

COOL STAR END MILL SERIES

CARBIDE

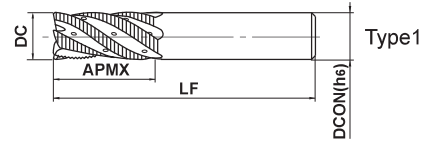
VF6SVRCH

Roughing end mill, Short cut length, 6 flute, 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



SQUARE

BALL

h6	DCON=16	DCON=20			
	$\begin{matrix} 0 \\ -0.011 \end{matrix}$	$\begin{matrix} 0 \\ -0.013 \end{matrix}$			

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

RADIUS

Unit : mm

Order Number	DC	APMX	LF	DCON	No. of Flutes	Stock	Type
VF6SVRCHD1600	16	33	90	16	6	●	1
VF6SVRCHD2000	20	38	100	20	6	●	1

TAPER

RECOMMENDED CUTTING CONDITIONS

Side milling

Dia. DC (mm)	Austenitic stainless steel, Titanium alloy AISI 304, AISI 306, Ti-6Al-4V		Heat resistant alloys Inconel718	
	Revolution (min ⁻¹)	Feed rate (mm/min)	Revolution (min ⁻¹)	Feed rate (mm/min)
16	2400	1200	800	160
20	2000	1000	640	140

Depth of cut	Austenitic stainless steel, Titanium alloy		Heat resistant alloys	
	Diagram	Value	Diagram	Value
		≤0.3DC 0.5DC—1.5DC		≤0.2DC 0.5DC—1.5DC

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 abnormal 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.