

FIN-INTEG

HC45FL

Finishing Endmills

MILLING
Solid Carbide

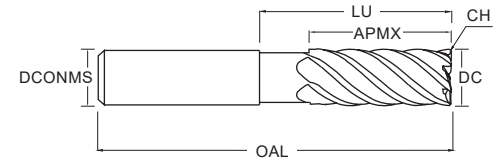
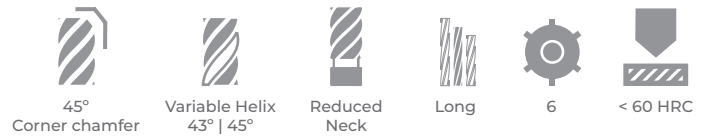


FIN INTEG Finishing End mills

HC45FL Corner chamfer



P M K H

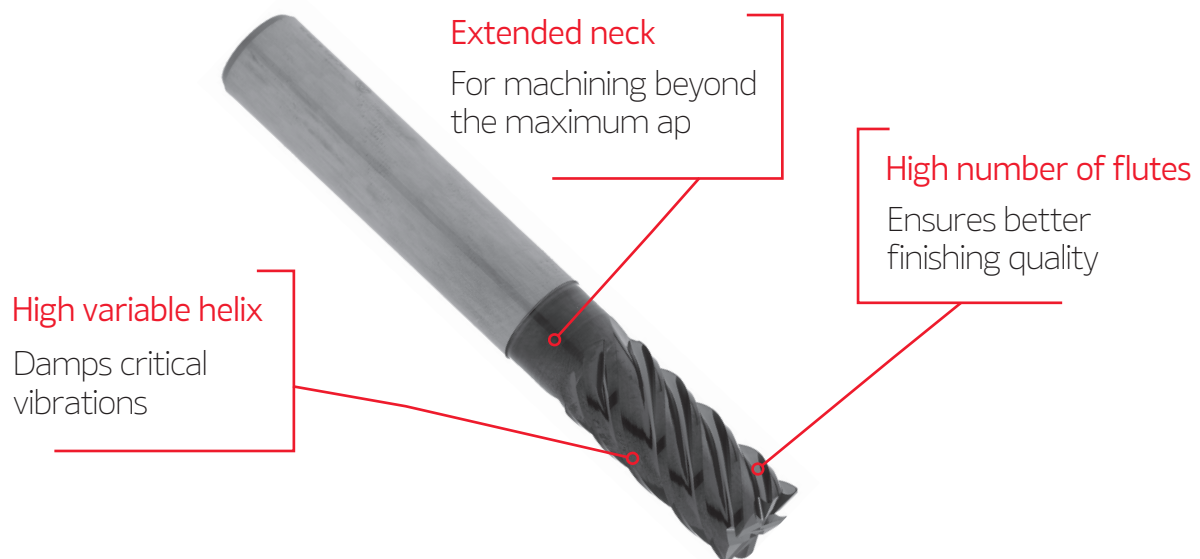


All order codes are cylindrical shank.
Weldon shank available under request.

(1) Geometry code	(2) Grade code		T1		X7						
	Reference Referência Referencia	NOF	PHP920	PHP603	Dimensions Dimensões Dimensiones (mm)						
					DC	DCONMS	APMX	CHW	KCH	LU	OAL
1180845	HC45FL 6 030 08	6	○	⊗	3	6	8	0,15	45°	15	57
1180846	HC45FL 6 040 11	6	○	⊗	4	6	11	0,15	45°	17	57
1180847	HC45FL 6 050 13	6	○	⊗	5	6	13	0,15	45°	19	57
1180342	HC45FL 6 060 13	6	⊗	⊗	6	6	13	0,15	45°	21	57
1180062	HC45FL 6 080 19	6	⊗	⊗	8	8	19	0,15	45°	28	63
1180344	HC45FL 6 100 22	6	⊗	⊗	10	10	22	0,20	45°	30	72
1180343	HC45FL 6 120 26	6	⊗	⊗	12	12	26	0,20	45°	34	83
1180848	HC45FL 6 160 32	6	○	○	16	16	32	0,35	45°	44	92
1180849	HC45FL 6 200 38	6	○	○	20	20	38	0,60	45°	54	104

