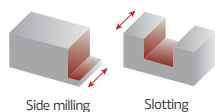


INOX-INTEG

Endmills for Stainless Steel



Integral Solid Carbide Solutions



INOX-INTEG = Endmills for Stainless Steel

NEW

HC40SS Corner Chamfer stainless steel specialized endmills



S - Short



4 - Variable Pitch



Variable Helix 40°/41°



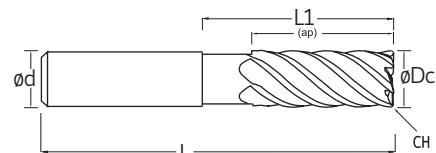
45° Corner chamfer



Reduced Neck Ø



< 42 HRC



		⁽²⁾ Grade code		Z9	Dimensions Dimensões Dimensiones (mm)					
⁽¹⁾ Geometry code		Reference Referência Referencia		PHU920						
HA (Cylindrical)	HB (Weldon)				ØDc	Ød (h6)	ap _{max}	CH	L	L1
1180484	1180485	HF40SS 4 010 03	4		1	6	2,5	-	57	5
1180380	1180487	HF40SS 4 020 05	4		2	6	5	-	57	10
1180381	1180488	HC40SS 4 030 08	4		3	6	8	45° x 0,15	57	15
1180382	1180489	HC40SS 4 040 11	4		4	6	11	45° x 0,15	57	17
1180383	1180490	HC40SS 4 050 13	4		5	6	13	45° x 0,15	57	19
1180384	1180389	HC40SS 4 060 13	4		6	6	13	45° x 0,15	57	21
1180329	1180491	HC40SS 4 080 19	4		8	8	19	45° x 0,15	63	27
1180385	1180492	HC40SS 4 100 22	4		10	10	22	45° x 0,20	72	32
1180386	1180493	HC40SS 4 120 26	4		12	12	26	45° x 0,20	83	38
1180436	1180494	HC40SS 4 140 26	4		14	14	26	45° x 0,25	83	38
1180387	1180390	HC40SS 4 160 32	4		16	16	32	45° x 0,35	92	44
1180555	1180556	HC40SS 4 180 32	4		18	18	32	45° x 0,45	92	44
1180388	1180455	HC40SS 4 200 38	4		20	20	38	45° x 0,60	104	54

First choice | Primeira opção | 1ª opción

Stock item | Produto de stock | Itens de stock

Available under request | Disponível sobre consulta
Disponível bajo consulta

Order code = (1) Geometry Code + (2) Grade Code

CUTTING PARAMETERS || Parâmetros de corte | Parámetros de corte

ISO	Material	fz (mm/t)			Vc (m/min)		
		ae			ae		
		25%	50%	100%	25%	50%	100%
M	SS - Ferritic / Martensitic	0,007 x ØDc	0,004 x ØDc	0,003 x ØDc	160	150	120
	SS - Austenitic	0,006 x ØDc	0,004 x ØDc	0,003 x ØDc	140	130	100
	SS - Austenitic-ferritic (Duplex)	0,006 x ØDc	0,003 x ØDc	0,003 x ØDc	130	120	100

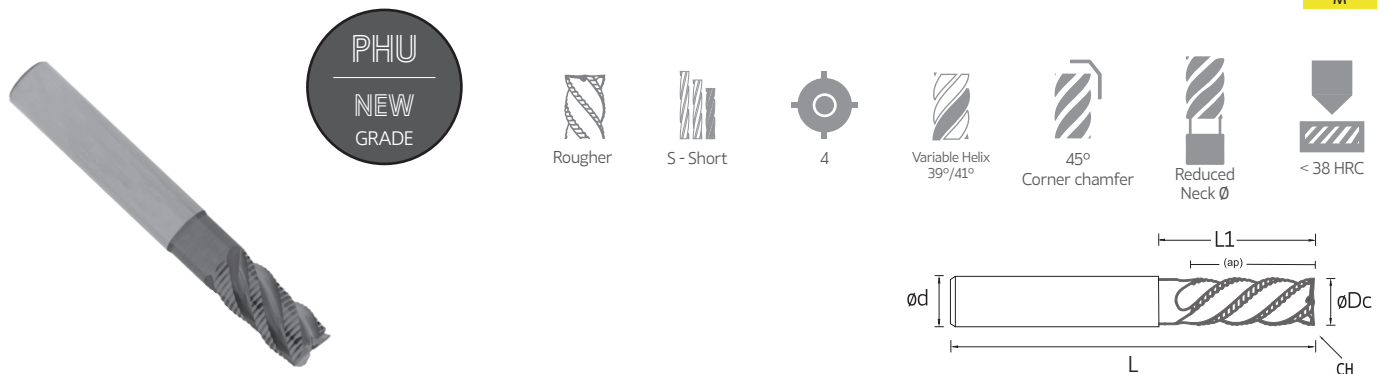
Note¹: Feed valid for when the endmill works with its whole ap, for when the endmill is working with lower depths of cut consider increasing the feed up to 25%.

