



# NiTiCo 30

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Uncover the new NiTiCo 30 specifically  
designed for trochoidal milling



## WITHOUT OIL HOLE ENDMILLS



EDP No.	Design	Z	Diameter Range	Page	Stock
K50 <b>NEW</b>	DH WITH CHIP BREAKER, RECESS & WELDON	5	4.0 - 20.0	4	•
K51 <b>NEW</b>	DH LONG WITH CHIP BREAKER, RECESS & WELDON	5	6.0 - 20.0	5	•
J89	DH	5	4.0 - 20.0	6	•
J90	DH WITH WELDON	5	4.0 - 20.0	6	•/○
J92	DH LONG	5	6.0 - 20.0	7	•
J93	DH LONG WITH WELDON	5	6.0 - 20.0	7	•/○

## WITH OIL HOLE ENDMILLS



EDP No.	Design	Z	Diameter Range	Page	Stock
K65	DH WITH INTERNAL OIL HOLE, CHIP BREAKER, RECESS & WELDON	5	4.0 - 20.0	9	•
K67	DH LONG WITH INTERNAL OIL HOLE, CHIP BREAKER, RECESS & WELDON	5	6.0 - 20.0	10	•

Legend : • Ex stock ○ Upon Request

# NiTiCo 30 DH

01

## 5 Flutes Design

- The 5 flute design offers increased feed rates up to 25% over 4 flute tools and can be used in slotting, profiling and semi-finishing applications.

02

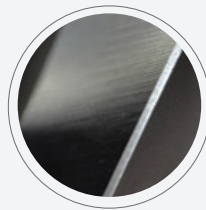
## Small Corner Radius

- For less chipping of the cutting edges and longer tool life.

03

## Variable Helix (DH)

- For chatter free machining and excellent surface finishes.



04

## Ideal Cutting Edge Design

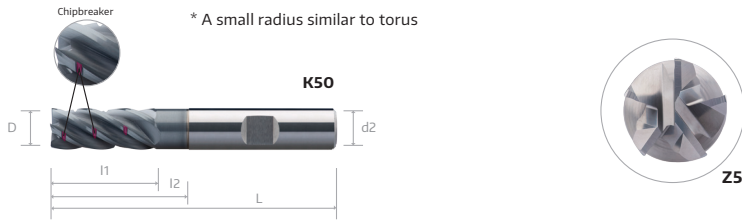
- Provides edge protection, prolonging tool life



05

## Optimized Geometry with Chipbreakers

- Efficiently shears work materials and shortens chips for improved chips removal.



Order Number <span style="border: 1px solid black; padding: 2px;">DIN 6535</span>	Dimension (mm)						K50
	D	l1	l2	L	d2(h6)	R	G6110
K50 0400 057 06	4	10	15	57	6	0.1	•
K50 0600 057 *	6	15	20	57	6	0.1	•
K50 0800 064	8	20	25	64	8	0.15	•
K50 1000 072 *	10	25	30	72	10	0.2	•
K50 1200 083 *	12	30	38	83	12	0.2	•
K50 1600 092 *	16	39	44	92	16	0.3	•
K50 2000 104 *	20	48	54	104	20	0.3	•

\* - DIN 6535

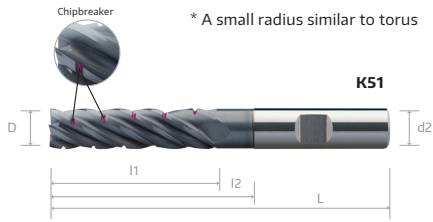
● Ex Stock	ab Lager	De Stock	Da Magazzino	有存库
○ Upon Request	auf Anfrage	à la demande	Su ordinazione	无存库

Material Group | Materialgruppe | Groupe Matiere | Gruppo Materiali | 材质主类

Cutting Parameter



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Order Number	DIN 6535	Dimension (mm)						K51
		D	l1	l2	L	d2(h6)	R	G6110
K51 0600 075		6	26	32	75	6	0.1	•
K51 0800 075	*	8	32	38	75	8	0.2	•
K51 1000 100		10	42	52	100	10	0.2	•
K51 1200 100	*	12	42	54	100	12	0.2	•
K51 1600 125		16	60	68	125	16	0.3	•
K51 2000 125	*	20	67	75	125	20	0.3	•

