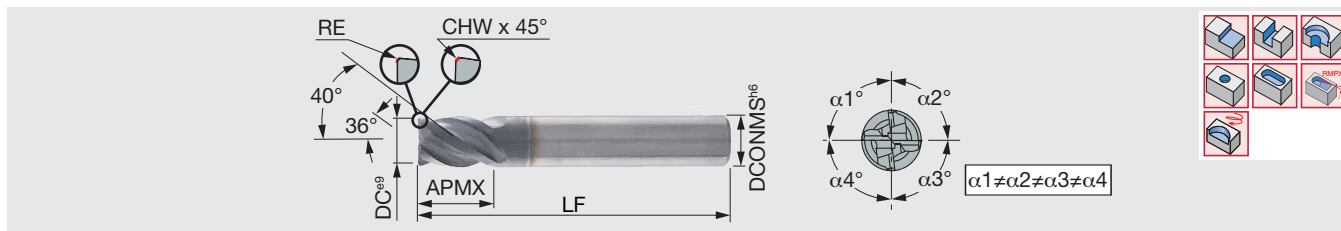


# VARIABLEMEISTER

## TEC\*\*H4S\*\*CF-E

4 flute chatter dampening endmill, variable helix and variable pitch, short type



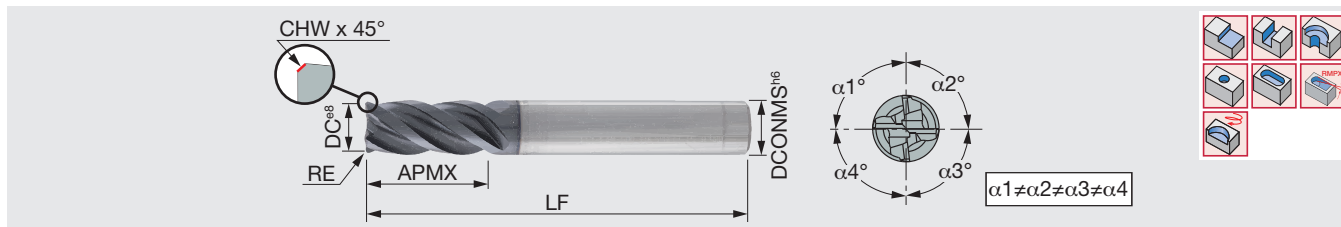
Designation	AH725	DC	DCONMS	NOF	CHW	RE	APMX	LF	Shank
TEC060H4S-06C06CF-E50	●	6	6	4	0.25	-	6	50	Cylindrical
TEC060H4S-06C06CF-R02E50	●	6	6	4	-	0.2	6	50	Cylindrical
TEC060H4S-06W06CF-E50	●	6	6	4	0.25	-	6	50	Weldon
TEC080H4S-08C08CF-E63	●	8	8	4	0.3	-	8	63	Cylindrical
TEC080H4S-08C08CF-R04E63	●	8	8	4	-	0.4	8	63	Cylindrical
TEC080H4S-08W08CF-E63	●	8	8	4	0.3	-	8	63	Weldon
TEC100H4S-10C10CF-E66	●	10	10	4	0.4	-	10	66	Cylindrical
TEC100H4S-10C10CFR.5E66	●	10	10	4	-	0.5	10	66	Cylindrical
TEC100H4S-10W10CF-E66	●	10	10	4	0.4	-	10	66	Weldon
TEC120H4S-12C12CF-E73	●	12	12	4	0.5	-	12	73	Cylindrical
TEC120H4S-12C12CF-R06E73	●	12	12	4	-	0.6	12	73	Cylindrical
TEC120H4S-12W12CF-E73	●	12	12	4	0.5	-	12	73	Weldon
TEC160H4S-16C16CF-E82	●	16	16	4	0.6	-	16	82	Cylindrical
TEC160H4S-16W16CF-E82	●	16	16	4	0.6	-	16	82	Weldon
TEC200H4S-20C20CF-E92	●	20	20	4	0.6	-	20	92	Cylindrical
TEC200H4S-20W20CF-E92	●	20	20	4	0.6	-	20	92	Weldon

