

# VHM HGT END MILLS



- ⊕ HIGH CHIP VOLUME
- ⊕ HIGH FEED RATES
- ⊕ INCREASED FEED MOTION





# 0384 56 END MILLS HGT

4 flutes for high precision milling

<b>VHM</b>	<b>HPC</b>	

4 flutes, plain shank, straight face, centre cutting, 50° right hand helix, PVTi-coated

- standard series
- corner radius
- unequal division
- also available with clamping flats, from 12 mm diam. upwards compulsory
- **on demand: available with working depths**

Material qualification	steel	heat-resistant alloys	stainless steel	cast iron	non-ferrous-metals / materials	hardened steel	grade	coating
A							UMGC	PVTi

Solid carbide end mills	Catalogue-No.										price €	features
	$d_1$	$l_2$	$l_3$	$d_3$	$l_1$	$r$	$d_2$	$z$				

no wd.   standard series												
	NVV 0384 56 060	6	12	-	-	57	0,5	6	4			<input checked="" type="checkbox"/>
	NVV 0384 56 061	6	12	-	-	57	1	6	4			<input checked="" type="checkbox"/>
	NVV 0384 56 080	8	16	-	-	63	0,5	8	4			<input checked="" type="checkbox"/>
	NVV 0384 56 081	8	16	-	-	63	1	8	4			<input checked="" type="checkbox"/>
	NVV 0384 56 100	10	20	-	-	72	0,5	10	4			<input checked="" type="checkbox"/>
	NVV 0384 56 101	10	20	-	-	72	1	10	4			<input checked="" type="checkbox"/>
	NVV 0384 56 120	12	24	-	-	83	1	12	4			<input checked="" type="checkbox"/>
	NVV 0384 56 021	12	24	-	-	83	2	12	4			<input checked="" type="checkbox"/>
	NVV 0384 56 160	16	32	-	-	92	1	16	4			<input checked="" type="checkbox"/>
	NVV 0384 56 161	16	32	-	-	92	2	16	4			<input checked="" type="checkbox"/>
	NVV 0384 56 200	20	40	-	-	104	1	20	4			<input checked="" type="checkbox"/>
	NVV 0384 56 201	20	40	-	-	104	2	20	4			<input checked="" type="checkbox"/>

# SPEED/FEED PER TOOTH/ DEPTH OF CUT

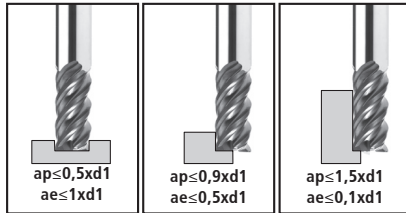


HGT- end mills for pocket- and slotmilling

0384



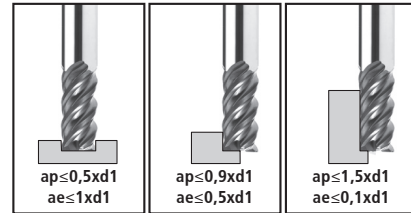
High-temperature alloys  
1.4542 usw.:



feed per tooth  $f_z$   
speed  $V_c = 25$  m/min

$d_1$	$f_z$	$f_z$	$f_z$
6	0,020	0,025	0,025
8	0,030	0,035	0,035
10	0,035	0,045	0,045
12	0,040	0,050	0,050
16	0,060	0,075	0,070
20	0,070	0,080	0,075

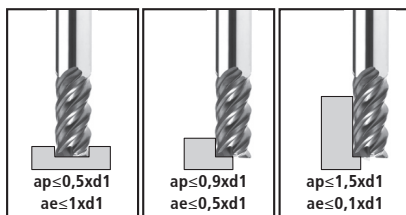
High nickel alloys (inconel)  
718 usw.:



feed per tooth  $f_z$   
speed  $V_c = 15$  m/min

$d_1$	$f_z$	$f_z$	$f_z$
6	0,020	0,025	0,025
8	0,030	0,035	0,035
10	0,035	0,045	0,045
12	0,040	0,050	0,050
16	0,060	0,075	0,070
20	0,070	0,080	0,075

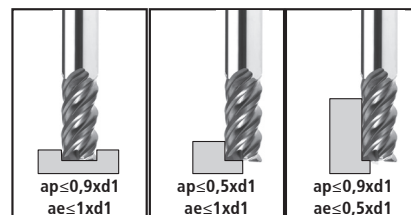
Stainless steel  
1.4401, 1.4571, 1.4404 (Cr-Ni-Mo) usw.:



feed per tooth  $f_z$   
speed  $V_c = 40$  m/min

$d_1$	$f_z$	$f_z$	$f_z$
6	0,025	0,025	0,035
8	0,035	0,035	0,050
10	0,045	0,045	0,070
12	0,050	0,050	0,080
16	0,075	0,075	0,090
20	0,080	0,080	0,100

Stainless steel  
1.4301, 1.4541, 1.4307 (Cr-Ni) usw.:



feed per tooth  $f_z$   
speed  $V_c = 80$  m/min

$d_1$	$f_z$	$f_z$	$f_z$
6	0,025	0,025	0,040
8	0,035	0,035	0,055
10	0,045	0,045	0,075
12	0,050	0,050	0,085
16	0,075	0,075	0,100
20	0,080	0,080	0,125

These speed and feed values are approximate. Customer-specific factors such as input power, machine stability, tool overhang, etc. are not taken into account. In order to guarantee optimum and economic cutting conditions with our tools, please ask our office or one of our application engineers.

## CONTACT

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