

Chamfering Milling Cutters - Metric - Standard Length



Standard



No. Flutes



Helix angle



Included Angle



Rake Angle



Tool material

Solid Carbide

Surface finish

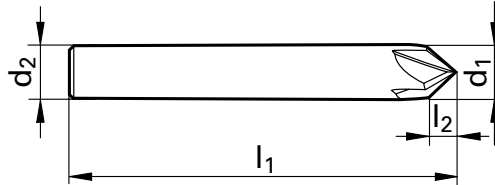
TiAlN

Series

6713

Application group	Material examples	Ideal for
P	Steel	●
M	Stainless steel	●
K	Cast iron	●
N	Aluminum	●
S	Ni / Ti alloys	○
H	Hardened steel	○

●=Optimal ○=Secondary



Speed and Feed data shown below

d1 h10	d2 h6	l1	l2	No. of Flutes	Code no.	EDP Number
mm	mm	mm	mm			
4.000	4.000	50.00	2.00	4	4.000	9067130040000
6.000	6.000	57.00	2.00	4	6.000	9067130060000
8.000	8.000	63.00	4.00	4	8.000	9067130080000
10.000	10.000	72.00	5.00	4	10.000	9067130100000
12.000	12.000	83.00	6.00	4	12.000	9067130120000

Speeds & Feeds - Chamfering milling cutters

Material	Hardness	Cutting speed SFM	Feed Rate Inch per Tooth - IPT d1 End Mill Diameter						
			3	6	8	10	12	16	20
Struct./free-cutting steels, unall. heat-treat./case hard. steels	Up To 28 HRc	525	0.0004	0.0005	0.0006	0.0010	0.0013	0.0017	0.0019
Free-cutting steels, unalloyed case hard. steels, nitr. steels	28-44 HRc	460	0.0003	0.0004	0.0005	0.0006	0.0010	0.0013	0.0017
Alloyed heat-treatable, tool and high speed steels	38-44 HRc	360	0.0003	0.0004	0.0005	0.0006	0.0010	0.0013	0.0017
Hardened Steels	up to 54 HRc	300	0.0003	0.0004	0.0005	0.0006	0.0010	0.0013	0.0017
	54-60 HRc	200	0.0003	0.0004	0.0005	0.0006	0.0010	0.0013	0.0017
Stainless steel - easy to machine / sulphured	up to 20 HRc	260	0.0003	0.0004	0.0005	0.0006	0.0010	0.0013	0.0017
Stainless steel - moderately difficult to machine	20-30 HRc	160	0.0003	0.0004	0.0005	0.0006	0.0010	0.0013	0.0017
Titanium, Titanium alloys	Up to 42 HRc	250	0.0003	0.0004	0.0005	0.0006	0.0010	0.0013	0.0017
High-temp alloys	Up to 42 HRc	148	0.0003	0.0004	0.0005	0.0006	0.0010	0.0013	0.0017
Cast iron, grey cast iron, spher. graphite/malleable cast iron	over 240 HB30	500	0.0004	0.0005	0.0006	0.0010	0.0013	0.0017	0.0019
		425	0.0003	0.0004	0.0005	0.0006	0.0010	0.0013	0.0017
Aluminum, Al-wrought alloys, Al-alloys	less than 7% Si	574	0.0005	0.0007	0.0010	0.0013	0.0017	0.0019	0.0025