●: Line up

# VARIABLEMEISTER

## TEC\*\*H4M\*\*CF-E

4 flute chatter dampening endmill, variable helix and variable pitch



Designation	AH725	DC	DCONMS	NOF	CHW	APMX	LF	Shank
TEC060H4M-12C06CF-E57	●	6	6	4	0.25	12	57	Cylindrical
TEC060H4M-12W06CF-E57	●	6	6	4	0.25	12	57	Weldon
TEC080H4M-16C08CF-E63	●	8	8	4	0.3	16	63	Cylindrical
TEC080H4M-16W08CF-E63	●	8	8	4	0.3	16	63	Weldon
TEC100H4M-20C10CF-E72	●	10	10	4	0.4	20	72	Cylindrical
TEC100H4M-20W10CF-E72	●	10	10	4	0.4	20	72	Weldon
TEC120H4M-24C12CF-E83	●	12	12	4	0.5	24	83	Cylindrical
TEC120H4M-24W12CF-E83	●	12	12	4	0.5	24	83	Weldon
TEC160H4M-32C16CF-E92	●	16	16	4	0.6	32	92	Cylindrical
TEC160H4M-32W16CF-E92	●	16	16	4	0.6	32	92	Weldon
TEC200H4M-40C20CF-E104	●	20	20	4	0.6	40	104	Cylindrical
TEC200H4M-40W20CF-E104	●	20	20	4	0.6	40	104	Weldon

●: Line up

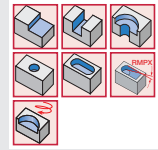
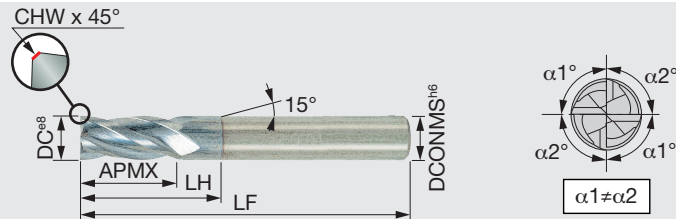
Reference pages: Standard cutting conditions → [I024](#)



# VARIABLEMEISTER

## TEC\*\*E4L\*\*CF

4 flute chatter dampening endmill, variable helix and variable pitch, short type



Designation	AH725	DC	DCONMS	NOF	CHW	APMX	LH	LF	Shank
TEC010E4L-2/04C04CF50	●	1	4	4	0.04	2.2	4	50	Cylindrical
TEC020E4L-4/06C04CF50	●	2	4	4	0.08	4.3	6.1	50	Cylindrical
TEC030E4L-8/11C06CF-57	●	3	6	4	0.1	8	11	57	Cylindrical
TEC040E4L-10/14C06CF-57	●	4	6	4	0.15	10	14	57	Cylindrical
TEC050E4L-12/17C06CF-57	●	5	6	4	0.18	12	17	57	Cylindrical
TEC060E4L-14/20C06CF-57	●	6	6	4	0.25	14	20	57	Cylindrical
TEC080E4L-18/26C08CFS63	●	8	8	4	-	18	26	63	Cylindrical
TEC080E4L-18/26C08CF-63	●	8	8	4	0.3	18	26	63	Cylindrical
TEC080E4L-18/26W08CF63	●	8	8	4	0.3	18	26	63	Weldon
TEC100E4L-22/32C10CFS72	●	10	10	4	-	22	32	72	Cylindrical
TEC100E4L-22/32C10CF-72	●	10	10	4	0.4	22	32	72	Cylindrical
TEC100E4L-22/32W10CF72	●	10	10	4	0.4	22	32	72	Weldon
TEC120E4L-26/38C12CFS83	●	12	12	4	-	26	38	83	Cylindrical
TEC120E4L-26/38C12CF-83	●	12	12	4	0.5	26	38	83	Cylindrical
TEC120E4L-26/38W12CF83	●	12	12	4	0.5	26	38	83	Weldon
TEC160E4L-34/50C16CF-100	●	16	16	4	0.6	34	50	100	Cylindrical
TEC160E4L-34/50W16CF-100	●	16	16	4	0.6	34	50	100	Weldon
TEC200E4L-42/60C20CF-110	●	20	20	4	0.6	42	60	110	Cylindrical
TEC200E4L-42/60W20CF-110	●	20	20	4	0.6	42	60	110	Weldon
TEC250E4L-50/65C25CF-121	●	25	25	4	0.6	50	65	121	Cylindrical
TEC250E4L-50/65W25CF121	●	25	25	4	0.6	50	65	121	Weldon

