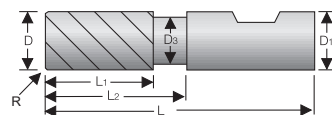


SARA® Steel end milling cutter



- Unequal pitch for vibration-free milling
- With corner protection radius R for improved service life



material	● very well suited	steel			stainless steel			cast iron		titanium alloys	superalloys Fe/NiCo-based		aluminium		copper Cu alloy	graphite GRP/CFP/thermo.	hardened steel		
	○ well suited	< 700 N/mm²	< 1000 N/mm²	< 1400 N/mm²	ferrit./martens.	austenitic	duplex	GG/GTS	GGG		< 30 HRc	≥ 30 HRc	< 8 % Si	≥ 8 % Si		< 55 HRc	< 60 HRc	≥ 60 HRc	
		200	160	150	80	120	80	170	110	60	30	30	330	300	280				

Cutting speed Vc m/min. Please adjust these guidelines according to clamping operation and machine set-up.

D mm	L1 mm	L2 mm	L mm	D1 mm	D3 mm	R mm	Z	Feed fz steel < 1000 N/mm² mm/tooth	Feed fz steel < 1000 N/mm² mm/tooth	art.no.	€
4	11	20	57	6	3.7	0.1	4	0.012	0.02	254111 0040	26,50
5	13	20	57	6	4.6	0.1	4	0.016	0.025	254111 0050	26,50
6	13	20	57	6	5.5	0.1	4	0.019	0.031	254111 0060	26,50
8	20	26	64	8	7.4	0.2	4	0.026	0.043	254111 0080	36,-
10	22	32	72	10	9.2	0.2	4	0.034	0.056	254111 0100	48,70
12	26	37	83	12	11	0.2	4	0.041	0.070	254111 0120	66,40
14	26	37	83	14	13	0.2	4	0.047	0.079	254111 0140	94,10
16	32	42	92	16	15	0.2	4	0.053	0.087	254111 0160	113,-
18	32	42	92	18	17	0.2	4	0.058	0.092	254111 0180	153,-
20	38	50	104	20	19	0.2	4	0.064	0.098	254111 0200	180,50

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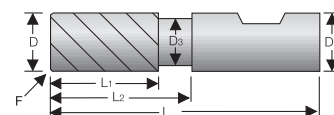


Steel professional

palbit® End milling cutters



- With clearance
- Unequal helix angle and pitch for low-vibration milling
- With protective chamfer F for improved service life



material	● very well suited	steel			stainless steel			cast iron		titanium alloys	superalloys Fe/NiCo-based		aluminium		copper Cu alloy	graphite GRP/CFP/thermo.	hardened steel		
	○ well suited	< 700 N/mm²	< 1000 N/mm²	< 1400 N/mm²	ferrit./martens.	austenitic	duplex	GG/GTS	GGG		< 30 HRc	≥ 30 HRc	< 8 % Si	≥ 8 % Si		< 55 HRc	< 60 HRc	≥ 60 HRc	
		170	155	140				200	185										

Cutting speed Vc m/min. Please adjust these guidelines according to clamping operation and machine set-up.

D mm	L1 mm	L2 mm	L mm	D3 mm	D1 mm	F x 45° mm	Feed fz steel < 1000 N/mm² mm/tooth	Feed fz steel < 1000 N/mm² mm/tooth	art.no.	€
3	8	15	57	2.8	6	0.15	0.012	0.015	254300 0030	17,95
4	11	17	57	3.8	6	0.15	0.012	0.015	254300 0040	17,95
5	13	19	57	4.8	6	0.15	0.024	0.030	254300 0050	17,95
6	12	21	57	5.8	6	0.15	0.024	0.030	254300 0060	17,95
8	19	27	63	7.6	8	0.15	0.024	0.030	254300 0080	24,-
10	22	32	72	9.5	10	0.20	0.032	0.040	254300 0100	32,70
12	26	38	83	11.5	12	0.20	0.032	0.040	254300 0120	44,50
16	32	44	92	15.5	16	0.35	0.040	0.050	254300 0160	75,30
20	38	54	104	19.5	20	0.60	0.048	0.060	254300 0200	122,-

2157

End milling cutter set, 14 pieces

- 3 of each Ø 6/8/10/12 mm
- 2 of each Ø 2 mm

Contents		art.no.	€
Set VHM 35°/38° 3 each Ø 6/8/10/12		254300 1001	509,-

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