

ST[®] 200NaNo Series



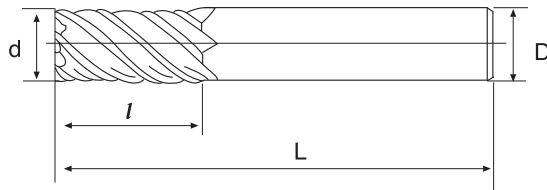
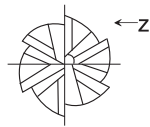
Production Power Multi Flute End Mill

Super Ultra Fine Micro Grain Carbide

WC = 91 Co = 9 HRA = 93.2 Rupture = 4000N/mm² Grain Size = 0.2μm

Application Iron, Carbon steel, Cast Iron, Alloy Steel, Tool Steel, Heat treatment Steel, Welding Steel

Main Character Super Ultra Fine Micro Grain Carbide that has high toughness, coating ALTIN (TiAlN) and wear-resisting, non-general titanium aluminium is specialized in milling on M/C high hardness at a high speed and can carry on rough machining get to detailed process directly for heat treatment mould to reduce change times, improve machine flexible rate and shorten producing time.



MODE	Diameter d	Flute Length l	Full Length L	Shank Diameter D	Flute No. Z	Packing Quantity	Price
SFUVT0606-HSC	6	15.0	60	6.0	6 Z	4	
SFUVT0806-HSC	8	20.0	60	8.0	6 Z	4	
SFUVT1006-HSC	10	25.0	75	10.0	6 Z	2	
SFUVT1206-HSC	12	30.0	75	12.0	6 Z	2	
SFUVT1606-HSC	16	45.0	100	16.0	6 Z	1	
SFUVT2008-HSC	20	45.0	100	20.0	8 Z	1	
SFUVT2508-HSC	25	45.0	100	25.0	8 Z	1	

High rigidity, high strength, multi-flute with high hexli, negative angle to cut, designed to cut the difficult material and the best choice to high speed side-cutting. You also use the waving type feed to process the high-efficiency flute depth, apply in the hardness degrees above HRC65°.



Attention : In order to get better cutting surface and lengthen the life-time of the end mill, please use high accuracy, high rigidity and dynamic equilibrium of holder.

1. Before using the end mill, please examine the end mill to lean towards and put, when the precision of the leaning towards of end mill exceeds 0.01mm, please cut after correcting.
2. It is better that end mill stretches out shorter from chuck, when the end mill stretches out longer, please adjust the rotational speed, feeding speed or cutting amount.
3. Unusual vibrations or sound happen when cutting, please adjust and lower the rotational speed of the main shaft one by one, feeding speed and cutting amount until improving the situation, or change the high-quality end mill.
4. It is the best way to cool steel material by spraying or air in order to make TiAlN efficiently; we commend to adopt non-water cutting liquid to cool the stainless steel, titanium alloy or heat-resisting alloy liquid.
5. Cutting will be influenced by work piece, machine and software; the above-mentioned data are only for reference, please improve feeding speed by 30%~50% up after cutting situation steadily.

SFUVT Recommended Milling conditions

Working material hardness	HRC45°~HRC52°		HRC52°~HRC62°	
	Rotational speed	Feeding speed	Rotational speed	Feeding speed
	RPM	mm/min.	RPM	mm/min.
D3.0	17550	1872	8450	936
D4.0	13650	2223	6500	1053
D5.0	11700	2516	5785	1229
D6.0	10400	3393	5200	1697
D8.0	5800	3393	3000	1697
D10.0	4200	3335	2500	1697
D12.0	3100	2808	1900	1404
D16.0	1800	2106	1350	1053