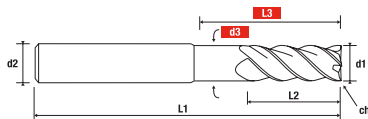


BIG PROMOTION | **Helion** YELLOW BLADE

91.4482

SET YELLOW BLADE SQUARE END MILL Z4



• High Durability and Strength

Manufactured from high-quality micrograin carbide with a Gold multi-layer coating, ensuring long service life and wear resistance even under demanding conditions.

• Optimized Design for Maximum Precision

Its geometry with variable helix and reinforced cutting edges ensures smooth and efficient milling, reducing vibrations and enhancing machining quality.

• Superior Performance in Stainless Steels

Optimized to deliver exceptional performance in stainless steels, surpassing competitors in efficiency and productivity, making it the ideal choice for challenging materials.

• Extended Tool Life and Lower Cost Per Part

Its robustness and multi-layer coating extend the tool's lifespan, reducing operational costs and improving long-term profitability.

LAUNCH PRICE
SET 06 08 010 012

139€

PRICE OF
SET + 016
SET 06 08 010 012 + 016

179€

-10% - ΓΙΑ 2 ΣΕΤ

-20% - ΓΙΑ 3 ΣΕΤ & ΑΝΩ



Cod.	d1	d2	d3	L1	L2	L3	Ch	Z
9144820600	6	6	5,50	60	13	21	0,20	4
9144820800	8	8	7,50	60	19	27	0,20	4
9144821000	10	10	9,50	70	22	32	0,20	4
9144821200	12	12	11,50	80	26	38	0,30	4
9144821600	16	16	15,50	90	32	44	0,40	4

CUTTING CONDITIONS 91.4482

		Roughing					
		ap: 0.75 x d1 / ae: 1 x d1					
		d1	d1	d1	d1	d1	
		6	8	10	12	16	
		Vc	fz	fz	fz	fz	
Steel	Carbon Steel <500 N/mm ²	207	0,028	0,055	0,047	0,057	0,075
	Carbon Steel <700 N/mm ²	184	0,026	0,055	0,044	0,052	0,070
	Carbon Steel <850 N/mm ²	155	0,026	0,051	0,043	0,051	0,068
	Carbon Steel <1000 N/mm ²	184	0,024	0,032	0,040	0,048	0,064
	Carbon Steel <1400 N/mm ²	138	0,022	0,032	0,037	0,044	0,059
	High Alloyed Steel <850 N/mm ²	104	0,026	0,051	0,044	0,052	0,070
	High Alloyed Steel <1000 N/mm ²	92	0,024	0,032	0,040	0,048	0,064
	High Alloyed Steel <1400 N/mm ²	81	0,024	0,032	0,040	0,048	0,064
High Alloyed Steel >1400 N/mm ²	69	0,022	0,029	0,037	0,044	0,059	
Inox	Rust and acid resitant steels <700 N/mm² (<205 HB)	85	0,024	0,030	0,040	0,050	0,057
	Rust and acid resistantsteels >700 N/mm² (>205 HB)	64	0,019	0,024	0,031	0,040	0,045
Cast Iron	Cast iron < 180HB (GG)	127	0,028	0,055	0,047	0,057	0,075
	Cast Iron > 250HB (GG)	104	0,026	0,051	0,044	0,052	0,070
	Nodular Cast Iron > 300 HB (GGG)	69	0,021	0,051	0,035	0,041	0,055
Exotic Materials	Titanium, Ti-, Ni-, Co- alloy (Inconel, Stellite...)	38	0,016	0,030	0,028	0,033	0,044

		Finishing					
		ap: 1.7 x d1 / ae: 0.3 - 0.5 x d1					
		d1	d1	d1	d1	d1	
		6	8	10	12	16	
		Vc	fz	fz	fz	fz	
Steel	Carbon Steel <500 N/mm ²	288	0,041	0,055	0,069	0,083	0,110
	Carbon Steel <700 N/mm ²	265	0,041	0,055	0,069	0,083	0,110
	Carbon Steel <850 N/mm ²	242	0,038	0,051	0,063	0,076	0,101
	Carbon Steel <1000 N/mm ²	207	0,024	0,032	0,040	0,048	0,064
	Carbon Steel <1400 N/mm ²	184	0,024	0,032	0,040	0,048	0,064
	High Alloyed Steel <850 N/mm ²	230	0,038	0,051	0,063	0,076	0,101
	High Alloyed Steel <1000 N/mm ²	207	0,024	0,032	0,040	0,048	0,064
	High Alloyed Steel <1400 N/mm ²	184	0,024	0,032	0,040	0,048	0,064
	High Alloyed Steel >1400 N/mm ²	161	0,022	0,029	0,037	0,044	0,059
	Hardened Steels 45-55 HRC	115	0,021	0,028	0,035	0,041	0,055
	Hardened Steels 55-60 HRC	92	0,019	0,026	0,032	0,039	0,052
Inox	Rust and acid resitant steels <700 N/mm² (<205 HB)	120	0,029	0,036	0,047	0,059	0,068
	Rust and acid resistantsteels >700 N/mm² (>205 HB)	90	0,023	0,029	0,037	0,047	0,054
Cast Iron	Cast iron < 180HB (GG)	253	0,041	0,055	0,069	0,083	0,110
	Cast Iron > 250HB (GG)	207	0,038	0,051	0,063	0,076	0,101
	Nodular Cast Iron > 300 HB (GGG)	104	0,038	0,051	0,063	0,076	0,101
Exotic Materials	Titanium, Ti-, Ni-, Co- alloy (Inconel, Stellite...)	30	0,022	0,030	0,038	0,045	0,060



WITH COOLANT | **CON REFRIGERACIÓN**
Working with cooling | **Mecanizado con refrigeración.**