\* - DIN 6535

• Ex Stock	ab Lager	De Stock	Da Magazzino	有库存
○ Upon Request	auf Anfrage	à la demande	Su ordinazione	无库存

Material Group | Materialgruppe | Groupe Matière | Gruppo Materiali | 材质主类

Cutting Parameter



# J89 / J90

## NiTiCo 30 DH ENDMILLS / WITH WELDON, 5 FLUTES



\* A small radius similar to torus



Order Number	Dimension ( mm )						J89	Order Number	Dimension ( mm )						J90
	D	l1	l2	L	d2(h6)	R	HA G6110		D	l1	l2	L	d2(h6)	R	HB G6110
J89 0400 057 06	4	12		57	6	0.1	•	J90 0400 057 06	4	12		57	6	0.1	○
J89 0500 057 06	5	13		57	6	0.1	•	J90 0500 057 06	5	13		57	6	0.1	•
J89 0600 057	6			57	6	0.1	•	J90 0600 057	6			57	6	0.1	•
J89 0800 064	8	20		64	8	0.2	•	J90 0800 064	8	20		64	8	0.2	•
J89 1000 072	10	22		72	10	0.2	•	J90 1000 072	10	22		72	10	0.2	•
J89 1200 083	12	26		83	12	0.3	•	J90 1200 083	12	26		83	12	0.3	○
J89 1600 092	16	32		92	16	0.3	•	J90 1600 092	16	32		92	16	0.3	○
J89 2000 104	20	38		104	20	0.3	•	J90 2000 104	20	38		104	20	0.3	○

• Ex Stock	ab Lager	De Stock	Da Magazzino	有库存
○ Upon Request	auf Anfrage	à la demande	Su ordinazione	无库存

Material Group | Materialgruppe | Groupe Matière | Gruppo Materiali | 材质主类

Cutting Parameter

N01	N02	N03	K01	K02	P01	P02	P03	M01	M02	S01	S02	S03	H01	H02	O01	O02
●	●	●	●	○	●	●	●	●	●	●	○	●	●	●	●	●

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# J92 / J93

## NiTiCo 30 DH LONG ENDMILLS / WITH WELDON, 5 FLUTES



\* A small radius similar to torus



Order Number	Dimension ( mm )						J92	Order Number	Dimension ( mm )						J93
	D	l1	l2	L	d2(h6)	R	HA G6110		D	l1	l2	L	d2(h6)	R	HB G6110
J92 0600 075	6	25		75	6	0.1	•	J93 0600 075	6	25		75	6	0.1	•
J92 0800 075	8			75	8	0.2	•	J93 0800 075	8			75	8	0.2	•
J92 1000 100	10	38		100	10	0.2	•	J93 1000 100	10	38		100	10	0.2	•
J92 1200 100	12	45		100	12	0.3	•	J93 1200 100	12	45		100	12	0.3	•
J92 1600 125	16	55		125	16	0.3	•	J93 1600 125	16	55		125	16	0.3	◦
J92 2000 125	20	65		125	20	0.3	•	J93 2000 125	20	65		125	20	0.3	•

• Ex Stock	ab Lager	De Stock	Da Magazzino	有库存
◦ Upon Request	auf Anfrage	à la demande	Su ordinazione	无库存

Material Group | Materialgruppe | Groupe Matière | Gruppo Materiali | 材质主类

Cutting Parameter

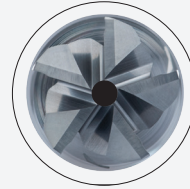


# NiTiCo 30 DH

01

## 5 Flutes Design

- The 5 flute design offers increased feed rates up to 25% over 4 flute tools and can be used in slotting, profiling and semi-finishing applications.



02

## Small Corner Radius

- For less chipping of the cutting edges and longer tool life.

03

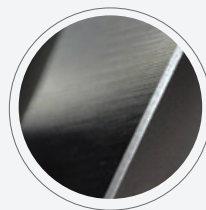
## Variable Helix (DH)

- For chatter free machining and excellent surface finishes.

