

VHM HGT END MILLS



- ➔ HIGH CHIP VOLUME
- ➔ HIGH FEED RATES
- ➔ INCREASED FEED MOTION





0384 56 END MILLS HGT

4 flutes for high performance milling

VHM	HPC	

4 flutes, plain shank, straight face, centre cutting, 50° right hand helix, PVTi-coated

- standard series
- corner radius
- unequal division
- also available with clamping flats, form 12 mm diam. upwards compulsory
- **on demand: available with working depths**

Material qualification	steel	heat-resistant alloys	stainless steel	cast iron	non-ferrous-metals / materials	hardened steel	grade	coating
A	○	●	●		○		UMGC	PVTi

Solid carbide end mills	Catalogue-No.	d ₁	l ₂	l ₃	d ₃	l ₁	r	d ₂	z	price	features
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no wd. standard series											
	NWV 0384 56 060	6	12	-	-	57	0,5	6	4		✓
	NWV 0384 56 061	6	12	-	-	57	1	6	4		✓
	NWV 0384 56 080	8	16	-	-	63	0,5	8	4		✓
	NWV 0384 56 081	8	16	-	-	63	1	8	4		✓
	NWV 0384 56 100	10	20	-	-	72	0,5	10	4		✓
	NWV 0384 56 101	10	20	-	-	72	1	10	4		✓
	NWV 0384 56 120	12	24	-	-	83	1	12	4		✓
	NWV 0384 56 021	12	24	-	-	83	2	12	4		✓
	NWV 0384 56 160	16	32	-	-	92	1	16	4		✓
	NWV 0384 56 161	16	32	-	-	92	2	16	4		✓
	NWV 0384 56 200	20	40	-	-	104	1	20	4		✓
	NWV 0384 56 201	20	40	-	-	104	2	20	4		✓



SPEED/FEED PER TOOTH/ DEPTH OF CUT

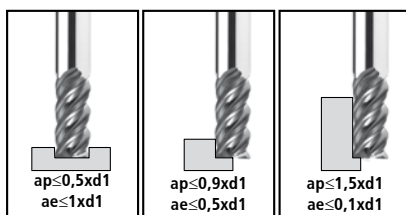
HPC

HGT- end mills for pocket- and slot milling

0384



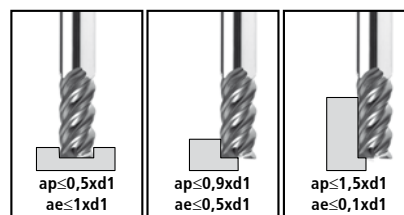
High-temperature alloys
1.4542 etc.:



feed per tooth f_z
speed $V_c = 25$ m/min

d_1	f_z	f_z	f_z
6	0,020	0,025	0,025
8	0,030	0,035	0,035
10	0,035	0,045	0,045
12	0,040	0,050	0,050
16	0,060	0,075	0,070
20	0,070	0,080	0,075

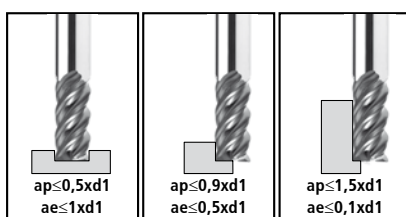
High nickel alloys (inconel)
718 etc.:



feed per tooth f_z
speed $V_c = 15$ m/min

d_1	f_z	f_z	f_z
6	0,020	0,025	0,025
8	0,030	0,035	0,035
10	0,035	0,045	0,045
12	0,040	0,050	0,050
16	0,060	0,075	0,070
20	0,070	0,080	0,075

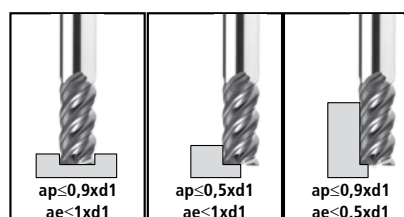
Stainless steel
1.4401, 1.4571, 1.4404 (Cr-Ni-Mo) etc.:



feed per tooth f_z
speed $V_c = 40$ m/min

d_1	f_z	f_z	f_z
6	0,025	0,025	0,035
8	0,035	0,035	0,050
10	0,045	0,045	0,070
12	0,050	0,050	0,080
16	0,075	0,075	0,090
20	0,080	0,080	0,100

Stainless steel
1.4301, 1.4541, 1.4307 (Cr-Ni) etc.:



feed per tooth f_z
speed $V_c = 80$ m/min

d_1	f_z	f_z	f_z
6	0,025	0,025	0,040
8	0,035	0,035	0,055
10	0,045	0,045	0,075
12	0,050	0,050	0,085
16	0,075	0,075	0,100
20	0,080	0,080	0,125

These speed and feed values are approximate. Customer-specific factors such as input power, machine stability, tool overhang, etc. are not taken into account. In order to guarantee optimum and economic cutting conditions with our tools, please ask our office or one of our application engineers.

CONTACT

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