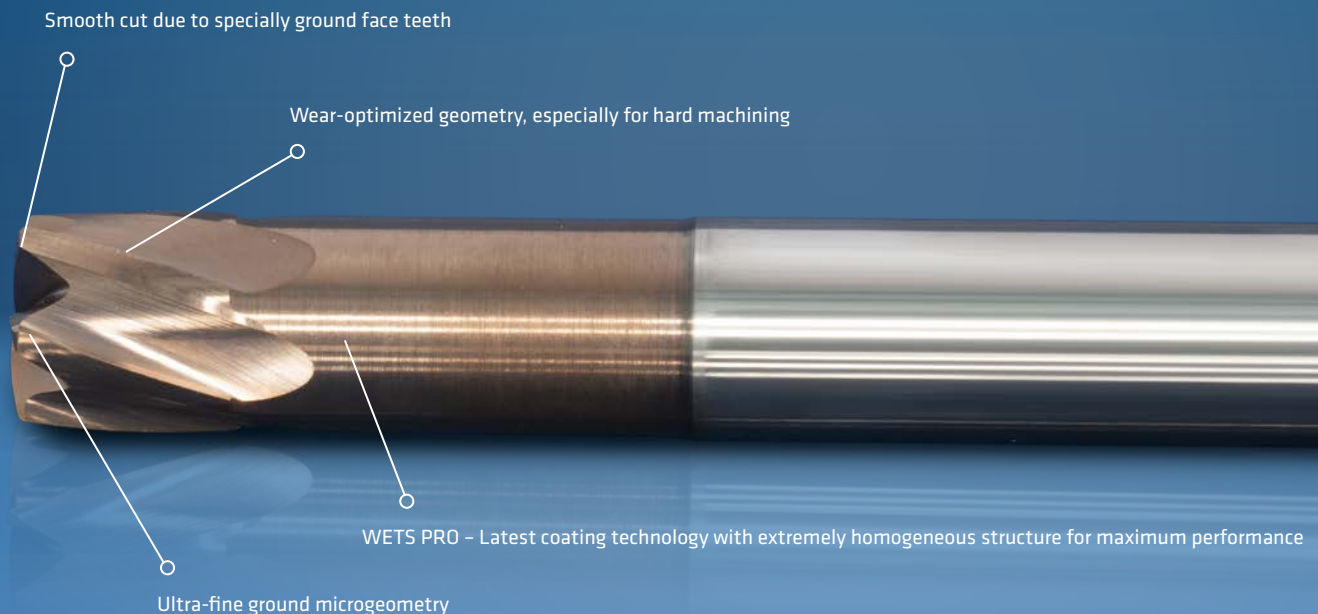


WHVH

High feed rate milling cutters for hardened materials up to 70HRC



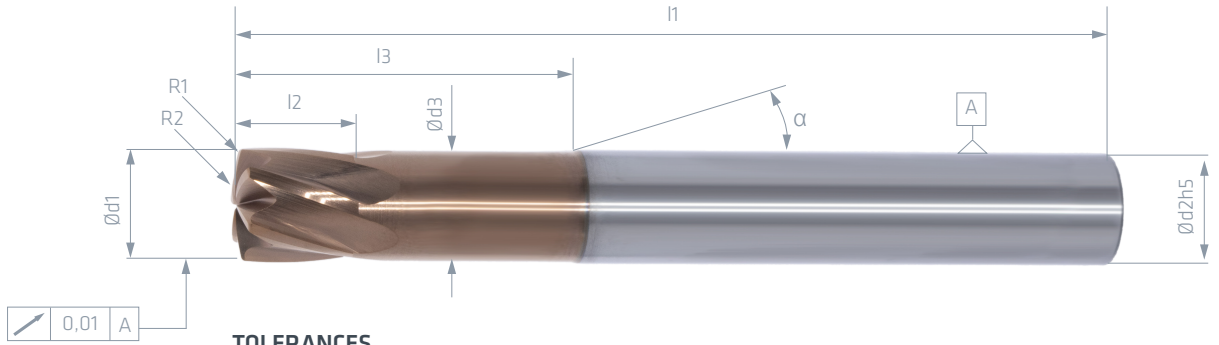
Versatile, precise and efficient, from the cutting edge to the shank

The innovative properties of the new WEDCO WHVH series, especially the new geometry, enable precise and efficient cutting, especially of demanding materials, and with their precision-ground cutting edge, they enable a very high surface quality and dimensional accuracy. The stable design of the milling cutter ensures very smooth running and minimizes vibrations. The WHVH is therefore the ideal choice for machining hardened materials in various sectors and industries such as tool and mold making or general mechanical engineering.