●: Line up

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or more

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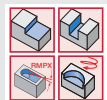
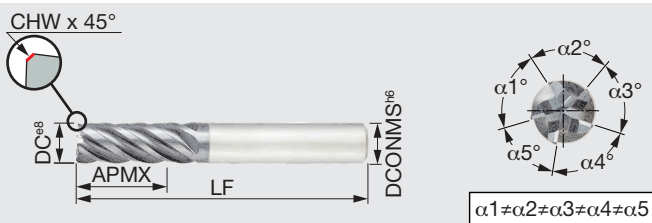
S

H

# VARIABLEMEISTER

## TEC\*\*E5L\*\*CF

4 flute chatter dampening endmill, variable helix and variable pitch



Designation	AH725	DC	DCONMS	NOF	CHW	APMX	LF	Shank
TEC060E5L-15C06CF-57	●	6	6	5	0.2	15	57	Cylindrical
TEC080E5L-20C08CF-63	●	8	8	5	0.25	20	63	Cylindrical
TEC100E5L-25C10CF-72	●	10	10	5	0.3	25	72	Cylindrical
TEC120E5L-30C12CF-83	●	12	12	5	0.4	30	83	Cylindrical
TEC160E5L-40C16CF-100	●	16	16	5	0.5	40	100	Cylindrical
TEC200E5L-50C20CF-125	●	20	20	5	0.5	50	125	Cylindrical

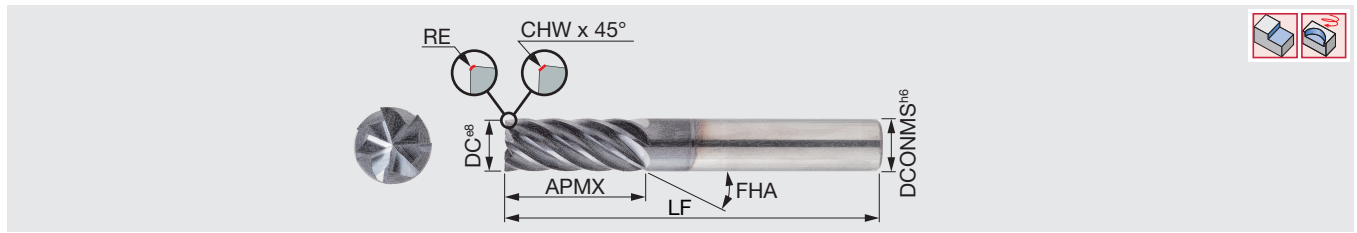
●: Line up

Reference pages: Standard cutting conditions → [I024](#)

# VARIABLE MEISTER

## TEC\*\*H7-CF

7 flute chatter dampening endmill, variable helix and variable pitch, for high speed finishing



