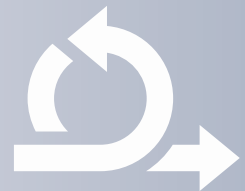


DOUBLE-CHAMFER

HBmicrotec[®]
ACTIONTOOLS & ENGINEERING



TARGETMILL[®]
by HB microtec Double-Chamfer



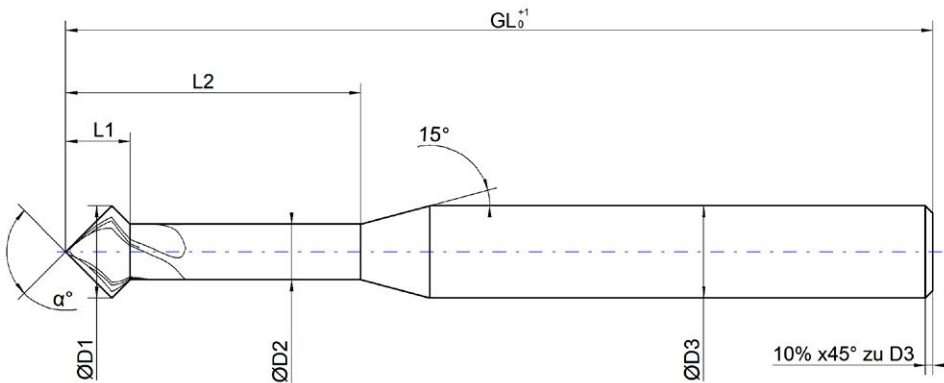
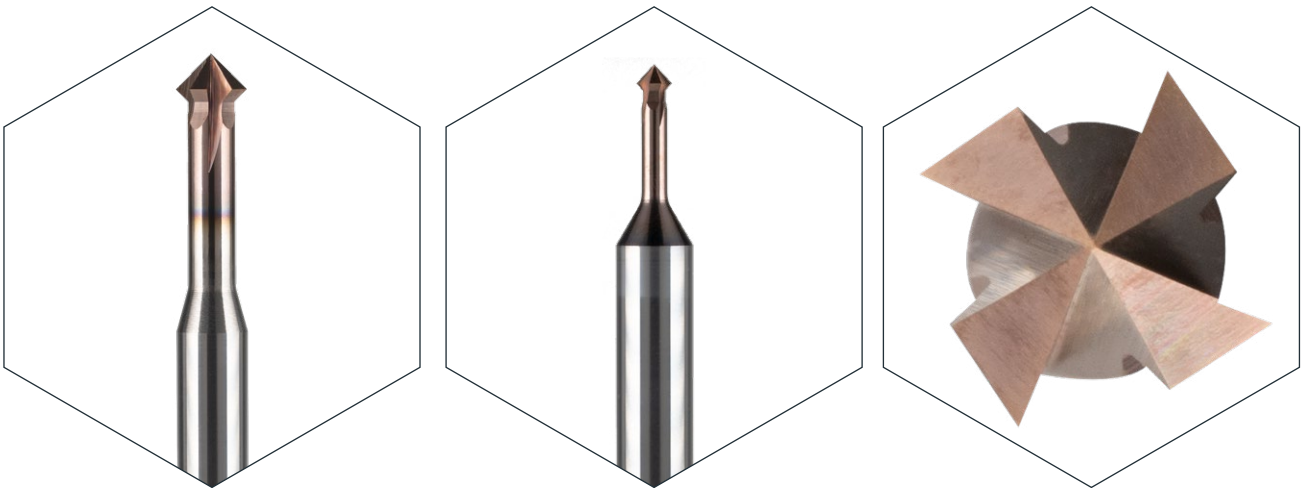
3 to 4 flutes enable very high feed rates

