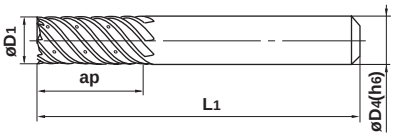
VF8MHVCH

End mill, Medium cut length, 8 flute,
Irregular helix flutes with multiple internal through coolant holes

Carbon Steel, Alloy Steel, Cast Iron (<30HRC)	Tool Steel, Pre-Hardened Steel, Hardened Steel (≤45HRC)	Hardened Steel (≤55HRC)	Hardened Steel (>55HRC)	Austenitic Stainless Steel	Titanium Alloy, Heat Resistant Alloy	Copper Alloy	Aluminium Alloy
				◎	◎		

CoolStar
END MILLS



Type1

16≤D1≤20				
0 - 0.03				
D4=16	D4=20			
0 - 0.011	0 - 0.013			

h6

● Vibration control end mill with multiple internal through coolant holes ensures stable machining on difficult-to-cut materials and applications requiring long overhangs.

Unit : mm

Order Number	D1	ap	L1	D4	Flutes	Stock	Type
VF8MHVCHD1600	16	32	90	16	8	●	1
D2000	20	38	100	20	8	●	1

RECOMMENDED CUTTING CONDITIONS

Shoulder milling

Work material	Austenitic stainless steel, Titanium alloy X5CrNi1810, X5CrNiMo17-12-2, Ti6Al4V		Heat resistant alloys Inconel718	
Dia. (mm)	Revolution (min^{-1})	Feed rate (mm/min)	Revolution (min^{-1})	Feed rate (mm/min)
16	3000	2100	800	240
20	2400	1900	640	200
Depth of cut	≤0.08D 0.5D—1.5D		≤0.05D 0.5D—1.5D	

D:Dia.

Trochoid milling

Work material	Austenitic stainless steel, Titanium alloy X5CrNi18-10, X5CrNiMo17-12-2	
Dia. (mm)	Revolution (min^{-1})	Feed rate (mm/min)
16	3000	1400
20	2400	1200
Depth of cut	1.5D≤ ≤0.08D 0.5D—1.5D	

D:Dia.

1) If the depth of cut is shallow, the revolution and feed rate can be increased.
2) The irregular helix flute end mill has a larger effect on controlling vibration when compared to standard end mills. However, if the rigidity of the machine or the workpiece installation is poor, vibration or abonrmal sound can occur. In this case, please reduce the revolution and feed rate proportionately, or set a lower depth of cut.