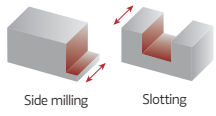


# INOX-INTEG

## Endmills for Stainless Steel

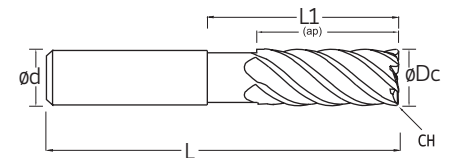


INOX-INTEG



SINCE 1916

## HC40SS Corner chamfer stainless steel specialized endmills



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

## 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

Note<sup>1</sup>: 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%.

Note<sup>2</sup>: Cutting speeds selected for an economic use of the tool, for higher productivity consider increasing up to 70%.



## HRO40SS Rougher stainless steel specialized endmills



Short



4



Variable Helix  
39°/41°



Reduced  
Neck Ø



Rougher

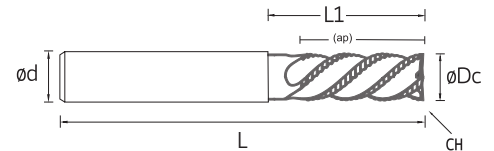


45°  
Corner chamfer



< 38 HRC

M



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

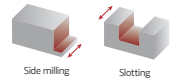
## CUTTING PARAMETERS | Parâmetros de corte | Parámetros de corte

ISO	Material	fz (mm/t)			Vc (m/min)		
		ae			ae		
		25%	50%	100%	25%	50%	100%
M	SS - Ferritic / Martensitic	0,006 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

Note<sup>1</sup>: 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%.

Note<sup>2</sup>: Cutting speeds selected for an economic use of the tool, for higher productivity consider increasing up to 70%.





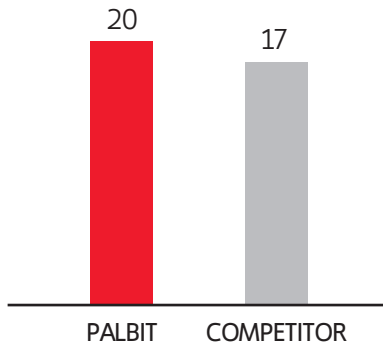
TEST REPORT | Relatório de teste | Informes de prueba

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



Tool Life [min]  
**Improvement: 18%**

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