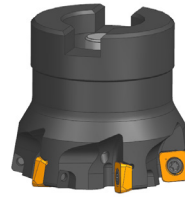
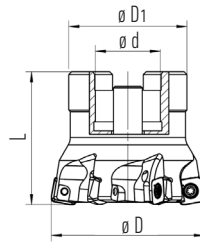


HFC mill F4260



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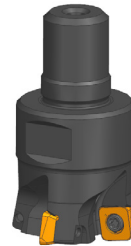
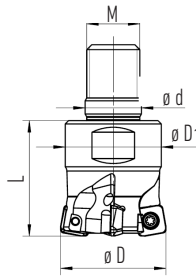
- calm and cultured running
- excellent performance
- positive inserts with 4 edges
- robust replaceable inserts
- for a wide range of milling operations
- internal cooling



Arbor mounting

Order code	Dimensions (mm)					Ap max. (mm)	Insert	Insert screw	Key	Torque value (Nm)	Stock
	D	d	d1	L	z						
F4260.40.N16.40.1.Z5.C	40	16	32	40	5	1,0	SDKW 080310 SDKT 080315	PT009246	XT09	1,4	●
F4260.50.N22.45.1.Z6.C	50	22	40	45	6						●
F4260.52.N22.45.1.Z6.C	52	22	40	45	6						●
F4260.63.N27.50.1.Z7.C	63	27	48	50	7						●
F4260.66.N27.50.1.Z7.C	66	27	48	50	7						●

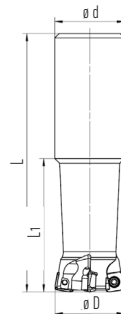
● = stock item



Threaded coupling

Order code	Dimensions (mm)					Ap max. (mm)	Insert	Insert screw	Key	Torque value (Nm)	Stock
	D	M	d1	L	z						
F4260.20.M10.25.1.Z2.C	20	M10	16	25	2	1,0	SDKW 080310 SDKT 080315	PT009246	XT09	1,4	●
F4260.25.M12.28.1.Z3.C	25	M12	21	28	3						●
F4260.32.M16.35.1.Z4.C	32	M16	29	35	4						●
F4260.35.M16.35.1.Z4.C	35	M16	29	35	4						●
F4260.42.M16.35.1.Z5.C	42	M16	29	35	5						●

● = stock item



Cylindrical shank

Order code	Dimensions (mm)					Ap max. (mm)	Insert	Insert screw	Key	Torque value (Nm)	Stock
	D	d	L	L1	z						
F4260.20.V20.130.75.1.Z2.C	20	20	130	75	2	1,0	SDKW 080310 SDKT 080315	PT009246	XT09	1,4	●
F4260.25.V25.140.80.1.Z3.C	25	25	140	80	3						●
F4260.32.V32.150.90.1.Z4.C	32	32	150	90	4						●

