

END MILL for TITANIUM

**钛合金
专用加工铣刀**

Hi-Efficiency: Vari Helix & Unequal Index eliminates the Harmonic Vibration in operation, which helps on the efficiency of Slotting/Side Milling significantly. Meanwhile, the most reliable Balzers is coated. Suitable for efficiently roughing or finishing of Titanium & Heat Resistant Alloy.



Carbide End Mills

08 End Mills for Titanium

HEYE & SUMMIT TOOLS

Four Flute Standard
四齿标准型

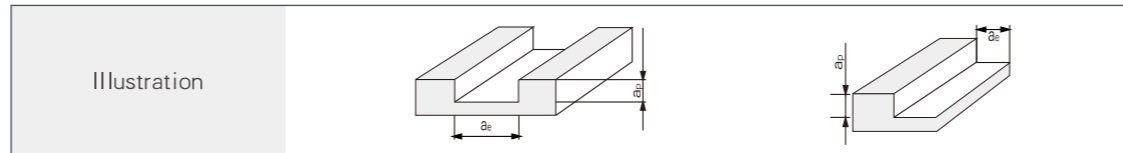


Type & Specifications/类型与规格

D1	D2	L2	L1	Corner Radius	Flute No.	Orde No.
	h6	js14	js14			
4	6	10	50	0.5	4	C4SUTL040006-05
5	6	12	50	0.5	4	C4SUTL050006-05
6	6	15	50	0.5	4	C4SUTL060006-05
6	6	15	50	1.0	4	C4SUTL060006-10
8	8	20	60	0.5	4	C4SUTL080008-05
8	8	20	60	1.0	4	C4SUTL080008-10
10	10	25	75	0.5	4	C4SUTL100010-05
10	10	25	75	1.0	4	C4SUTL100010-10
12	12	30	75	1.0	4	C4SUTL120012-10
12	12	30	75	2.0	4	C4SUTL120012-20
16	16	40	100	1.0	4	C4SUTL160016-10
16	16	40	100	2.0	4	C4SUTL160016-20
20	20	45	100	1.0	4	C4SUTL200020-10
20	20	45	100	2.0	4	C4SUTL200020-20

Recommendation/推荐切削条件

Diameter	Titanium Alloy			
	Slotting		Side Milling	
	Speed	Feed	Speed	Feed
D1 (mm)	n (R/min)	Vf (mm/min)	n (R/min)	Vf (mm/min)
4	2787	110	3180	190
5	2229	134	2550	200
6	1858	110	2120	170
8	1393	139	1590	160
10	1115	134	1270	180
12	929	110	1060	150
16	697	110	795	140
20	557	100	635	145
ap (Depth)	ap=0.2D		ap=1.5D	
ae (Width)	ae=1.0D		ae=0.1D	



- 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								

HEYE & SUMMIT TOOLS

09 End Mills for Titanium

09

Four Flute Long Length
四齿加长型

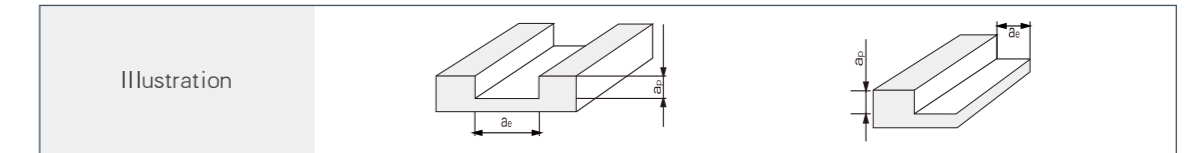


Type & Specifications/类型与规格

D1	D2	L2	L1	D3	L3	Corner Radius	Flute No.	Orde No.
	h6	js14	js14					
6	6	20	75	5.7	35	0.5	4	C4SUVL060006-05
6	6	20	75	5.7	35	1.0	4	C4SUVL060006-10
8	8	25	75	7.7	35	0.5	4	C4SUVL080008-05
8	8	25	75	7.7	35	1.0	4	C4SUVL080008-10
10	10	30	100	9.7	50	0.5	4	C4SUVL100010-05
10	10	30	100	9.7	50	1.0	4	C4SUVL100010-10
12	12	35	100	11.5	50	1.0	4	C4SUVL120012-10
12	12	35	100	11.5	50	2.0	4	C4SUVL120012-20
16	16	45	150	15.0	70	1.0	4	C4SUVL160016-10
16	16	45	150	15.0	70	2.0	4	C4SUVL160016-20
20	20	50	150	19.0	70	1.0	4	C4SUVL200020-10
20	20	50	150	19.0	70	2.0	4	C4SUVL200020-20

Recommendation/推荐切削条件

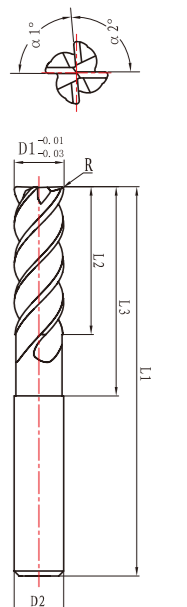
Diameter	Titanium Alloy			
	Slotting		Side Milling	
	Speed	Feed	Speed	Feed
D1 (mm)	n (R/min)	Vf (mm/min)	n (R/min)	Vf (mm/min)
6	1765	88	2014	145
8	1323	111	1511	136
10	1059	107	1207	153
12	883	88	1007	128
16	662	88	755	123
20	529	80	603	119
ap (Depth)	ap=0.2D		ap=1.5D	
ae (Width)	ae=1.0D		ae=0.1D	



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Work Materials/被加工材质

Steels			Cast Iron	Aluminium Alloys	Copper Alloys	Stainless Steel	Titanium Alloys	Graphite
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◎ Preferential ○ Suitable								



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