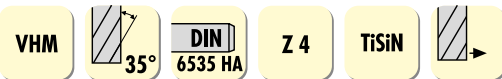


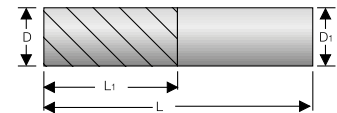
SPECIAL OFFER

PROMOTIONAL PERIOD VALID UNTIL 31/10/2024

End milling cutter set, 4-piece



- 4 cutting edges, right-cutting
- Eccentric relief grinding
- Cutting material: superfine grain solid carbide



Application	Very well suited	Steel			Stainless steel			Cast iron		Titanium alloys	Super alloys Fe/NiCo-based		Aluminium		Copper	Graphite	Hardened steel			
	○ well suited	< 700 N/mm ²	< 1,000 N/mm ²	< 1,400 N/mm ²	Ferrit./martens.	Austenitic	Duplex	GG/GTS	GGG		< 30 HRC	≥ 30 HRC	< 8% Si	≥ 8% Si	Cu alloy	GRP/CFP/thermo.	< 55 HRC	< 60 HRC	≥ 60 HRC	
		●	●	●		●		●	●											
		140	130	120		60		120	100											

Cutting speed Vc m/min. Please adjust these guideline values according to clamping operation and machine set-up!



D	L1	L	D1	Article no.	€
mm	mm	mm	mm		
6	15	50	6	251005 0001	59.00
8	20	60	8		
10	25	75	10		
12	30	75	12		

Cutting data recommendations

- Please adjust these guideline values according to clamping operation and machine set-up.

ISO	Materials group	Strength/ Hardness N/mm ²	Material chemical example	Material number	Cutting speed Vc m/min	Feed rate fz in mm/Z in relation to milling cutter diameter in mm			
						6	8	10	12
P	Machining steel	up to 700	9 SMn 28	1.0715	105	0.045	0.049	0.053	0.057
	Unalloyed structural steel	up to 700	St-52	1.0052	105	0.045	0.049	0.053	0.057
	Structural steel	700 - 950	Ck45	1.1191	105	0.045	0.049	0.053	0.057
	Cast steel	up to 950	GS 40	1.0416	100	0.043	0.049	0.053	0.057
	Case-hardening steel	up to 1200	16 MnCr 5	1.7131	90	0.043	0.047	0.051	0.055
	Tempering steel	950 - 1300	42CrMo4-QT	1.7225	90	0.043	0.047	0.051	0.055
	Nitriding steel	950 - 1300	31CrMoV9	1.8519	80	0.041	0.045	0.049	0.053
	Tool steel	950 - 1400	X 38 CrMoV 5 1	1.2343	70	0.035	0.039	0.044	0.047
M	Stainless steel, austenitic	500 - 950	X10Cr13	1.4006	40	0.054	0.056	0.058	0.060
K	Grey cast iron	up to 260 HB	GG 25	0.6025	85	0.043	0.047	0.051	0.054
	alloyed grey cast iron	Up to 310 HB	GGL-NiCr 35 2	0.6678	90	0.042	0.045	0.047	0.049
	Ductile iron	up to 280 HB	GGG 60	0.7060	100	0.042	0.045	0.047	0.049
	Malleable cast iron	up to 280 HB	GTS 55	0.8155	105	0.042	0.045	0.047	0.049
H	Hardened materials up to 50 HRC		X40Cr14	1.2083	50	0.017	0.020	0.022	0.023

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