

# Chamfering Milling Cutters - Metric - Standard Length

**NEW**

**A**



Standard



No. Flutes



Helix angle



Included Angle



Rake Angle



Tool material

**Solid Carbide**

Surface finish

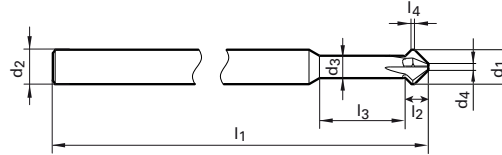
nano-A™

Series

**495**

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

●=Optimal    ○=Secondary



Speed and Feed data shown below

This tool is capable of chamfering on both front and backside of tool.

d1 h10	d2 h6	d3	d4	l1	l2	l3	l4	No. of Flutes	Code no.	EDP Number
mm	mm	mm	mm	mm	mm	mm	mm			
3.000	4.000	2.200	0.600	75.00	2.10	10.00	0.50	4	3.000	<b>9004950030000</b>
4.000	4.000	2.900	0.800	75.00	2.70	13.00	0.50	4	4.000	<b>9004950040000</b>
5.000	5.000	3.900	1.000	75.00	3.00	15.00	0.50	4	5.000	<b>9004950050000</b>
6.000	6.000	3.900	1.200	100.00	3.50	15.00	0.50	4	6.000	<b>9004950060000</b>
8.000	6.000	6.000	1.600	100.00	4.70		0.50	4	8.000	<b>9004950080000</b>
10.000	6.000	6.000	2.000	100.00	6.50		0.50	4	10.000	<b>9004950100000</b>
12.000	6.000	6.000	2.400	100.00	8.30		0.50	4	12.000	<b>9004950120000</b>

## 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