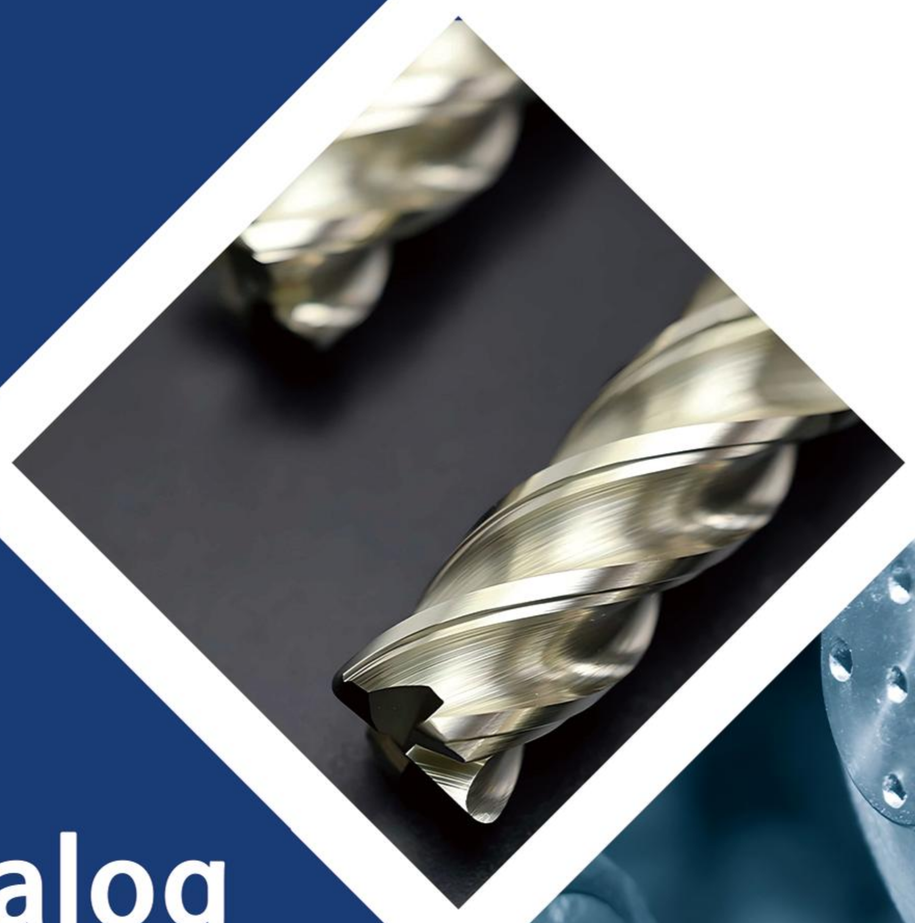
Precision Engineering&Exceptional Results

HNCARBIDE



Product Catalog

2025

Zhangjiagang Bonded Zone Huanatools Co., Ltd

- HNCarbide is a leading High-Performance Cutting Tool Manufacturer,founded in 2008.
- Specializes in precision carbide end mills, drills
- Offers custom machining solutions
- Committed to efficiency, accuracy, durability

HNCARBIDE

OUR EQUIPMENT

High precision grinding equipment

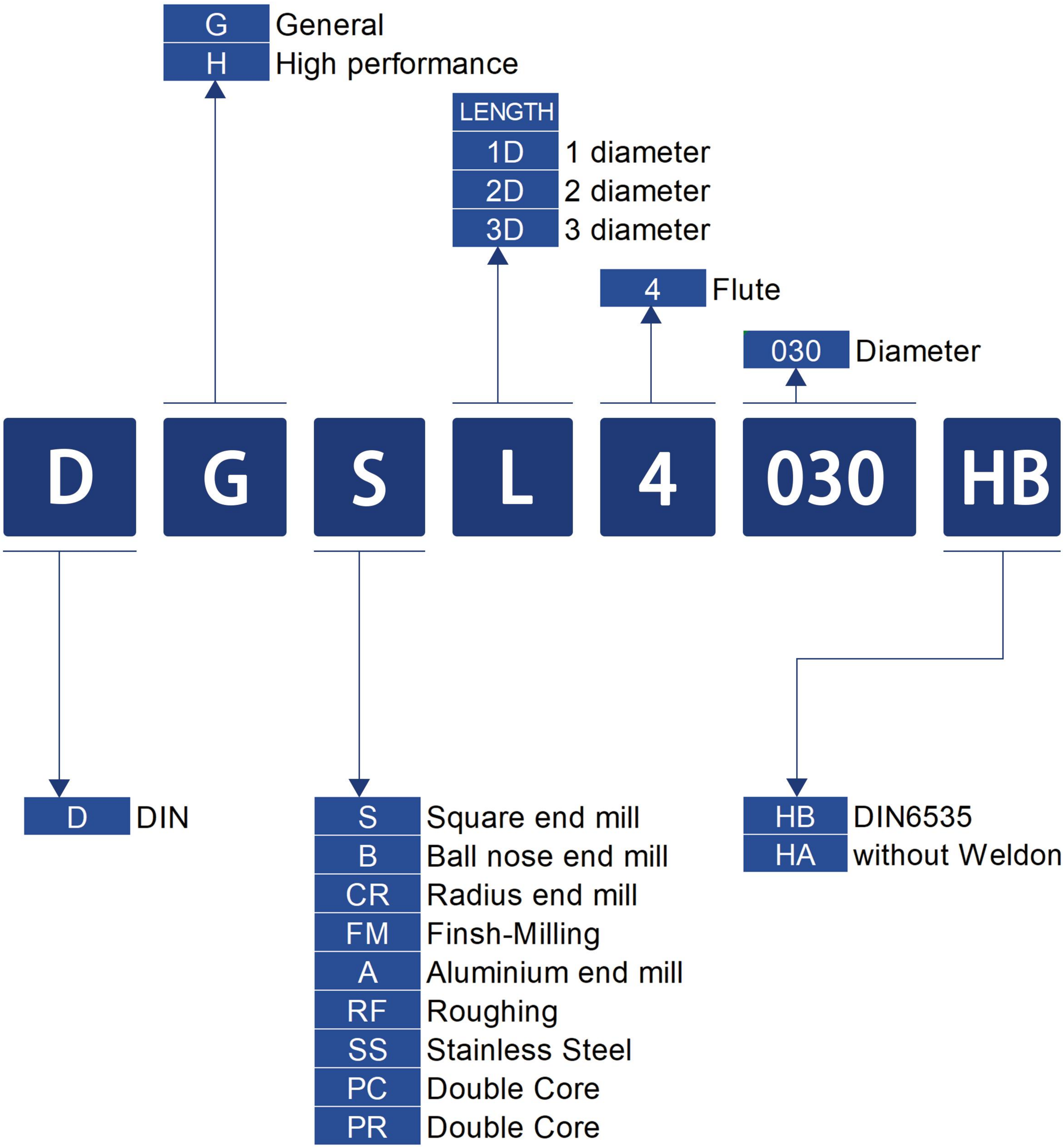
makinoseiki

WALTER

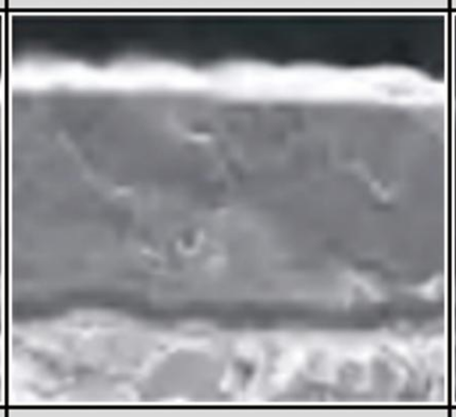
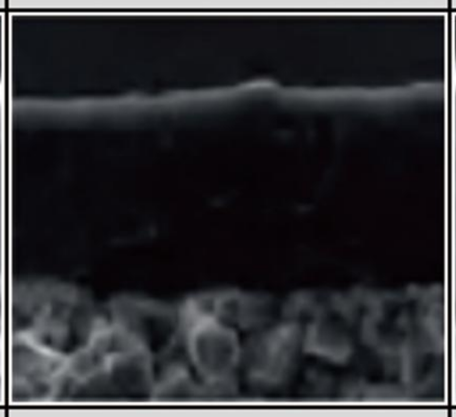
ZOLLER

High precision testing equipment

Cutting Tool Type Marking Guidelines



Coating materials

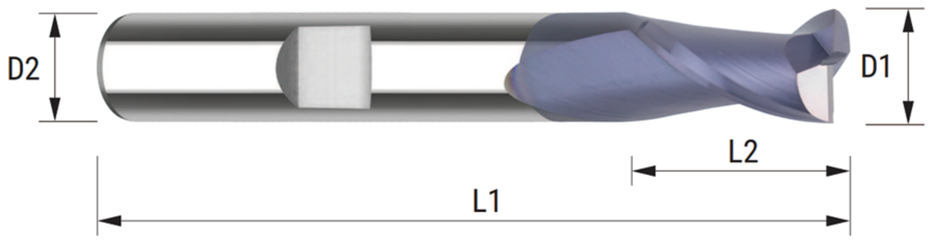
Feature of coating layer				
Coating name	**RZ**	**RU**	**RX**	**RA**
Components	TiAlN+CrAlN	AlCrN	TiSiN	DLC
Coating structure				
Properties	Superoxidation resistance、Low friction	Super oxidation resistance、Low friction	Super hardness、super oxidation resistance、High adhesion	Super oxidation resistance、Low friction
Hardness	3600(HV)	3400(HV)	3300(HV)	5000(HV)
Coefficeient of friction	0.3	0.32	0.4	0.1
Oxidation start temperature	1200	1100	1000	500
Coating thickness	2-4um	2-4um	2-4um	0.2-1.0um

