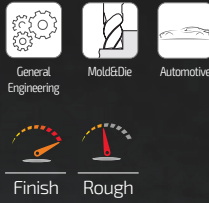


102 Series Finishing Endmill



High Performance In Hard Materials After Heat Treatment

Special geometry and edge preparations ensure a better chip removal up to

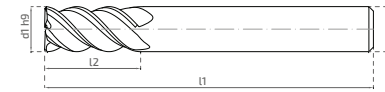
% 30

Chatter free geometry reduces tensions up to

% 30

Available from stock in all sizes

% 100



Short Series					
Stock	Code	d1h9	d2h6	l1	l2
*	102403045	3	6	45	8
*	102404045	4	6	45	11
*	102405050	5	6	50	13
*	102406060	6	6	60	20
*	102408060	8	8	60	20
*	102410070	10	10	70	25
*	102412075	12	12	75	26

Long Series					
Stock	Code	d1h9	d2h6	l1	l2
*	102403060	3	3	60	15
*	102404075	4	4	75	15
*	102405075	5	5	75	20
*	102406080	6	6	80	20
*	102408100	8	8	100	25
*	102410100	10	10	100	30
*	102412100	12	12	100	35

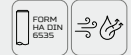
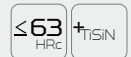
Cutting Parameters	
Shoulder Milling ap≤150 ae≤0.050	Shoulder Milling ap≤10 ae≤0.030 (D<Ø3) ae≤0.050 (D≥Ø3) max 0.5mm
Vc (m/min) Hardened Steel / 45-55 HRC	Vc (m/min) Hardened Steel / 48-63 HRC



Ø		Ø	
3	140 - 160	3	90 - 110
4	140 - 160	4	90 - 110
5	180 - 220	5	110 - 130
6	180 - 220	6	110 - 130
8	180 - 220	8	110 - 130
10	180 - 220	10	110 - 130
12	180 - 220	12	110 - 130

Feed Per Tooth (mm/tooth)			
Ø		Ø	
3	0.020	3	0.015
4	0.025	4	0.020
5	0.030	5	0.025
6	0.035	6	0.030
8	0.045	8	0.035
10	0.050	10	0.040
12	0.060	12	0.045

102 Finishing Endmill



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.