● = stock item

HFC mill F4260

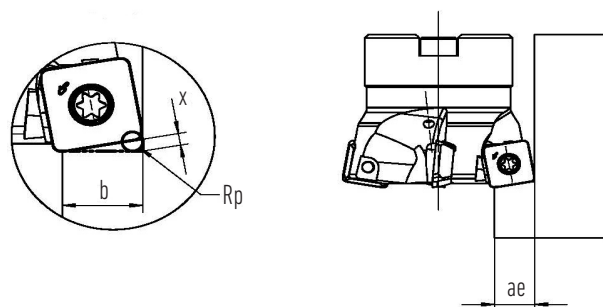
SQUARE MINI



Overview of suitable inserts

Order code	P	M	K	S
SDKW 080310-JGP19	●	○	●	○
SDKT 080315-IKM19	○	●	○	●

● = stock item ○ = available under request



Insert reference	Program			
	Rp	X	b	ae
SDKW	2,0	0,8	6,8	6,3
SDKT				

Recommended cutting conditions

	HB	Coating		Sharper type		
		P19	M19	SDKW	SDKT	
		Cutting speed Vc (m/min.)		Feed fz (mm/t)		
P	Unalloyed steel	125 - 220	180 - 250	-	0,40 - 1,80	0,40 - 1,80
	Low-alloyed steel	220 - 280	160 - 230	-	0,40 - 1,80	-
	High-alloyed steel	280 - 380	140 - 220	-	0,40 - 1,50	-
M	SS - Ferritic / Martensitic	200 - 330	-	140 - 210	-	0,40 - 1,30
	SS - Austenitic	200 - 330	-	120 - 170	-	0,40 - 1,30
	SS - austenitic - ferritic (Duplex)	230 - 260	-	100 - 150	-	0,10 - 1,00
K	Grey cast iron	180 - 245	160 - 270	-	0,40 - 1,80	0,40 - 1,80
	Malleable cast Iron	130 - 230	140 - 250	-	0,40 - 1,80	-
		160 - 250	120 - 210	-	0,40 - 1,80	-
S	Superalloys	200 - 320	-	30 - 110	-	0,40 - 1,00

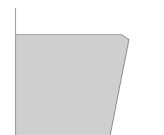
Cutting conditions ae/D=70%

Insert reference

SDKW



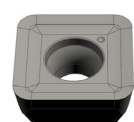
Blade shape



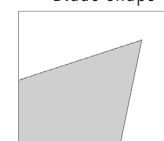
solid cutting edge for roughing steel, alloy steel and hardened steel

Insert reference

SDKT



Blade shape



low cutting force for medium machining of stainless steel and high-temperature alloys

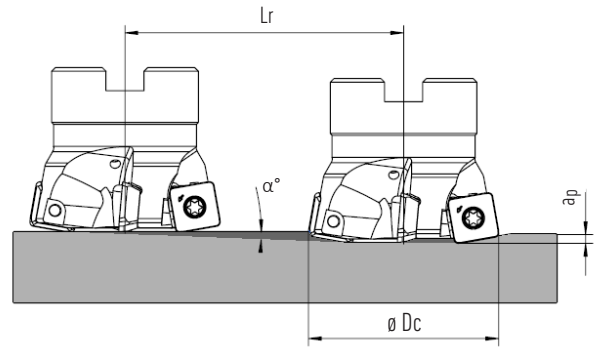
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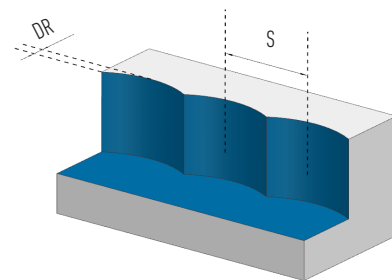
Ramping

Ø Dc	Ramping		
	Max Ramp a°	Max ap	Min Lr
20	15	1,0	3,2
25	9,5	1,0	6,0
32	5,5	1,0	10,4
35	4,5	1,0	12,7
40	3,5	1,0	16,3
42	3,5	1,0	16,3
50	3,5	1,0	16,3
52	3,5	1,0	16,3



Plunging

L ≤ 3Dc	L > 3Dc	S max.
Fz (mm/t)		
0,08-0,15	0,05-0,10	$S_{max} = \sqrt{D \cdot DR - DR^2}$



S max and DR corresponding to Dc (mm)

DR (mm)	Dc (mm)									
	20	25	32	35	40	42	50	52	63	66
1,0	4,4	4,9	5,6	5,8	6,2	6,4	7,0	7,1	7,9	8,1
2,0	6,0	6,8	7,7	8,1	8,7	8,9	9,8	10,0	11,0	11,3
3,0	7,1	8,1	9,3	9,8	10,5	10,8	11,9	12,1	13,4	13,7
4,0	8,0	9,2	10,6	11,1	12,0	12,3	13,6	13,9	15,4	15,7
5,0	8,7	10,0	11,6	12,2	13,2	13,6	15,0	15,3	17,0	17,5
6,0	9,2	10,7	12,5	13,2	14,3	14,7	16,2	16,6	18,5	19,0