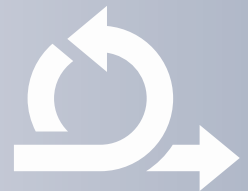


DOUBLE-CHAMFER

HBmicrotec[®]
ACTIONTOOLS & ENGINEERING



ACTIONMILL[®]
by HB microtec
Double-Chamfer



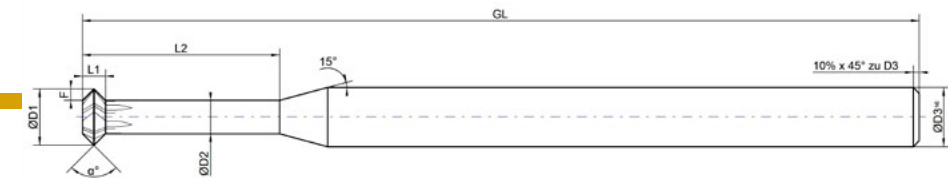
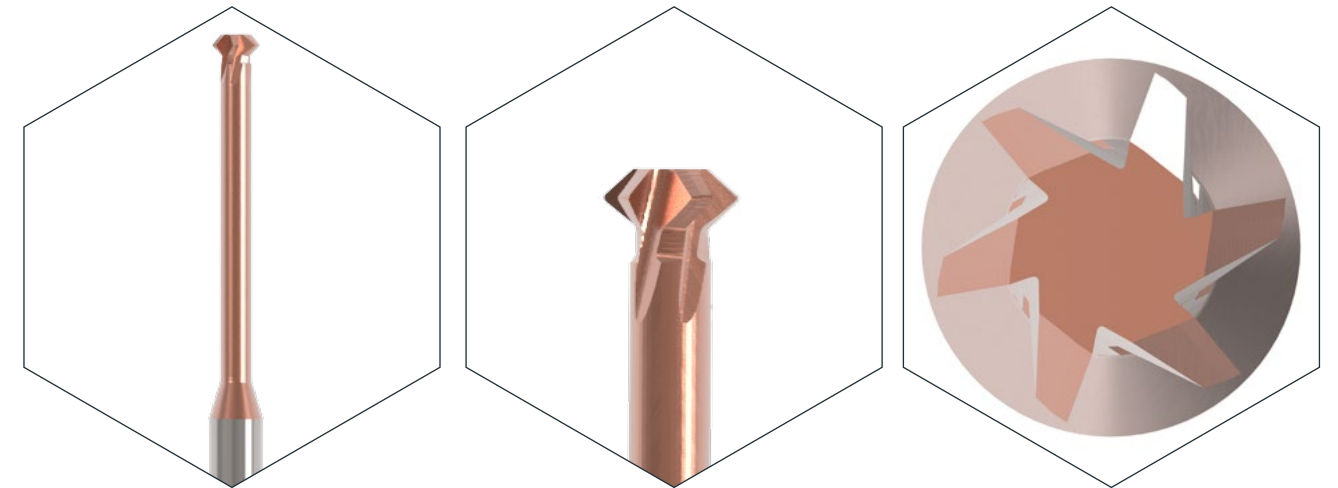
5 to 6 teeth enable very high feed rates

The α -INOXthin coating guarantees long tool life and prevents the cutting edges from sticking

90° Double-Chamfer from $\varnothing$ 0.90 mm to $\varnothing$ 5.70 mm

Fine-grain solid carbide (high cutting and feed rates are possible)

Shaft according to DIN 6535 HA h6 shank $\varnothing$ tolerance



☐ Inquiry

☐ Order

Order number: _____

Other: _____

Dimensions:

D₁: _____ GL: _____ α : _____
D₂: _____ L₁: _____ Z: _____
D₃: _____ L₂: _____

Coating:

☐ Coated*: _____
☐ Uncoated

Cooling channels:

☐ Yes ☐ No

Cutting direction:

☐ Left ☐ Right

Material to be machined:

Shank shape:

Quantity:

