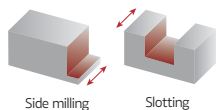


STEEL-INTEG

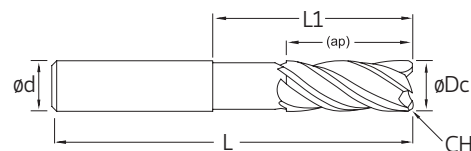
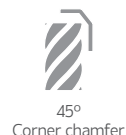
Steel Specialized Endmills



Integral Solid Carbide Solutions



HC35ML Corner chamfer steel specialized endmills



		(2) Grade code		T1	Dimensions Dimensões Dimensiones (mm)					
(1) Geometry code		Reference Referência Referencia		PHP920						
HA (Cylindrical)	HB (Weldon)				ØDc	Ød (h6)	ap _{max}	CH	L	L1
1180480	-	HF35ML 4 010 03	4		1	6	2,5	-	57	5
1180482	1180483	HC35ML 4 020 05	4		2	6	5	0,07 x 45°	57	10
1180466	1180467	HC35ML 4 030 08	4		3	6	8	0,15 x 45°	57	15
1180137	1180468	HC35ML 4 040 11	4		4	6	11	0,15 x 45°	57	17
1180469	1180521	HC35ML 4 050 13	4		5	6	13	0,15 x 45°	57	19
1180138	1180470	HC35ML 4 060 13	4		6	6	12	0,15 x 45°	57	21
1180052	1180471	HC35ML 4 080 19	4		8	8	19	0,15 x 45°	63	27
1180053	1180472	HC35ML 4 100 22	4		10	10	22	0,20 x 45°	72	32
1180139	1180473	HC35ML 4 120 26	4		12	12	26	0,20 x 45°	83	38
1180474	1180475	HC35ML 4 140 26	4		14	14	26	0,25 x 45°	83	38
1180153	1180476	HC35ML 4 160 32	4		16	16	32	0,35 x 45°	92	44
1180477	1180478	HC35ML 4 180 32	4		18	18	32	0,45 x 45°	92	44
1180140	1180479	HC35ML 4 200 38	4		20	20	38	0,60 x 45°	104	54

First choice | Primeira opção | 1ª opción

Stock item | Produto de stock | Itens de stock

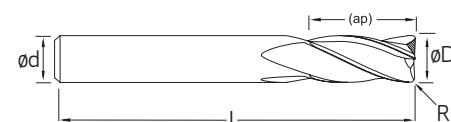
Available under request | Disponível sobre consulta
Disponible bajo consulta

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

Note: For HB (Weldon) endmills, the reference ends with "-W"

Example: "HC35ML 4 030 08-W"

HR35GL Corner radius hard steel specialized endmills



(1) Geometry code	(2) Grade code		T1	Dimensions Dimensões Dimensiones (mm)				
	Reference Referência Referencia			ØDc	Ød (h6)	ap _{max}	R	L
1180042	HR35GL 4 120 26 R100	4	⊗	12	12	26	1	81
1180043	HR35GL 4 120 26 R200	4	⊗	12	12	26	2	81
1180044	HR35GL 4 120 26 R300	4	⊗	12	12	26	3	81
1180187	HR35GL 4 160 24 R100	4	⊗	16	16	24	1	100
1180188	HR35GL 4 160 24 R200	4	⊗	16	16	24	2	100
1180189	HR35GL 4 200 40 R100	4	⊗	20	20	40	1	100
1180190	HR35GL 4 200 40 R200	4	⊗	20	20	40	2	100

⊗ First choice | Primeira opção | 1ª opção

⊗ 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 CONDITIONS || Condições de corte | Condiciones de corte

ISO	Material	f _z (mm/t)			V _c (m/min)		
		a _e = 25%	a _e = 50%	a _e = 100%	a _e = 25%	a _e = 50%	a _e = 100%
P	Unalloyed Steel	0,008 x ØDc	0,005 x ØDc	0,004 x ØDc	190	180	150
	Low-Alloyed Steel	0,007 x ØDc	0,004 x ØDc	0,003 x ØDc	180	160	130
	High-Alloyed Steel	0,006 x ØDc	0,004 x ØDc	0,003 x ØDc	160	150	120
K	Malleable Cast Iron	0,008 x ØDc	0,005 x ØDc	0,004 x ØDc	230	210	180
	Grey Cast Iron	0,008 x ØDc	0,005 x ØDc	0,004 x ØDc	230	210	170
	Nodular Cast Iron	0,008 x ØDc	0,004 x ØDc	0,004 x ØDc	210	190	160
H	Hardened steels	0,004 x ØDc	0,003 x ØDc	0,002 x ØDc	70	60	50

Note¹: Recommended feed values for maximum a_p. For reduced a_p, consider increasing F_z up to 25%.

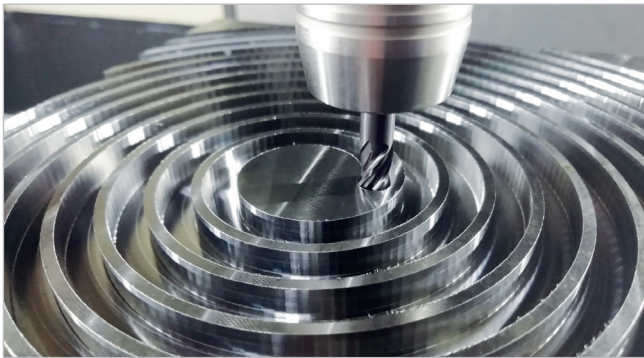
Note²: Cutting speeds selected for an economic use of the tool, for higher productivity consider increasing up to 70%.



TEST REPORT || Relatório de teste | Informes de prueba

Tool: HC35ML 4 060 13

Grade: PHP920

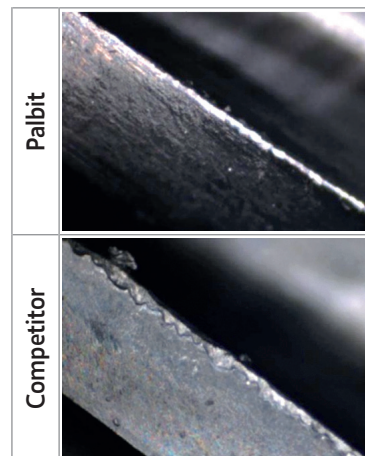


Workpiece Material: Steel 1.2738 (38 HRC)

Cutting speed: V_c	140 m/min
Feed per tooth: f_z	0,03 mm/t
Depth of cut: a_p	6,0 mm
Stepover : a_e	100%
Operation	Spiral Slotting
Coolant	Emulsion



Endmill after 15 mins



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