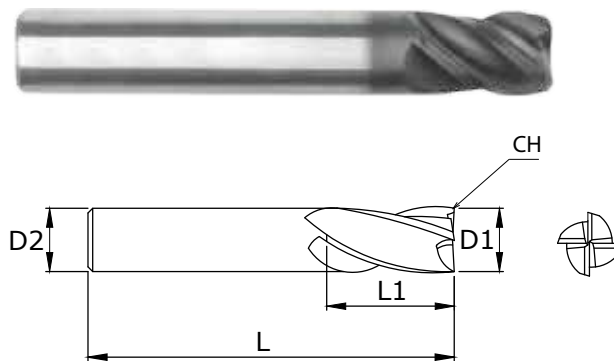


4 Flute

Centre cutting stub length high performance end mill for better economics



P1-P4
K1-K3
M1-M2

						Unit : mm
ØD1	L1	L	ØD2	CH	Z	EDP No
(mm)	(mm)	(mm)	(mm)	(mm)		
4	7	38	6	0.40	4	FBK0508782
5	7	38	6	0.40	4	FBK0508783
6	8	38	6	0.40	4	FBK0508784
8	11	43	8	0.40	4	FBK0508785
10	13	50	10	0.50	4	FBK0508786
12	15	55	12	0.50	4	FBK0508787
16	15	76	16	CR0.5	6	FBK0508788

Nano is an economic choice for high quality and performance when regrinding is not an option. Designed to minimise tool costs for applications when short lengths-of-cut are required. Nano has a short, compact design with minimised vibration and soft cut to support mill-turn machines. A good substrate and coating offers high tool life and stable manufacturing on a wide range of workpiece materials. This can be produced with different corner styles, Nano covers a wide range of applications. Roughing and finishing with one tool reduces tool inventory and tool changes providing increased productivity and value.

- One tool for roughing and finishing operations.
- Milling at a value price when re-grinding is not justified.
- Stable, low-vibration solution with soft cut for mill-turn machines.
- Stable, low-vibration solution with soft cut for mill-turn machines.
- Ask your local sales representatives about the options with corner radius

Features

- 4 Flutes
- Center Cutting
- Short length better economics

Functions

- High MRR
- Stable cutting at high cutting speeds

Benefits

- Superior tool life
- Low operating cost

Application data on page no 2.136



Solid Carbide End Mills

Cutting parameters for Nano

END MILLS

Material		Side Milling		Slot Milling		Cutting Speed Vc (m/min)		Recommended feed per tooth (fz = mm/tooth) for side milling & For slotting, reduce fz by 20%.					
		Diameter in mm											
		ap	ae	ap	min	max	mm	4.0	6.0	8.0	10.0	12.0	
Steel	P	1	1.5xD	0.5xD	1xD	180	220	Fz	0.030	0.050	0.060	0.070	0.072
		2	1.5xD	0.5xD	1xD	160	200	Fz	0.030	0.050	0.060	0.070	0.072
		3	1.5xD	0.5xD	1xD	160	180	Fz	0.025	0.040	0.050	0.060	0.070
		4	1.5xD	0.5xD	1xD	140	160	Fz	0.023	0.036	0.045	0.054	0.063
Stainless Steel	M	1	1.5xD	0.5xD	1xD	90	115	Fz	0.025	0.040	0.050	0.060	0.065
		2	1.5xD	0.5xD	1xD	60	80	Fz	0.020	0.030	0.040	0.050	0.060
Cast Iron	K	1	1.5xD	0.5xD	1xD	120	150	Fz	0.030	0.050	0.060	0.070	0.080
		2	1.5xD	0.5xD	1xD	110	130	Fz	0.025	0.040	0.050	0.060	0.070
		3	1.5xD	0.5xD	1xD	100	130	Fz	0.020	0.030	0.040	0.050	0.060