

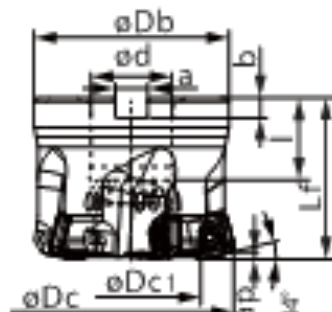
TUNGSTOL SINGLE-SIDE INSERTS SQUARE SHOULDERING END MILLS

MILLQFEED

ITEM: B5F12

High feed multi-task end mill for various materials

Coupling type Bore
Insert type SWMT1506...
Application Multi-task
Rake angle A.R. +5° R.R. = 0°



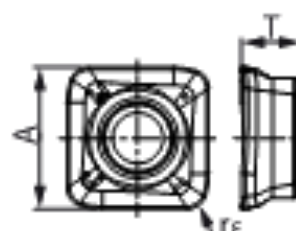
SHELL END MILL

	Tech. Code		Denomination	Z	Dc mm	Dc1 mm	Db mm	Lf mm	d mm	l mm	a mm	b mm	Max Op. mm	Weight Kg	Air hole	
Bore	B5F1263Z4		TXSW15M063B22.0R04	4	63	37,1	59	50	22	20	10.4	6.3	2.5	0.66	With	
	B5F1280Z5		TXSW15M080B27.0R05	5	80	54,1	76	63	27	22	12.4	7		1.41		
	B5F12100Z6		TXSW15M100B32.0R06	6	100	74,1	96		32	25	14.4	8		2.26		
	B5F12125Z7		TXSW15M125B40.0R07	7	125	99,1	100		40	32	16.4	9		2.83		
	B5F12160Z8		TXSW15M160B40.0R08	8	160	134,1								4.23		

TUNGSTOL GEOMETRY AND CUTTING CONDITIONS

MILLQFEED

MJ type
A = 15,875mm
T = 6,8mm
rE = 2,0mm
ap max = 2,5mm



		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
ROUG.	MJ	SWMT 1506ZER-MJ	AH120	B5A40MTMJ01		○	○			●	●		●	●

● RECOMMENDED FOR... ○ USABLE FOR...

RECOMMENDED CUTTING DATA

Material	Hardness Brinell HB	Priority	Recommended geometries	Recommended grades	Cutting speed Vc (m/min.)	Feed MJ 1/2 mm
Carbon steel (C45-C55, etc.)	~ 300 HB	First choice	MJ	AH3135	100 - 300	0.5 - 2.0
	~ 300 HB	Second choice	MJ	AH120	100 - 300	0.5 - 2.0
Alloy steel (42CRMo4, 17Cr3, etc.)	~ 300 HB	First choice	MJ	AH3135	100 - 300	0.5 - 2.0
	~ 300 HB	Second choice	MJ	AH120	100 - 200	0.5 - 2.0
Hardened and tempered steel (NAK80, PX5, etc.)	30 ~ 40HRC	First choice	MJ	AH3135	100 - 200	0.5 - 1.5
	30 ~ 40HRC	Second choice	MJ	AH120	100 - 200	0.5 - 1.5
Stainless steel (X5CrNi 18-9, etc.)	~ 200HB	First choice	MJ	AH3135	100 - 150	0.3 - 1.0
	~ 200HB	First choice	MJ	AH120	100 - 300	0.5 - 2.0
Cast iron (GG25, GG30, etc.)	150 ~ 250HB	First choice	MJ	AH120	80 - 200	0.5 - 2.0
Spheroidal cast iron (GGG40, etc.)	150 ~ 250HB	First choice	MJ	AH3135	30 - 60	0.3 - 0.7
Titanium alloys (Ti-6AL-4V, etc.)	~ 40HRC	First choice	MJ	AH120	20 - 50	0.1 - 0.3
Hardened steel (SKD61, etc.)	40 ~ 50HRC	First choice	MJ	AH3135	80 - 130	0.1 - 0.3
Hardened steel (SKD11, etc.)	50 ~ 60HRC	First choice	MJ	AH120	50 - 70	0.03 - 0.07