



High Feed Radius End Mill for Titanium Alloy

HFC-TI



FEATURES: HFC-TI

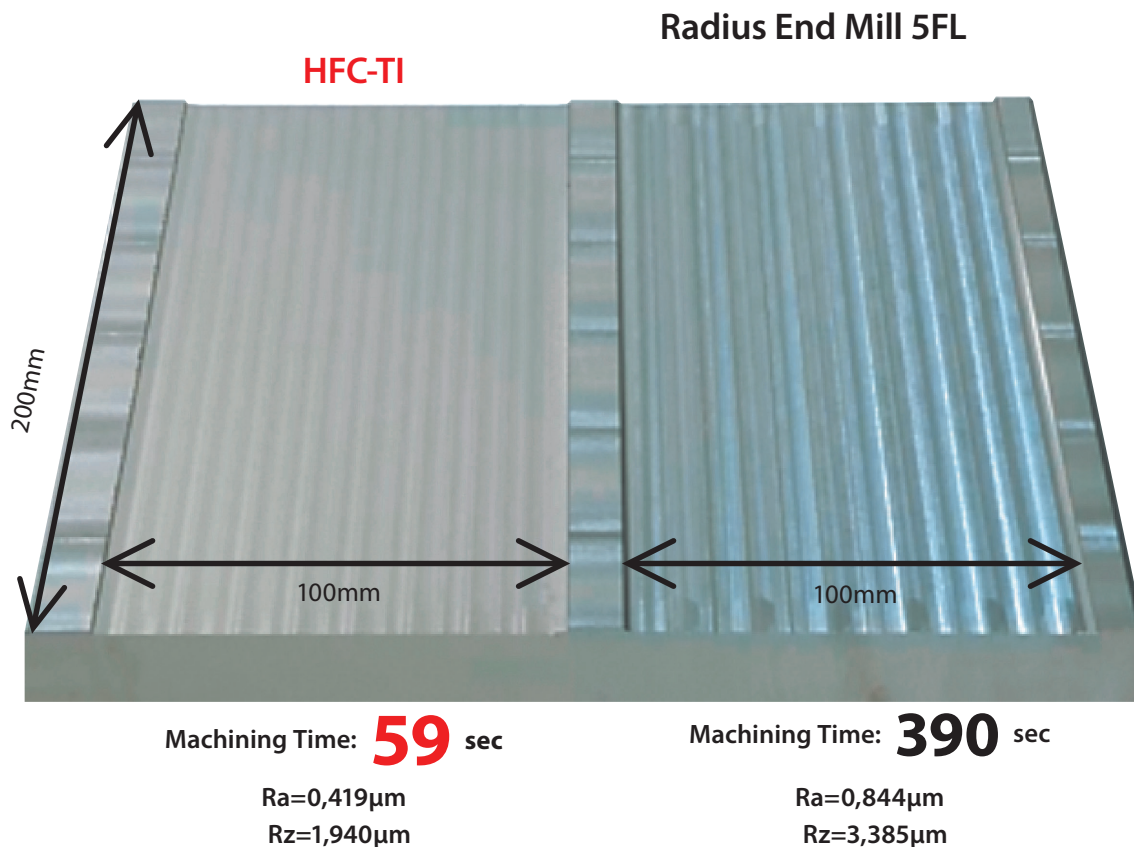


CUTTING DATA

Average Milling Condition

HFC-TI, the high efficiency bottom finishing end mill, achieves superior surface accuracy with reduction of large amount machining time.

Surface Roughness (Ra)	≤ 3,2 μm
Depth of Cut (ap)	0,5 mm
Feed Rate	≥ 3.000 mm/min



