

COOL STAR END MILL SERIES

VFSFPRCH

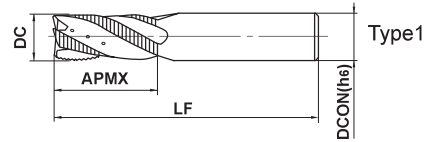
Roughing end mill, Short cut length, 4 flute, with multiple internal through coolant holes



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

h6	DCON=16	DCON=20			
	0 - 0.011	0 - 0.013			

● Roughing end mill with multiple internal through coolant holes suitable for difficult-to-cut materials.

Unit : mm

Order Number	DC	APMX	LF	DCON	No. of Flutes	Stock	Type
VFSFPRCHD1600	16	33	90	16	4	●	1
VFSFPRCHD2000	20	38	100	20	4	●	1

RECOMMENDED CUTTING CONDITIONS

Side milling

Work material	Austenitic stainless steel, Titanium alloy		Heat resistant alloys	
	AISI 304, AISI 306, Ti-6Al-4V		Inconel718	
Dia. DC (mm)	Revolution (min ⁻¹)	Feed rate (mm/min)	Revolution (min ⁻¹)	Feed rate (mm/min)
16	1200	300	800	110
20	1000	300	600	100
Depth of cut				

DC: Dia.

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	800	100
20	600	80
Depth of cut		

DC: Dia.

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

2) If the rigidity of the machine or the work materials installation is very low, or chattering and noise are generated, reduce the revolution and feed rate proportionately.

● : Inventory maintained in Japan.