

HPC

156 Gen-Z Series

High Performance Machining



General Engineering



Mold&Die



Defence



Aviation & Aerospace



Energy



Finish



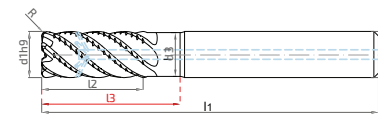
Rough

Designed to have high performance machining of advanced technology materials.

new product



www.karcan.com



Short Series

Stock	Code	d1h9	d2h6	d3	l1	l2	l3	R
	156606005	6	6	5,7	58	13	20	0,5
	156608005	8	8	7,6	64	18	25	0,5
	156610005	10	10	7,5	73	22	30	0,5
	156610010	10	10	7,5	73	22	30	1
	156612005	12	12	11,4	82	26	36	0,5
	156612010	12	12	11,4	82	26	36	1
	156616010	16	16	15,2	93	34	42	1
	156616020	16	16	15,2	93	34	42	2
	156620030	20	20	19	105	42	52	3

Cutting Parameters - Trochoidal

Material	Shoulder Milling	Shoulder Milling	Shoulder Milling
	ap=2x0/ae=0,05-0,120 Vc (m/min)	ap=3x0/ae=0,05-0,10 Vc (m/min)	ap=4x0/ae=0,05-0,10 Vc (m/min)



Material	ap=2x0/ae=0,05-0,120 Vc (m/min)	ap=3x0/ae=0,05-0,10 Vc (m/min)	ap=4x0/ae=0,05-0,10 Vc (m/min)
Unalloyed Steel	220-250	220-250	200-230
Steel	210-240	210-240	190-220
Tempered Steel	110-140	110-140	100-120
Cold Work Tool Steel	80-110	75-105	70-90
Hot Work Tool Steel	80-110	75-105	70-90
AISI 304-416-420	120-150	120-150	95-125
AISI 316-440	100-130	90-120	80-110
T7-4 PH 15-5 PH	90-120	80-110	70-100
Chrome-Cobalt Alloy	70-100	70-90	65-85
Duplex F51	90-130	90-130	70-110
Super Duplex F55	90-130	90-130	70-110
Gray Cast Iron	200-235	200-235	195-215
Alloyed Cast Iron	200-240	200-240	190-220
Precision Cast Iron	200-245	200-245	190-225
Iron-Based Super Alloys	45-65	45-65	40-60
Nickel-Based Super Alloys	40-55	40-55	40-50
Titanium-Based Super Alloys	100-120	95-115	90-105

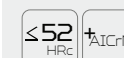
Feed Per Tooth (mm/tooth)

D	Feed Per Tooth (mm/tooth)		
	ap=2x0	ap=3x0	ap=4x0
4	0,016-0,032		
6	0,036-0,072	0,036-0,072	0,04-0,07
8	0,048-0,096	0,048-0,086	0,05-0,08
10	0,075-0,15	0,06-0,12	0,05-0,08
12	0,09-0,18	0,072-0,144	0,06-0,09
14	0,105-0,21	0,084-0,168	0,07-0,1
16	0,12-0,24	0,07-0,1	0,07-0,1
18	0,135-0,27	0,12-0,15	0,12-0,15
20	0,15-0,3	0,12-0,24	0,13-0,16

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Gen-Z **156**
High Performance Machining



Z6



Steel	●
Stainless Steel	●
Hardened Steel ≤54 HRC	●
Hardened Steel >54 HRC	○
Cast Iron	○
Graphite	○
Non Ferrous Material	○
HRSA	●
Titanium	●

● Recommended ○ Acceptable ○ Not Recommended

* Marked products can be delivered quickly from stock.