04

## Ideal Cutting Edge Design

- Provides edge protection, prolonging tool life



05

## Oil Hole for High Performance Milling

- Enables a wide range of machining processes
- Especially beneficial for Difficult to Cut Materials, offering stable machining

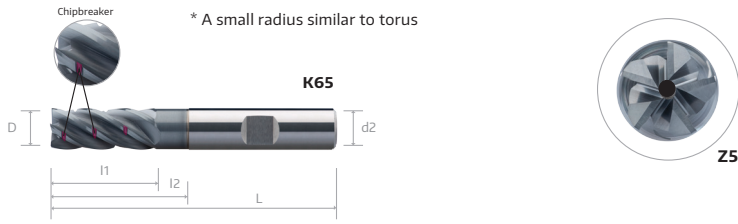


06

## Optimized Geometry with Chipbreakers

- Efficiently shears work materials and shortens chips for improved chips removal.





Order Number <span style="border: 1px solid black; padding: 2px;">DIN 6535</span>	Dimension (mm)						K65
	D	L1	L2	L	d2(h6)	R	G6110
K65 0400 057 06	4	10	15	57	6	0.1	•
K65 0600 057 *	6	15	20	57	6	0.1	•
K65 0800 064	8	20	25	64	8	0.15	•
K65 1000 072 *	10	25	30	72	10	0.2	•
K65 1200 083 *	12	30	38	83	12	0.2	•
K65 1600 092 *	16	39	44	92	16	0.3	•
K65 2000 104 *	20	48	54	104	20	0.3	•

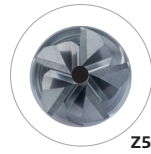
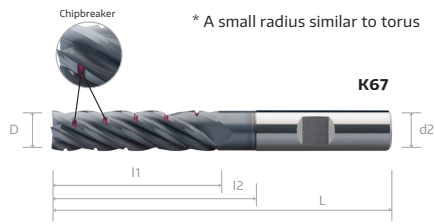
\* - DIN 6535

● Ex Stock	ab Lager	De Stock	Da Magazzino	有存库
○ Upon Request	auf Anfrage	à la demande	Su ordinazione	无存库

Material Group | Materialgruppe | Groupe Matiere | Gruppo Materiali | 材质主类

Cutting Parameter





Order Number	DIN 6535	Dimension (mm)						K67
		D	l1	l2	L	d2(h6)	R	G6110
K67 0600 075		6	26	32	75	6	0.1	•
K67 0800 075	*	8	32	38	75	8	0.2	•
K67 1000 100		10	42	52	100	10	0.2	•
K67 1200 100	*	12	42	54	100	12	0.2	•
K67 1600 125		16	60	68	125	16	0.3	•
K67 2000 125	*	20	67	75	125	20	0.3	•

\* - DIN 6535

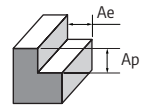
● Ex Stock	ab Lager	De Stock	Da Magazzino	有存库
○ Upon Request	auf Anfrage	à la demande	Su ordinazione	无存库

Material Group | Materialgruppe | Groupe Matiere | Gruppo Materiali | 材质主类

Cutting Parameter



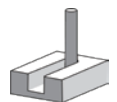
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## DH Endmill with Chip Breaker, Recess and Weldon, 5 Flutes - K50

Side Milling	P01		P02		M01		K01		S01	
Working Material	Carbon Steel		Alloy steel		Stainless Steel		Grey Cast Iron		Titanium	
Properties	-		520 < Rm < 1200		High Machinability		-		-	
Cutting Depth, Ap (mm)	1.00 × D		1.00 × D		1.00 × D		1.00 × D		1.00 × D	
Cutting Width, Ae (mm)	0.25 × D		0.20 × D		0.18 × D		0.25 × D		0.15 × D	
D (mm)	Vc (m/min)	Fz (mm)	Vc (m/min)	Fz (mm)	Vc (m/min)	Fz (mm)	Vc (m/min)	Fz (mm)	Vc (m/min)	Fz (mm)
4	295	0.017	240	0.018	135	0.017	265	0.017	90	0.022
5		0.022		0.024		0.022		0.021		0.028
6		0.027		0.029		0.027		0.026		0.034
8		0.037		0.040		0.037		0.036		0.047
10		0.047		0.052		0.047		0.047		0.060
12		0.057		0.065		0.057		0.057		0.074
16		0.073		0.082		0.072		0.074		0.093
20		0.089		0.097		0.085		0.085		0.111

