

Short Series

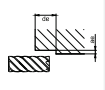
Stock	Code	d1h9	d2h6	L	Lz	Ch	Z
*	112606058	6	6	58	13	0.1	6
*	112608064	8	8	64	19	0.1	6
*	112610073	10	10	73	22	0.1	6
*	112612082	12	12	82	26	0.1	6
*	112616093	16	16	93	32	0.2	6
*	11282005	20	20	105	38	0.2	8

Long Series

Stock	Code	d1h9	d2h6	L	Lz	Ch	Z
*	112606080	6	6	80	30	0.1	6
*	112608090	8	8	90	35	0.1	6
*	112610100	10	10	100	45	0.1	6
*	112612110	12	12	110	55	0.1	6
*	112616125	16	16	125	65	0.2	6
*	112820150	20	20	150	75	0.2	8

Cutting Parameters

Material	Shoulder Milling ap=200 / ae=0.25-0.100 Vc (m/min)	
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Material	Shoulder Milling ap=200 / ae=0.25-0.100 Vc (m/min)	Shoulder Milling ap=200 / ae=0.25-0.100 Vc (m/min)
Cold Work Tool Steel	110-150	150-180
Hot Work Tool Steel	100-140	140-170
AISI 304 - 416 - 420	70-100	100-130
AISI 316 - 440	70-100	100-130
T7-4 PH 15-5 PH	65-90	90-120
Chrome-Cobalt Alloy	65-90	90-120
Duplex F51	60-80	80-110
Super Duplex F55	60-80	80-110
Titanium	60-80	70-100
Titanium Alloys	55-75	65-95
≤ 54 HRC	80-110	110-140
> 54 HRC	20-50	50-80

Feed Per Tooth (mm/tooth)

Material	Feed Per Tooth (mm/tooth)	
	ap=0.250	ap=0.100
0	0.018	0.024
6	0.019	0.024
8	0.027	0.042
10	0.035	0.048
12	0.037	0.054
16	0.045	0.064
20	0.052	0.075



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



To have a super smooth surface in heat treated materials.



New geometry and developed coating ensure an expanded tool life up to **% 40**

Better surface roughness thanks to unique edge preparation. **% 30**

