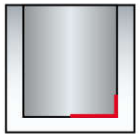
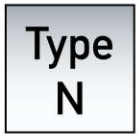
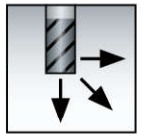
HAJ CUT

10429

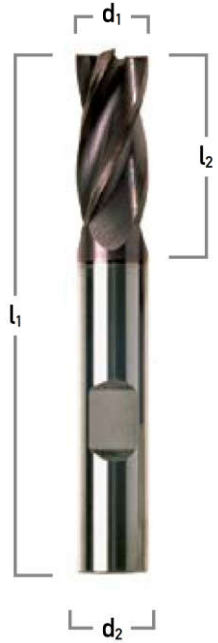









Solid Carbide End Mill



d_1	d_2	l_2	l_1		Coated
mm	mm	mm	mm	Z	Part No.
3,0	6	12	50	4	10429030
4,0	6	15	50	4	10429040
5,0	6	20	60	4	10429050
6,0	6	20	60	4	10429060
8,0	8	25	70	4	10429080
10,0	10	30	90	4	10429100
12,0	12	30	90	4	10429120
16,0	16	50	110	4	10429160
20,0	20	55	110	4	10429200

f_z Roughing			f_z Finishing		
mm/Z			mm/Z		
0,009	–	0,030	0,007	–	0,028
0,012	–	0,037	0,010	–	0,035
0,017	–	0,037	0,015	–	0,035
0,027	–	0,042	0,025	–	0,040
0,032	–	0,052	0,030	–	0,050
0042	–	0,072	0,040	–	0,070
0,062	–	0,092	0,060	–	0,090
0,092	–	0,132	0,090	–	0,130
0,132	–	0,172	0,130	–	0,170

Peripheral milling
$a_e = 0,2xD$
$a_p = 2,0xD$

Full slot milling
$a_p = 0,3xD$

Material	Steel	Stainless	Cast	Alu	Titanium
Tensile strength/Hardness	< 1200 N/mm²	< 850 N/mm²	< 800 N/mm²	< 600 N/mm²	<850 N/mm²
V_c (m/min) Finishing	100	65	125	220	70
V_c (m/min) Roughing	85	45	105	200	50

d_1	d_2
h10	h6