

CHAMF-INTEG

HCHGS

Chamfering Endmills

MILLING
Solid Carbide

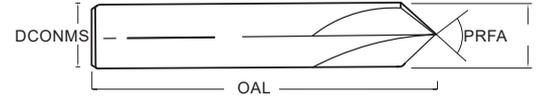


CHAMF INTEG Chamfering End mills

HCHGS



P M K



⁽¹⁾ Order code		⁽²⁾ Grade code		Z9	Dimensions Dimensões Dimensiones (mm)			
		Reference Referência Referencia	NOF	PHU920	DC	DCONMS	PRFA	OAL
HA (Cylindrical)	HB (Weldon)							
1180366	-	HCHGS 4 030 02 90	4	⊗	3	3	90°	38
1180367	-	HCHGS 4 040 02 90	4	⊗	4	4	90°	50
1180368	1180496	HCHGS 4 060 03 90	4	⊗	6	6	90°	57
1180369	1180497	HCHGS 4 080 04 90	4	⊗	8	8	90°	63
1180370	1180498	HCHGS 4 100 05 90	4	⊗	10	10	90°	72
1180371	1180499	HCHGS 4 120 06 90	4	⊗	12	12	90°	83
1180372	1180500	HCHGS 4 160 08 90	4	⊗	16	16	90°	92
1180373	1180553	HCHGS 4 200 10 90	4	⊗	20	20	90°	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

Note: For HB (weldon) end mills, the reference ends with "-W"

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

ISO	Material	Chamfering	
		fz (mm/t)	Vc (m/min)
P	Unalloyed Steel	0,008 x DC	180
	Low-Alloyed Steel	0,007 x DC	160
	High-Alloyed Steel	0,006 x DC	140
M	Stainless Steel (Ferritic / Martensitic)	0,007 x DC	150
	Stainless Steel (Austenitic)	0,006 x DC	130
	Stainless Steel (Austenitic/Ferritic/Duplex)	0,004 x DC	110
K	Malleable Cast Iron	0,008 x DC	210
	Grey Cast Iron	0,008 x DC	210
	Nodular Cast Iron	0,008 x DC	190



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