 四齿加长型



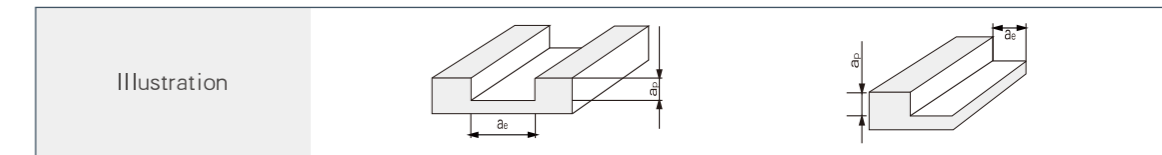
Type & Specifications/类型与规格

D1	D2	L2	L1	D3	L3	Corner Radius	Flute No.	Orde No.
	h6	js14	js14					
6	6	17	60	5.7	28	0.3	4	C4UHGA060006-03
8	8	22	75	7.7	32	0.3	4	C4UHGA080008-03
10	10	30	90	9.5	45	0.4	4	C4UHGA100010-04
12	12	33	90	11.5	45	0.5	4	C4UHGA120012-05
16	16	45	110	15.0	64	0.7	4	C4UHGA160016-07
20	20	50	120	19.0	75	1.0	4	C4UHGA200020-10

Recommendation/推荐切削条件

Slotting Diameter	Carbon Steel		Alloy Steel		Hardened Steel		Ni-Based Stainless Steel	
	Speed	Feed	Speed	Feed	Speed	Feed	Speed	Feed
D1 (mm)	n (R/min)	Vf (mm/min)	n (R/min)	Vf (mm/min)	n (R/min)	Vf (mm/min)	n (R/min)	Vf (mm/min)
6	6000	1000	4000	640	2600	370	2700	400
8	4600	1000	3000	580	1900	360	2030	330
10	3600	1000	2400	550	1400	300	1600	300
12	2860	830	2000	450	1150	270	1300	280
16	2100	530	1500	360	880	180	1000	210
20	1680	450	1200	310	715	160	800	160
ap (Depth)	ap=1.0D		ap=1.0D		ap=0.5D		ap=0.5D	
ae (Width)	ae=1.0D		ae=1.0D		ae=1.0D		ae=1.0D	

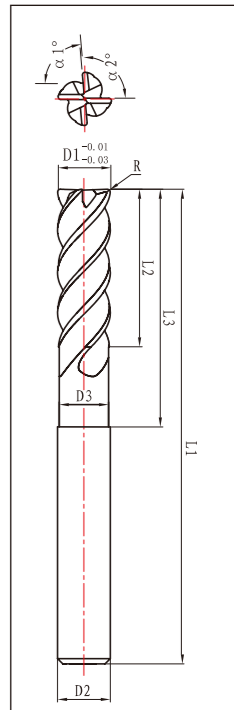
Side milling Diameter	Carbon Steel		Alloy Steel		Hardened Steel		Ni-Based Stainless Steel	
	Speed	Feed	Speed	Feed	Speed	Feed	Speed	Feed
D1 (mm)	n (R/min)	Vf (mm/min)	n (R/min)	Vf (mm/min)	n (R/min)	Vf (mm/min)	n (R/min)	Vf (mm/min)
6	6250	620	5800	1400	3350	300	3680	400
8	4680	630	4400	1300	2550	285	2760	360
10	3715	650	3500	1200	2150	285	2200	320
12	3150	570	3000	1100	1750	265	1850	280
16	2350	430	2250	810	1300	190	1380	230
20	1880	390	1800	720	1040	170	1100	200
ap (Depth)	ap=1.0D		ap=1.0D		ap=1.5D		ap=1.5D	
ae (Width)	ae=0.45D		ae=0.2D		ae=0.2D		ae=0.2D	



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Work Materials/被加工材质

Steels			Cast Iron	Aluminium Alloys	Copper Alloys	Stainless Steel	Titanium Alloys	Graphite
<HRC45	<HRC60	<HRC65						
○						⊙	○	
⊙ Preferential ○ Suitable								



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