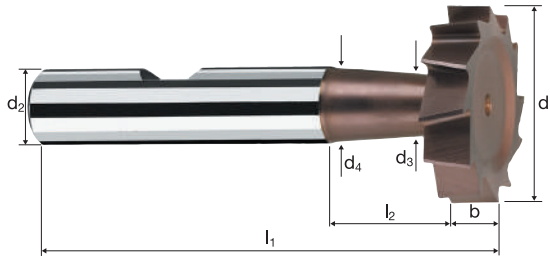


Slotting end mills

HSS

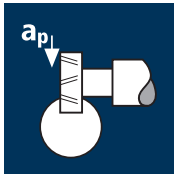
HSS-E λ 10°
Co8 γ 8°



Rm < 850	Rm 850-1100	Rm 1100-1300					Inox Stainless	Ti Titanium	GG(G) Aluminium Copper
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Example: Order-N°.										UNICUT-4X	
										U0905	
Coating: U Article-N°: 0905 ø-Code: 100											
Ø Code	d ₁ h11	d ₂ h6	d ₃	d ₄	l ₁	l ₂	b e8	z			
100	4.50	6.00	1.80	5.50	50	12.00	1.0	8	●		
150	7.50	6.00	2.80	5.50	50	11.00	1.5	8	●		
160	7.50	6.00	3.20	5.50	50	10.00	2.0	8	●		
200	10.50	6.00	4.00	5.50	50	11.00	2.0	8	●		
210	10.50	6.00	4.00	5.50	50	10.00	2.5	8	●		
220	10.50	6.00	4.20	5.50	50	9.00	3.0	8	●		
310	13.50	10.00	4.60	9.50	56	13.00	2.5	8	●		
320	13.50	10.00	4.60	9.50	56	12.00	3.0	8	●		
330	13.50	10.00	4.60	9.50	56	11.00	4.0	8	●		
360	16.50	10.00	4.60	9.50	56	12.00	3.0	8	●		
370	16.50	10.00	4.60	9.50	56	11.00	4.0	8	●		
380	16.50	10.00	5.00	9.50	56	10.00	5.0	8	●		
410	19.50	10.00	5.60	9.50	63	18.00	3.0	10	●		
420	19.50	10.00	5.60	9.50	63	17.00	4.0	10	●		
430	19.50	10.00	6.00	9.50	63	16.00	5.0	10	●		
440	19.50	10.00	6.50	9.50	63	15.00	6.0	10	●		
500	22.50	10.00	6.00	9.50	63	17.00	4.0	10	●		
510	22.50	10.00	6.00	9.50	63	16.00	5.0	10	●		
520	22.50	10.00	6.50	9.50	63	15.00	6.0	10	●		
540	22.50	10.00	6.50	9.50	63	14.00	8.0	10	●		

Application



Material

Steel
< 850 N/mm²



d1 [mm]	z	v _c [m/min]	f _t [mm]	a _p [mm]	a _e [mm]	n [min ⁻¹]	v _r [mm/min]
7.50	8	55	0.005	2.000	2.000	2335	95
10.50	8	55	0.010	2.900	3.000	1665	135
13.50	8	55	0.010	3.800	4.000	1295	105
16.50	8	55	0.025	5.000	5.000	1060	210
19.50	10	55	0.035	5.500	6.000	900	315
22.50	10	55	0.040	6.600	8.000	780	310

Steel
850 - 1100 N/mm²



7.50	8	45	0.005	2.000	2.000	1910	75
10.50	8	45	0.010	2.900	3.000	1365	110
13.50	8	45	0.010	3.800	4.000	1060	85
16.50	8	45	0.025	5.000	5.000	870	175
19.50	10	45	0.035	5.500	6.000	735	255
22.50	10	45	0.040	6.600	8.000	635	255

Steel
1100 - 1300 N/mm²



7.50	8	34	0.005	2.000	2.000	1445	60
10.50	8	34	0.010	2.900	3.000	1030	80
13.50	8	34	0.010	3.800	4.000	800	65
16.50	8	34	0.025	5.000	5.000	655	130
19.50	10	34	0.035	5.500	6.000	555	195
22.50	10	34	0.040	6.600	8.000	480	190