Machining Data

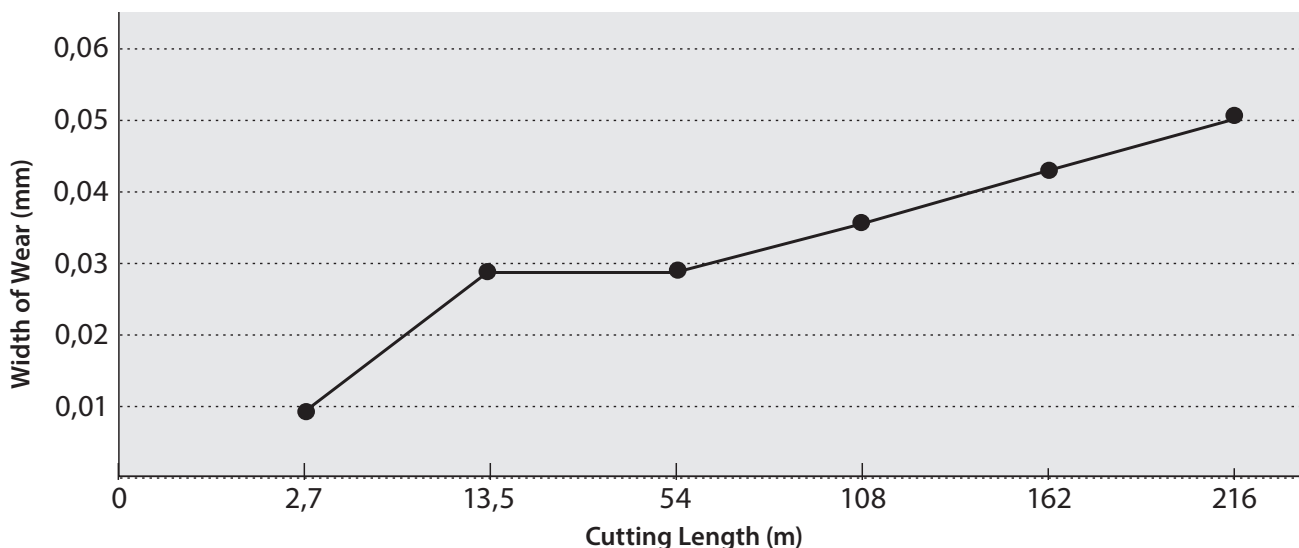
Tool	HFC-TI Ø16 6 Flutes	Radius End mill Ø16 5 Flutes
Cutting Speed	70 m/min	
Feed	4.500 mm/min (0,54 mm/t)	489 mm/min (0,07 mm/t)
Milling Method	Contour Milling	
Depth of Cut	ap=0,5 mm ae=6 mm	ap=0,5 mm ae=8 mm
Coolant	Water Soluble	



High efficiency milling of HFC-TI

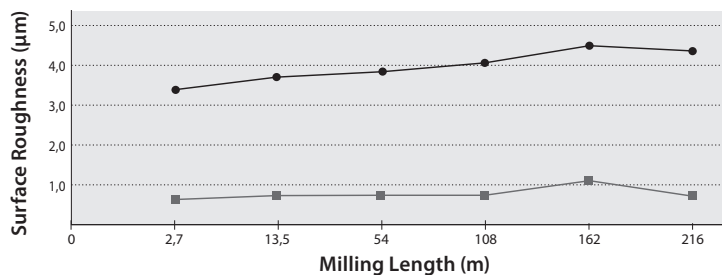
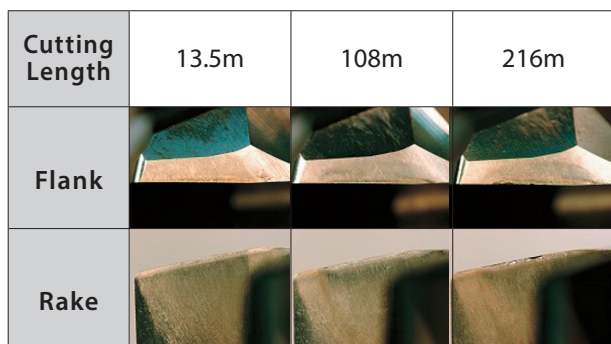
Size	16 mm
Work Material	Ti-6Al-4V
Cutting Speed	100 m/min (1.990 min ⁻¹)
Feed Rate	6.000 mm/min (0,5 mm/t)
Milling Method	Contour Milling
Depth of Cut	ap= 0,5mm ae= 6mm
Coolant	Water Soluble
Overhang Length	70 mm
Machine	Horizontal Machining Center

Wear Amount



Milling | Solid carbide

Change in Surface Roughness



●	3,557	3,812	3,903	4,151	4,520	4,403
■	0,849	0,944	0,946	0,980	1,016	0,997

CUTTING CONDITIONS

Milling | Endmills | Cutting conditions

HFC-TI

Titanium Alloy (Ti-6Al-4V)

Contour milling									
Vc	50 ~ 100 m/min								
Ø	S (min ⁻¹)	F (mm/min)	Ramping Angle E	rt	Z				
16	1.490	4.500	2°	0,86	0,46				
20	1.190	3.600	2°	1,01	0,58				
25	850	4.860	2°	1,2	0,74				
Max cutting depth	<table border="1" style="margin-left: auto; margin-right: auto;"> <tr> <td>ap</td> <td>ae</td> </tr> <tr> <td>≤ 0,035 Dc</td> <td>0,39 Dc</td> </tr> </table>					ap	ae	≤ 0,035 Dc	0,39 Dc
ap	ae								
≤ 0,035 Dc	0,39 Dc								





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