

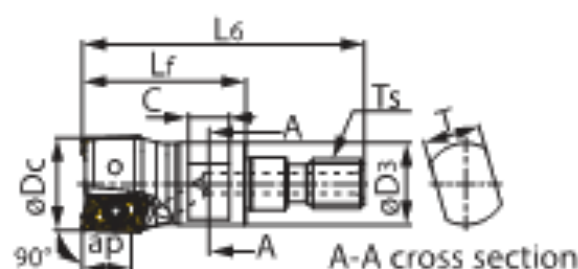
TUNGALOY SINGLE SIDE SQUARE SHOULDERING END MILLS

TUNGFRREC

ITEM: B4F56

End mills for square shouldering in small diameters

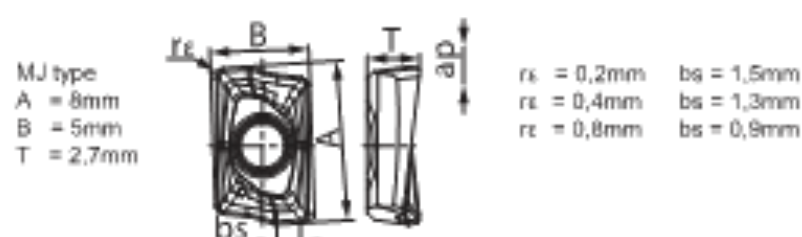
Coupling type Screw-On shank
Insert type AVGT06...
Application Square shouldering for small diameters
Rake angle A.R. = +6° ~ +7,6°, R.R = -37,1 ~ -32,4°



	Tech. Code	Denomination	Z	Dc mm	D3 mm	Lf mm	Ts mm	L6 mm	Max a.p. mm	Weight Kg	Air hole
Screw-On	B4F5610Z2	HPAV06M010M06R02	2	10	9,5	20	M6	34,5	6	0,01	With
	B4F5612Z3	HPAV06M012M06R03	3	12	10						
	B4F5616Z4	HPAV06M016M08R04	4	16	13	25	M8	42		0,03	

GEOMETRY AND CUTTING CONDITIONS - TUNGFORCEREC

TUNGFRREC



		Description	Grade	Tech. Code	P			M		K		N	S	H
					<500 N/mm²	<850 N/mm²	<1200 N/mm²	<600 N/mm²	<850 N/mm²	<240 HB	<300 HB	Alu	HTA	<60 HRC
MEDIUM CUTTING	MJ	AVGT 060302PBER-MJ	AH120	B4T12AVMJ01					●	●	●		●	●
			AH3135	B4T12AVMJ02	●	●	●	●	○					
		AVGT 060304PBER-MJ	AH120	B4T12AVMJ03					●	●	●		●	●
			AH3135	B4T12AVMJ04	●	●	●	●	○					
		AVGT 060308PBER-MJ	AH120	B4T12AVMJ05					●	●	●		●	●
			AH3135	B4T12AVMJ06	●	●	●	●	○					

● RECOMMENDED FOR... ○ USABLE FOR...

RECOMMENDED CUTTING DATA

Material	Hardness Brinnell HB	Priority	Recommended grades	Geometry	Cutting speed Vc (m/min)	Feed fz mm
Carbon steels (C45-C55 etc.)	~ 300HB	First choice	AH3135	MJ	230 - 430	0,07 - 0,12
Alloyed steel (42CRMo4, 17Cr3 etc.)	~ 300HB	First choice	AH3135	MJ	150 - 350	0,07 - 0,12
Hardened and tempered steels (NAK80, PX5 etc.)	30 - 40HRC	First choice	AH120	MJ	100 - 230	0,07 - 0,12
Stainless steels (X5CrNi 18-9, etc.)	-	First choice	AH3135	MJ	150 - 220	0,06 - 0,1
Cast irons (GG25, GG30 etc.)	150 - 250HB	First choice	AH120	MJ	200 - 330	0,07 - 0,12
Spheroidal cast irons (GGG40 etc.)	150 - 250HB	First choice	AH120	MJ	150 - 240	0,07 - 0,12
Titanium alloys (Ti-6AL-4V, etc.)	-	First choice	AH120	MJ	70 - 90	0,06 - 0,1
Super Alloy (Inconel718, ecc.)	-	First choice	AH120	MJ	45 - 65	0,06 - 0,09
Hardened steel (SKD11 etc.)	40 - 50HRC	First choice	AH120	MJ	45 - 70	0,05 - 0,08
Hardened steel(SKD11 etc.)	50 - 60HRC	First choice	AH120	MJ	40 - 60	0,04 - 0,06