Designation	AH710	DC	DCONMS	NOF	RE	CHW	APMX	FHA	LF	Shank
TEC060H7-12C06CF-M57	●	6	6	7	-	-	12	37°	57	Cylindrical
TEC060H7-12C06CF-R02M57	●	6	6	7	0.2	-	12	37°	57	Cylindrical
TEC060H7-18C06CF-M65	●	6	6	7	-	0.2	18	37°	65	Cylindrical
TEC060H7-24C06CF-70	●	6	6	7	-	0.2	24	37°	70	Cylindrical
TEC060H7-36C06CF-90	●	6	6	7	-	0.2	36	37°	90	Cylindrical
TEC080H7-16C08CF-M63	●	8	8	7	-	-	16	37°	63	Cylindrical
TEC080H7-16C08CF-R04M63	●	8	8	7	0.4	-	16	37°	63	Cylindrical
TEC080H7-24C08CF-M90	●	8	8	7	-	0.2	24	37°	90	Cylindrical
TEC080H7-32C08CF-90	●	8	8	7	-	0.2	32	37°	90	Cylindrical
TEC080H7-48C08CF-110	●	8	8	7	-	0.2	48	37°	110	Cylindrical
TEC100H7-20C10CF-M72	●	10	10	7	-	-	20	37°	72	Cylindrical
TEC100H7-20C10CF-R05M72	●	10	10	7	0.5	-	20	37°	72	Cylindrical
TEC100H7-20W10CF-M72	●	10	10	7	-	-	20	37°	72	Weldon
TEC100H7-30C10CF-M100	●	10	10	7	-	0.3	30	37°	100	Cylindrical
TEC100H7-40C10CF-100	●	10	10	7	-	0.3	40	37°	100	Cylindrical
TEC100H7-60C10CF-130	●	10	10	7	-	0.3	60	37°	130	Cylindrical
TEC120H7-24C12CF-M83	●	12	12	7	-	-	24	37°	83	Cylindrical
TEC120H7-24C12CF-R06M83	●	12	12	7	0.6	-	24	37°	83	Cylindrical
TEC120H7-24W12CF-M83	●	12	12	7	-	-	24	37°	83	Weldon
TEC120H7-36C12CF-M110	●	12	12	7	-	0.3	36	37°	110	Cylindrical
TEC120H7-48C12CF-110	●	12	12	7	-	0.3	48	37°	110	Cylindrical
TEC120H7-72C12CF-140	●	12	12	7	-	0.3	72	37°	140	Cylindrical
TEC160H7-32C16CF-M92	●	16	16	7	-	-	32	37°	92	Cylindrical
TEC160H7-32C16CF-R08M92	●	16	16	7	0.8	-	32	37°	92	Cylindrical
TEC160H7-32W16CF-M92	●	16	16	7	-	-	32	37°	92	Weldon
TEC160H7-48C12CF-M131	●	16	16	7	-	0.3	48	37°	131	Cylindrical
TEC160H7-64C16CF-131	●	16	16	7	-	0.3	64	37°	131	Cylindrical
TEC160H7-96C16CF-175	●	16	16	7	-	0.3	96	37°	175	Cylindrical
TEC200H7-40C20CF-M104	●	20	20	7	-	-	40	37°	104	Cylindrical
TEC200H7-40C20CF-R10M104	●	20	20	7	1	-	40	37°	104	Cylindrical
TEC200H7-40W20CF-M104	●	20	20	7	-	-	40	37°	104	Weldon
TEC200H7-60C20CF-M140	●	20	20	7	-	0.4	60	37°	140	Cylindrical
TEC200H7-80C20CF-140	●	20	20	7	-	0.4	80	37°	140	Cylindrical

