

ST[®] 200NaNo Series



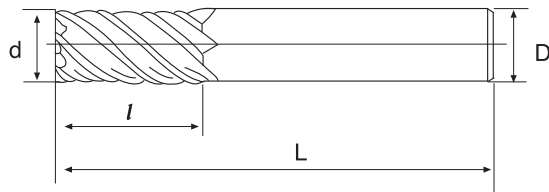
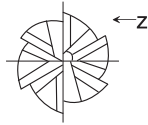
Production Power Multi Long Flute End Mill

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
SFULVT0606-HSC	6	25.0	75	6.0	6 Z	2	
SFULVT0806-HSC	8	35.0	100	8.0	6 Z	2	
SFULVT1006-HSC	10	45.0	100	10.0	6 Z	2	
SFULVT1206-HSC	12	50.0	100	12.0	6 Z	2	
SFULVT1606-HSC	16	65.0	150	16.0	6 Z	1	
SFULVT2008-HSC	20	75.0	150	20.0	8 Z	1	
SFULVT2508-HSC	25	80.0	150	25.0	8 Z	1	

High rigidity, high strength, multi-flute with high hexli, negative angle to cut. The best choice for you is that long flute can carry on diameter 4D precise side-cutting.



! 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 TiAIN 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.

SFULVT 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	6500	749	3380	374
D4.0	5800	889	2600	421
D5.0	4200	1006	2314	492
D6.0	3850	1357	2080	679
D8.0	2800	1357	1560	679
D10.0	2250	1334	1248	679
D12.0	1650	1123	1040	562
D16.0	850	842	780	421