

**Short Series**

Stock	Code	dH9	dZh6	L1	L2	Ch	Z
*	110606058	6	6	58	15	01	6
*	110608064	8	8	64	19	01	6
*	110610073	10	10	73	22	01	6
*	110612082	12	12	82	26	01	6
*	110614082	14	14	82	31	015	6
*	110616093	16	16	93	32	015	6
*	110818093	18	18	93	32	015	8
*	110820105	20	20	105	38	015	8

**Long Series**

Stock	Code	dH9	dZh6	L1	L2	Ch	Z
*	110606080	6	6	80	30	01	6
*	110608090	8	8	90	40	01	6
*	110610100	10	10	100	45	01	6
*	110612110	12	12	110	55	01	6
*	110614110	14	14	110	60	015	6
*	110616125	16	16	125	70	015	6
*	110818140	18	18	140	70	015	8
*	110820150	20	20	150	75	015	8

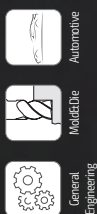
**Cutting Parameters**

Material	Shoulder Milling ap=Z100 / ae=0.250 Vc (m/min)	
	ap=Z100	ae=0.250
Unalloyed Steel	100-140	140-170
Steel	80-110	110-140
Tempered Steel	80-100	105-130
Cold Work Tool Steel	60-80	80-105
Hot Work Tool Steel	60-80	80-105
AlSi304 - 416 - 420	40-60	55-80
AISI 316 - 440	40-60	55-80
Ti-4 PH 15-5 PH	40-60	55-80
Cobalt-Chrome Alloys	40-60	55-80
Duplex F51	40-60	55-80
Super Duplex F55	40-60	55-80
Gray Cast Iron	80-110	110-140
Alloyed Cast Iron	80-100	105-130
Precision Cast Iron	80-100	105-130
Titanium	40-50	50-70
Titanium Alloys	40-50	50-70



Material	ap=Z100 / ae=0.250 Vc (m/min)	ae=0.100 Feed Per Tooth (mm/tooth)
Unalloyed Steel	100-140	0.024
Steel	80-110	0.024
Tempered Steel	80-100	0.045
Cold Work Tool Steel	60-80	0.051
Hot Work Tool Steel	60-80	0.051
AlSi304 - 416 - 420	40-60	0.057
AISI 316 - 440	40-60	0.063
Ti-4 PH 15-5 PH	40-60	0.063
Cobalt-Chrome Alloys	40-60	0.069
Duplex F51	40-60	0.074
Super Duplex F55	40-60	0.074
Gray Cast Iron	80-110	0.080
Alloyed Cast Iron	80-100	0.080
Precision Cast Iron	80-100	0.080
Titanium	40-50	0.080
Titanium Alloys	40-50	0.080

Special multi-flute geometry reduces milling time up to **% 30**



**110** Series  
Finishing Endmill



≤48 HRC  
FORM 40-50  
TiCN  
TiAlN  
TiN



Material	Recommended	Acceptable	Not Recommended
Steel	●	○	○
Stainless Steel	●	○	○
Hardened Steel ≤54 HRC	●	○	○
Hardened Steel >54 HRC	○	○	○
Cast Iron	●	○	○
Graphite	○	○	○
Non-Ferrous Material	○	○	○
HSSA	○	○	○
Titanium	●	○	○



\*Marked products can be delivered quickly from stock.