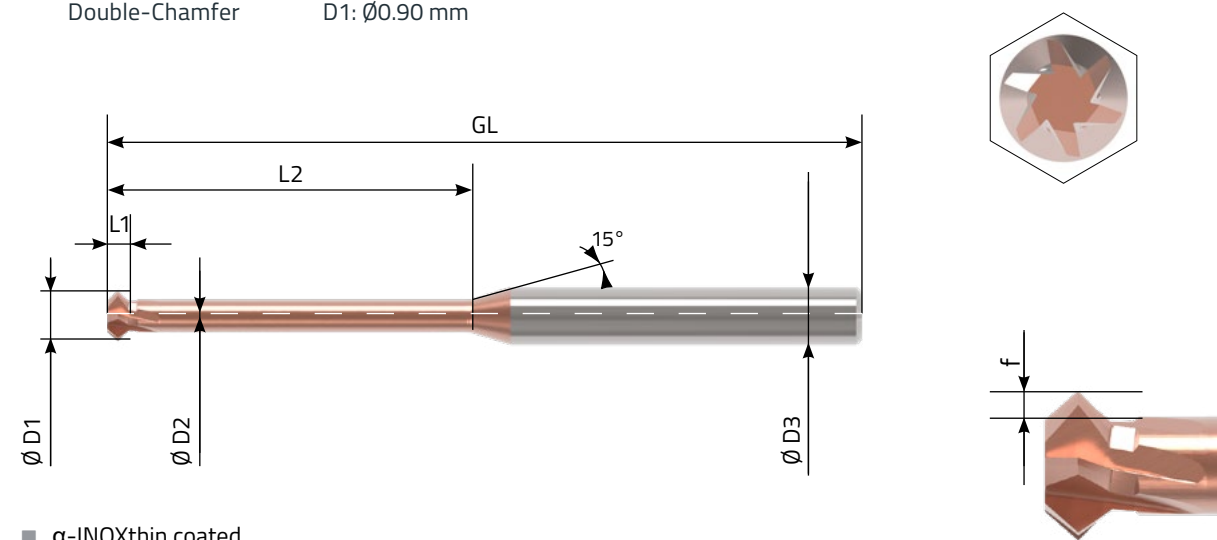
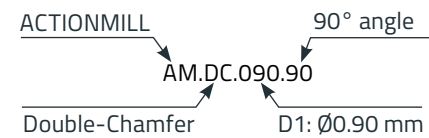
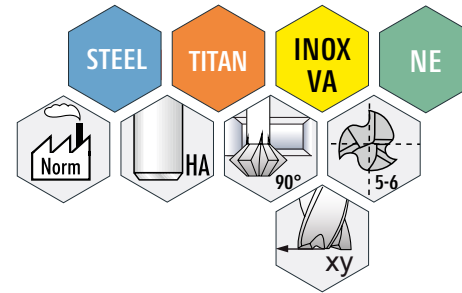
Date, signature & company stamp:

Contact person:

* Without further information, the most suitable coating will be used.



Double-Chamfer



■ α -INOXthin coated



Online shop

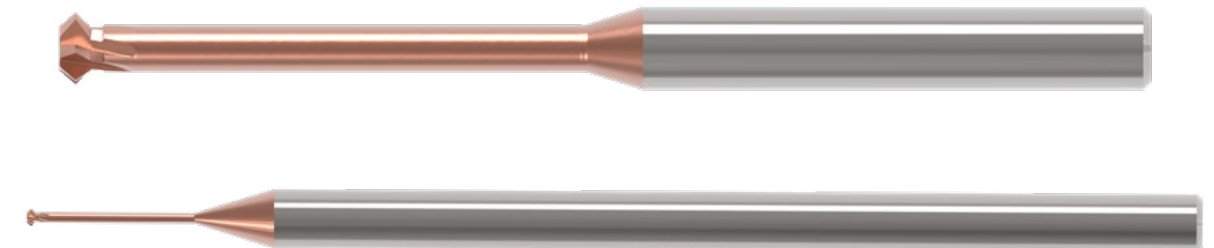


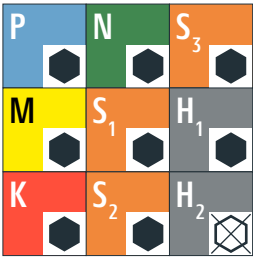
5 PRO's of the ACTIONMILL:

- Forward & backward deburring for holes from Ø 0.9 mm
- Extremely versatile and flexible
- Universally applicable with 90° chamfer angle
- 5 to 6 teeth (cutting edges) enable high feed rates
- High process reliability without secondary burrs