Stainless steel
[Cr-Ni/1.4301]



7.50	8	21	0.005	2.000	2.000	890	35
10.50	8	21	0.010	2.900	3.000	635	50
13.50	8	21	0.010	3.800	4.000	495	40
16.50	8	21	0.025	5.000	5.000	405	80
19.50	10	21	0.035	5.500	6.000	345	120
22.50	10	21	0.040	6.600	8.000	295	120

Cast iron
(lamellar / spheroidal)



7.50	8	21	0.005	2.000	2.000	890	35
10.50	8	21	0.010	2.900	3.000	635	50
13.50	8	21	0.010	3.800	4.000	495	40
16.50	8	21	0.025	5.000	5.000	405	80
19.50	10	21	0.035	5.500	6.000	345	120
22.50	10	21	0.040	6.600	8.000	295	120

Unalloyed copper



7.50	8	65	0.005	2.000	2.000	2760	110
10.50	8	65	0.010	2.900	3.000	1970	160
13.50	8	65	0.010	3.800	4.000	1535	125
16.50	8	65	0.025	5.000	5.000	1255	250
19.50	10	65	0.035	5.500	6.000	1060	370
22.50	10	65	0.040	6.600	8.000	920	370

Titanium alloys
up to 300 HB
[Ti5Al2.5Sn]



7.50	8	23	0.005	2.000	2.000	975	40
10.50	8	23	0.010	2.900	3.000	695	55
13.50	8	23	0.010	3.800	4.000	540	45
16.50	8	23	0.025	5.000	5.000	445	90
19.50	10	23	0.035	5.500	6.000	375	130
22.50	10	23	0.040	6.600	8.000	325	130

Wrought aluminium
Si < 6%

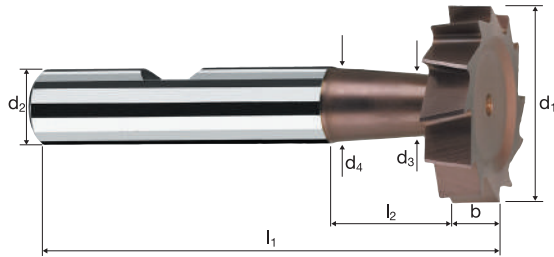
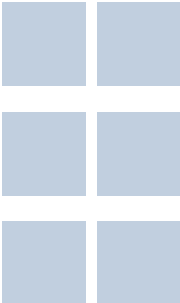


7.50	8	80	0.005	2.000	2.000	3395	135
10.50	8	80	0.010	2.900	3.000	2425	195
13.50	8	80	0.010	3.800	4.000	1885	150
16.50	8	80	0.025	5.000	5.000	1545	310
19.50	10	80	0.035	5.500	6.000	1305	455
22.50	10	80	0.040	6.600	8.000	1130	455

Slotting end mills

HSS

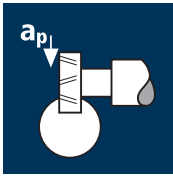
HSS-E λ 10°
Co8 γ 8°



Rm < 850	Rm 850-1100	Rm 1100-1300					Inox Stainless	Ti Titanium	GG(G) Aluminium Copper
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									UNICUT-4X	
Example: Order-N°.									U0905	
									[Profile Icon]	
									[Coating: U]	
									[Article-N°: 0905]	
									[ø-Code: 600]	
Ø Code	d ₁ h11	d ₂ h6	d ₃	d ₄	l ₁	l ₂	b e8	z		
600	25.50	10.00	7.50	9.50	63	16.00	5.0	12		●
610	25.50	10.00	7.50	9.50	63	15.00	6.0	12		●
650	28.50	10.00	8.50	9.50	63	14.00	6.0	12		●
660	28.50	10.00	8.50	9.50	63	13.00	8.0	12		●
700	28.50	12.00	9.30	11.50	71	14.00	10.0	12		●
750	32.50	12.00	8.50	11.50	71	18.00	6.0	12		●
760	32.50	12.00	8.50	11.50	71	17.00	7.0	12		●
770	32.50	12.00	8.50	11.50	71	16.00	8.0	12		●
800	32.50	12.00	9.30	11.50	71	15.00	10.0	12		●
900	45.50	12.00	11.00	11.50	71	14.00	10.0	14		●

