

VFSFPRCH

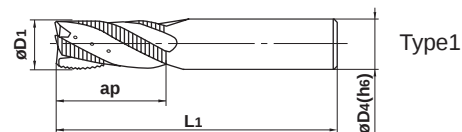
Roughing end mill, Short cut length, 4 flute, with multiple internal through coolant holes



CARBIDE

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



SQUARE

BALL

RADIUS

TAPER

SOLID END MILLS

h6	D4=16	D4=20			
	0 - 0.011	0 - 0.013			

- Roughing end mill with multiple internal through coolant holes suitable for difficult-to-cut materials.

Unit : mm

Order Number	D1	ap	L1	D4	Flutes	Stock	Type
VFSFPRCHD1600	16	33	90	16	4	●	1
D2000	20	38	100	20	4	●	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	1200	300	800	110
20	1000	300	600	100
Depth of cut				

D:Dia.

Slotting

Work material	Austenitic stainless steel, Titanium alloy X5CrNi1810, X5CrNiMo17-12-2, Ti6Al4V	
Dia. (mm)	Revolution (min ⁻¹)	Feed rate (mm/min)
16	800	100
20	600	80
Depth of cut		

D:Dia.

- 1) If the depth of cut is shallow, the revolution and feed rate can be increased.
- 2) If the rigidity of the machine or the work materials installation is very low, or chattering and noise are generated, reduce the revolution and feed rate proportionately.

● : Inventory maintained.