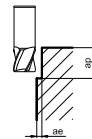
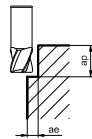


Long Series

S	Order No	Code	d1h9	d2h6	d3	l1	l2	l3	Corner
*	20162	114.4.0400.0750.R0050.0100.0380.0200.00.S06G1A01.01	4	6	3,8	75	10	20	R 0.50
	20164	114.4.0400.0750.R0100.0100.0380.0200.00.S06G1A01.01	4	6	3,8	75	10	20	R 1.00
*	20166	114.4.0400.0750.R0050.0100.0380.0200.00.S04G1A01.01	4	4	3,8	75	10	20	R 0.50
*	20168	114.4.0600.0750.R0050.0160.0580.0220.00.S06G1A01.01	6	6	5,8	75	16	22	R 0.50
*	20170	114.4.0600.0750.R0100.0160.0580.0220.00.S06G1A01.01	6	6	5,8	75	16	22	R 1.00
*	20172	114.4.0600.1000.R0050.0160.0580.0210.00.S06G1A01.01	6	6	5,8	100	16	21	R 0.50
*	20174	114.4.0600.1000.R0100.0160.0580.0210.00.S06G1A01.01	6	6	5,8	100	16	21	R 1.00
*	20176	114.4.0800.0750.R0050.0160.0770.0230.00.S08G1A01.01	8	8	7,7	75	16	23	R 0.50
*	20178	114.4.0800.0750.R0100.0160.0770.0230.00.S08G1A01.01	8	8	7,7	75	16	23	R 1.00
	20180	114.4.0800.0750.R0150.0160.0770.0230.00.S08G1A01.01	8	8	7,7	75	16	23	R 1.50
*	20182	114.4.0800.1000.R0050.0160.0770.0230.00.S08G1A01.01	8	8	7,7	100	16	23	R 0.50
*	20184	114.4.0800.1000.R0100.0160.0770.0230.00.S08G1A01.01	8	8	7,7	100	16	23	R 1.00
*	20186	114.4.1000.1000.R0050.0180.0970.0310.00.S10G1A01.01	10	10	9,7	100	18	31	R 0.50
*	20188	114.4.1000.1000.R0100.0180.0970.0310.00.S10G1A01.01	10	10	9,7	100	18	31	R 1.00
	20190	114.4.1000.1000.R0150.0180.0970.0310.00.S10G1A01.01	10	10	9,7	100	18	31	R 1.50
	20192	114.4.1000.1000.R0200.0180.0970.0310.00.S10G1A01.01	10	10	9,7	100	18	31	R 2.00
*	20194	114.4.1200.1000.R0050.0200.1170.0350.00.S12G1A01.01	12	12	11,7	100	20	35	R 0.50
*	20196	114.4.1200.1000.R0100.0200.1170.0350.00.S12G1A01.01	12	12	11,7	100	20	35	R 1.00
	20198	114.4.1200.1000.R0150.0200.1170.0350.00.S12G1A01.01	12	12	11,7	100	20	35	R 1.50
	20200	114.4.1200.1000.R0200.0200.1170.0350.00.S12G1A01.01	12	12	11,7	100	20	35	R 2.00

Cutting Parameters

Material	Shoulder Milling ap=0.100 / ae=0.025 - 0.010	Finish Milling ap=0.100 / ae=0.010
	Vc (m/min)	Vc (m/min)



Steel	Cold Work Tool Steel	110-150	150-180
	Hot Work Tool Steel	100-140	140-170
	Gray Cast Iron	70-100	100-130
	Alloyed Cast Iron	70-100	100-130
	Precision Cast Iron	65-90	90-120
	≤ 54 HRC	65-90	90-120
Cast Iron	>54 HRC	60-80	80-110
Hardened Steel			

Feed Per Tooth (mm/tooth)

Ø	ae=0.0250	ae=0.020	ae=0.0150	ae=0.010
4	0.031	0.034	0.037	0.040
6	0.031	0.034	0.037	0.041
8	0.038	0.042	0.047	0.053
10	0.049	0.052	0.056	0.061
12	0.052	0.056	0.062	0.068
16	0.063	0.068	0.076	0.082

ULTR△-BITE

Long **114**
Corner Radius
Endmill

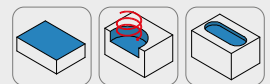


Z4



≤ 62 HRC + AlCrN

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