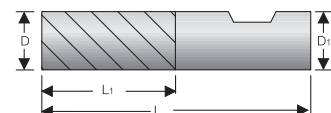
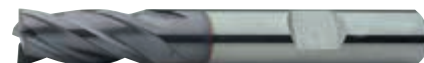


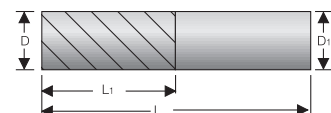
Short with driving plane

D mm	L1 mm	L mm	D1 mm	Feed fz		DIN 6535-HB art.no.	€
				steel < 1000 N/mm <sup>2</sup> mm/tooth	steel < 1000 N/mm <sup>2</sup> mm/tooth		
3.0	8	45	6.0	0.010	0.055	254006 0030	36,30
4.0	11	45	6.0	0.010	0.044	254006 0040	36,30
5.0	13	50	6.0	0.020	0.044	254006 0050	36,30
6.0	13	50	6.0	0.020	0.041	254006 0060	36,30
7.0	16	60	8.0	0.020	0.041	254006 0070	45,70
8.0	19	60	8.0	0.030	0.041	254006 0080	45,70
9.0	19	70	10.0	0.030	0.041	254006 0090	67,50
10.0	22	70	10.0	0.040	0.042	254006 0100	67,50
11.0	22	75	12.0	0.045	0.042	254006 0110	91,50
12.0	26	75	12.0	0.050	0.042	254006 0120	91,50
14.0	26	85	14.0	0.060	0.042	254006 0140	118,-
16.0	32	100	16.0	0.060	0.042	254006 0160	157,-
20.0	38	105	20.0	0.080	0.045	254006 0200	220,-
25.0	45	120	25.0	0.100	0.058	254006 0250	400,-



Long

D mm	L1 mm	L mm	D1 mm	Feed fz		DIN 6535-HA art.no.	€
				steel < 1000 N/mm <sup>2</sup> mm/tooth	steel < 1000 N/mm <sup>2</sup> mm/tooth		
2.0	8	40	4.0	0.010	0.055	254007 0020	29,-
3.0	12	50	6.0	0.010	0.055	254007 0030	42,60
4.0	15	50	6.0	0.020	0.044	254007 0040	42,60
5.0	20	60	6.0	0.020	0.044	254007 0050	42,60
6.0	20	60	6.0	0.020	0.041	254007 0060	42,60
8.0	25	70	8.0	0.030	0.041	254007 0080	52,50
10.0	30	90	10.0	0.040	0.042	254007 0100	80,50
12.0	30	90	12.0	0.050	0.042	254007 0120	109,-
14.0	40	110	16.0	0.060	0.042	254007 0140	157,-
16.0	50	110	16.0	0.060	0.042	254007 0160	205,-
20.0	55	110	20.0	0.080	0.045	254007 0200	350,-
25.0	75	140	25.0	0.100	0.058	254007 0250	579,-



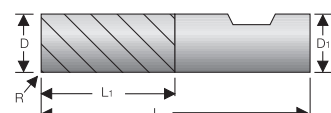
2109

2109

VAN HOORN CARBIDE VHRS end milling cutter

VHM Z 4 Z 5 TiAlN 727

- Cutting material, solid carbide ultra-fine grain TiAlN-coated
- Special pre-treatment and finishing treatment due to micro radiation
- Version with 4 or 5 cutting edges
- For wet and dry machining, extremely high chip removal rates and service life



material	● very well suited	steel			stainless steel			cast iron		titanium alloys	superalloys Fe/NiCo-based		aluminium		copper	graphite	hardened steel			
	○ well suited	< 700 N/mm <sup>2</sup>	< 1000 N/mm <sup>2</sup>	< 1400 N/mm <sup>2</sup>	ferrit/martens.	austenitic	duplex	GG/GTS	GGG		< 30 HRc	≥ 30 HRc	< 8 % Si	≥ 8 % Si	Cu-alloy	GRP/CFP/thermo.	< 55 HRc	< 60 HRc	≥ 60 HRc	
		●	●	●	●	●		●	●											
		140-220	100-180	70-160	80-130	60-100		100-160	90-140											

Cutting speed Vc m/min. Please adjust these guidelines according to clamping operation and machine set-up.

Standard, 4 cutting edges

D mm	R mm	D1 mm	L mm	L1 mm	Z	Feed fz		DIN 6535-HB art.no.	€
						steel < 1000 N/mm <sup>2</sup> mm/tooth	steel < 1000 N/mm <sup>2</sup> mm/tooth		
3	0.2	6	51	7	4	0.01	0.015	255100 0302	38,10
4	0.2	6	51	9	4	0.012	0.02	255100 0402	41,80
5	0.2	6	51	11	4	0.02	0.03	255100 0502	45,20
6	0.1	6	64	13	4	0.025	0.035	255100 0601	49,10
6	0.3	6	64	13	4	0.025	0.035	255100 0603	49,10
6	0.5	6	64	13	4	0.025	0.035	255100 0605	49,10
6	1	6	64	13	4	0.025	0.035	255100 0610	49,10
8	0.1	8	64	18	4	0.035	0.045	255100 0801	64,60
8	0.3	8	64	18	4	0.035	0.045	255100 0803	64,60



The specialist in steel

Continued on next page >>>

2113