**110**

Finishing Endmill

110 Ultra-Bite

Short Series

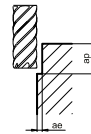
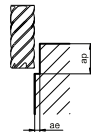
S	Order No	Code	d1h9	d2h6	L1	L2	Corner	Z
*	15128	110.6.0600.0580.C0010.0150.0000.0000.00.S06B1A01.01	6	6	58	15	Ch 0.10	6
*	15130	110.6.0800.0640.C0010.0190.0000.0000.00.S08B1A01.01	8	8	64	19	Ch 0.10	6
*	15132	110.6.1000.0730.C0010.0220.0000.0000.00.S10B1A01.01	10	10	73	22	Ch 0.10	6
*	15134	110.6.1200.0820.C0010.0260.0000.0000.00.S12B1A01.01	12	12	82	26	Ch 0.10	6
*	15136	110.6.1400.0820.C0015.0310.0000.0000.00.S14B1A01.01	14	14	82	31	Ch 0.15	6
*	15138	110.6.1600.0930.C0015.0320.0000.0000.00.S16B1A01.01	16	16	93	32	Ch 0.15	6
	15140	110.8.1800.0930.C0015.0320.0000.0000.00.S18B1A01.01	18	18	93	32	Ch 0.15	8
	15142	110.8.2000.1050.C0015.0380.0000.0000.00.S20B1A01.01	20	20	105	38	Ch 0.15	8

Long Series

S	Order No	Code	d1h9	d2h6	L1	L2	Corner	Z
*	15144	110.6.0600.0820.C0010.0300.0000.0000.00.S06B1A01.01	6	6	82	30	Ch 0.10	6
*	15146	110.6.0800.0910.C0010.0400.0000.0000.00.S08B1A01.01	8	8	91	40	Ch 0.10	6
*	15148	110.6.1000.1000.C0010.0450.0000.0000.00.S10B1A01.01	10	10	100	45	Ch 0.10	6
*	15150	110.6.1200.1100.C0010.0550.0000.0000.00.S12B1A01.01	12	12	110	55	Ch 0.10	6
*	15152	110.6.1400.1100.C0015.0600.0000.0000.00.S14B1A01.01	14	14	110	60	Ch 0.15	6
*	15154	110.6.1600.1250.C0015.0700.0000.0000.00.S16B1A01.01	16	16	125	70	Ch 0.15	6
	15156	110.8.1800.1430.C0015.0700.0000.0000.00.S18B1A01.01	18	18	143	70	Ch 0.15	8
	15158	110.8.2000.1500.C0015.0750.0000.0000.00.S20B1A01.01	20	20	150	75	Ch 0.15	8

Cutting Parameters

Material	Shoulder Milling ap=2.00 / ae=0.250 Vc (m/min)	Shoulder Milling ap=2.00 / ae=0.20-0.100 Vc (m/min)

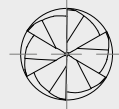


Steel	Unalloyed Steel	100-140	140-170
	Steel	80-110	110-140
	Tempered Steel	80-100	105-130
	Cold Work Tool Steel	60-80	80-105
	Hot Work Tool Steel	60-80	80-105
Stainless Steel	AISI 304 - 416 - 420	40-60	55-80
	AISI 316 - 440	40-60	55-80
	17-4 PH 15-5 PH	40-60	55-80
	Cobalt-Chrome Alloys	40-60	55-80
	Duplex F51	40-60	55-80
Cast Iron	Super Duplex F55	40-60	55-80
	Gray Cast Iron	80-110	110-140
	Alloyed Cast Iron	80-100	105-130
	Precision Cast Iron	80-100	105-130
	Titanium	40-50	50-70
Titanium	Titanium Alloys	40-50	50-70

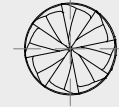
Feed Per Tooth (mm/tooth)

Ø	ae=0.250	ae=0.200	ae=0.100
6	0.028	0.030	0.024
8	0.046	0.051	0.045
10	0.054	0.059	0.051
12	0.060	0.066	0.057
14	0.064	0.074	0.063
16	0.073	0.079	0.069
18	0.078	0.086	0.074
20	0.085	0.092	0.080

Z6



Z8



≤48 HRC + TiCrN

FORM HA DIN 6535



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

● Recommended ● Acceptable ○ Not Recommended