## DH Endmill with Chip Breaker, Recess and Weldon, 5 Flutes- K50

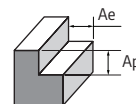


Trochoidal Milling	P01		P02		M01		K01		S01	
Working Material	Carbon Steel		Alloy steel		Stainless Steel		Grey Cast Iron		Titanium	
Properties	-		520 < Rm < 1200		High Machinability		-		-	
Maximum Slot Width (mm)	1.25 × D		1.25 × D		1.25 × D		1.25 × D		1.25 × D	
Cutting Depth, Ap (mm)	1.50 × D		1.50 × D		1.50 × D		1.50 × D		1.50 × D	
Cutting Width, Ae (mm)	0.15 × D		0.12 × D		0.10 × D		0.15 × D		0.10 × D	
D (mm)	Vc (m/min)	Fz (mm)	Vc (m/min)	Fz (mm)	Vc (m/min)	Fz (mm)	Vc (m/min)	Fz (mm)	Vc (m/min)	Fz (mm)
4	345	0.018	290	0.020	170	0.019	315	0.018	120	0.028
5		0.024		0.028		0.026		0.024		0.036
6		0.032		0.037		0.035		0.031		0.045
8		0.044		0.052		0.048		0.044		0.063
10		0.059		0.071		0.064		0.059		0.082
12		0.075		0.094		0.084		0.076		0.108
16		0.094		0.116		0.104		0.094		0.133
20		0.107		0.131		0.117		0.109		0.157



Recommended Cutting Data

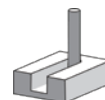
Note: These recommended cutting data indicators are just for reference. They should be adjusted according to the different cutting condition



### DH Long Endmill with Chip Breaker, Recess and Weldon, 5 Flutes - K51

Side Milling	P01		P02		M01		K01		S01	
Working Material	Carbon Steel		Alloy steel		Stainless Steel		Grey Cast Iron		Titanium	
Properties	-		520 < Rm < 1200		High Machinability		-		-	
Cutting Depth, Ap (mm)	1.50 × D		1.50 × D		1.50 × D		1.50 × D		1.50 × D	
Cutting Width, Ae (mm)	0.15 × D		0.12 × D		0.10 × D		0.15 × D		0.10 × D	
D (mm)	Vc (m/min)	Fz (mm)	Vc (m/min)	Fz (mm)	Vc (m/min)	Fz (mm)	Vc (m/min)	Fz (mm)	Vc (m/min)	Fz (mm)
4	270	0.015	220	0.017	120	0.017	240	0.014	80	0.019
5		0.019		0.022		0.020		0.019		0.024
6		0.024		0.027		0.025		0.023		0.030
8		0.032		0.037		0.034		0.031		0.043
10		0.041		0.048		0.043		0.041		0.055
12		0.052		0.06		0.054		0.053		0.070
16		0.066		0.077		0.069		0.067		0.089
20		0.078		0.09		0.080		0.079		0.106

### DH Long Endmill with Chip Breaker, Recess and Weldon, 5 Flutes- K51

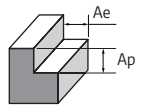


Trochoidal Milling	P01		P02		M01		K01		S01	
Working Material	Carbon Steel		Alloy steel		Stainless Steel		Grey Cast Iron		Titanium	
Properties	-		520 < Rm < 1200		High Machinability		-		-	
Maximum Slot Width (mm)	1.25 × D		1.25 × D		1.25 × D		1.25 × D		1.25 × D	
Cutting Depth, Ap (mm)	2.00 × D		2.00 × D		2.00 × D		2.00 × D		2.00 × D	
Cutting Width, Ae (mm)	0.12 × D		0.10 × D		0.08 × D		0.12 × D		0.08 × D	
D (mm)	Vc (m/min)	Fz (mm)	Vc (m/min)	Fz (mm)	Vc (m/min)	Fz (mm)	Vc (m/min)	Fz (mm)	Vc (m/min)	Fz (mm)
4	315	0.014	270	0.014	150	0.014	285	0.013	105	0.018
5		0.019		0.021		0.019		0.018		0.024
6		0.025		0.028		0.026		0.024		0.030
8		0.035		0.040		0.036		0.034		0.042
10		0.046		0.055		0.049		0.046		0.056
12		0.060		0.071		0.063		0.060		0.074
16		0.071		0.089		0.077		0.070		0.091
20		0.080		0.100		0.088		0.080		0.107



