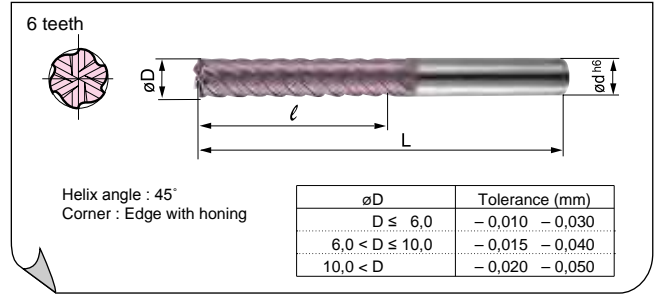
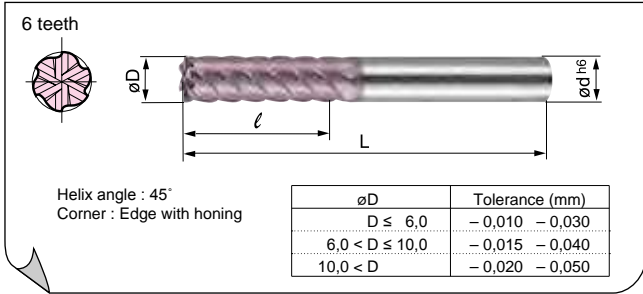


ZX Coated Long Fast Helix Endmills LHHM 4000/6000/8000 ZX Type

ZX Coated Extra Long Fast Helix Endmills EHHM 4000/6000/8000 ZX Type

Coated carbide grade: ACZ10M

Coated carbide grade: ACZ10M

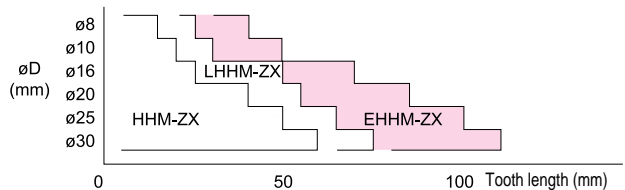
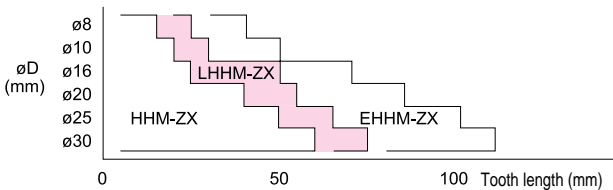


Endmills (mm)

Endmills (mm)

	Cat. No.	Stock	øD	l	L	ød
4	LHHM 4030ZX	☐	3,0	12	55	6
	LHHM 4040ZX	☐	4,0	15	60	6
	LHHM 4050ZX	☐	5,0	18	60	6
6	LHHM 6060ZX	☐	6,0	18	60	6
	LHHM 6080ZX	☐	8,0	25	75	8
	LHHM 6100ZX	☐	10,0	30	80	10
	LHHM 6120ZX	☐	12,0	30	100	12
8	LHHM 8160ZX	☐	16,0	50	105	16
	LHHM 8200ZX	☐	20,0	55	120	20
	LHHM 8250ZX	☐	25,0	65	140	25
	LHHM 8300ZX	☐	30,0	75	160	32
	LHHM 8320ZX	☐	32,0	85	170	32

	Cat. No.	Stock	øD	l	L	ød
4	EHHM 4030ZX	☐	3,0	20	60	6
	EHHM 4040ZX	☐	4,0	25	65	6
	EHHM 4050ZX	☐	5,0	30	70	6
6	EHHM 6060ZX	☐	6,0	30	70	6
	EHHM 6080ZX	☐	8,0	40	90	8
	EHHM 6100ZX	☐	10,0	50	100	10
	EHHM 6120ZX	☐	12,0	50	120	12
8	EHHM 8160ZX	☐	16,0	70	140	16
	EHHM 8200ZX	☐	20,0	85	165	20
	EHHM 8250ZX	☐	25,0	100	185	25
	EHHM 8300ZX	☐	30,0	110	205	32
	EHHM 8320ZX	☐	32,0	110	205	32



Recommended conditions (Shoulder processing) $d_{oc} = 1,5 \times \phi D$
 $w_{oc} = 0,025(\text{HRC}56-65) \sim 0,2(\text{below HRC}25) \times \phi D$

øD	Material	Carbon steel, Alloy steel		Hardened steel	Cast iron
		(Below HRC25)	(Below HRC45)	(Below HRC65)	
3,0 ~ 5,0	v_c	200-250-300	100-150-200	80-100-120	60-75-90
	f_t	0,030-0,060	0,022-0,037	0,007-0,015	0,030-0,060
6,0 ~ 12,0	v_c	200-250-300	100-150-200	80-100-120	40-50-60
	f_t	0,061-0,090	0,037-0,067	0,015-0,028	0,060-0,165
16,0 ~ 32,0	v_c	200-250-300	100-150-200	80-100-120	40-50-60
	f_t	0,090-0,098	0,067-0,075	0,028-0,038	0,187-0,262

Recommended conditions (Shoulder processing) $d_{oc} = 1,5 \times \phi D$
 $w_{oc} = 0,025(\text{HRC}56-65) \sim 0,2(\text{below HRC}25) \times \phi D$

øD	Material	Carbon steel, Alloy steel		Hardened steel	Cast iron
		(Below HRC25)	(Below HRC45)	(Below HRC65)	
3,0 ~ 5,0	v_c	200-250-300	100-150-200	80-100-120	100-120-150
	f_t	0,020-0,040	0,015-0,025	0,005-0,010	0,020-0,040
6,0 ~ 12,0	v_c	200-250-300	100-150-200	80-100-120	100-120-150
	f_t	0,041-0,060	0,025-0,045	0,010-0,019	0,040-0,110
16,0 ~ 32,0	v_c	200-250-300	100-150-200	80-100-120	100-120-150
	f_t	0,060-0,065	0,045-0,050	0,019-0,025	0,125-0,175