GP

Solid Carbide End Mill Z2

VHM-Schaftfräser kurz

Fraise carbure



Werkzeugdaten / Description / Donees doutils

Order Number	D1	D2	L2	L1		
DGS2-010	1	3	2	38	HA	-
DGS2-015	1.5	3	3	38	HA	-
DGS2-020	2	3	6	38	HA	-
DGS2-025	2.5	3	6	38	HA	-
DGS2-030	3	3	7	38	HA	-
DGS2-040	4	6	8	57	HA	HB
DGS2-050	5	6	10	57	HA	HB
DGS2-060	6	6	10	57	HA	HB
DGS2-080	8	8	16	63	HA	HB
DGS2-100	10	10	19	72	HA	HB
DGS2-120	12	12	22	83	HA	HB
DGS2-140	14	14	22	83	HA	HB
DGS2-160	16	16	26	92	HA	HB
DGS2-200	20	20	32	104	HA	HB

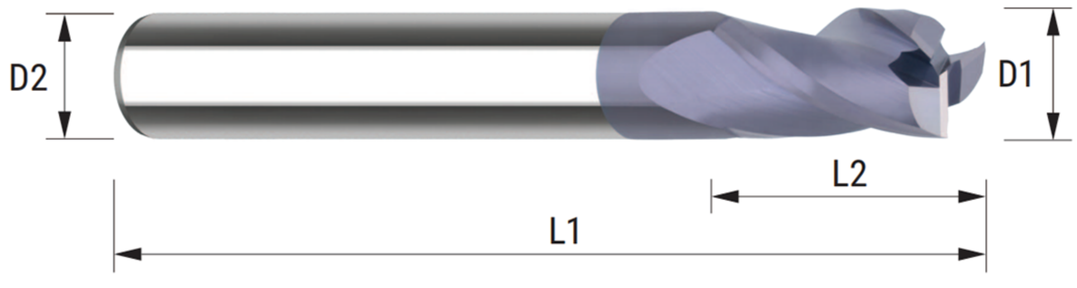
Order Number	D1	D2	L2	L1		
DGS2L-030	3	3	20	75	HA	-
DGS2L-040	4	4	25	75	HA	-
DGS2L-050	5	5	30	75	HA	-
DGS2L-060	6	6	30	75	HA	HB
DGS2L-080	8	8	40	100	HA	HB
DGS2L-100	10	10	40	100	HA	HB
DGS2L-120	12	12	45	150	HA	HB
DGS2L-160	16	16	65	150	HA	HB
DGS2L-200	20	20	65	150	HA	HB

GP

Solid Carbide End Mill Z3

VHM-Schaftfräser

Fraise carbure



Werkzeugdaten / Description / Donees doutils

Order Number	D1	D2	L2	L1	HA	HB
DGS3-010	1	3	3	38	HA	-
DGS3-015	1.5	3	5	38	HA	-
DGS3-020	2	3	7	38	HA	-
DGS3-025	2.5	3	7	38	HA	-
DGS3-030	3	3	8	38	HA	-
DGS3-040	4	4	11	50	HA	-
DGS3-050	5	5	10	50	HA	-
DGS3-060	6	6	10	57	HA	HB
DGS3-080	8	8	16	63	HA	HB
DGS3-100	10	10	22	72	HA	HB
DGS3-120	12	12	22	83	HA	HB
DGS3-140	14	14	22	83	HA	HB
DGS3-160	16	16	26	83	HA	HB
DGS3-200	20	20	32	104	HA	HB

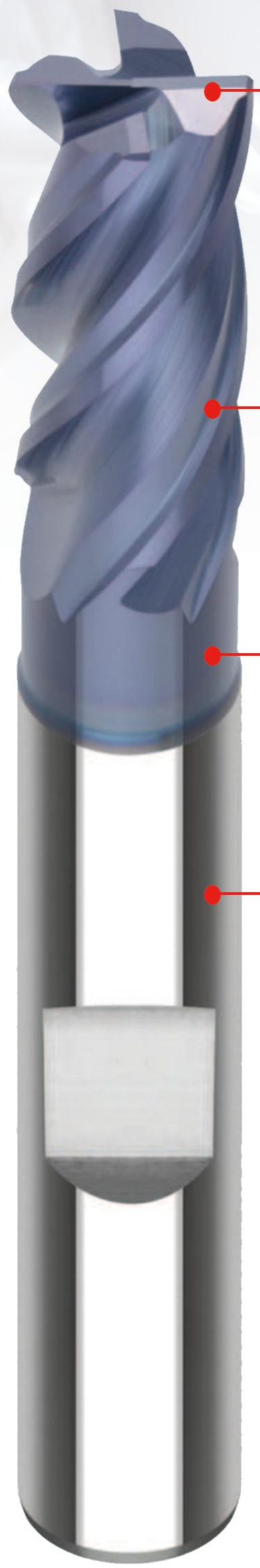
Multi-functional high-efficiency milling cutter

HNCARBIDE

Suitable for high efficiency machining of mild steel, alloy steel and cast iron.

Advantages

- Anti-seismic design effectively suppress vibration and noise.
- Geometric groove design optimizes chip removal and is suitable for heavy cutting.
- Cooperate with high-quality coating to effectively reduce wear.



High-performance arc angle shape including chamfer

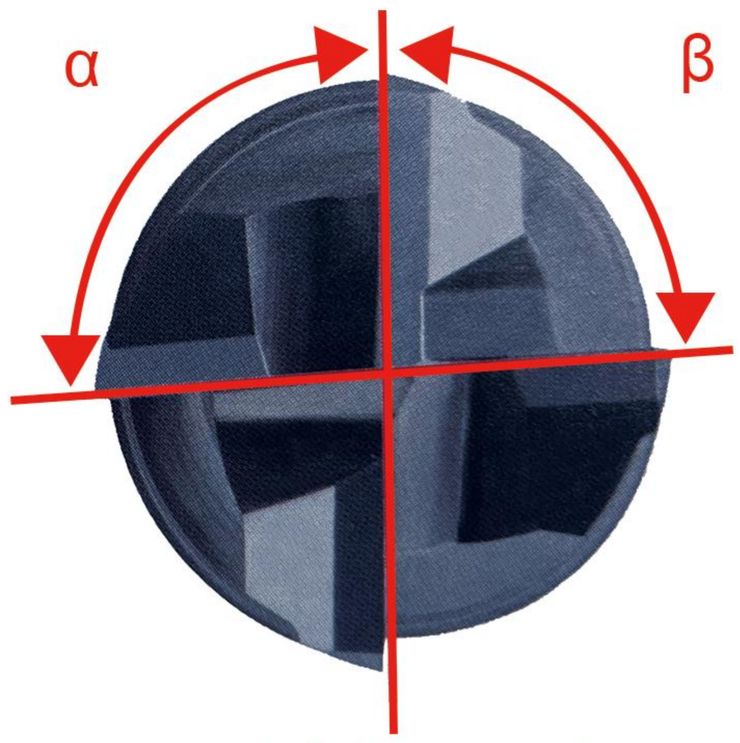
Variable helix angle design

High-quality composite coating

High quality cemented carbide bar

Application

- Mild steel
- Alloy steels
- Cast iron
- Below HRC45 Medium hardness materials



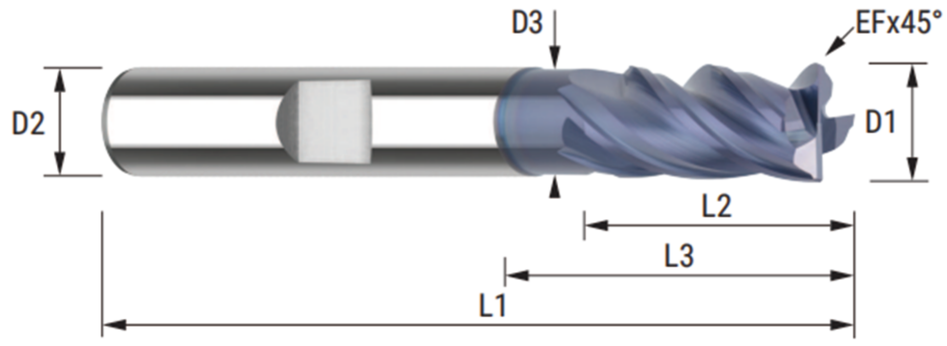
α ≠ β Unequal

GP

Square Unequal Helix Milling Cutter 2xD

VHM-Schaftfräser 2xD

Fraise carbure 2xD



Werkzeugdaten / Description / Donees doutils

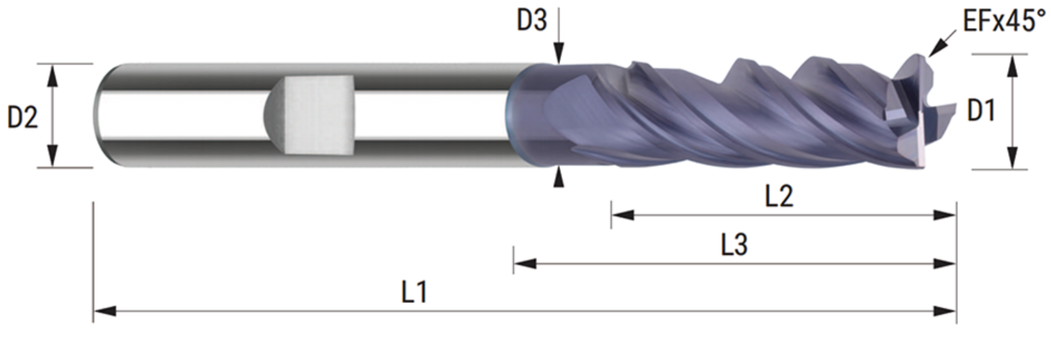
Order Number	D1	D2	L2	L1	D3	L3	EF		
DGS4-2D-030	3	6	8	57	2.8	18	0.13	HA	HB
DGS4-2D-040	4	6	11	57	3.6	21	0.13	HA	HB
DGS4-2D-050	5	6	13	57	4.6	21	0.2	HA	HB
DGS4-2D-060	6	6	13	57	5.5	21	0.2	HA	HB
DGS4-2D-080	8	8	19	63	7.5	27	0.2	HA	HB
DGS4-2D-100	10	10	22	72	9.5	32	0.2	HA	HB
DGS4-2D-120	12	12	26	83	11.5	38	0.3	HA	HB
DGS4-2D-140	14	14	26	83	13.5	42	0.3	HA	HB
DGS4-2D-160	16	16	32	92	15.5	44	0.3	HA	HB
DGS4-2D-180	18	18	32	92	17.5	50	0.4	HA	HB
DGS4-2D-200	20	20	38	104	19.5	54	0.4	HA	HB

