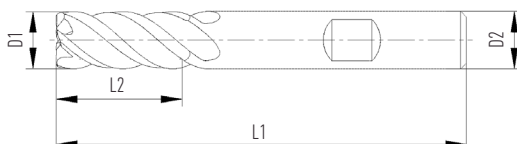


End mill F8301

UNIVERSAL / 4 FLUTES

- helix angle 40°/42°
- length of flute 2xD
- unequal flute spacing
- internal coolant
- corner chamfer 45°
- coating PVD



Weldon shank

| Order code | Dimensions (mm) | | | | |
|------------------------|-----------------|----|-----|----|---|
| | D1 | D2 | L1 | L2 | Z |
| F8301.6.W6.57.12.Z4 | 6 | 6 | 57 | 12 | 4 |
| F8301.8.W8.63.16.Z4 | 8 | 8 | 63 | 16 | 4 |
| F8301.10.W10.72.20.Z4 | 10 | 10 | 72 | 20 | 4 |
| F8301.12.W12.83.24.Z4 | 12 | 12 | 83 | 24 | 4 |
| F8301.16.W16.92.32.Z4 | 16 | 16 | 92 | 32 | 4 |
| F8301.20.W20.104.40.Z4 | 20 | 20 | 104 | 40 | 4 |

Recommended cutting conditions

| ISO | Strenght (N/mm ²) Material | Ap (mm) | Ae (mm) | Vc (m/min.) | Feed fz (mm/t) | | | | | |
|-----|---|----------------------------|------------|----------------|------------------|-------|-------|-------|-------|-------|
| | | | | | by mill diameter | | | | | |
| | | | | | 6 | 8 | 10 | 12 | 16 | 20 |
| M | Ferritic materials | D×2 | D×0,1 | 75 | 0,040 | 0,060 | 0,070 | 0,080 | 0,120 | 0,140 |
| | | D×2 | D×0,20 | 55 | 0,025 | 0,035 | 0,038 | 0,045 | 0,068 | 0,080 |
| | | Dx1 | Dx1 | 45 | 0,020 | 0,030 | 0,030 | 0,040 | 0,060 | 0,070 |
| | | Ramping = 7° | | 40 | 0,010 | 0,014 | 0,014 | 0,019 | 0,028 | 0,033 |
| | | Helical interpolation = 7° | | 40 | 0,010 | 0,014 | 0,014 | 0,019 | 0,028 | 0,033 |
| M | Austenitic materials | Dx2 | D×0,1 | 63 | 0,040 | 0,060 | 0,070 | 0,080 | 0,120 | 0,140 |
| | | Dx2 | D×0,20 | 47 | 0,025 | 0,035 | 0,038 | 0,045 | 0,068 | 0,080 |
| | | Dx1 | Dx1 | 38 | 0,020 | 0,030 | 0,030 | 0,040 | 0,060 | 0,070 |
| | | Ramping = 7° | | 30 | 0,010 | 0,014 | 0,014 | 0,019 | 0,028 | 0,033 |
| | | Helical interpolation = 7° | | 30 | 0,010 | 0,014 | 0,014 | 0,019 | 0,028 | 0,033 |