

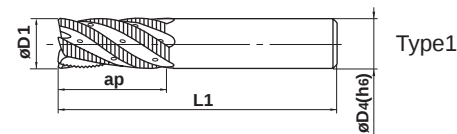
IMPACT MIRACLE END MILLS

VF6SVRCH

Roughing end mill, Short cut length, 6 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

SQUARE

BALL

RADIUS

TAPER

SOLID END MILLS

h6	D4=16	D4=20			
	0	0			
	- 0.011	- 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
VF6SVRCHD1600	16	33	90	16	6	●	1
D2000	20	38	100	20	6	●	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	2400	1200	800	160
20	2000	1000	640	140
Depth of cut				

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 abnormal sound can occur. In this case, please reduce the revolution and feed rate proportionately, or set a lower depth of cut.

● : Inventory maintained.