GP

Square Unequal Helix Milling Cutter 3xD

VHM-Schaftfräser 3xD

Fraise carbure 3xD



Werkzeugdaten / Description / Donees doutils

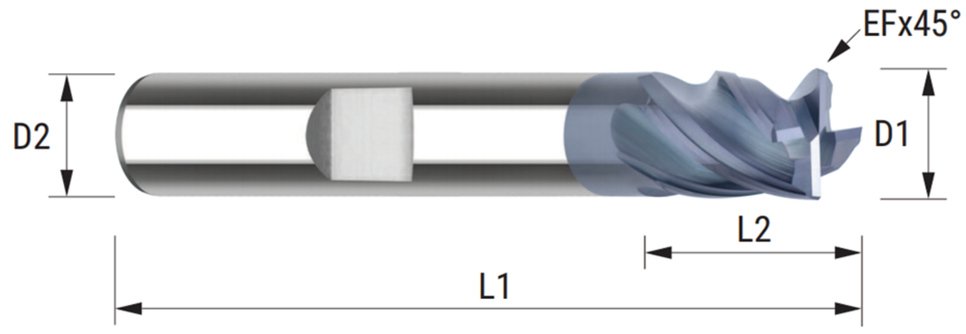
4 | EF | 35°/38° | ≠ | xyz | ALCRN | HA | HB

Order Number	D1	D2	L2	L1	D3	L3	EF		
DGS4-3D-060	6	6	22	63	5.5	30	0.2	HA	HB
DGS4-3D-080	8	8	28	80	7.5	36	0.2	HA	HB
DGS4-3D-100	10	10	33	100	9.5	54	0.2	HA	HB
DGS4-3D-120	12	12	42	100	11.5	54	0.3	HA	HB
DGS4-3D-160	16	16	53	150	15.5	69	0.3	HA	HB
DGS4-3D-200	20	20	68	150	19.5	84	0.4	HA	HB

Square Unequal Helix Milling Cutter 1xD

VHM-Schaftfräser 1xD

Fraise carbure 1xD



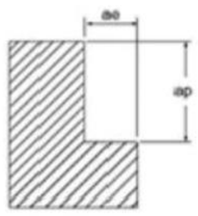
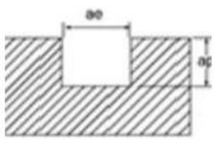
Werkzeugdaten / Description / Donees doutils

Order Number	D1	D2	L2	L1	EF		
DGS4-1D-030	3	6	6	54	0.1	HA	HB
DGS4-1D-040	4	6	8	54	0.13	HA	HB
DGS4-1D-050	5	6	9	54	0.18	HA	HB
DGS4-1D-060	6	6	10	54	0.2	HA	HB
DGS4-1D-080	8	8	12	58	0.2	HA	HB
DGS4-1D-100	10	10	14	66	0.2	HA	HB
DGS4-1D-120	12	12	16	73	0.3	HA	HB
DGS4-1D-140	14	14	18	75	0.3	HA	HB
DGS4-1D-160	16	16	22	82	0.3	HA	HB
DGS4-1D-180	18	18	24	84	0.4	HA	HB
DGS4-1D-200	20	20	26	92	0.4	HA	HB

Unequal parts, unequal helix, general-purpose milling cutter machining case

Tool / List	Unequal parts, unequal screws, general purpose milling cutter
Size	φ10×φ10×22×72
Work Material	carbon steelC45
Actual processing surface effect	Workpiece dimensions： 65*46*20mm Number of pieces processed：500pieces Number of metres processed：200m 
Cutting Speed	95 m/min
RPM	3000 rev/min
Feed	700 mm/min
Feed per tooth	0.05 mm/tooth
Miling Method	Down&Side Cutting
Milling Depth	Axial:20mm Radial:0.1mm
Coolant	gas cooling

Cutting Parameter Table for Unequal, Unequal Helix, Universal Milling Cutter (Standard)

Processing method	processed material	Processing method	depth of cut (apxae mm)	outer diameter D(mm)	3	4	5	6	8	10	12	16	20
 	Carbon Steel	Side milling	Standard2Dx0.08D	rotation speed(min^{-1})	10000	10000	8000	8000	5000	4000	3500	2500	2200
				feed(mm/min)	1000	1000	800	800	800	800	700	600	500
		grooving	ap≦0.3D	rotation speed(min^{-1})	10000	10000	8000	8000	5000	4000	3500	2500	2200
				feed(mm/min)	900	900	700	700	700	700	600	500	400
	alloy steel	Side milling	Standard2Dx0.06D	rotation speed(min^{-1})	9000	9000	7000	7000	4500	3800	3000	2200	2200
				feed(mm/min)	1000	1000	800	800	800	800	700	600	500
		grooving	ap≦0.2D	rotation speed(min^{-1})	9000	9000	7000	7000	4500	3800	3000	2200	2200
				feed(mm/min)	1000	900	700	700	700	700	600	500	400
	Stainless steel/titanium alloy	Side milling	Standard2Dx0.04D	rotation speed(min^{-1})	8000	8000	6000	6000	4000	3500	3000	2200	2000
				feed(mm/min)	800	800	600	600	800	800	700	600	500
		grooving	ap≦0.1D	rotation speed(min^{-1})	8000	8000	6000	6000	4000	3500	3000	2200	2000
				feed(mm/min)	400	500	500	500	500	500	500	400	400

Adjust the machining parameters according to the shank clamping, jigs and fixtures, and machine rigidity.
Water-soluble coolant is recommended for machining stainless steel and titanium alloys.

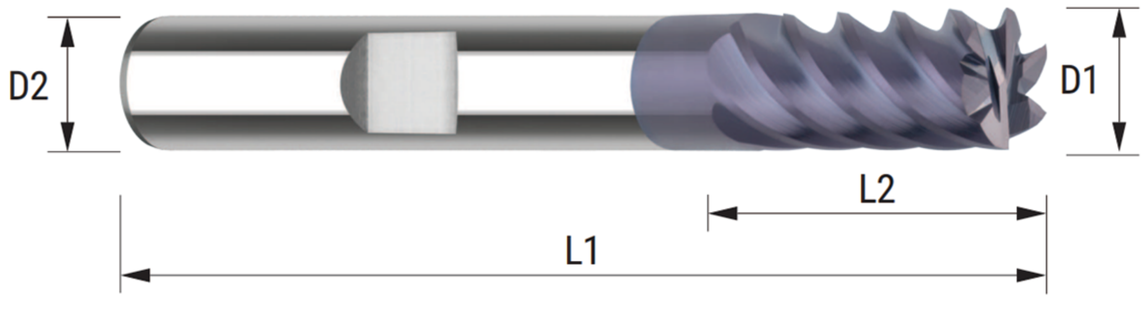
Carbon steel / alloy steel main materials: (A3, 45 steel, 20Cr, 40Cr, 20CrMo, 35CrMo, 42CrMo, 20CrMnTi, 35CrMoA, etc.)
Stainless steel / titanium alloy main materials: (201, 202, 301, 304, 316, 430, 630, TC4, TC6, etc.)

GP

Finsh-Milling Square Milling Cutter

VHM-Schlichtfräser

Fraise finition carbure



Werkzeugdaten / Description / Donees doutils

6-8 | 45° | Norm | ALCRN | HA | HB

Order Number	D1	D2	L2	L1	Z		
DGFM-060	6	6	13	57	6	HA	HB
DGFM-080	8	8	19	63	6	HA	HB
DGFM-100	10	10	22	72	6	HA	HB
DGFM-120	12	12	26	83	6	HA	HB
DGFM-160	16	16	32	92	6	HA	HB
DGFML-160	16	16	65	120	6	HA	HB
DGFM-200	20	20	38	104	8	HA	HB
DGFML-200	20	20	75	135	8	HA	HB

End mills for finishing stainless steel

HNCARBIDE

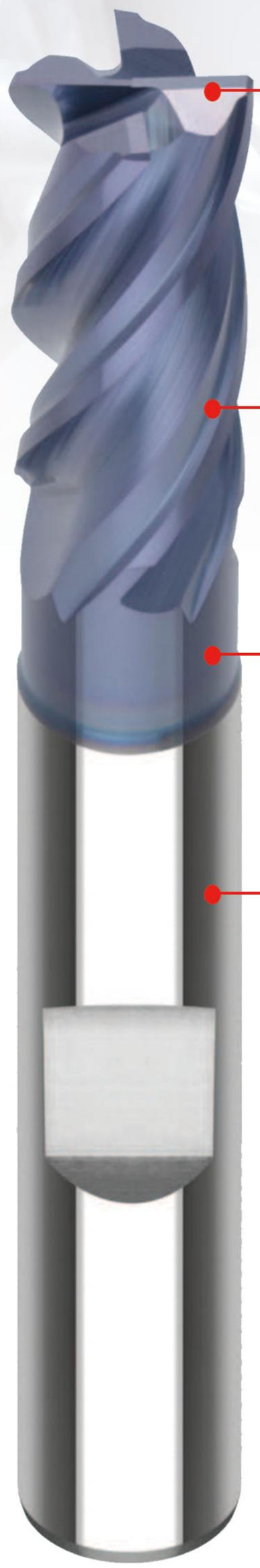
Suitable for fine milling of stainless steel, titanium alloy, steel parts, cast iron, etc..