Note²: Cutting speeds selected for an economic use of the tool, for higher productivity consider increasing up to 70%.

INOX-INTEG = Endmills for Stainless Steel

NEW

HRO40SS Rougher stainsteel specialized endmills



		(2) Grade code		Z9	Dimensions Dimensões Dimensiones (mm)					
(1) Geometry code		Reference Referência Referencia		PHU920						
HA (Cylindrical)	HB (Weldon)				ØDc	Ød (h6)	ap _{max}	CH	L	L1
1180445	1180392	HRO40SS 4 040 11	4		4	6	11	45° x 0,15	57	17
1180446	1180393	HRO40SS 4 050 13	4		5	6	13	45° x 0,15	57	19
1180447	1180394	HRO40SS 4 060 13	4		6	6	13	45° x 0,15	57	21
1180448	1180395	HRO40SS 4 080 19	4		8	8	19	45° x 0,15	63	27
1180391	1180396	HRO40SS 4 100 22	4		10	10	22	45° x 0,20	72	32
1180449	1180397	HRO40SS 4 120 26	4		12	12	26	45° x 0,20	83	38
1180450	1180398	HRO40SS 4 140 26	4		14	14	26	45° x 0,25	83	38
1180451	1180399	HRO40SS 4 160 32	4		16	16	32	45° x 0,35	92	44
1180452	1180400	HRO40SS 4 180 32	4		18	18	32	45° x 0,45	92	44
1180453	1180454	HRO40SS 4 200 38	4		20	20	38	45° x 0,60	104	54

First choice | Primeira opção | 1ª opción

Stock item | Produto de stock | Itens de stock

Available under request | Disponível sobre consulta
Disponível bajo consulta

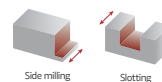
Order code = (1) Geometry Code + (2) Grade Code

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ISO	Material	Fz			Vc		
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		25%	50%	100%	25%	50%	100%
M	SS - Ferritic / Martensitic	0,006 x ØDc	0,005 x ØDc	0,004 x ØDc	140	130	110
	SS - Austenitic	0,006 x ØDc	0,005 x ØDc	0,003 x ØDc	130	120	110
	SS - Austenitic-ferritic (Duplex)	0,005 x ØDc	0,004 x ØDc	0,003 x ØDc	120	110	100

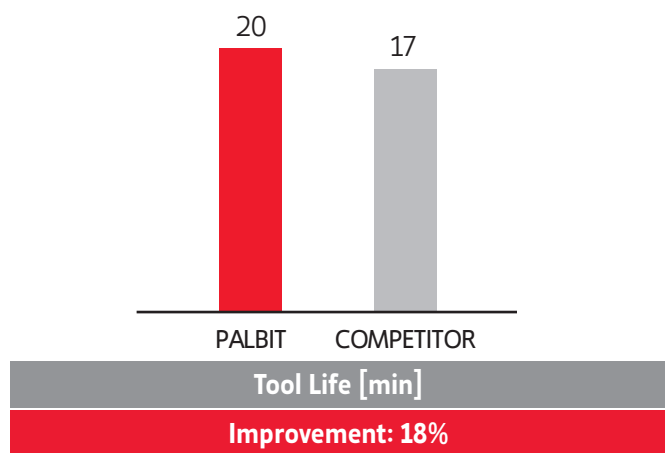
Note¹: Feed valid for when the endmill works with its whole ap, for when the endmill is working with lower depths of cut consider increasing the feed up to 25%.

Note²: Cutting speeds selected for an economic use of the tool, for higher productivity consider increasing up to 70%.



TEST REPORT || Relatório de teste | Informes de prueba

Tool: HC40SS 4 080 19 PHU920



Workpiece Material: AISI 316L	
Cutting speed: V_c	120 m/min
Feed per tooth: f_z	0,024 mm/t
Depth of cut: a_p	8,0 mm
Stepover : a_e	100%
Operation	Slotting
Coolant	Air

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