- Ultra-fine grain carbide with optimized microstructure
- Developed to withstand high thermal loads
- High dimensional and shape accuracy
- High cutting performance and productivity
- Regrindable with original finish

Solid Carbide Corner Radius End Mills

P		HA DIN6535
M		20° HELIX
K		<70 HRC
N		R
S		
H		



TOLERANCES

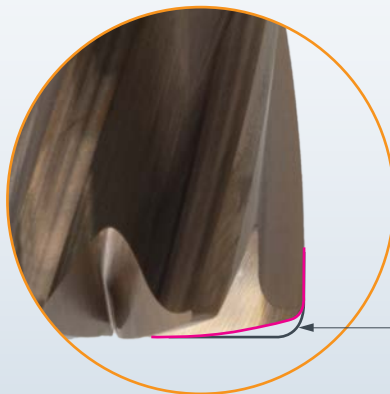
d1<d2	d1=d2≤Ø12	d3	R
+0,00/-0,01	-0,01/-0,02	+0,00/-0,05	±0,01

SIDE MILLING

Art. No.	Ød1	Ød2	Ød3	l1	l2	l3	R theo	R1	R2	α	Z	H 50-56HRC fz mm			H 57-62HRC fz mm			H 63-66HRC fz mm			H 67-70HRC fz mm		
												ap mm	ae mm		ap mm	ae mm		ap mm	ae mm		ap mm	ae mm	
WHVH057-01004	1	6	0,95	57	1	3	0,129	0,1	1,2	15°	4	0,036	0,04	0,72	0,022	0,024	0,72	0,017	0,019	0,72	0,011	0,013	0,62
WHVH057-02004	2	6	1,95	57	2	4	0,187	0,11	2,4	15°	4	0,071	0,08	1,44	0,044	0,048	1,44	0,033	0,038	1,44	0,022	0,026	1,24
WHVH057-03004	3	6	2,9	57	3	8	0,308	0,2	3,6	15°	4	0,111	0,12	2,16	0,069	0,072	2,16	0,052	0,057	2,16	0,034	0,039	1,86
WHVH057-04004	4	6	3,9	57	3	8	0,36	0,2	4,8	15°	4	0,225	0,16	2,88	0,138	0,096	2,88	0,104	0,076	2,88	0,07	0,052	2,48
WHVH057-05006	5	6	4,8	57	4	15	0,45	0,25	6	15°	6	0,191	0,2	3,6	0,116	0,12	3,6	0,089	0,095	3,6	0,058	0,065	3,1
WHVH057-06006	6	6	5,8	57	5	15	0,539	0,3	7,2	-	6	0,226	0,24	4,32	0,141	0,144	4,32	0,108	0,114	4,32	0,07	0,078	3,72
WHVH070-08006	8	8	7,8	70	7	20	0,718	0,4	9,6	-	6	0,316	0,32	5,76	0,194	0,192	5,76	0,146	0,152	5,76	0,099	0,104	4,96
WHVH080-10006	10	10	9,7	80	10	30	0,898	0,5	12	-	6	0,386	0,4	7,2	0,24	0,24	7,2	0,182	0,19	7,2	0,125	0,13	6,2
WHVH090-12006	12	12	11,7	90	12	30	1	0,5	14,4	-	6	0,444	0,48	8,64	0,276	0,288	8,64	0,203	0,228	8,64	0,145	0,156	7,44

SIDE MILLING

Material	50-56 HRC	56-62 HRC	62-66 HRC	66-70 HRC
VC (m/min)	105	75	65	53



R_{theo}
Programming radius for simulating a corner radius cutter in CAM