Advantages

- Anti-seismic design effectively suppress vibration and noise.
- Variable helix angle design makes cutting easier.
- Cooperate with high-quality coating to effectively reduce wear.

Application

- Stainless Steel
- Titanium alloy
- Low carbon steel and cast iron
- Medium hardness material lower than HRC40

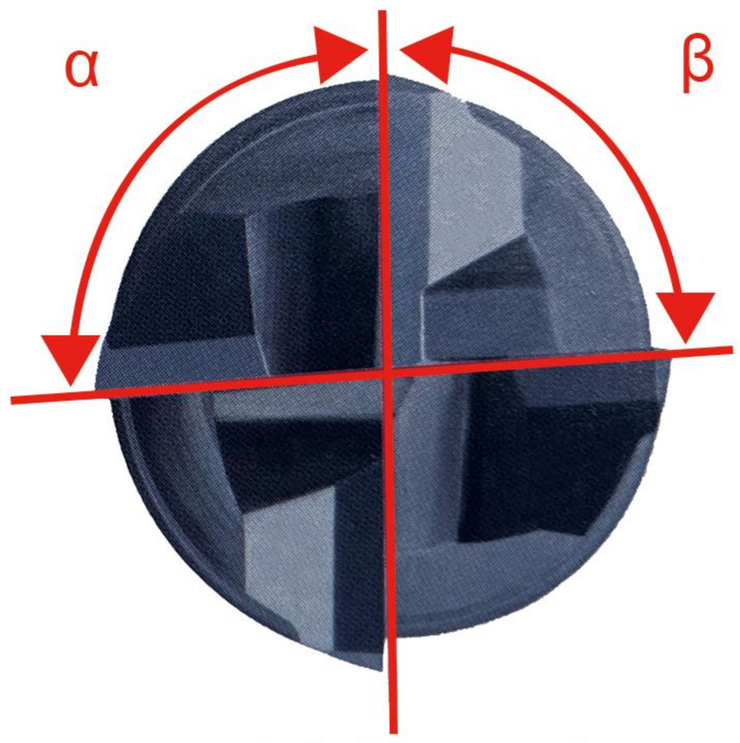


Seismic efficient cutting with unequal design

Eccentric rounded rear corner design ensures tool rigidity

Small blade design ensures surface finish

High flexural strength alloy rods



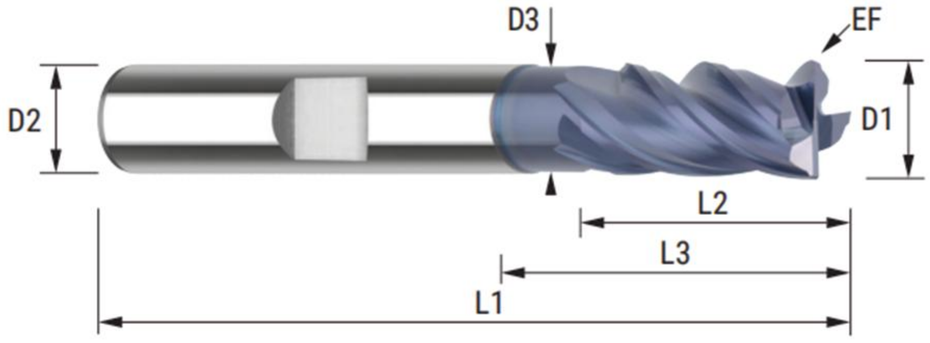
α ≠ β Unequal

GP

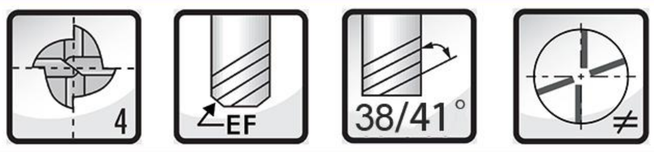
Square Unequal Helix Milling Cutter for Stainless Steel

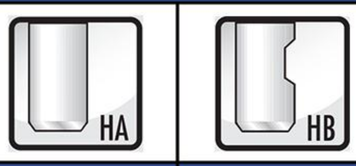
VHM-Schaftfräser

Fraise carbure



Werkzeugdaten / Description / Donees doutils



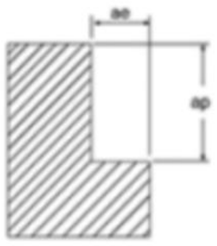
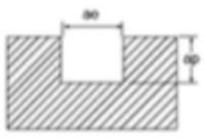


Order Number	D1	D2	L2	L1	D3	L3	EF		
DGSS-030	3	6	8	57	2.8	18	0.13	HA	HB
DGSS-040	4	6	11	57	3.6	21	0.13	HA	HB
DGSS-050	5	6	13	57	4.6	21	0.2	HA	HB
DGSS-060	6	6	13	57	5.5	21	0.2	HA	HB
DGSS-080	8	8	19	63	7.5	27	0.2	HA	HB
DGSS-100	10	10	22	72	9.5	32	0.2	HA	HB
DGSS-120	12	12	26	83	11.5	38	0.3	HA	HB
DGSS-140	14	14	26	83	13.5	42	0.3	HA	HB
DGSS-160	16	16	32	92	15.5	44	0.3	HA	HB
DGSS-180	18	18	32	92	17.5	50	0.4	HA	HB
DGSS-200	20	20	38	104	19.5	54	0.4	HA	HB

Stainless steel milling cutter machining case

Tool / List	Unequal parts, unequal screws, general purpose milling cutter
Size	φ10×φ10×22×72
Work Material	Stainless steel304
Actual processing surface effect	Workpiece dimensions： 42*42*30mm Number of pieces processed：180pieces Number of metres processed：235m 
Cutting Speed	94.2 m/min
RPM	3000 rev/min
Feed	1000 mm/min
Feed per tooth	0.08 mm/tooth
Miling Method	Down&Side Cutting
Milling Depth	Axial:20mm Radial:0.1mm
Coolant	Cutting Fluid

Cutting Parameter Table for Milling cutter for stainless steel

Processing method	processed material	Processing method	depth of cut (apxae mm)	outer diameter D(mm)	3	4	5	6	8	10	12	16	20
	carbon steel	Side milling	Standard <2.0Dx0.2D	rotation speed(min^{-1})	10000	8000	5000	4500	4000	3500	3000	2500	2200
				feed(mm/min)	1500	1500	1500	1500	1500	1300	1300	1200	1200
	alloy steel	Side milling	Standard <2.0Dx0.15D	rotation speed(min^{-1})	8000	6000	4500	4000	3500	3000	2500	2000	1800
				feed(mm/min)	1200	1200	1200	1200	1200	1100	1100	1000	1000
	prehardened steel (30-45HRC)	Side milling	Standard <2.0Dx0.06D	rotation speed(min^{-1})	6000	4000	3500	3000	2500	2500	2000	1500	1200
				feed(mm/min)	1000	1000	1000	1000	1000	900	800	800	800
	Stainless steel / Titanium alloys / Nickel-based alloys	Side milling	Standard <2.0Dx0.08D	rotation speed(min^{-1})	8000	6000	4000	3500	3000	2500	2000	1800	1500
				feed(mm/min)	1200	1200	1200	1200	1200	1000	1000	800	800
Processing method	**processed material**	**Processing method**	**depth of cut (apxae mm)**	**outer diameter D(mm)**	**3**	**4**	**5**	**6**	**8**	**10**	**12**	**16**	**20**
	carbon steel	grooving	AP≤1D	rotation speed(min^{-1})	10000	8000	5000	4500	4000	3500	3000	2500	2200
				feed(mm/min)	800	900	900	900	900	900	800	800	600
	alloy steel	grooving	AP≤0.8D	rotation speed(min^{-1})	8000	6000	4500	4000	3500	3000	2500	2000	1800
				feed(mm/min)	700	800	800	800	800	800	700	700	500
	prehardened steel (30-45HRC)	grooving	AP≤0.5D	rotation speed(min^{-1})	6000	4000	3500	3000	2500	2500	2000	1500	1200
				feed(mm/min)	400	400	500	500	500	500	400	400	400
	Stainless steel / Titanium alloys / Nickel-based alloys	grooving	AP≤0.5D	rotation speed(min^{-1})	8000	6000	4000	3500	3000	2500	2000	1800	1500
				feed(mm/min)	500	600	600	600	600	600	500	500	500

Adjust the machining parameters according to the shank clamping, jigs and fixtures, and machine rigidity.
Water-soluble coolant is recommended for machining stainless steel and titanium alloys.

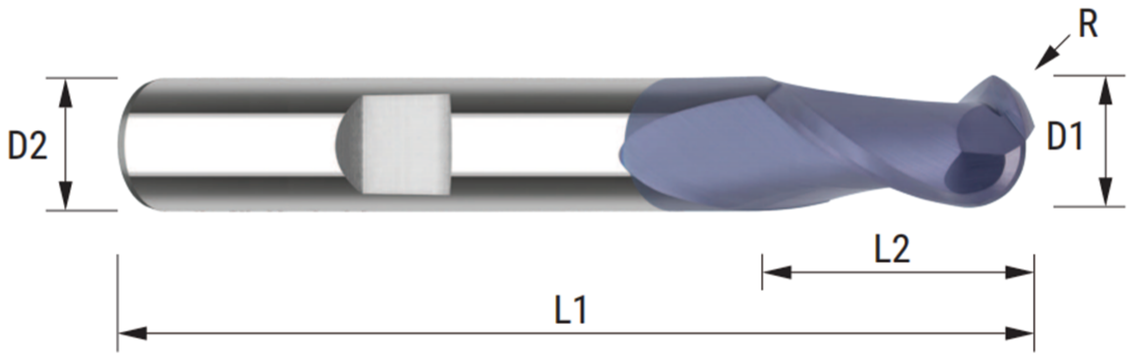
Carbon steel / alloy steel main materials: (A3, 45 steel, 20Cr, 40Cr, 20CrMo, 35CrMo, 42CrMo, 20CrMnTi, 35CrMoA, etc.)
Stainless steel / titanium alloy main materials: (201, 202, 301, 304, 316, 430, 630, TC4, TC6, etc.)

