



COBALT END MILLS

VFP635M



METRIC MULTI FLUTE - HSCO

Price Code B

VFP635M

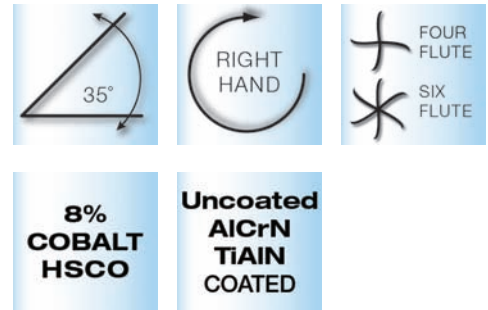
Flute Dia	Shank Dia	Length of Cut	Overall Length	#F	Corner Chamfer	Unc EDP	TiAlN EDP	AlCrN EDP
16mm	16mm	32mm	92mm	4	0.50	68921	68922	68923
18mm	16mm	32mm	92mm	4	0.50	68924	68925	68926
20mm	20mm	38mm	114mm	4	0.75	68927	68928	68929
25mm	25mm	45mm	121mm	4	0.75	68930	68931	68932
25mm	25mm	45mm	121mm	6	0.75	68933	68934	68935
30mm	30mm	45mm	121mm	4	1.00	68936	68937	68938
30mm	30mm	45mm	121mm	6	1.00	68939	68940	68941
32mm	32mm	53mm	132mm	4	1.00	68942	68943	68944
32mm	32mm	53mm	132mm	6	1.00	68945	68946	68947

Features

- Variable Face Profile
- Polished Flute Faces
- Center-Cutting
- Corner Chamfer

Applications

- Aerospace Materials
- For Stainless Steels, Titanium & Titanium Alloys



VFP635M - Recommended Starting Point Speed & Feeds (Slotting) METRIC

Material	16mm Diameter				20mm Diameter			25mm Diameter			32mm Diameter			Axial Depth
	m/min	RPM	CPT	mm/min	RPM	CPT	mm/min	RPM	CPT	mm/min	RPM	CPT	mm/min	Maximum
Titanium 6Al4V														
<38 Rc	23	419	0.084	141	335	0.097	130	268	0.122	196	209	0.142	178	1 x Dia
>38 Rc	17	309	0.051	63	248	0.017	70	198	0.091	108	155	0.102	95	0.75 x Dia

VFP635M - Recommended Starting Point Speed & Feeds (Profiling) METRIC

Material	16mm Diameter				20mm Diameter			25mm Diameter			32mm Diameter			Radial Depth	Axial Depth
	m/min	RPM	CPT	mm/min	RPM	CPT	mm/min	RPM	CPT	mm/min	RPM	CPT	mm/min	Maximum	Maximu
Titanium 6Al4V															
<38 Rc	23	419	0.102	171	335	0.119	150	268	0.152	244	209	0.178	223	0.4 x Dia	1.5 x Dia
>38 Rc	17	309	0.071	88	248	0.089	88	198	0.114	135	155	0.127	118	0.25 x Dia	1 x Dia