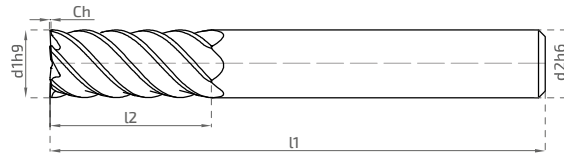


PLUS 112

Finishing Endmill



Short Series

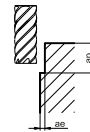
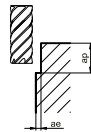
S	Order No	Code	d1h9	d2h6	l1	l2	Corner	Z
*	19100	112P.6.0600.0570.K0000.0130.0000.0000.00.S06E2S01.01	6	6	57	13	Ch 0.00	6
*	19102	112P.6.0800.0630.K0000.0190.0000.0000.00.S08E2S01.01	8	8	63	19	Ch 0.00	6
*	19104	112P.6.1000.0720.K0000.0220.0000.0000.00.S10E2S01.01	10	10	72	22	Ch 0.00	6
*	19106	112P.6.1200.0820.K0000.0260.0000.0000.00.S12E2S01.01	12	12	82	26	Ch 0.00	6
	19108	112P.6.1400.0820.K0000.0260.0000.0000.00.S14E2S01.01	14	14	82	26	Ch 0.00	6
*	19110	112P.6.1600.0920.K0000.0320.0000.0000.00.S16E2S01.01	16	16	92	32	Ch 0.00	6
	19112	112P.8.2000.1040.K0000.0380.0000.0000.00.S20E2S01.01	20	20	104	38	Ch 0.00	8

Long Series

S	Order No	Code	d1h9	d2h6	l1	l2	Corner	Z
*	19114	112P.6.0600.0700.K0000.0260.0000.0000.00.S06E2S01.01	6	6	70	26	Ch 0.00	6
*	19116	112P.6.0800.0900.K0000.0360.0000.0000.00.S08E2S01.01	8	8	90	36	Ch 0.00	6
*	19118	112P.6.1000.1000.K0000.0460.0000.0000.00.S10E2S01.01	10	10	100	46	Ch 0.00	6
*	19120	112P.6.1200.1100.K0000.0560.0000.0000.00.S12E2S01.01	12	12	110	56	Ch 0.00	6
*	19122	112P.6.1600.1300.K0000.0660.0000.0000.00.S16E2S01.01	16	16	130	66	Ch 0.00	6
	19124	112P.8.2000.1400.K0000.0760.0000.0000.00.S20E2S01.01	20	20	140	76	Ch 0.00	8

Cutting Parameters

Material	Shoulder Milling ap=2.00 / ae=0.0350	Finish Milling ap=2.00 / ae=0.020 - 0.0100
	Vc (m/min)	Vc (m/min)

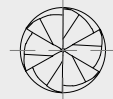


Steel	Cold Work Tool Steel	110-150	150-180
	Hot Work Tool Steel	100-140	140-170
Stainless Steel	AISI 304 - 416 - 420	70-100	100-130
	AISI 316 - 440	70-100	100-130
	17-4 PH 15-5 PH	65-90	90-120
	Chrome-Cobalt Alloy	65-90	90-120
Titanium	Duplex F51	60-80	80-110
	Super Duplex F55	60-80	80-110
	Titanium	60-80	70-100
	Titanium Alloys I	55-75	65-95
	Titanium Alloys II	55-75	65-95
Hardened Steel	≤ 54 HRC	80-110	110-140
	> 54 HRC	20-50	50-80

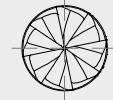
Feed Per Tooth (mm/tooth)

Ø	ae=0.0250	ae=0.0200	ae=0.0100	ae=0.0100
6	0.018	0.019	0.024	0.024
8	0.027	0.030	0.042	0.045
10	0.035	0.037	0.048	0.051
12	0.037	0.040	0.054	0.057
16	0.045	0.049	0.064	0.069
20	0.052	0.058	0.075	0.080

Z6



Z8



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

● Recommended ● Acceptable ○ Not Recommended