



Short Series

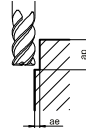
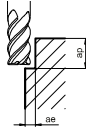
S	Order No	Code	d1h9	d2h6	L1	L2
*	15100	102.4.0300.0510.K0000.0080.0000.0000.00.S06H1A02.01	3	6	51	8
*	15102	102.4.0400.0510.K0000.0110.0000.0000.00.S06H1A02.01	4	6	51	11
*	15104	102.4.0500.0510.K0000.0130.0000.0000.00.S06H1A02.01	5	6	51	13
*	15106	102.4.0600.0580.K0000.0200.0000.0000.00.S06H1A02.01	6	6	58	20
*	15108	102.4.0800.0640.K0000.0200.0000.0000.00.S08H1A02.01	8	8	64	20
*	15110	102.4.1000.0730.K0000.0250.0000.0000.00.S10H1A02.01	10	10	73	25
*	15112	102.4.1200.0750.K0000.0260.0000.0000.00.S12H2A02.01	12	12	75	26

Long Series

S	Order No	Code	d1h9	d2h6	L1	L2
*	15114	102.4.0300.0600.K0000.0150.0000.0000.00.S03H2A02.01	3	3	60	15
*	15116	102.4.0400.0750.K0000.0150.0000.0000.00.S04J1A02.01	4	4	75	15
*	15118	102.4.0500.0750.K0000.0200.0000.0000.00.S05J1A02.01	5	5	75	20
*	15120	102.4.0600.0800.K0000.0200.0000.0000.00.S06J1A02.01	6	6	80	20
*	15122	102.4.0800.1000.K0000.0250.0000.0000.00.S08H1A02.01	8	8	100	25
*	15124	102.4.1000.1000.K0000.0300.0000.0000.00.S10H1A02.01	10	10	100	30
*	15126	102.4.1200.1000.K0000.0350.0000.0000.00.S12H1A02.01	12	12	100	35

Cutting Parameters

Shoulder Milling $a_p \leq 1.50$ $a_e \leq 0.050$	Shoulder Milling $a_p \leq 10$ $a_e \leq 0.030$ ($D < \phi 3$) $a_e \leq 0.050$ ($D \geq \phi 3$) max: 0.5mm
Vc (m/min)	Vc (m/min)
Hardened Steel / 45-55 HRC	Hardened Steel / 48-63 HRC



ϕ		ϕ	
3	140 - 160	3	90 - 110
4	140 - 160	4	90 - 110
5	180 - 220	5	110 - 130
6	180 - 220	6	110 - 130
8	180 - 220	8	110 - 130
10	180 - 220	10	110 - 130
12	180 - 220	12	110 - 130

Feed Per Tooth (mm/tooth)

ϕ		ϕ	
3	0.020	3	0.015
4	0.025	4	0.020
5	0.030	5	0.025
6	0.035	6	0.030
8	0.045	8	0.035
10	0.050	10	0.040
12	0.060	12	0.045

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Finishing Endmill

Z4



Steel	●
Stainless Steel	●
Hardened Steel ≤ 54 HRC	●
Hardened Steel > 54 HRC	●
Cast Iron	○
Graphite	○
Non Ferrous Material	○
HRSA	○
Titanium	○

● Recommended ● Acceptable ○ Not Recommended