Article number	D1 (mm)	D2 (mm)	D3 h6 (mm)	L1 (mm)	L2 (mm)	GL (mm)	f	Flutes
AM.DC.090.90	Ø 0.90	Ø 0.54	Ø 3.00	0.36	8.00	60.00	0.18	5
AM.DC.140.90	Ø 1.40	Ø 0.84	Ø 3.00	0.56	10.00	60.00	0.28	5
AM.DC.180.90	Ø 1.80	Ø 1.08	Ø 4.00	0.72	12.00	60.00	0.36	5
AM.DC.220.90	Ø 2.20	Ø 1.48	Ø 4.00	0.72	14.00	60.00	0.36	5
AM.DC.280.90	Ø 2.80	Ø 1.68	Ø 4.00	1.12	18.00	60.00	0.56	5
AM.DC.370.90	Ø 3.70	Ø 2.22	Ø 4.00	1.48	24.00	70.00	0.74	5
AM.DC.470.90	Ø 4.70	Ø 2.82	Ø 6.00	1.88	30.00	80.00	0.94	5
AM.DC.570.90	Ø 5.70	Ø 3.42	Ø 6.00	2.28	36.00	80.00	1.14	6

Available from stock





Material group	Material group	Mat. no.	DIN	AISI/ASTM/UNS
P	Steels up to RM < 1200N/mm ²	1.0044	S275JR	AISI 1020
		1.0715	11SMn30	AISI 1215
		1.7131	16MnCr5	AISI 5115
		1.3505	100Cr6	AISI 52100
		1.7225	42CrMo4	AISI 4140
M	Stainless steels: ferritic, martensitic, austenitic	1.4034	X46Cr13	AISI 420C
		1.4542	X5CrNiCuNb 16-4	AISI 630 / ASTM 17-4 PH
		1.4545	X5CrNiCuNb 15-5	ASTM 15-5 PH
		1.4301	X5CrNi 18-10	AISI 304
		1.4435	X2CrNiMo 18-14-3	AISI 316L
K	Cast iron	0.6020	GG20	ASTM 30
		0.6030	GG30	ASTM 40B
		0.7040	GGG40	ASTM 60-40-18
		0.7060	GGG60	ASTM 80-60-03
N	Non-ferrous metals	3.2315	AlMgSi1	ASTM 6351
		2.0065	Cu-ETP / CW004A	UNS C11000
		2.0321	CuZn37 CW508L	UNS C27400
		2.0401	CuZn39Pb3 / CW614N	UNS C38500
		2.0966	CuAl10Ni5Fe4	UNS C63000
S (S1, S2, S3)	Heat-resistant steels, titanium, CrCo	2.4617	NiMo28	Hastelloy B-2
		2.4665	NiCr22Fe18Mo	Hastelloy X
		3.7165	TiAl6V4	ASTM B348 / F136
		9.9367	TiAl6Nb7	ASTM F1295
		2.4964	CoCr20W15Ni	Haynes 25
H	Hardened steels ≥ 55 HRC		CrCoMo28	ASTM F1537
		1.2510	100MnCrMoW4	AISI O1
		1.2379	X153CrMoV12	AISI D2

Recommended use Highly suitable Partially suitable Not recommended

from Ø 0.9 mm		from Ø 3.0 mm		from Ø 4.0 mm - Ø 5.7 mm	
vc [m/min]	fz [mm]	vc [m/min]	fz [mm]	vc [m/min]	fz [mm]
100-140	0.02 - 0.035	100-140	0.02 - 0.045	100-140	0.05 - 0.065
100-140	0.02 - 0.03	100-140	0.02 - 0.04	100-140	0.05 - 0.055
80-110	0.01 - 0.03	80-110	0.015 - 0.045	80-110	0.045 - 0.055
70-100	0.01 - 0.025	70-100	0.015 - 0.045	70-100	0.045 - 0.055
80-140	0.01 - 0.04	80-140	0.02 - 0.055	80-140	0.05 - 0.065
80-160	0.02 - 0.04	80-160	0.035 - 0.06	80-160	0.055 - 0.06
80-140	0.02 - 0.045	80-140	0.035 - 0.06	80-140	0.055 - 0.06
80-120	0.02 - 0.045	80-120	0.035 - 0.06	80-120	0.055 - 0.06
50 - 80	0.008 - 0.015	50 - 80	0.015 - 0.04	50 - 80	0.03 - 0.05
50-80	0.008 - 0.015	50-80	0.015 - 0.04	50-80	0.03 - 0.05
50-80	0.008 - 0.015	50-80	0.015 - 0.04	50-80	0.03 - 0.05
no data available					
no data available					

ACTIONMILL®
by HB microtec *Double-Chamfer*



HB microtec®
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