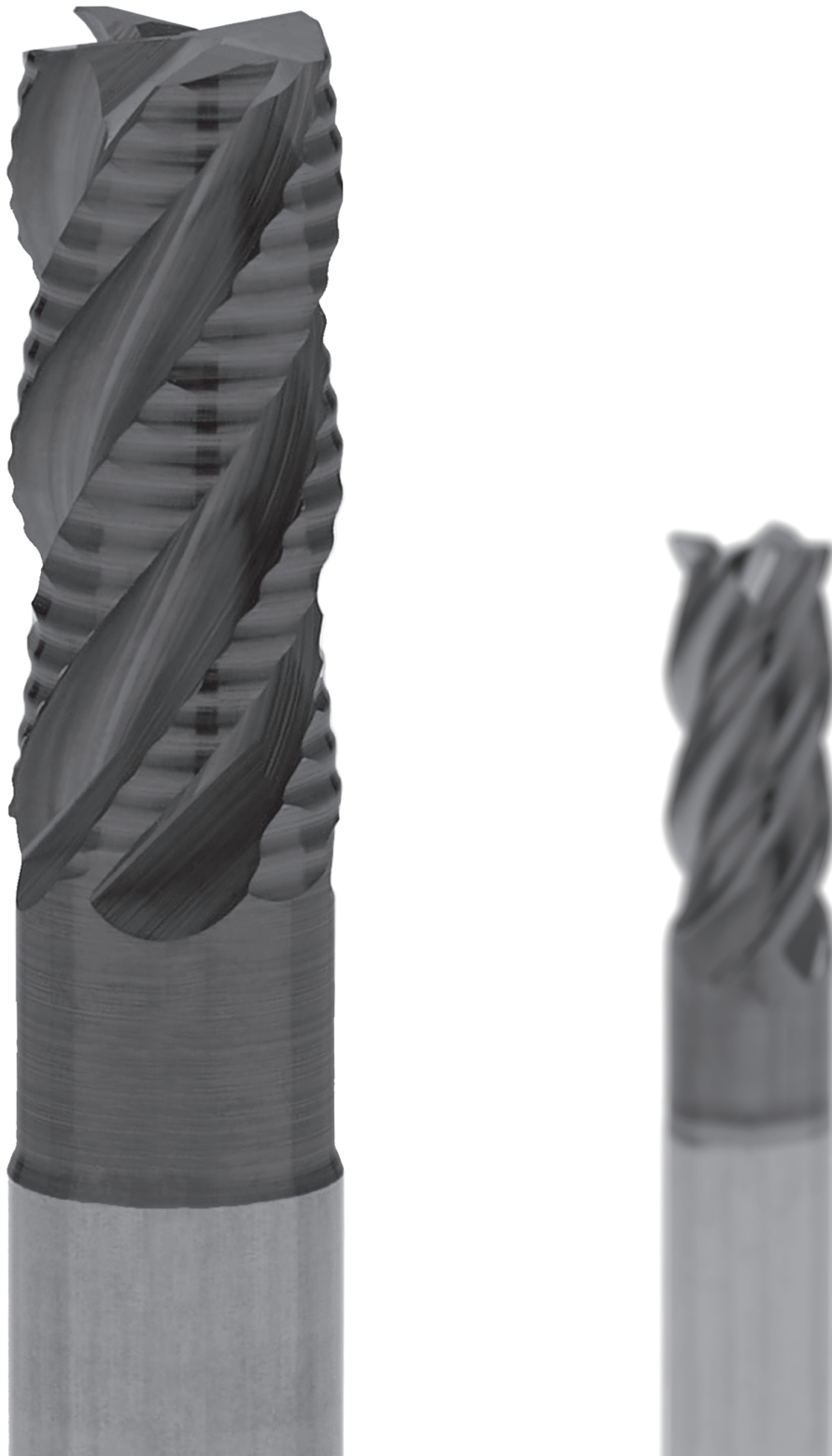
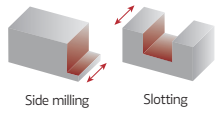


# INOX-INTEG

## Stainless Steel Specialized Endmills



Integral Solid Carbide Solutions



## HC40SS Corner Chamfer stainless steel specialized endmills

M



S - Short



Variable Pitch



Variable Helix 40°/41°



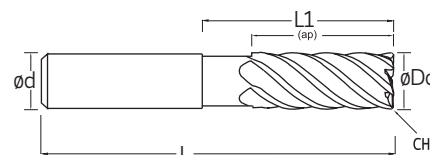
45° Corner chamfer



Reduced Neck Ø



< 42 HRC



<sup>(1)</sup> Geometry code		<sup>(2)</sup> Grade code		Z9	Dimensions   Dimensões   Dimensiones (mm)					
HA (Cylindrical)	HB (Weldon)	Reference Referência Referencia		PHU920	ØDc	Ød (h6)	ap <sub>max</sub>	CH	L	L1
1180484	1180485	HF40SS 4 010 03	4		1	6	2,5	-	57	5
1180380	1180487	HF40SS 4 020 05	4		2	6	5	-	57	10
1180381	1180488	HC40SS 4 030 08	4		3	6	8	0,15 x 45°	57	15
1180382	1180489	HC40SS 4 040 11	4		4	6	11	0,15 x 45°	57	17
1180383	1180490	HC40SS 4 050 13	4		5	6	13	0,15 x 45°	57	19
1180384	1180389	HC40SS 4 060 13	4		6	6	12	0,15 x 45°	57	21
1180329	1180491	HC40SS 4 080 19	4		8	8	19	0,15 x 45°	63	27
1180385	1180492	HC40SS 4 100 22	4		10	10	22	0,20 x 45°	72	32
1180386	1180493	HC40SS 4 120 26	4		12	12	26	0,20 x 45°	83	38
1180436	1180494	HC40SS 4 140 26	4		14	14	26	0,25 x 45°	83	38
1180387	1180390	HC40SS 4 160 32	4		16	16	32	0,35 x 45°	92	44
1180555	1180556	HC40SS 4 180 32	4		18	18	32	0,45 x 45°	92	44
1180388	1180455	HC40SS 4 200 38	4		20	20	38	0,60 x 45°	104	54