Application



Material

Steel
< 850 N/mm²



d1 [mm]	z	v _c [m/min]	f _c [mm]	a _p [mm]	a _c [mm]	n [min ⁻¹]	v _r [mm/min]
25.50	12	55	0.045	7.000	6.000	685	370
28.50	12	55	0.050	8.200	10.000	615	370
32.50	12	55	0.060	9.800	10.000	540	390
45.50	14	55	0.080	12.000	10.000	385	430

Steel
850 - 1100 N/mm²



d1 [mm]	z	v _c [m/min]	f _c [mm]	a _p [mm]	a _c [mm]	n [min ⁻¹]	v _r [mm/min]
25.50	12	45	0.045	7.000	6.000	560	305
28.50	12	45	0.050	8.200	10.000	505	300
32.50	12	45	0.060	9.800	10.000	440	315
45.50	14	45	0.080	12.000	10.000	315	355

Steel
1100 - 1300 N/mm²



d1 [mm]	z	v _c [m/min]	f _c [mm]	a _p [mm]	a _c [mm]	n [min ⁻¹]	v _r [mm/min]
25.50	12	34	0.045	7.000	6.000	425	230
28.50	12	34	0.050	8.200	10.000	380	230
32.50	12	34	0.060	9.800	10.000	335	240
45.50	14	34	0.080	12.000	10.000	240	265

Stainless steel
[Cr-Ni/1.4301]



d1 [mm]	z	v _c [m/min]	f _c [mm]	a _p [mm]	a _c [mm]	n [min ⁻¹]	v _r [mm/min]
25.50	12	21	0.045	7.000	6.000	260	140
28.50	12	21	0.050	8.200	10.000	235	140
32.50	12	21	0.060	9.800	10.000	205	150
45.50	14	21	0.080	12.000	10.000	145	165

Cast iron
(lamellar / spheroidal)



d1 [mm]	z	v _c [m/min]	f _c [mm]	a _p [mm]	a _c [mm]	n [min ⁻¹]	v _r [mm/min]
25.50	12	21	0.045	7.000	6.000	260	140
28.50	12	21	0.050	8.200	10.000	235	140
32.50	12	21	0.060	9.800	10.000	205	150
45.50	14	21	0.080	12.000	10.000	145	165

Unalloyed copper



d1 [mm]	z	v _c [m/min]	f _c [mm]	a _p [mm]	a _c [mm]	n [min ⁻¹]	v _r [mm/min]
25.50	12	65	0.045	7.000	6.000	810	440
28.50	12	65	0.050	8.200	10.000	725	435
32.50	12	65	0.060	9.800	10.000	635	460
45.50	14	65	0.080	12.000	10.000	455	510

Titanium alloys
up to 300 HB
[Ti5Al2.5Sn]



d1 [mm]	z	v _c [m/min]	f _c [mm]	a _p [mm]	a _c [mm]	n [min ⁻¹]	v _r [mm/min]
25.50	12	23	0.045	7.000	6.000	285	155
28.50	12	23	0.050	8.200	10.000	255	155
32.50	12	23	0.060	9.800	10.000	225	160
45.50	14	23	0.080	12.000	10.000	160	180

Wrought aluminium
Si < 6%



d1 [mm]	z	v _c [m/min]	f _c [mm]	a _p [mm]	a _c [mm]	n [min ⁻¹]	v _r [mm/min]
25.50	12	80	0.045	7.000	6.000	1000	540
28.50	12	80	0.050	8.200	10.000	895	535
32.50	12	80	0.060	9.800	10.000	785	565
45.50	14	80	0.080	12.000	10.000	560	625