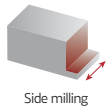


FIN-INTEG

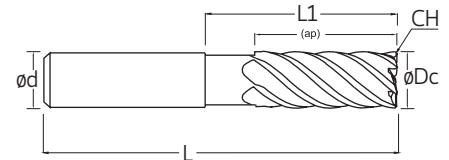
Finishing Endmills



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HC45FL Corner chamfer finishing endmills



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

(1) Geometry code	(2) Grade code Reference Referência Referencia	⊕	T1		Dimensions Dimensões Dimensiones (mm)					
			PHP920	X7	ØDc	Ød (h6)	ap _{max}	CH	L1	L
1180845	HC45FL 6 030 08	6	○	⊕	3	6	8	0,15 x 45°	15	57
1180846	HC45FL 6 040 11	6	○	⊕	4	6	11	0,15 x 45°	17	57
1180847	HC45FL 6 050 13	6	○	⊕	5	6	13	0,15 x 45°	19	57
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	63
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
1180848	HC45FL 6 160 32	6	○	○	16	16	32	0,35 x 45°	44	92
1180849	HC45FL 6 200 38	6	○	○	20	20	38	0,60 x 45°	54	104

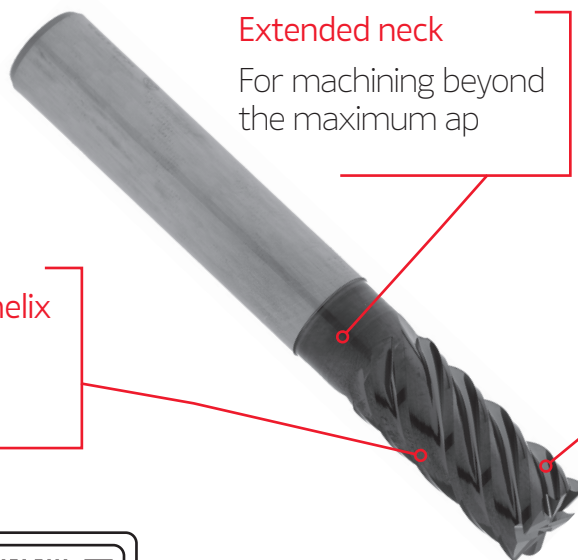
⊕ Stock item | Produto de stock | Itens de stock ○ Available under request | Disponível sobre consulta | Disponible bajo consulta

Endmill order code = (1) Geometry Code + (2) Grade Code

High variable helix
Damps critical vibrations

Extended neck
For machining beyond the maximum ap

High number of flutes
Ensures better finishing quality



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

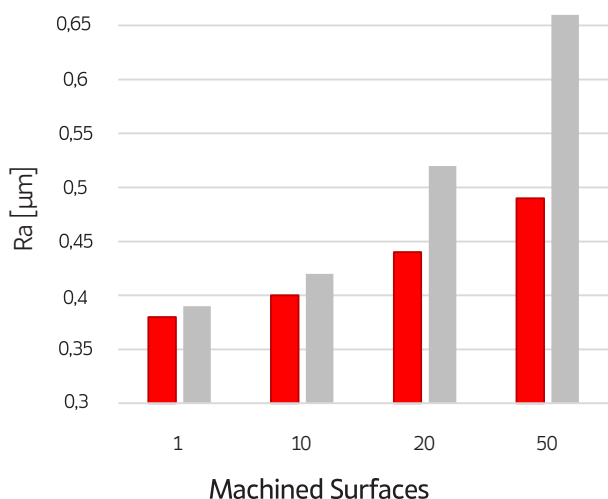
CUTTING PARAMETERS | Parâmetros de corte | Parámetros de corte

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%.

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



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NEW

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