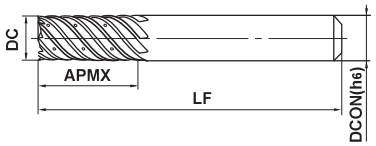
VF8MHVCH

End mill, Medium cut length, 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



Type1

h6				
16≤DC≤20				
0 -0.03				
DCON=16	DCON=20			
0 -0.011	0 -0.013			

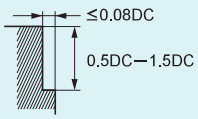
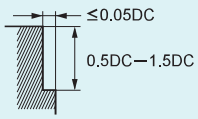
● Vibration control end mill with multiple internal through coolant holes ensures stable machining on difficult-to-cut materials and applications requiring long overhangs.

Unit : mm

Order Number	DC	APMX	LF	DCON	No. of Flutes	Stock	Type
VF8MHVCHD1600	16	32	90	16	8	●	1
VF8MHVCHD2000	20	38	100	20	8	●	1

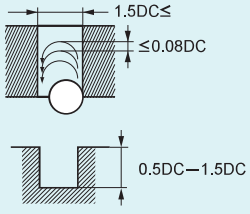
RECOMMENDED CUTTING CONDITIONS

Side milling

Work material	Austenitic stainless steel, Titanium alloy AISI 304, AISI 306, Ti-6Al-4V		Heat resistant alloys Inconel718	
Dia. **DC** (mm)	Revolution (min^{-1})	Feed rate (mm/min)	Revolution (min^{-1})	Feed rate (mm/min)
16	3000	2100	800	240
20	2400	1900	640	200
Depth of cut				

DC:Dia.

Trochoidal slotting

Work material	Austenitic stainless steel, Titanium alloy AISI 304, AISI 306, Ti-6Al-4V	
Dia. **DC** (mm)	Revolution (min^{-1})	Feed rate (mm/min)
16	3000	1400
20	2400	1200
Depth of cut		

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

● : Inventory maintained in Japan.