GP

Solid Carbide Ball Nose End Mill Z2

VHM-Vollradiusfräser

Fraise sphérique carbure



Werkzeugdaten / Description / Donees doutils

2 R 30° ALCRN HA HB

Order Number	D1	D2	L2	L1	R		
DGB2-030	3	3	7	38	1.5	HA	-
DGB2-040	4	4	14	50	2	HA	-
DGB2-050	5	5	16	50	2.5	HA	-
DGB2-060	6	6	19	57	3	HA	HB
DGB2-080	8	8	20	63	4	HA	HB
DGB2-100	10	10	21	72	5	HA	HB
DGB2-120	12	12	25	83	6	HA	HB
DGB2-160	16	16	32	92	8	HA	HB
DGB2-200	20	20	38	104	10	HA	HB

Order Number	D1	D2	L2	L1	R		
DGB2L-030	3	3	20	60	1.5	HA	-
DGB2L-040	4	4	25	60	2	HA	-
DGB2L-050	5	5	25	75	2.5	HA	-
DGB2L-060	6	6	30	75	3	HA	HB
DGB2L-080	8	8	45	100	4	HA	HB
DGB2L-100	10	10	45	100	5	HA	HB
DGB2L-120	12	12	45	100	6	HA	HB
DGB2L-160	16	16	45	100	8	HA	HB

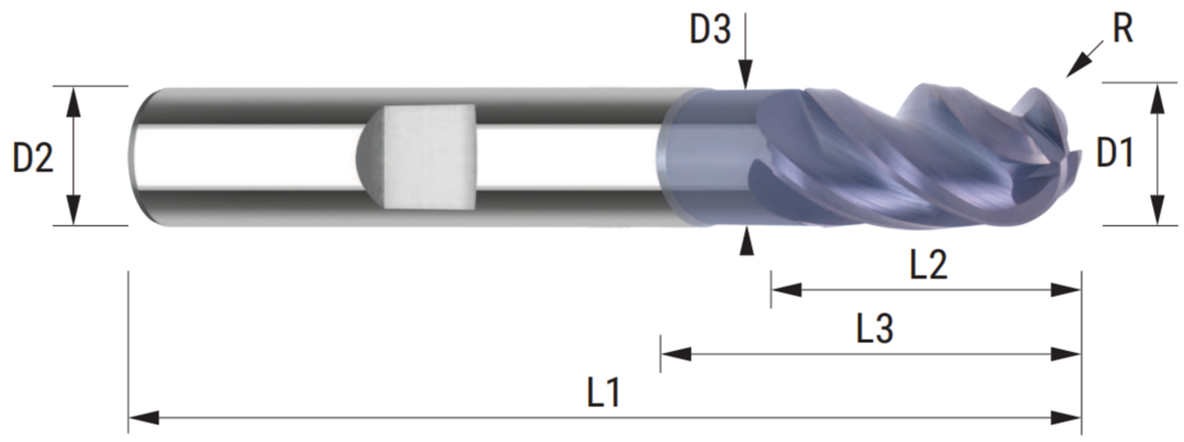
Order Number	D1	D2	L2	L1	R		
DGB2E-060	6	6	40	150	3	HA	HB
DGB2E-080	8	8	40	150	4	HA	HB
DGB2E-100	10	10	40	150	5	HA	HB
DGB2E-120	12	12	50	150	6	HA	HB
DGB2E-160	16	16	50	150	8	HA	HB
DGB2E-200	20	20	50	150	10	HA	HB
DGB2E-250	25	25	50	150	12.5	HA	HB

GP

Solid Carbide Ball Nose End Mill Z4

VHM-Vollradiusfräser

Fraise sphérique carbure



Werkzeugdaten / Description / Donees doutils

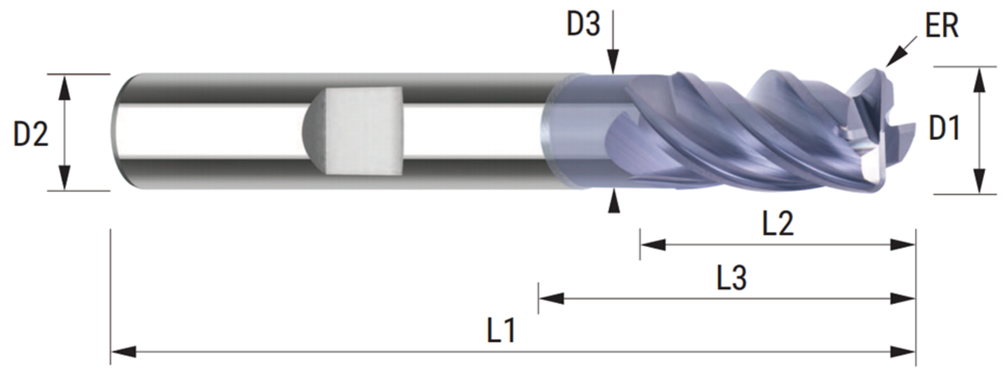
Order Number	D1	D2	L2	L1	D3	L3	R	
DGB4-030	3	6	8	57	2.8	18	1.5	HB
DGB4-040	4	6	10	57	3.7	21	2	HB
DGB4-050	5	6	13	57	4.7	21	2.5	HB
DGB4-060	6	6	13	57	5.5	21	3	HB
DGB4-080	8	8	16	63	7.5	27	4	HB
DGB4-100	10	10	22	72	9.5	32	5	HB
DGB4-120	12	12	26	83	11	38	6	HB
DGB4-140	14	14	26	83	13	38	7	HB
DGB4-160	16	16	32	92	15	44	8	HB
DGB4-200	20	20	38	104	19	54	10	HB

GP

Solid Carbide Corner Radius End Mill

VHM-Torusfräser

Fraise torique carbure



Werkzeugdaten / Description / Donees doutils

4 | ER | 35°/38° | ≠ | ALCRN | HA | HB

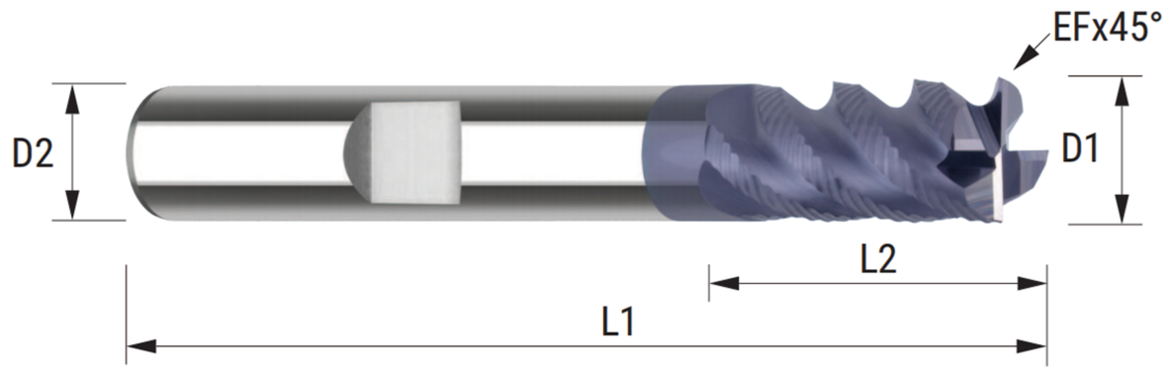
Order Number	D1	D2	L2	L1	D3	L3	ER		
DGCR-04005	4	6	11	57	3.7	21	0.5	HA	HB
DGCR-04010	4	6	11	57	3.7	21	1	HA	HB
DGCR-05005	5	6	13	57	4.7	21	0.5	HA	HB
DGCR-05010	5	6	13	57	4.7	21	1	HA	HB
DGCR-05015	5	6	13	57	4.7	21	1.5	HA	HB
DGCR-06005	6	6	13	57	5.5	21	0.5	HA	HB
DGCR-06010	6	6	13	57	5.5	21	1	HA	HB
DGCR-06015	6	6	13	57	5.5	21	1.5	HA	HB
DGCR-06020	6	6	13	57	5.5	21	2	HA	HB
DGCR-08005	8	8	19	63	7.5	27	0.5	HA	HB
DGCR-08010	8	8	19	63	7.5	27	1	HA	HB
DGCR-08015	8	8	19	63	7.5	27	1.5	HA	HB
DGCR-08020	8	8	19	63	7.5	27	2	HA	HB
DGCR-10005	10	10	22	72	9.5	32	0.5	HA	HB
DGCR-10010	10	10	22	72	9.5	32	1	HA	HB
DGCR-10015	10	10	22	72	9.5	32	1.5	HA	HB
DGCR-10020	10	10	22	72	9.5	32	2	HA	HB
DGCR-12005	12	12	26	83	11	38	0.5	HA	HB
DGCR-12010	12	12	26	83	11	38	1	HA	HB
DGCR-12015	12	12	26	83	11	38	1.5	HA	HB
DGCR-12020	12	12	26	83	11	38	2	HA	HB
DGCR-14010	14	14	26	83	13	38	1	HA	HB
DGCR-14020	14	14	26	83	13	38	2	HA	HB
DGCR-16010	16	16	32	92	15	44	1	HA	HB
DGCR-16015	16	16	32	92	15	44	1.5	HA	HB
DGCR-16020	16	16	32	92	15	44	2	HA	HB
DGCR-16025	16	16	32	92	15	44	2.5	HA	HB
DGCR-18015	18	18	32	92	17	44	1.5	HA	HB
DGCR-18025	18	18	32	92	17	44	2.5	HA	HB
DGCR-20010	20	20	38	104	19	54	1	HA	HB
DGCR-20015	20	20	38	104	19	54	1.5	HA	HB
DGCR-20020	20	20	38	104	19	54	2	HA	HB
DGCR-20025	20	20	38	104	19	54	2.5	HA	HB
DGCR-20030	20	20	38	104	19	54	3	HA	HB
DGCR-20040	20	20	38	104	19	54	4	HA	HB
DGCR-20050	20	20	38	104	19	54	5	HA	HB

