

VQ6MHVCH NEW

End mill, Medium cut length, 6 flute, Irregular helix flutes, With multiple thru-coolant

VQ6MHVRBCH NEW

Corner radius, Medium cut length, 6 flute, Irregular helix flutes, With multiple thru-coolant

CARBIDE

RECOMMENDED CUTTING CONDITIONS

Shoulder milling

(inch)

DC (mm) (inch)	Alloy Steel, Tool Steel, Pre-hardened Steel AISI H13, AISI W1-10, AISI P21		Austenitic Stainless Steel(≤200HB) Titanium Alloy AISI 304, AISI 316, Ti-6AL-4V		Copper, Copper Alloy		Heat Resistant Alloy Inconel 718	
	Revolution (min ⁻¹)	Table feed (IPM)	Revolution (min ⁻¹)	Table feed (IPM)	Revolution (min ⁻¹)	Table feed (IPM)	Revolution (min ⁻¹)	Table feed (IPM)
10 .394	—	—	4800	78.7	—	—	1300	10.2
12 .472	—	—	4000	78.7	—	—	1100	9.1
16 .630	4000	86.6	3000	63.0	2400	55.1	800	7.1
20 .787	3200	74.8	2400	55.1	1900	43.3	640	5.9
Depth of Cut								

DC : Dia.

Trochoid milling

(inch)

DC (mm) (inch)	Alloy Steel, Tool Steel, Pre-hardened Steel AISI H13, AISI W1-10, AISI P21		Austenitic Stainless Steel(≤200HB) Titanium Alloy AISI 304, AISI 316, Ti-6AL-4V	
	Revolution (min ⁻¹)	Table feed (IPM)	Revolution (min ⁻¹)	Table feed (IPM)
10 .394	—	—	4800	55.1
12 .472	—	—	4000	47.2
16 .630	4000	63.0	3000	43.3
20 .787	3200	55.1	2400	35.4
Depth of Cut				

DC : Dia.

Note 1) If the depth of cut is smaller, the revolution and the feed rate can be increased.

Note 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 work material installation is very low, then vibration can occur. In this case, please reduce the revolution and the feed rate proportionately, or set a lower depth of cut.

SQUARE

BALL

RADIUS

TAPER

BARREL

ROUGHING

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SOLID END MILLS