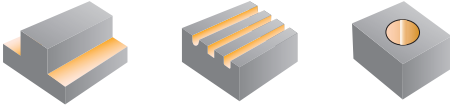
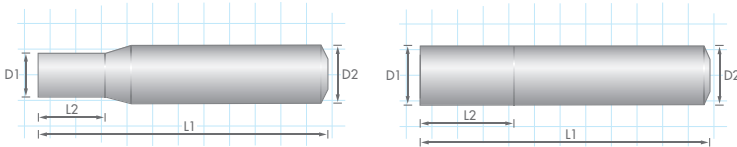


Tool Series 361: HPC Universal & Hard Milling Carbide End Mills



Tolerance	(Uncoated*)	(Coated):
D1:	4-6: -0.007 -0.020	h8
D1:	8-10: -0.007 -0.024	h8
D1:	12: -0.007 -0.026	h8
D2:	h5	h5

* Tools are recommended to be operated in "coated condition" only. Uncoated tolerances allow for custom coatings by third parties.



Uncoated Tool Number	Coated Tool Number	D1	D2	L1	L2	Z
361-4040	361-4040-R	4	6	50	12	4
361-4060	361-4060-R	6	6	50	15	4
361-4080	361-4080-R	8	8	63	20	4
361-4100	361-4100-R	10	10	75	25	4
361-4120	361-4120-R	12	12	75	30	4



Technical Information

Material:	Cast Iron	Carbon Steel	Alloy Steel	Pre-Hardend Steel	Hardend Steel					
Hardness:	150-200 HB	180-220 HB	200-250 HB	25-35 HRC	35-50 HRC					
Cutting Depth:	axial (l) ap: 1.5D1 radial (-) ae: 0.1D1									
Vc (m/min):	90-100	100-110	80-90	60-70	40-50					
Speed & Feed:	n	Vf	n	Vf	n	Vf	n	Vf	n	Vf
	RPM	mm/min	RPM	mm/min	RPM	mm/min	RPM	mm/min	RPM	mm/min
Side Milling (General Conditions / for HSC up to +50% / Finishing Vf -30% to -50%)										
D1: 4	7155	736	8350	1565	6760	1373	4770	397	3580	268
D1: 6	4770	848	5565	1983	4505	1608	3180	397	2385	295
D1: 8	3580	737	4175	1865	3380	1478	2385	616	1790	458
D1: 10	2865	721	3340	1400	2705	1406	1910	603	1430	451
D1: 12	2385	674	2783	1100	2255	1288	1590	506	1195	398
Slotting (General Conditions / for HSC up to +50% / Finishing Vf -30% to -50%)										
D1: 4	3580	268	7555	661	6360	477	4375	317	2785	197
D1: 6	2385	295	5035	765	4240	668	2915	367	1855	267
D1: 8	1790	458	3775	692	3180	625	2185	371	1390	267
D1: 10	1430	451	3020	624	2545	498	1750	339	1115	246
D1: 12	1195	398	2520	609	2120	477	1460	325	930	232

This data recommendation may serve as a general guidance only. The actual cutting parameters may vary in each application. A proportional feed rate adjustment is necessary when the actual RPM is lower than the stated recommendation.