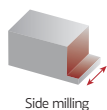


FIN-INTEG

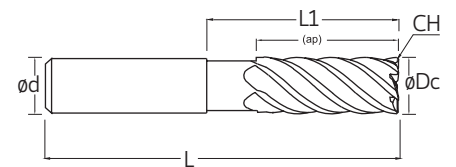
Finishing Endmills



Integral Solid Carbide Solutions



HC45FL Corner chamfer Finishing Endmills

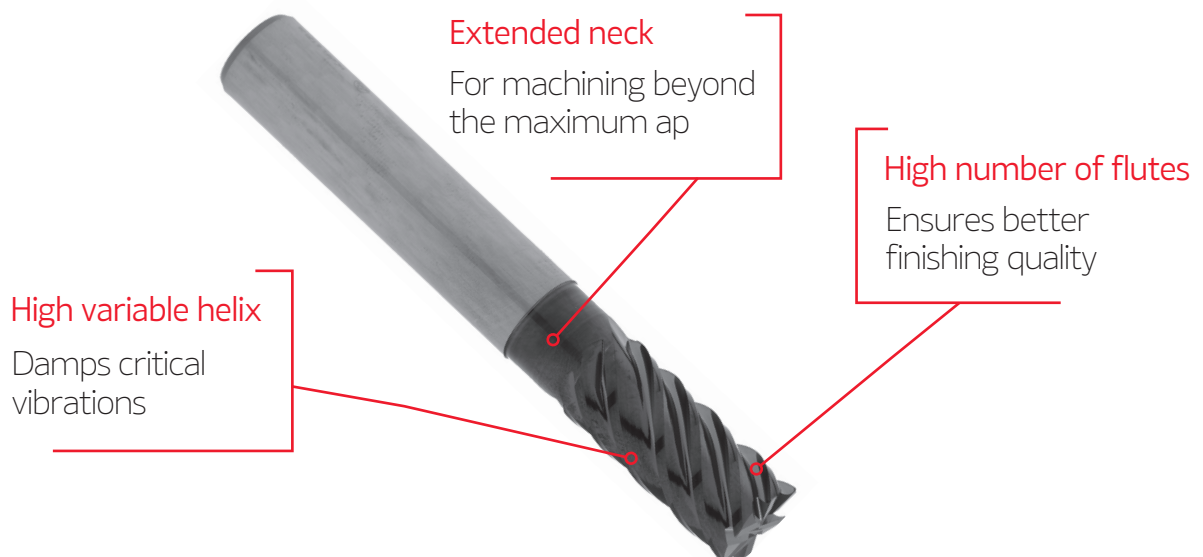


All order codes are cylindrical shank.
Weldon shank available under request.

(1) Geometry code	(2) Grade code		T1		Dimensions Dimensões Dimensiones (mm)					
	Reference Referência Referencia		PHP920	PHP603	ØDc	Ød (h6)	ap _{max}	CH	L1	L
1180342	HC45FL 6 060 13	6			6	6	13	0,15 x 45°	21	57
1180062	HC45FL 6 080 19	6			8	8	19	0,15 x 45°	28	64
1180344	HC45FL 6 100 22	6			10	10	22	0,20 x 45°	30	72
1180343	HC45FL 6 120 26	6			12	12	26	0,20 x 45°	34	83

 Stock item | Produto de stock | Itens de stock

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



CUTTING PARAMETERS || Parâmetros de corte | Parámetros de corte

ISO	Material	Vc (m/min)		fz (mm/t)
		PHP603	PHP920	
P	Unalloyed Steel	200	190	0,009 x ØDc
	Low-Alloyed Steel	170	160	0,007 x ØDc
	High-Alloyed Steel	140	130	0,005 x ØDc
M	Stainless Steel (Ferritic / Martensitic)	130	120	0,006 x ØDc
	Stainless Steel (Austenitic)	120	110	0,005 x ØDc
	Stainless Steel (Austenitic/Ferritic/Duplex)	90	90	0,004 x ØDc
K	Malleable Cast Iron	240	230	0,009 x ØDc
	Grey Cast Iron	240	230	0,009 x ØDc
	Nodular Cast Iron	200	190	0,008 x ØDc
H	Hardened Steels	80		0,004 x ØDc

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%.

GRADES SELECTION GUIDE || Guia para selecção de graus | Tabla para selección de calidades

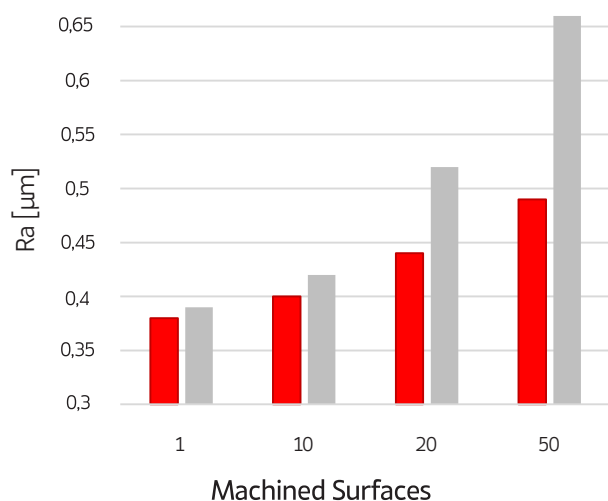
ISO	Material	Grades	
		PHP603	PHP920
P	Unalloyed Steel	Ⓐ	Ⓑ
	Low-Alloyed Steel	Ⓑ	Ⓐ
	High-Alloyed Steel	Ⓑ	Ⓐ
M	Stainless Steel (Ferritic / Martensitic)	Ⓐ	Ⓑ
	Stainless Steel (Austenitic)	Ⓐ	Ⓑ
	Stainless Steel (Austenitic/Ferritic/Duplex)	Ⓐ	Ⓑ
K	Malleable Cast Iron	Ⓐ	Ⓑ
	Grey Cast Iron	Ⓑ	Ⓐ
	Nodular Cast Iron	Ⓑ	Ⓐ
H	Hardened Steels	Ⓑ	

Ⓑ First choice | 1ª Escolha | 1ª Opción

Ⓐ Suitable | Adequado | Adecuado

Insert Order Code: ⁽¹⁾Geometry code + ⁽²⁾Grade code

TEST REPORT || Relatório de teste | Informe de prueba



HC45FL 6 120 26 PHP603

Competitor Equivalent

Material 55NiCrMoV7 (41,5 HRC)	
Cutting Speed (V _c)	110 m/min
Feed per tooth (f _z)	0,06 mm/t
Stepover (a _e)	0,7 mm

FIN-INTEG

Finishing Endmills

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