GP

Solid Carbide Roughing End Mill

VHM-Schruppfräser Typ HR

Fraise d'ébauche carbure



Werkzeugdaten / Description / Donees doutils

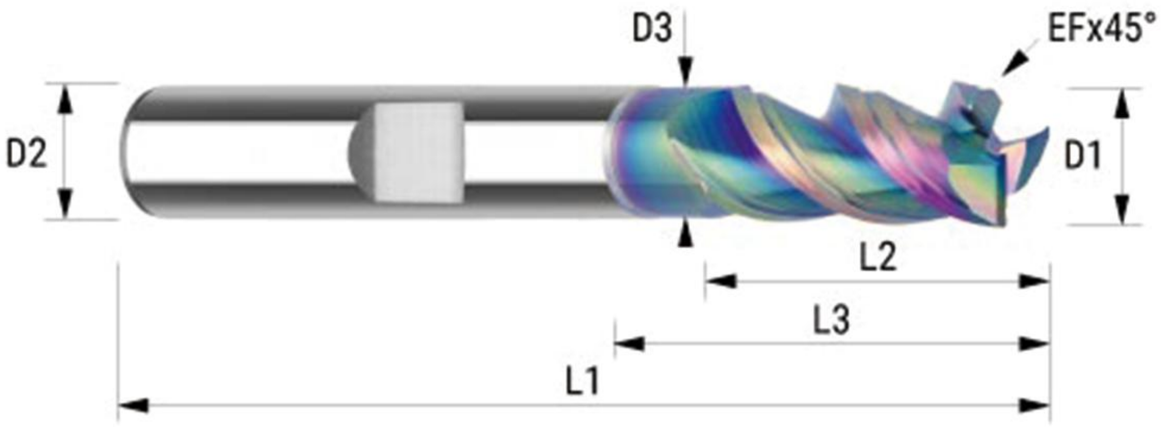
Order Number	D1	D2	L2	L1	EF	Z		
DGRF-040	4	4	11	57	0.15	3	HA	-
DGRF-050	5	5	13	57	0.15	4	HA	-
DGRF-060	6	6	16	57	0.15	4	HA	HB
DGRF-080	8	8	16	63	0.15	4	HA	HB
DGRF-100	10	10	22	72	0.2	4	HA	HB
DGRF-120	12	12	28	83	0.2	4	HA	HB
DGRF-160	16	16	32	92	0.25	5	HA	HB
DGRF-200	20	20	38	104	0.25	6	HA	HB

GP

Square End Mill For Aluminium Z3

VHM-Schaftfräser ALU-Cutter

Fraise carbure ALU-Cutter



Werkzeugdaten / Description / Donees doutils

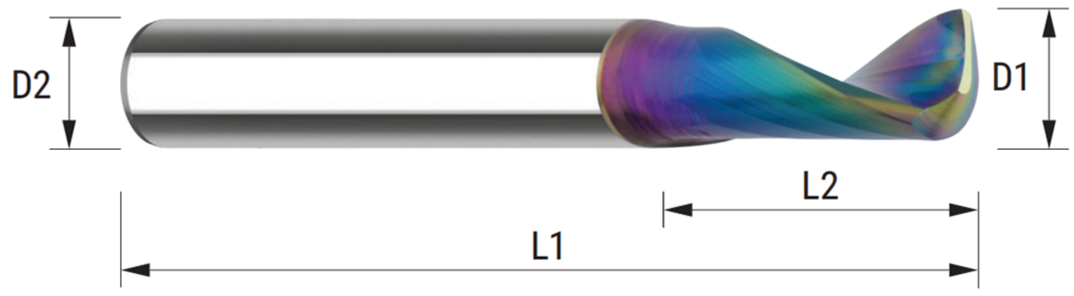
Order Number	D1	D2	L2	L1	D3	L3		
DGA3-030	3	6	12	38	-	-	HA	HB
DGA3-040	4	6	15	54	3.8	18	HA	HB
DGA3-050	5	6	15	54	4.8	18	HA	HB
DGA3-060	6	6	16	57	5.8	21	HA	HB
DGA3-080	8	8	22	64	7.8	28	HA	HB
DGA3-100	10	10	25	73	9.7	33	HA	HB
DGA3-120	12	12	28	84	11.7	39	HA	HB
DGA3-160	16	16	35	93	15.7	45	HA	HB
DGA3-200	20	20	40	104	19.7	54	HA	HB
DGA3-250	25	25	45	121	24	65	HA	HB

GP

Square End Mill For Aluminium Z1

VHM-Einzahnfräser

Fraise une dent carbure



Werkzeugdaten / Description / Donees doutils

Order Number	D1	D2	L2	L1	HA	HB
DGA1-01003	1	3.175	3	38	HA	-
DGA1-01505	1.5	3.175	5	38	HA	-
DGA1-02004	2	3.175	4	38	HA	-
DGA1-02006	2	3.175	6	38	HA	-
DGA1-02008	2	3.175	8	38	HA	-
DGA1-02504	2.5	3.175	4	38	HA	-
DGA1-02506	2.5	3.175	6	38	HA	-
DGA1-02508	2.5	3.175	8	38	HA	-
DGA1-03106	3.175	3.175	6	38	HA	-
DGA1-03107	3.175	3.175	7	38	HA	-
DGA1-03112	3.175	3.175	12	38	HA	-
DGA1-03117	3.175	3.175	17	38	HA	-
DGA1-03009	3	3	9	38	HA	-
DGA1-04008	4	4	8	45	HA	-
DGA1-04010	4	4	10	45	HA	-
DGA1-04012	4	4	12	45	HA	-
DGA1-04015	4	4	15	45	HA	-
DGA1-04017	4	4	17	45	HA	-
DGA1-04022	4	4	22	45	HA	-
DGA1-05017	5	5	17	50	HA	-
DGA1-06012	6	6	12	50	HA	HB
DGA1-06015	6	6	15	50	HA	HB
DGA1-06017	6	6	17	50	HA	HB
DGA1-06022	6	6	22	50	HA	HB
DGA1-08022	8	8	22	60	HA	HB
DGA1-08025	8	8	25	60	HA	HB
DGA1-10025	10	10	25	60	HA	HB
DGA1-10032	10	10	32	75	HA	HB
DGA1-10042	10	10	42	85	HA	HB
DGA1-12035	12	12	35	75	HA	HB
DGA1-12042	12	12	42	80	HA	HB

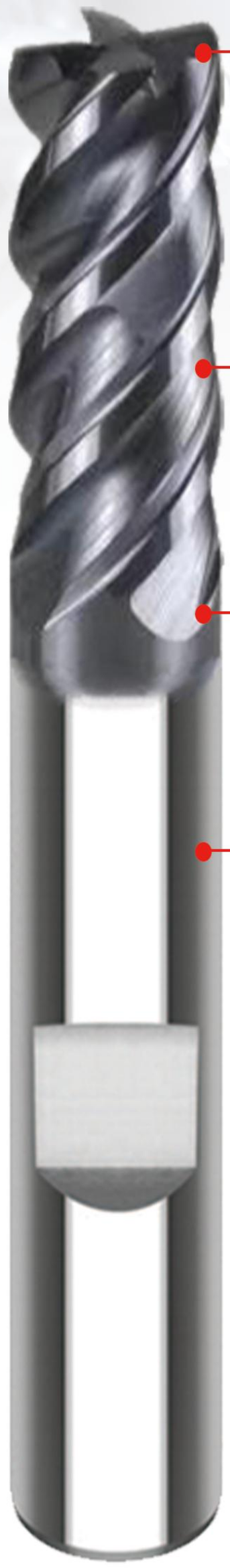
High-Performance Double Core End Mill

HNCARBIDE

Suitable for high efficiency machining of Stainless steel, Titanium alloys, High temperature alloys.

Advantages

- The use of ultra-fine-grained tungsten steel ensures stable tool life.
- Large capacity moulding groove design for efficient chip removal during high efficiency machining.
- Special treatment on the edge of the blade to enhance the chipping resistance.