⊗ Stock item | Produto de stock | Itens de stock ○ Available under request | Disponível sobre consulta | Disponible bajo consulta

End mill order code = (1) Geometry Code + (2) Grade Code



GRADES SELECTION GUIDE Guia para selecção de graus | Tabla para selección de calidades

ISO	Material	Grades	
		PHP603	PHP920
P	Unalloyed Steel	△	⊗
	Low-Alloyed Steel	⊗	△
	High-Alloyed Steel	⊗	△
M	Stainless Steel (Ferritic / Martensitic)	△	⊗
	Stainless Steel (Austenitic)	△	⊗
	Stainless Steel (Austenitic/Ferritic/Duplex)	△	⊗
K	Malleable Cast Iron	△	⊗
	Grey Cast Iron	⊗	△
	Nodular Cast Iron	⊗	△
H	Hardened Steels	⊗	-

⊗ First choice | 1ª Escolha | 1ª Opción

△ Suitable | Adequado | Adecuado

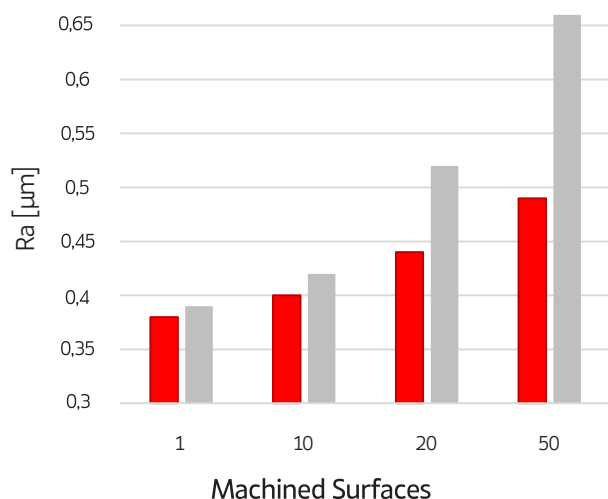
RECOMMENDED CUTTING CONDITIONS Condições de corte recomendadas | Condiciones de corte recomendables

ISO	Material	Vc (m/min)		fz (mm/t)
		PHP603	PHP920	
P	Unalloyed Steel	200	190	0,009 x DC
	Low-Alloyed Steel	170	160	0,007 x DC
	High-Alloyed Steel	140	130	0,005 x DC
M	Stainless Steel (Ferritic / Martensitic)	130	120	0,006 x DC
	Stainless Steel (Austenitic)	120	110	0,005 x DC
	Stainless Steel (Austenitic/Ferritic/Duplex)	90	90	0,004 x DC
K	Malleable Cast Iron	240	230	0,009 x DC
	Grey Cast Iron	240	230	0,009 x DC
	Nodular Cast Iron	200	190	0,008 x DC
H	Hardened Steels	80	-	0,004 x DC

Note¹: Feed valid for when the end mill works with its whole ap, for when the end mill is working with lower depths of cut consider increasing the feed up to 25%.

Note²: Cutting speeds selected for an economic use of the tool, for higher productivity consider increasing up to 70%.

TEST REPORT Relatório de Teste | Informe de Prueba



HC45FL 6 120 26 PHP603

Competitor Equivalent

Material 55NiCrMoV7 (41,5 HRC)	
Cutting Speed (V _c)	110 m/min
Feed per tooth (f _z)	0,06 mm/t
Stepover (a _e)	0,7 mm

FIN-INTEG

HC45FL

Finishing Endmills



Check the QrCode for more information



HEADQUARTERS

PALBIT. S.A.

T (+351) 234 540 300 | F (+351) 234 540 301

palbit@palbit.pt | www.palbit.pt

Branch office

PALBIT México, S de RL de CV

T (+52) 5555 454 543 | F (+52) 5552 509 190

info@palbit.com.mx | www.palbit.pt/mx

Branch office

PALBIT Brasil

T (+55) 011 25 343 648

palbit@palbit.com.br | www.palbit.pt/br