Recommended Cutting Data

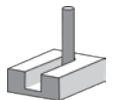
Note: These recommended cutting data indicators are just for reference. They should be adjusted according to the different cutting condition



## DH Endmill, 5 Flutes - J89, J90

Side Milling	P01		P02		M01		K01		S01	
Working Material	Carbon Steel		Alloy steel		Stainless Steel		Grey Cast Iron		Titanium	
Properties	-		520 < Rm < 1200		High Machinability		-		-	
Cutting Depth, Ap (mm)	1.00 × D		1.00 × D		1.00 × D		1.00 × D		1.00 × D	
Cutting Width, Ae (mm)	0.25 × D		0.20 × D		0.18 × D		0.25 × D		0.15 × D	
D (mm)	Vc (m/min)	Fz (mm)	Vc (m/min)	Fz (mm)	Vc (m/min)	Fz (mm)	Vc (m/min)	Fz (mm)	Vc (m/min)	Fz (mm)
4	280	0.018	230	0.018	160	0.018	250	0.017	85	0.024
5		0.023		0.022		0.023		0.022		0.030
6		0.028		0.027		0.028		0.027		0.037
8		0.038		0.038		0.039		0.036		0.051
10		0.048		0.049		0.050		0.049		0.065
12		0.057		0.062		0.063		0.059		0.081
16		0.074		0.076		0.077		0.077		0.103
20		0.089		0.086		0.088		0.086		0.122

## DH Endmill, 5 Flutes - J89, J90

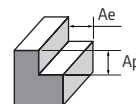


Trochoidal Milling	P01		P02		M01		K01		S01	
Working Material	Carbon Steel		Alloy steel		Stainless Steel		Grey Cast Iron		Titanium	
Properties	-		520 < Rm < 1200		High Machinability		-		-	
Maximum Slot Width (mm)	1.25 × D		1.25 × D		1.25 × D		1.25 × D		1.25 × D	
Cutting Depth, Ap (mm)	1.50 × D		1.50 × D		1.50 × D		1.50 × D		1.50 × D	
Cutting Width, Ae (mm)	0.15 × D		0.12 × D		0.10 × D		0.15 × D		0.10 × D	
D (mm)	Vc (m/min)	Fz (mm)	Vc (m/min)	Fz (mm)	Vc (m/min)	Fz (mm)	Vc (m/min)	Fz (mm)	Vc (m/min)	Fz (mm)
4	330	0.015	280	0.016	200	0.017	300	0.015	110	0.024
5		0.020		0.022		0.023		0.021		0.031
6		0.028		0.030		0.031		0.027		0.038
8		0.039		0.043		0.044		0.038		0.054
10		0.051		0.058		0.059		0.051		0.071
12		0.064		0.078		0.079		0.064		0.092
16		0.082		0.095		0.096		0.080		0.115
20		0.093		0.108		0.109		0.094		0.135



Recommended Cutting Data

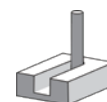
Note: These recommended cutting data indicators are just for reference. They should be adjusted according to the different cutting condition



### DH Long Endmill, 5 Flute - J92, J93

Side Milling	P01		P02		M01		K01		S01	
Working Material	Carbon Steel		Alloy steel		Stainless Steel		Grey Cast Iron		Titanium	
Properties	-		520 < Rm < 1200		High Machinability		-		-	
Cutting Depth, Ap (mm)	1.50 × D		1.50 × D		1.50 × D		1.50 × D		1.50 × D	
Cutting Width, Ae (mm)	0.15 × D		0.12 × D		0.10 × D		0.15 × D		0.10 × D	
D (mm)	Vc (m/min)	Fz (mm)	Vc (m/min)	Fz (mm)	Vc (m/min)	Fz (mm)	Vc (m/min)	Fz (mm)	Vc (m/min)	Fz (mm)
4	260	0.015	210	0.016	140	0.017	230	0.014	75	0.023
5		0.019		0.020		0.021		0.019		0.029
6		0.023		0.025		0.027		0.024		0.036
8		0.032		0.035		0.037		0.031		0.049
10		0.041		0.046		0.048		0.041		0.063
12		0.050		0.057		0.060		0.053		0.078
16		0.062		0.071		0.074		0.066		0.099
20		0.073		0.080		0.085		0.078		0.119

