Product Expansion

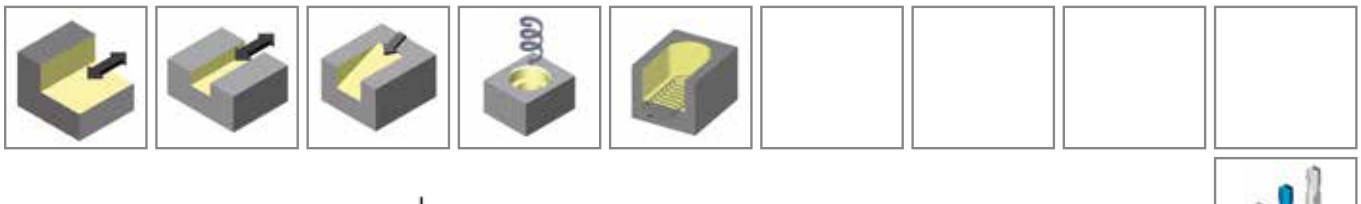
VHM 442 TI08

for stainless steel machining

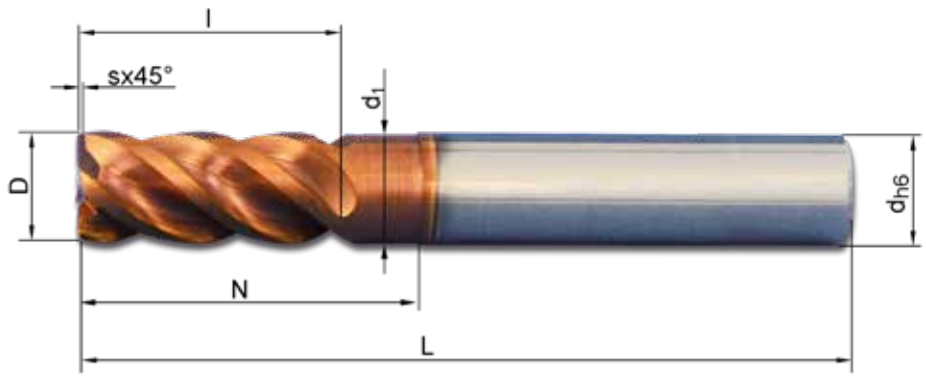
We are expanding our range of solid carbide tools for stainless steel machining.

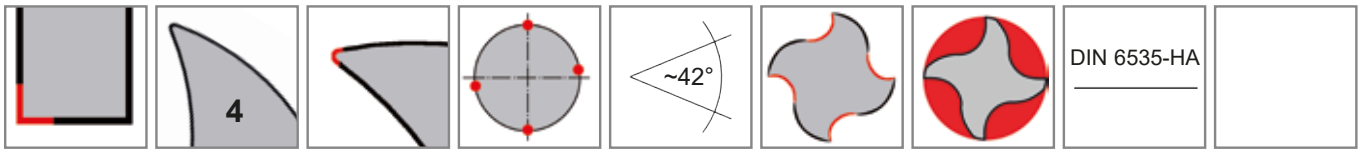
This involves a new variant of the VHM 441 TI08 without an edge chamfer.

The product will be listed in the new main catalogue under the VHM 441.





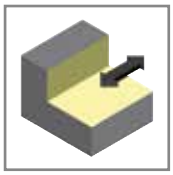




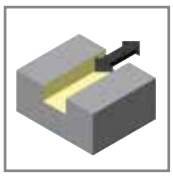
Bestell-Nr. *Order-No., Référence, Codice*	Artikel *Article, Article, Articolo*	D	s	l	N	d_1	d	L	Z	Preis EUR *Price, Prix, Prezzo*
VU442M02A-TI08	**VHM 442-02 TI08**	2	-	6	6	-	6	50	4	36,20 €
VU442M03A-TI08	**VHM 442-03 TI08**	3	-	6	6	-	6	50	4	36,20 €
VU442M04A-TI08	**VHM 442-04 TI08**	4	-	8	8	-	6	50	4	36,20 €

Jongen Werkzeugtechnik GmbH | Siemensring 11 | 47877 Willich | Germany
Tel.: 0 21 54 9285 2900 | Fax: 0 21 54 9285 92900
Email: export@jongen.de | www.jongen.de

Parameters recommendation VHM 442 TI08



Material	D [mm]	V_c [m/min]	f_z [mm]	a_p [mm]	a_e [mm]	n [min^{-1}]	V_f [mm/min]	Q [cm^3/min]
High grade steel High alloyed steel	2	100 (60-120)	0,012 (0,005-0,020)	3,5	0,40	15.920	765	1,1
	3	100 (60-120)	0,015 (0,005-0,030)	5,0	1,20	10.610	640	3,5
	4	100 (60-120)	0,018 (0,010-0,040)	6,0	1,60	7.960	570	5,5
Titanium alloys >300 HB (e.g. TiAlV6)	2	50 (30-80)	0,012 (0,005-0,020)	3,5	0,4	7.960	380	0,5
	3	50 (30-80)	0,015 (0,005-0,030)	5,0	1,20	5.310	320	1,7
	4	50 (30-80)	0,018 (0,010-0,040)	6,0	1,60	3.980	290	2,8
Nickel-base alloy hardenable (e.g. Inconel 718)	2	30 (20-60)	0,012 (0,005-0,020)	3,5	0,4	4.770	230	0,3
	3	30 (20-60)	0,015 (0,005-0,030)	5,0	1,20	3.180	190	1,0
	4	30 (20-60)	0,018 (0,010-0,040)	6,0	1,00	2.390	170	1,0
Structural steel Unalloyed steel <800 N/mm^2	2	120 (90-180)	0,012 (0,005-0,020)	3,5	0,4	19.100	920	1,3
	3	120 (90-180)	0,015 (0,005-0,030)	5,0	1,20	12.730	760	4,1
	4	120 (90-180)	0,018 (0,010-0,040)	7,0	1,80	9.550	690	8,9



Material	D [mm]	V_c [m/min]	f_z [mm]	a_p [mm]	a_e [mm]	n [min^{-1}]	V_f [mm/min]	Q [cm^3/min]
High grade steel High alloyed steel	2	80 (60-120)	0,010 (0,005-0,020)	1	2	12.730	510	1,0
	3	80 (60-120)	0,010 (0,005-0,030)	3	3	8.490	320	2,9
	4	80 (60-120)	0,010 (0,005-0,030)	4	4	6.370	290	4,6
Titanium alloys (z.B. TiAlV6)	2	40 (30-80)	0,010 (0,005-0,020)	1	2	6.370	255	0,5
	3	40 (30-80)	0,010 (0,005-0,030)	3	3	4.240	160	1,4
	4	40 (30-80)	0,010 (0,010-0,040)	4	4	3.180	140	2,2
Nickel-base alloy hardenable (e.g. Inconel 718)	2	30 (20-60)	0,010 (0,005-0,020)	1	2	4.770	190	0,4
	3	30 (20-60)	0,010 (0,005-0,030)	3	3	3.180	120	1,1
	4	30 (20-60)	0,010 (0,010-0,040)	4	4	2.390	110	1,8
Structural steel Unalloyed steel <800 N/mm^2	2	100 (90-150)	0,010 (0,005-0,020)	1	2	15.920	635	1,3
	3	100 (90-150)	0,010 (0,005-0,030)	3	3	10.610	400	3,6
	4	100 (90-150)	0,010 (0,010-0,040)	4	4	7.960	360	5,8

For ramping and helical milling operations, we recommend to reduce fz (feed speed per tooth) by 50% compared to full slot milling

Errors, omissions and technical modifications are reserved.

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