

VFMHVRBCH

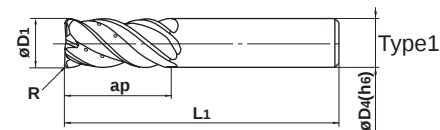
Corner radius end mill, Medium cut length, 4 flute, Irregular helix flutes, with multiple internal through coolant holes



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

R	1 ≤ R ≤ 3				
	±0.015				
D1	16 ≤ D1 ≤ 20				
	0 - 0.03				
h6	D4=16	D4=20			
	0 - 0.011	0 - 0.013			

- Vibration control corner radius 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	R	ap	L1	D4	Flutes	Stock	Type
VFMHVRBCHD1600R100	16	1	35	90	16	4	●	1
D1600R300	16	3	35	90	16	4	●	1
D2000R100	20	1	45	110	20	4	●	1
D2000R300	20	3	45	110	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	2000	560	800	110
20	1600	510	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	1400	170
20	1100	130
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.