High-performance arc angle shape including chamfer

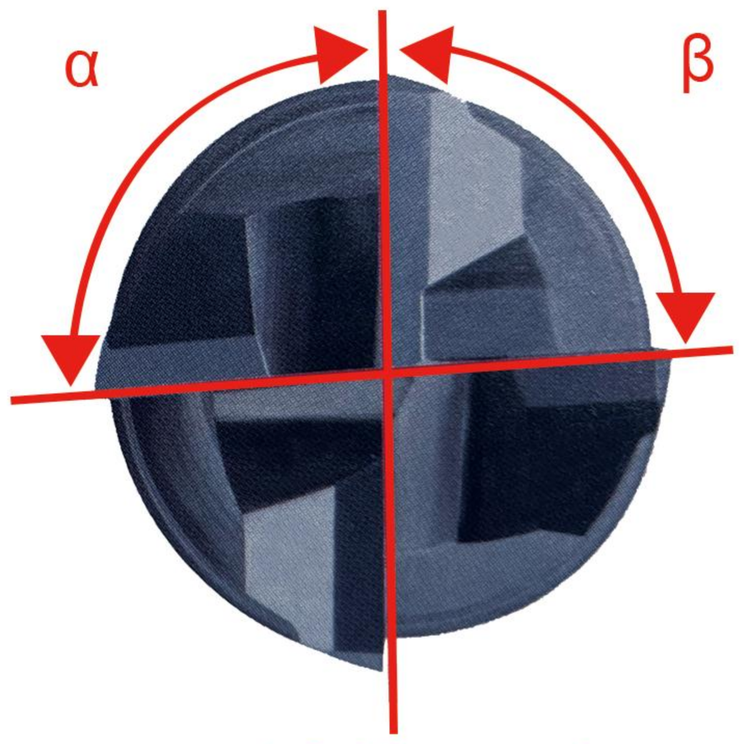
Variable helix angle design

High-quality composite coating

High quality cemented carbide bar

Application

- Stainless Steel
- Titanium Alloy
- Nickel-based alloy
- High Temperature Alloy

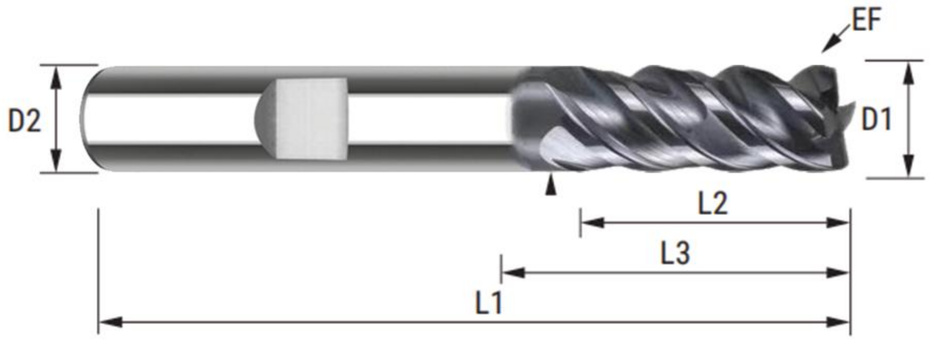


α ≠ β Unequal

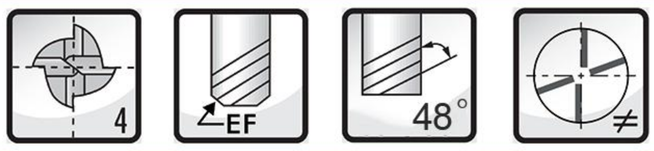
High-Performance Double Core End Mill

Doppelkern-Schaftfräser

Fraise à double noyau



Werkzeugdaten / Description / Donees doutils



Order Number	D1	D2	L2	L1	L3	EF		
DHPC-030	3	6	8	57	18	0.13	HA	HB
DHPC-040	4	6	11	57	21	0.13	HA	HB
DHPC-050	5	6	13	57	21	0.2	HA	HB
DHPC-060	6	6	13	57	21	0.2	HA	HB
DHPC-080	8	8	19	63	27	0.2	HA	HB
DHPC-100	10	10	22	72	32	0.2	HA	HB
DHPC-120	12	12	26	83	38	0.3	HA	HB
DHPC-160	16	16	40	92	50	0.3	HA	HB
DHPC-200	20	20	50	104	60	0.4	HA	HB
DHPC-080L	8	8	19	80	42	0.2	HA	HB
DHPC-100L	10	10	22	95	52	0.2	HA	HB
DHPC-120L	12	12	26	110	62	0.3	HA	HB

Order Number	D1	D2	L2	L1	L3	R		
DHPR-0305	3	6	8	18	57	0.5	HA	HB
DHPR-0405	4	6	11	21	57	0.5	HA	HB
DHPR-0505	5	6	13	21	57	0.5	HA	HB
DHPR-0605	6	6	13	21	57	0.5	HA	HB
DHPR-0805	8	8	19	27	63	0.5	HA	HB
DHPR-1005	10	10	22	32	72	0.5	HA	HB
DHPR-1205	12	12	26	38	83	0.5	HA	HB
DHPR-1605	16	16	40	50	92	0.5	HA	HB
DHPR-2005	20	20	50	60	104	0.5	HA	HB
DHPR-0310	3	6	8	18	57	1	HA	HB
DHPR-0410	4	6	11	21	57	1	HA	HB
DHPR-0510	5	6	13	21	57	1	HA	HB
DHPR-0610	6	6	13	21	57	1	HA	HB
DHPR-0810	8	8	19	27	63	1	HA	HB
DHPR-1010	10	10	22	32	72	1	HA	HB
DHPR-1210	12	12	26	38	83	1	HA	HB
DHPR-1610	16	16	40	50	92	1	HA	HB
DHPR-2010	20	20	50	60	104	1	HA	HB

2-flute End Mill

	Carbon Stoeks Aloy Stoeks (≤ HRC35)				Pre-Hardoned Stooks (HRC35-45)				Hardoned Stoeks (HRC46-55)			
D(mm)	Rotation Speed (min^{-1})	Feed mm/min	Ap mm	Ae mm	Rotation Speed (min^{-1})	Feed mm/min	Ap mm	Ae mm	Rotation Speed (min^{-1})	Feed mm/min	Ap mm	Ae mm
0.4	**33000**	300	0.03	0.28	30000	300	0.03	0.28	28000	250	0.03	0.28
0.5	30000	360	0.03	0.3	13000	300	0.04	0.3	25000	300	0.03	0.3
0.6	26000	400	0.04	0.42	27000	400	0.04	0.42	22000	350	0.04	0.42
0.8	24000	480	0.04	0.56	24000	440	0.1	0.56	20000	400	0.04	0.56
1	21000	600	0.05	0.7	22000	550	0.1	0.7	18000	500	0.05	0.7
1.5	18000	700	0.05	1.05	20000	660	0.1	1.05	15000	600	0.05	1.05
2	15000	900	0.1	1.5	16000	800	0.03	1.5	12500	750	0.05	1.5
2.5	12000	1200	0.1	1.75	11000	1100	0.05	1.75	10000	1000	0.05	1.75
3	9600	1200	0.1	2.1	8800	1100	0.05	2.1	8000	1000	0.05	2.1
4	7800	2400	0.1	2.8	7100	2200	0.1	2.8	6500	2000	0.05	2.8
5	7200	1200	0.1	3.5	6600	1100	0.1	3.5	6000	1000	0.1	3.5
6	6000	700	0.1	4.2	5000	660	0.1	4.2	5000	600	0.1	4.2
8	5400	700	0.2	5.6	4400	660	0.2	5.6	4500	600	0.1	5.6
10	4800	600	0.2	7	3300	550	0.2	7	4000	500	0.1	7
12	4200	600	0.2	8.4	5500	550	0.2	8.4	3500	500	0.1	8.4
14	3600	600	0.2	9.6	3800	550	0.2	9.6	3000	500	0.1	9.6
16	3300	600	0.2	11.2	3000	550	0.2	11.2	2800	500	0.1	11.2
20	3000	600	0.2	14	2700	550	0.2	14	2500	500	0.1	14

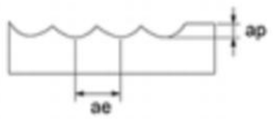
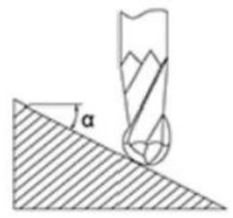
2-flute Ball End Mill

	Carbon Stoeks Aloy Stoeks (≤ HRC35)				Pre-Hardoned Stooks (HRC35-45)				Hardoned Stoeks (HRC46-55)			
D(mm)	Rotation Speed (min-1)	Feed mm/min	Ap mm	Ae mm	Rotation Speed (min-1)	Feed mm/min	Ap mm	Ae mm	Rotation Speed (min-1)	Feed mm/min	Ap mm	Ae mm
R0.2	28000	600	0.03	0.03	28000	600	0.03	0.03	25200	540	0.03	0.03
R0.25	25000	720	0.03	0.0	25000	720	0.03	0.0	22500	648	0.03	0.0
R0.3	22000	800	0.03	0.03	22000	800	0.03	0.03	19800	720	0.03	0.03
R0.4	20000	1000	0.03	0.03	20000	1000	0.0	0.03	18000	900	0.03	0.03
R0.5	18000	1200	0.03	0.1	18000	1200	0.0	0.1	16200	1080	0.03	0.1
R0.75	16000	1500	0.03	0.05	16000	1500	0.0	0.05	14400	1350	0.03	0.05
R1	14800	1560	0.0	0.1	14800	1560	0.04	0.1	13320	1404	0.04	0.1
R1.25	14400	1680	0.0	0.06	14400	1680	0.04	0.06	12960	1512	0.04	0.06
R1.5	13000	2000	0.1	0.1	13000	2000	0.05	0.1	11700	1800	0.05	0.1
R2	12000	2400	0.1	0.1	12000	2400	0.1	0.1	10800	2160	0.05	0.1
R2.5	10000	2500	0.1	0.1	10000	2500	0.1	0.1	9000	2250	0.1	0.1
R3	9000	2800	0.1	0.2	9000	2800	0.1	0.2	8100	2520	0.1	0.2
R4	8000	3000	0.1	0.2	8000	3000	0.1	0.2	7200	2700	0.1	0.2
R5	7200	3000	0.1	0	7200	3000	0.1	0	6480	2700	0.1	0
R6	6400	3200	0.1	0.3	6400	3200	0.1	0.3	5760	2880	0.1	0.3
R8	6000	3600	0.1	0.3	6000	3600	0.1	0.3	5400	3240	0.1	0.3