### DH Long Endmill, 5 Flute - J92, J93



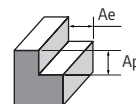
Trochoidal Milling	P01		P02		M01		K01		S01	
Working Material	Carbon Steel		Alloy steel		Stainless Steel		Grey Cast Iron		Titanium	
Properties	-		520 < Rm < 1200		High Machinability		-		-	
Maximum Slot Width (mm)	1.25 × D		1.25 × D		1.25 × D		1.25 × D		1.25 × D	
Cutting Depth, Ap (mm)	2.00 × D		2.00 × D		2.00 × D		2.00 × D		2.00 × D	
Cutting Width, Ae (mm)	0.12 × D		0.10 × D		0.08 × D		0.12 × D		0.08 × D	
D (mm)	Vc (m/min)	Fz (mm)	Vc (m/min)	Fz (mm)	Vc (m/min)	Fz (mm)	Vc (m/min)	Fz (mm)	Vc (m/min)	Fz (mm)
4	300	0.014	260	0.014	170	0.016	270	0.014	95	0.021
5		0.018		0.020		0.022		0.018		0.027
6		0.025		0.027		0.029		0.023		0.035
8		0.035		0.040		0.042		0.034		0.049
10		0.046		0.054		0.056		0.047		0.065
12		0.059		0.070		0.071		0.061		0.083
16		0.068		0.089		0.090		0.068		0.106
20		0.078		0.101		0.103		0.080		0.126



Recommended Cutting Data

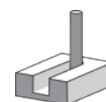
Note: These recommended cutting data indicators are just for reference. They should be adjusted according to the different cutting condition

### DH Endmill, with internal oil hole, chip breaker, recess and weldon, 5 Flutes - K65



Side Milling	P01		P02		M01		K01		S01	
Working Material	Carbon Steel		Alloy steel		Stainless Steel		Grey Cast Iron		Titanium	
Properties	-		520 < Rm < 1200		High Machinability		-		-	
Cutting Depth, Ap (mm)	1.00 × D		1.00 × D		1.00 × D		1.00 × D		1.00 × D	
Cutting Width, Ae (mm)	0.25 × D		0.20 × D		0.18 × D		0.25 × D		0.15 × D	
D (mm)	Vc (m/min)	Fz (mm)	Vc (m/min)	Fz (mm)	Vc (m/min)	Fz (mm)	Vc (m/min)	Fz (mm)	Vc (m/min)	Fz (mm)
4	310	0.017	250	0.019	180	0.021	280	0.016	100	0.025
5		0.022		0.025		0.027		0.021		0.032
6		0.027		0.031		0.033		0.025		0.039
8		0.036		0.043		0.045		0.035		0.054
10		0.046		0.055		0.057		0.045		0.069
12		0.056		0.069		0.071		0.056		0.087
16		0.072		0.087		0.089		0.071		0.108
20		0.088		0.107		0.109		0.084		0.128

### DH Endmill, with internal oil hole, chip breaker, recess and weldon, 5 Flutes - K65



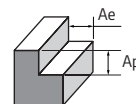
Trochoidal Milling	P01		P02		M01		K01		S01	
Working Material	Carbon Steel		Alloy steel		Stainless Steel		Grey Cast Iron		Titanium	
Properties	-		520 < Rm < 1200		High Machinability		-		-	
Maximum Slot Width (mm)	1.25 × D		1.25 × D		1.25 × D		1.25 × D		1.25 × D	
Cutting Depth, Ap (mm)	1.50 × D		1.50 × D		1.50 × D		1.50 × D		1.50 × D	
Cutting Width, Ae (mm)	0.15 × D		0.12 × D		0.10 × D		0.15 × D		0.10 × D	
D (mm)	Vc (m/min)	Fz (mm)	Vc (m/min)	Fz (mm)	Vc (m/min)	Fz (mm)	Vc (m/min)	Fz (mm)	Vc (m/min)	Fz (mm)
4	360	0.016	300	0.017	220	0.019	330	0.015	130	0.025
5		0.021		0.023		0.025		0.020		0.032
6		0.027		0.031		0.033		0.026		0.040
8		0.037		0.044		0.046		0.037		0.055
10		0.049		0.059		0.061		0.049		0.072
12		0.064		0.078		0.080		0.063		0.096
16		0.079		0.097		0.099		0.078		0.117
20		0.089		0.110		0.112		0.089		0.138