First choice | Primeira opção | 1ª opción

Stock item | Produto de stock | Itens de stock

Available under request | Disponível sobre consulta  
Disponível bajo consulta

Order code = (1) Geometry Code + (2) Grade Code

## CUTTING PARAMETERS || Parâmetros de corte | Parámetros de corte

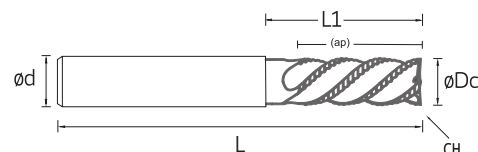
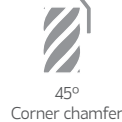
ISO	Material	Fz			Vc		
		ae			ae		
		25%	50%	100%	25%	50%	100%
M	Stainless Steel (Ferritic / Martensitic)	0,007 x ØDc	0,004 x ØDc	0,003 x ØDc	160	150	120
	Stainless Steel (Austenitic)	0,006 x ØDc	0,004 x ØDc	0,003 x ØDc	140	130	100
	Stainless Steel (Austenitic/Ferritic/Duplex)	0,006 x ØDc	0,003 x ØDc	0,003 x ØDc	130	120	100

Note<sup>1</sup>: Feed valid for when the endmill works with its whole ap, for when the endmill is working with lower depths of cut consider increasing the feed up to 25%.

Note<sup>2</sup>: Cutting speeds selected for an economic use of the tool, for higher productivity consider increasing up to 70%.

## HRO40SS Rougher stainless steel specialized endmills

M



(1) Geometry code		(2) Grade code		Z9	Dimensions   Dimensões   Dimensiones (mm)					
		Reference Referência Referencia			PHU920	ØDc	Ød (h6)	ap <sub>max</sub>	CH	L
HA (Cylindrical)	HB (Weldon)									
1180445	1180392	HRO40SS 4 040 11	4		4	6	11	45°x0,15	57	17
1180446	1180393	HRO40SS 4 050 13	4		5	6	13	45°x0,15	57	19
1180447	1180394	HRO40SS 4 060 13	4		6	6	13	45°x0,15	57	21
1180448	1180395	HRO40SS 4 080 19	4		8	8	19	45°x0,15	63	27
1180391	1180396	HRO40SS 4 100 22	4		10	10	22	45°x0,20	72	32
1180449	1180397	HRO40SS 4 120 26	4		12	12	26	45°x0,20	83	38
1180450	1180398	HRO40SS 4 140 26	4		14	14	26	45°x0,25	83	38
1180451	1180399	HRO40SS 4 160 32	4		16	16	32	45°x0,35	92	44
1180452	1180400	HRO40SS 4 180 32	4		18	18	32	45°x0,45	92	44
1180453	1180454	HRO40SS 4 200 38	4		20	20	38	45°x0,60	104	54

First choice | Primeira opção | 1ª opción

Stock item | Produto de stock | Itens de stock

Available under request | Disponível sobre consulta  
Disponible bajo consulta

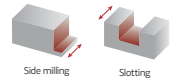
Order code = (1) Geometry Code + (2) Grade Code

## CUTTING PARAMETERS || Parâmetros de corte | Parámetros de corte

ISO	Material	Fz			Vc		
		ae			ae		
		25%	50%	100%	25%	50%	100%
M	Stainless Steel (Ferritic / Martensitic)	0,006 x ØDc	0,005 x ØDc	0,004 x ØDc	140	130	110
	Stainless Steel (Austenitic)	0,006 x ØDc	0,005 x ØDc	0,003 x ØDc	130	120	110
	Stainless Steel (Austenitic/Ferritic/Duplex)	0,005 x ØDc	0,004 x ØDc	0,003 x ØDc	120	110	100

Note<sup>1</sup>: Feed valid for when the endmill works with its whole ap, for when the endmill is working with lower depths of cut consider increasing the feed up to 25%.

Note<sup>2</sup>: Cutting speeds selected for an economic use of the tool, for higher productivity consider increasing up to 70%.



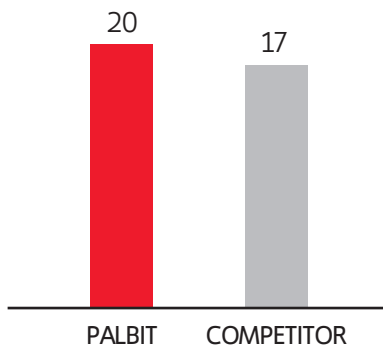
# TEST REPORT | Relatório de teste | Informes de prueba

Tool: HC40SS 4 080 19 PHU920



Workpiece Material: AISI 316L

Cutting speed: $V_c$	120 m/min
Feed per tooth: $f_z$	0,024 mm/t
Depth of cut: $a_p$	8,0 mm
Stepover : $a_e$	100%
Operation	Slotting
Coolant	Air



Tool Life [min]  
**Improvement: 18%**