4-flute End Mill

	Carbon Stoeks Aloy Stoeks (≤ HRC35)				Pre-Hardoned Stooks (HRC35-45)				Hardoned Stoeks (HRC46-55)			
D(mm)	Rotation Speed (min-1)	Feed mm/min	Ap mm	Ae mm	Rotation Speed (min-1)	Feed mm/min	Ap mm	Ae mm	Rotation Speed (min-1)	Feed mm/min	Ap mm	Ae mm
1	21000	336	2.00	0.10	22000	320	2.00	0.05	18000	250	1.50	0.05
1.5	18000	378	3.00	0.1	20000	360	3.00	0.1	15000	300	2.25	0.1
2	15000	420	4.00	0.15	16000	400	4.00	0.10	12500	350	3.00	0.05
2.5	12000	462	5.00	0.15	11000	440	5.0	0.10	10000	400	4.00	5.00
3	9600	504	6.00	0.2	8800	480	6.0	0.1	8000	450	4.50	0.1
4	7800	630	8.00	0.20	7100	600	8.0	0.10	6500	550	6.00	0.05
5	7200	735	10.0	0.2	6600	700	10.00	0.1	6000	580	7.50	0.1
6	6000	1050	12.0	0.20	5000	1000	12.00	0.10	5000	600	8.00	0.10
8	5400	1575	16.0	3.0	4400	1500	16.00	0.2	4500	600	12.00	0.1
10	4800	2100	20.0	0.3	3300	2000	20.0	0.2	4000	550	15.00	0.1
12	4200	2625	24.0	0.3	5500	2500	24.0	0.2	3500	500	18.0	0.1
14	3600	2100	28.0	0.3	3800	2000	28.0	0.2	3000	500	21.0	0.1
16	3300	2100	32.0	0.3	3000	2000	32.0	0.2	2800	450	24.0	0.1
20	3000	2100	40.0	0	2700	2000	40.0	0	2500	400	30.0	0

4-flute Ball End Mill

	Carbon Stoeks Aloy Stoeks (≤ HRC35)				Pre-Hardoned Stooks (HRC35-45)				Hardoned Stoeks (HRC46-55)			
D(mm)	Rotation Speed (min-1)	Feed mm/min	Ap mm	Ae mm	Rotation Speed (min-1)	Feed mm/min	Ap mm	Ae mm	Rotation Speed (min-1)	Feed mm/min	Ap mm	Ae mm
R1.5	29000	6560	0.03	0.10	22800	4560	0.03	0.10	21100	4240	0.03	0.10
R2.0	22000	6250	0.04	0.2	17100	4000	0.04	0.2	15800	3520	0.04	0.2
R2.5	17400	5600	0.05	0.15	13600	3520	0.05	0.15	12700	3200	0.05	0.15
R3.0	14500	5000	0.06	0.20	11400	3000	0.1	0.20	10600	2500	0.06	0.20
R4.0	10900	4200	0.08	0.3	8550	2500	0.1	0.3	7950	2250	0.08	0.3
R5.0	8700	3500	0.10	0.30	6850	2200	0.1	0.30	6350	2000	0.10	0.30
R6.0	7250	3000	0.1	0.4	5700	2000	0.10	0.4	5300	1900	0.10	0.4
R8.0	5450	3000	0.1	0.40	4280	2000	0.10	0.40	4000	1900	0.10	0.40
R10.0	4350	3000	0.1	0.5	3425	2000	0.10	0.5	3200	1900	0.10	0.5
Maximum depth of cut	 											

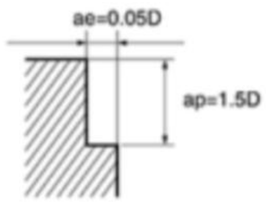
4-flute Corner Radius End Mill -Side Milling

	Carbon Stoeks Aloy Stoeks (≤ HRC35)				Pre-Hardoned Stooks (HRC35-45)				Hardoned Stoeks (HRC46-55)			
D(mm)	Rotation Speed (min-1)	Feed mm/min	Ap mm	Ae mm	Rotation Speed (min-1)	Feed mm/min	Ap mm	Ae mm	Rotation Speed (min-1)	Feed mm/min	Ap mm	Ae mm
1	13270	720	0.05	0.03	12064	672	0.05	0.03	9280	480	0.05	0.03
1.5	10868	960	0.05	0.0	9880	896	0.05	0.0	7600	640	0.05	0.0
2	10296	1800	0.10	0.05	9360	1680	0.10	0.05	7200	1200	0.10	0.05
3	9724	2400	0.10	0.05	8840	2240	0.1	0.05	6800	1600	0.10	0.05
4	9152	2400	0.20	0.1	8320	2240	0.2	0.1	6400	1600	0.20	0.1
6	6864	2700	0.20	0.08	6240	2520	0.2	0.08	4800	1800	0.20	0.08
8	5720	3600	0.2	0.1	5200	3360	0.20	0.1	4000	2400	0.20	0.1
10	5148	3600	0.2	0.10	4680	3360	0.20	0.10	3600	2400	0.20	0.10
12	4576	3600	0.2	0.1	4160	3360	0.20	0.1	3200	2400	0.20	0.1
16	4000	3000	0.20	0.1	3600	3000	0.2	0.1	2700	2000	0.20	0.1

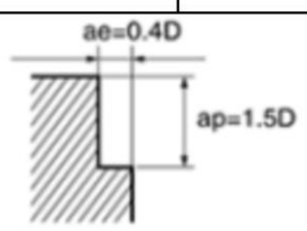
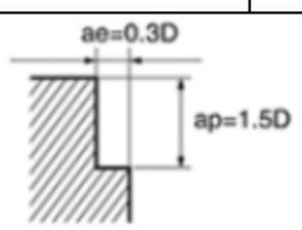
4-flute Corner Radius End Mill -Bottom milling

	Carbon Stoeks Aloy Stoeks (≤ HRC35)				Pre-Hardoned Stooks (HRC35-45)				Hardoned Stoeks (HRC46-55)			
D(mm)	Rotation Speed (min-1)	Feed mm/min	Ap mm	Ae mm	Rotation Speed (min-1)	Feed mm/min	Ap mm	Ae mm	Rotation Speed (min-1)	Feed mm/min	Ap mm	Ae mm
6	6050	484	0.10	3.50	5500	440	0.08	3.50	5000	400	0.05	3.50
8	5445	726	0.10	4.5	4950	660	0.08	4.5	4500	600	0.05	4.5
10	5082	968	0.10	6.00	4620	880	0.08	6.00	4200	800	0.06	6.00
12	4235	968	0.10	8.00	3850	880	0.1	8.00	3500	800	0.06	8.00

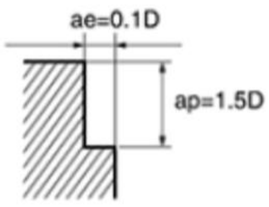
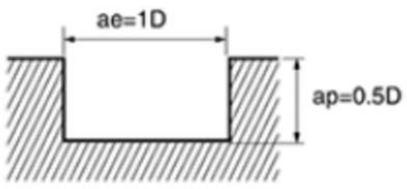
6-flute End Mill-Side milling

	CarbonSteel		Hardened steel (45-65HRC)		Stainless steel Titanlum aloy		Hardoned Stoeks (HRC46-55)	
D(mm)	Rotation Speed (min-1)	Feed mm/min	Rotation Speed (min-1)	Feed mm/min	Rotation Speed (min-1)	Feed mm/min	Rotation Speed (min-1)	Feed mm/min
6	8000	1000	6000	800	8000	1000	4000	500
8	6000	1000	5000	800	6000	1000	3000	500
10	5000	1000	4000	800	5000	1000	2500	500
12	4000	1000	3500	800	4000	1000	2000	500
16	3000	800	2500	700	3000	800	1500	300
20	2500	800	2200	700	2500	800	1200	300
Maximum depth of cut								

4-flute Wave edge milling cutter——Face Cutting

	Cast iron ductle iron		Carbon stool,aloy stoel (~750N/mm²)		Carbon stoel,alloy stool (~30HRC)		Pre-hardened stoed bempend sed (~40HRC)		Stainless steel	
D(mm)	Rotation Speed (min-1)	Feed mm/min	Rotation Speed (min-1)	Feed mm/min	Rotation Speed (min-1)	Feed mm/min	Rotation Speed (min-1)	Feed mm/min	Rotation Speed (min-1)	Feed mm/min
6	6350	760	5300	640	4500	360	3450	280	2650	210
7	5460	760	4550	640	3650	360	3000	280	2250	310
8	4750	760	4000	640	3400	410	2650	310	2000	240
9	4250	760	3540	640	2850	410	2300	310	1750	240
10	3800	760	3200	640	2700	430	2050	330	1600	260
11	3470	760	2900	640	2400	430	1850	330	1450	260
12	3200	770	2250	650	1950	470	1500	360	1150	280
16	2400	770	2000	640	1700	480	1300	360	1000	280
20	1900	760	1600	610	1350	470	1050	350	800	260
Maximum depth of cut										

2/3-flute Aluminum End Mill

	Aluminium Aloy		Slicon aluminum alloy Si≤10%	
D(mm)	Rotation Speed (min-1)	Feed mm/min	Rotation Speed (min-1)	Feed mm/min
1	40000	800	40000	600
2	40000	1200	32000	900
3	26500	1800	21000	1300
4	20000	2000	16000	1500
5	16000	1750	13000	1300
6	13000	1500	10600	1200
8	10000	1650	8000	1300
10	8000	1900	6500	1500
12	6600	1950	5300	1550
14	5700	2000	4600	1600
16	5000	2000	4000	1600
18	4400	2000	3500	1600
20	4000	2000	3200	1600
Maximum depth of cut				

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