

ITEM: B5F04

General, multifunctional shouldering mills

Coupling type

Bore

Insert type

LNMU03...

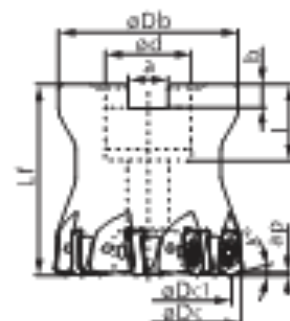
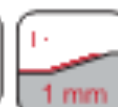
Application

Multi-task

Rake angle

A.R. +6° R.R. +5°~+11°

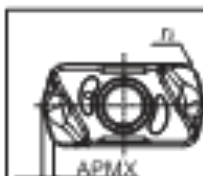
Ø40 - 50 mm



SHELL END MILL

TXN03	Tech. Code		Denomination	Z	Dc mm	Dc1 mm	Db mm	d mm	l mm	Lf mm	b mm	a mm	K°	Air hole
Bore	B5F0440Z5		TXN03R040M16.0E05	5	40	33,6	35	16	18	40	5.6	8.4	17	With
	B5F0440Z6		TXN03R040M16.0E06	6										
	B5F0450Z5		TXN03R050M22.0E05	5	50	43,6	47	22	20	50	6.3	10.4		
	B5F0450Z8		TXN03R050M22.0E08	8										

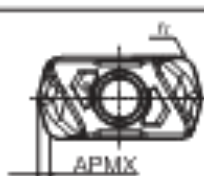
DOFEED MINI GEOMETRY AND CUTTING CONDITIONS



MJ

(general application)

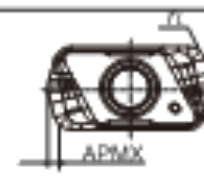
$f_c = 1,2 \text{ mm}$
APMX = 1 mm



ML

(low cutting force)

$f_c = 1,2 \text{ mm}$
APMX = 1 mm



MS

(stainless steel)

$f_c = 1,2 \text{ mm}$
APMX = 1 mm

			Description	Grade	Tech. Code	P			M		K		N	S	H
						<500 N/mm²	<850 N/mm²	<1200 N/mm²	<600 N/mm²	<850 N/mm²	<240 HB	<300 HB	Alu	HTA	<60 HRC
MED. CUT.	ML		LNMU 0303ZER-ML	AH725	B5A2103MUML01	●	●	●	●	○	●	●		●	●
				AH130	B5A2103MUML02	●	●	●	●	○				●	
				AH3035	B5A2103MUML03	○	●	●	○	○	○				●
				AH8015	B5A2103MUML04	○	○	○			○				●
ROUGH.	MJ		LNMU 0303ZER-MJ	AH725	B5A3103MUMJ01	●	●	●	●	○	●	●			○
				AH130	B5A3103MUMJ02	●	●	●	●	○				●	
				AH3035	B5A3103MUMJ03	○	●	●	○	○	○				●
				AH8015	B5A3103MUMJ04	○	○	○			○				●
INOX	MS		LNMU 0303ZER-MS	AH130	B5A4103MUMS02	○	○		●	○				●	

● RECOMMENDED FOR... ○ USABLE FOR...

RECOMMENDED CUTTING DATA

Material	Hardness Brinell HB	Priority	Recommended grades	Geometry	Cutting speed Vc (m/min.)	Feed ø 16 22 fz mm	Feed ø 25 32 fz mm
Carbon steel (C45-C55, etc.)	~ 300 HB	First choice	AH725	MJ	100 - 200 - 300	0.5 - 0.8 - 1.2	0.5 - 1.0 - 1.5
	~ 300 HB	Low cutting forces	AH725	ML	100 - 200 - 300	0.5 - 0.6 - 0.7	0.5 - 0.8 - 1.0
	~ 300 HB	Impact-resistant	AH3035	MJ	100 - 200 - 300	0.5 - 0.8 - 1.2	0.5 - 1.0 - 1.5
Alloy steel (42CRMo4, 17Cr3, etc.)	~ 300 HB	First choice	AH3035	MJ	100 - 150 - 200	0.5 - 0.8 - 1.2	0.5 - 1.0 - 1.5
	~ 300 HB	Low cutting forces	AH3035	ML	100 - 150 - 200	0.5 - 0.6 - 0.7	0.5 - 0.8 - 1.0
	~ 300 HB	Impact-resistant	AH3035	MJ	100 - 150 - 200	0.5 - 0.8 - 1.2	0.5 - 1.0 - 1.5
Hardened and tempered steel (NAK80, PX5, etc.)	30 - 40 HRC	-	AH3035	MJ	100 - 150 - 200	0.5 - 0.6 - 0.7	0.5 - 0.8 - 1.0
Stainless steel (X5CrNi 18-9, etc.)	~ 200 HB	First choice	AH130	MS	80 - 120 - 150	0.3 - 0.4 - 0.5	0.3 - 0.5 - 0.7
	~ 200 HB	Impact-resistant	AH3035	MJ	100 - 120 - 150	0.3 - 0.5 - 0.8	0.3 - 0.6 - 0.8
Cast iron (GG25, GG30, etc.)	150 - 250HB	First choice	AH725	MJ	100 - 200 - 300	0.5 - 0.8 - 1.2	0.5 - 1.0 - 1.5
Spheroidal cast iron (GGG40, etc.)	150 - 250HB	First choice	AH725	MJ	100 - 200 - 300	0.5 - 0.8 - 1.2	0.5 - 1.0 - 1.5
Titanium alloys (Ti-6AL-4V, etc.)	~ 40 HRC	First choice	AH130	ML	30 - 40 - 60	0.3 - 0.4 - 0.5	0.3 - 0.5 - 0.7
Hardened steel (SKD61, etc.)	40 - 50 HRC	First choice	AH8015	MJ	80 - 100 - 130	0.1 - 0.15 - 0.2	0.1 - 0.2 - 0.3
Hardened steel (SKD11, etc.)	50 - 60 HRC	First choice	AH8015	MJ	50 - 60 - 70	0.03 - 0.04 - 0.05	0.03 - 0.05 - 0.07