Recommended Cutting Data

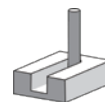
Note: These recommended cutting data indicators are just for reference. They should be adjusted according to the different cutting condition

### DH Long Endmill, with internal oil hole, chip breaker, recess and weldon, 5 Flutes - K67



Side Milling	P01		P02		M01		K01		S01	
Working Material	Carbon Steel		Alloy steel		Stainless Steel		Grey Cast Iron		Titanium	
Properties	-		520 < Rm < 1200		High Machinability		-		-	
Cutting Depth, Ap (mm)	1.50 × D		1.50 × D		1.50 × D		1.50 × D		1.50 × D	
Cutting Width, Ae (mm)	0.15 × D		0.12 × D		0.10 × D		0.15 × D		0.10 × D	
D (mm)	Vc (m/min)	Fz (mm)	Vc (m/min)	Fz (mm)	Vc (m/min)	Fz (mm)	Vc (m/min)	Fz (mm)	Vc (m/min)	Fz (mm)
4	280	0.014	230	0.018	160	0.020	250	0.014	85	0.020
5		0.019		0.023		0.025		0.019		0.027
6		0.024		0.029		0.031		0.023		0.035
8		0.032		0.039		0.041		0.031		0.050
10		0.041		0.050		0.052		0.040		0.066
12		0.054		0.063		0.065		0.053		0.084
16		0.069		0.082		0.084		0.068		0.107
20		0.083		0.099		0.101		0.080		0.126

### DH Long Endmill, with internal oil hole, chip breaker, recess and weldon, 5 Flutes - K67



Trochoidal Milling	P01		P02		M01		K01		S01	
Working Material	Carbon Steel		Alloy steel		Stainless Steel		Grey Cast Iron		Titanium	
Properties	-		520 < Rm < 1200		High Machinability		-		-	
Maximum Slot Width (mm)	1.25 × D		1.25 × D		1.25 × D		1.25 × D		1.25 × D	
Cutting Depth, Ap (mm)	2.00 × D		2.00 × D		2.00 × D		2.00 × D		2.00 × D	
Cutting Width, Ae (mm)	0.12 × D		0.10 × D		0.08 × D		0.12 × D		0.08 × D	
D (mm)	Vc (m/min)	Fz (mm)	Vc (m/min)	Fz (mm)	Vc (m/min)	Fz (mm)	Vc (m/min)	Fz (mm)	Vc (m/min)	Fz (mm)
4	330	0.014	280	0.014	200	0.016	300	0.013	115	0.021
5		0.019		0.021		0.023		0.018		0.028
6		0.025		0.028		0.030		0.024		0.035
8		0.035		0.040		0.042		0.034		0.049
10		0.046		0.055		0.057		0.045		0.066
12		0.060		0.072		0.074		0.059		0.089
16		0.074		0.088		0.090		0.072		0.107
20		0.082		0.099		0.101		0.081		0.123



Recommended Cutting Data

Note: These recommended cutting data indicators are just for reference. They should be adjusted according to the different cutting condition



# Certificate

Standard **ISO 9001:2015**

Certificate Registr. No. **01 100 053515**

Certificate Holder:



**HPMT Industries Sdn. Bhd.**

No. 5, Jalan Sungai Kayu Ara 32/39, Taman Berjaya,  
Seksyen 32, Shah Alam, Selangor Darul Ehsan, Malaysia

Scope:

Design and Manufacturing of Standard and Custom-made Metal  
Removing Cutting Tools

Proof has been furnished by means of an audit that the  
requirements of ISO 9001:2015 are met.

Validity:

The certificate is valid from 2021-08-15 until 2024-08-14.  
First certification 2005

2021-12-13

A handwritten signature in blue ink, appearing to read 'K. H. L.', positioned above a horizontal line.

TÜV Rheinland Cert GmbH  
Am Grauen Stein · 51105 Köln



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