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

90° Double-Chamfer from $\varnothing$ 2.0 mm to $\varnothing$ 6.0 mm

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

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



☐ Inquiry

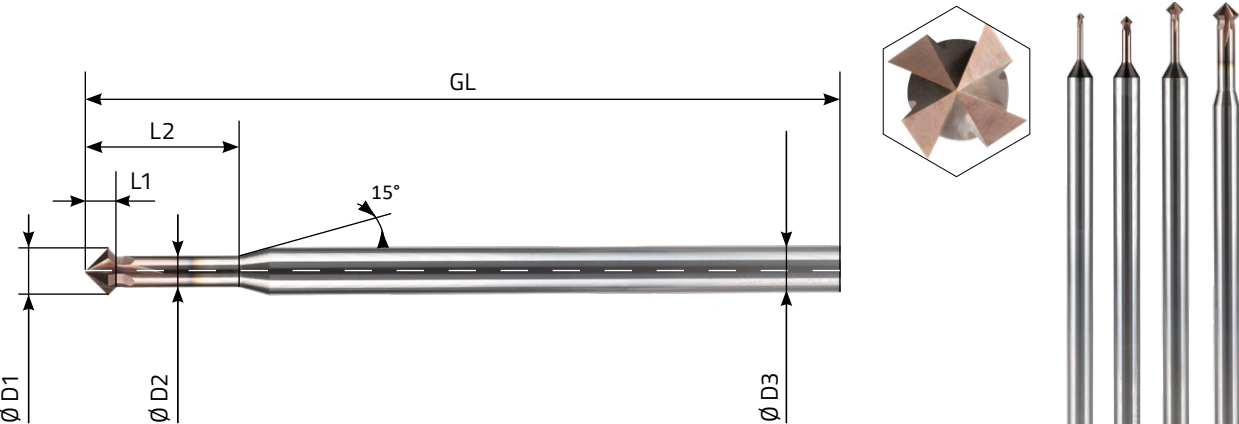
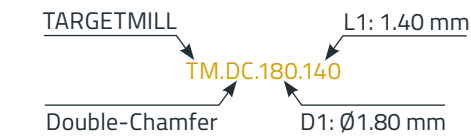
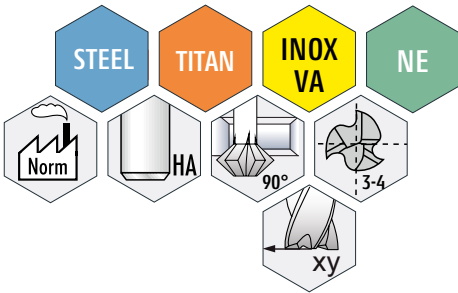
☐ Order

Order number: _____ Other: _____

Dimensions: D ₁ : _____ GL: _____ α : _____ D ₂ : _____ L ₁ : _____ Z: _____ D ₃ : _____ L ₂ : _____	Coating: ☐ Coated*: _____ ☐ Uncoated	With 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



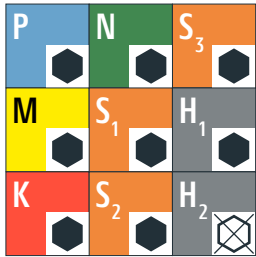
5 PRO's of the TARGETMILL:

- Forward & backward deburrer from Ø 1.8 mm to Ø 6 mm (D1)
- High flexibility in the variety of applications
- No secondary burrs form
- Universally usable in a wide variety of materials
- 3 to 4 flutes ensure excellent surface quality

Article number	Coating	Flutes	D1 (mm)	D2 h6 (mm)	D3 (mm)	L1 (mm)	L2 (mm)	GL (mm)
TM.DC.180.140	α-INOX	3	Ø 1.80	Ø 1.00	Ø 6.00	1.30	10.00	100.00
TM.DC.200.140	α-INOX	3	Ø 2.00	Ø 1.20	Ø 6.00	1.40	10.00	100.00
TM.DC.280.200	α-INOX	4	Ø 2.80	Ø 1.80	Ø 6.00	1.90	10.00	100.00
TM.DC.300.200	α-INOX	4	Ø 3.00	Ø 2.00	Ø 6.00	2.00	10.00	100.00
TM.DC.380.300	α-INOX	4	Ø 3.80	Ø 1.80	Ø 6.00	2.90	14.00	100.00
TM.DC.400.300	α-INOX	4	Ø 4.00	Ø 2.00	Ø 6.00	3.00	13.00	100.00
TM.DC.580.400	α-INOX	4	Ø 5.80	Ø 3.80	Ø 6.00	3.90	20.00	100.00
TM.DC.600.400	α-INOX	4	Ø 6.00	Ø 4.00	Ø 6.00	4.00	19.00	100.00

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

Ø 1.8 - Ø 3 mm		Ø 3 - Ø 4 mm		Ø 4 - Ø 6 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					

TARGETMILL®

by HB microtec

Double-Chamfer



HB microtec®
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