

ITEM: B5F09

Multifunctional high speed end mills for various materials

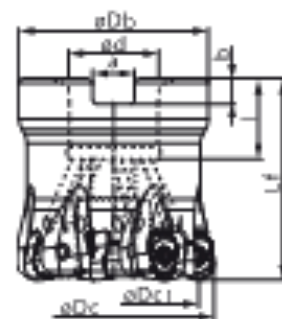
Coupling type Bore
Insert type LNMX04..
Application Multi task
Rake angle A.R. +3° R.R. = -13°

Ø20 - 32 mm

1,3 mm



P M K S H

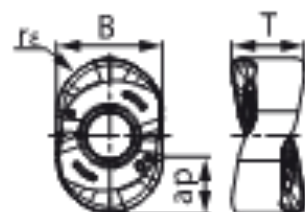


SHELL CUTTER

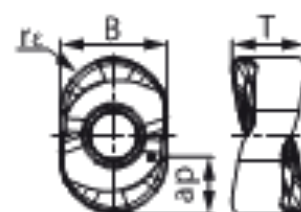
	Tech. Code	Denomination	Z	Dc mm	Dc1 mm	Db mm	Lf mm	d mm	l mm	b mm	Ap max mm	Weight Kg	Air hole
	B5F0940Z6	TXLN04M040B16.0R06	6	40	32	35	40	16,00	18,00	5,60	4	0.35	With
	B5F0950Z7	TXLN04M050B22.0R07	7	50	42	47	50	22,00	20,00	6,30			

lungolou GEOMETRY AND CUTTING CONDITIONS

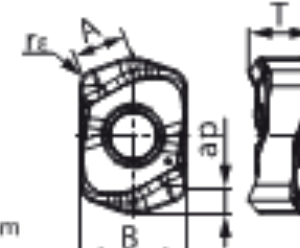
ML type
 B = 8,2mm
 T = 5,6mm
 re = 4,0mm
 ap max = 4mm



MJ type
 B = 8,2mm
 T = 5,6mm
 re = 4,0mm
 ap max = 4mm



HJ type
 B = 8,2mm
 T = 5,0mm
 A = 4,2mm
 re = 1,3mm
 ap max = 1,3mm



			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		LNMX 0405R4-ML	AH120	B5A35MXML01	●	○	○	●	●	●	●	●	●	●
				AH3135	B5A35MXML02	●	●	●	●	●	●	●	●	○	●
ROUGH.	MJ		LNMX 0405R4-MJ	AH120	B5A36MXMJ01	●	○	○	●	●	●	●	●	●	●
				AH3135	B5A36MXMJ02	●	●	●	●	●	●	●	●	○	●
HIGH FEED	HJ		LNMX 0405ZER-HJ	AH120	B5A37MXHJ01	●	○	○	●	●	●	●	●	●	●
				AH3135	B5A37MXHJ02	●	●	●	●	●	●	●	●	○	●

● RECOMMENDED FOR... ○ USABLE FOR...

RECOMMENDED CUTTING DATA

Material	Hardness Brinnell HB	Priority	Recommended geometries	Recommended grades	Cutting speed Vc (m/min.)	Feed MJ - ML f/2 mm	Feed HJ f/2 mm
Carbon steel (C45-C55, etc.)	~ 300 HB	Low cutting forces	ML	AH3135	150 - 250	0.20 - 0.60	0.50 - 1.30
	~ 300 HB	Impact resistant	MJ	AH3135	150 - 250	0.20 - 0.60	0.50 - 1.30
Alloy steel (42CRMo4, 17Cr3, etc.)	~ 300 HB	Low cutting forces	ML	AH3135	150 - 250	0.20 - 0.60	0.50 - 1.30
	~ 300 HB	Impact resistant	MJ	AH3135	150 - 250	0.20 - 0.60	0.50 - 1.30
Hardened and tempered steel (NAK80, PX5, etc.)	30 ~ 40 HRC	Low cutting forces	ML	AH3135	100 - 200	0.15 - 0.40	0.30 - 0.70
	30 ~ 40 HRC	Impact resistant	MJ	AH3135	100 - 200	0.15 - 0.40	0.30 - 0.70
Stainless steel (X5CrNi 18-9, etc.)	~ 200 HB	First choice	ML	AH3135	100 - 200	0.20 - 0.60	0.30 - 0.70
	~ 200 HB	Impact resistant	MJ	AH3135	100 - 200	0.20 - 0.60	0.30 - 0.70
Cast iron (GG25, GG30, etc.)	150 ~ 250HB	First choice	MJ	AH120	150 - 250	0.20 - 0.60	0.50 - 1.30
Spheroidal cast iron (GGG40, etc.)	150 ~ 250HB	First choice	MJ	AH120	150 - 250	0.20 - 0.60	0.50 - 1.30
Titanium alloys (Ti-6AL-4V, etc.)	~ 40HRC	First choice	ML	AH3135	20 - 50	0.15 - 0.40	0.30 - 0.70
Hardened steel (SKD61, etc.)	40 ~ 50 HRC	First choice	MJ	AH3135	50 - 150	0.10 - 0.30	0.10 - 0.50
Hardened steel (SKD11, etc.)	40 ~ 50 HRC	First choice	MJ	AH120	50 - 70	0.05 - 0.15	0.05 - 0.20