

# ROUGHING 2.0

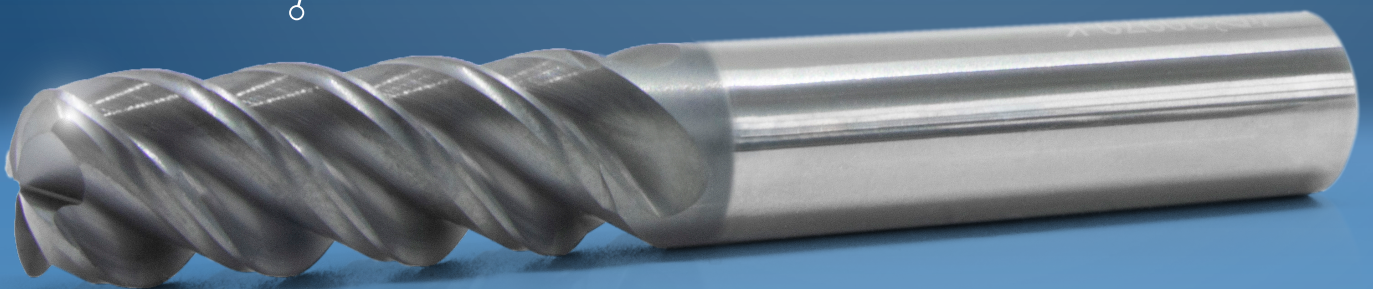


# WHSC

## HIGH-SPEED CORNER RADIUS END MILLS

for HSC und HPC applications in alloyed and unalloyed steels up to 52 HRC

- + Due to the face geometry, significantly higher tooth feeds are possible
- + More efficient roughing, even close to the final contour
- + VSO-optimized cutting edge
- + Well matched micro-grain carbide

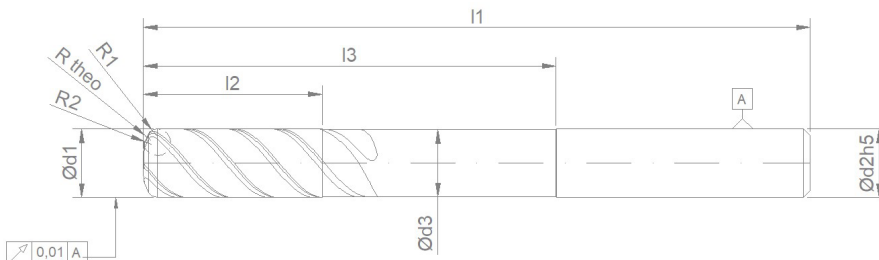


- + Specially shaped geometry around the circumference for more efficient trochoidal milling
- + High-performance coating that meets highest standards
- + Perfect for roughing, face milling and copy milling

# SOLID CARBIDE CORNER RADIUS END MILLS

## for general steel machining

WHSC



Art. Nr.	Ød1	Ød2h6	Ød3	l1	l2	l3	ER-theo	R1	R2	Z	PROFILING			SIDE MILLING		
											fz mm	ap mm	ae mm	fz mm	ap mm	ae mm
WHSC060 04004-016	4	6	3,8	60	11	16	0,65	0,5	2	4	0,1	0,17	4	0,09	6	0,5
WHSC060 05004-025	5	6	4,8	60	13	25	0,68	0,5	3	4	0,12	0,2	5	0,1	7,5	0,6
WHSC070 05004-030	5	6	4,8	70	13	30	0,68	0,5	3	4	0,12	0,2	5	0,1	7,5	0,6
WHSC060 06004-025	6	6	5,8	60	15	25	0,68	0,5	3	4	0,15	0,25	6	0,11	9	0,75
WHSC070 08004-032	8	8	7,8	70	20	32	1,35	1	4	4	0,2	0,3	8	0,12	12	0,9
WHSC080 10004-040	10	10	9,8	80	26	40	2	1,5	5	4	0,3	0,4	10	0,14	15	1
WHSC090 12004-050	12	12	11,8	90	30	50	2,1	1,5	6	4	0,4	0,6	12	0,15	18	1,15
WHSC120 16004-072	16	16	15,8	120	36	72	2,75	2	8,2	4	0,5	0,8	16	0,18	24	1,25

### TOLERANCES

Ød1	Ød3
-0,01 / -0,03	-0,1

### APPLICATION EXAMPLE

Material	Tool	Vc	fz	ae	ap	Tool life (min)
Toolox44 (1420 N/mm <sup>2</sup> )	WHSC070 08004-032	131	0,35	8	0,25	287,78

### PROFILING

Material	<1000N/mm <sup>2</sup> (32 HRC)	<1400N/mm <sup>2</sup> (44 HRC)	<1800N/mm <sup>2</sup> (52 HRC)
Vc m/min	180	150	130

### SIDE MILLING

Material	<1000N/mm <sup>2</sup> (32 HRC)	<1400N/mm <sup>2</sup> (44 HRC)	<1800N/mm <sup>2</sup> (52 HRC)
Vc m/min	190	160	140