●: Line up

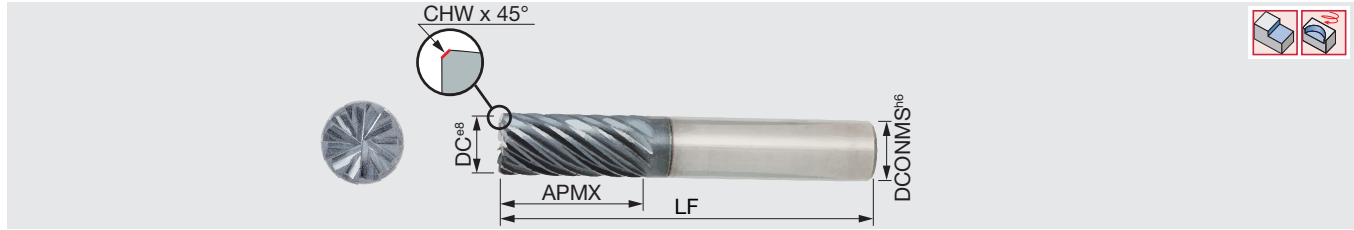
Reference pages: Standard cutting conditions → I024



# VARIABLEMEISTER

## TEC\*\*H\*\*CF

6-20 flute chatter dampening endmill, variable helix and variable pitch, for high speed finishing



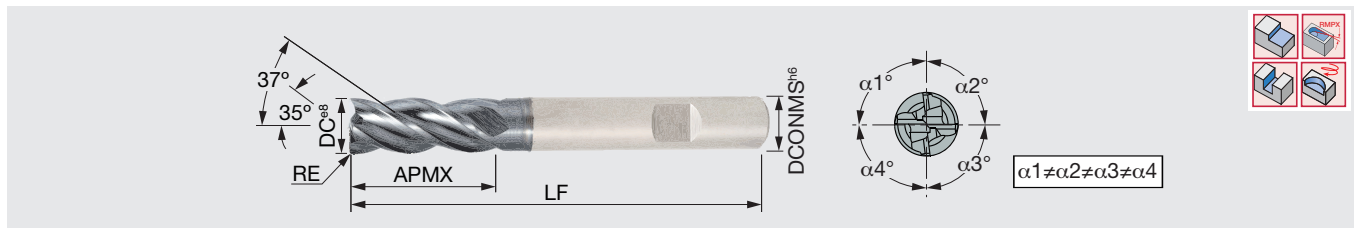
Designation	AH710	DC	DCONMS	NOF	CHW	APMX	LF	Shank
TEC060H6-12C06CF-H57	●	6	6	6	0.2	12	57	Cylindrical
TEC080H8-16C08CF-H63	●	8	8	8	0.2	16	63	Cylindrical
TEC100H10-20C10CF-H72	●	10	10	10	0.3	20	72	Cylindrical
TEC120H12-24C12CF-H83	●	12	12	12	0.3	24	83	Cylindrical
TEC160H16-32C16CF-H92	●	16	16	16	0.3	32	92	Cylindrical
TEC200H20-40C20CFH104	●	20	20	20	0.4	40	104	Cylindrical

●: Line up

# VARIABLEMEISTER

## TECK\*\*H4M\*\*CF-R

4 flute chatter dampening endmill, variable helix and variable pitch, for titanium machining



Designation	AH725	DC	DCONMS	NOF	RE	APMX	RMPX	LF	Shank
TECK040H4M-08C06CF-R02	●	4	6	4	0.2	8	5°	57	Cylindrical
TECK050H4M-10C06CF-R02	●	5	6	4	0.2	10	5°	57	Cylindrical
TECK060H4M-12C06CF-R02	●	6	6	4	0.2	12	5°	57	Cylindrical
TECK060H4M-12W06CF-R02	●	6	6	4	0.2	12	5°	57	Weldon
TECK080H4M-16C08CF-R04	●	8	8	4	0.4	16	5°	63	Cylindrical
TECK080H4M-16W08CF-R04	●	8	8	4	0.4	16	5°	63	Weldon
TECK100H4M-20C10CF-R05	●	10	10	4	0.5	20	5°	72	Cylindrical
TECK100H4M-20W10CF-R05	●	10	10	4	0.5	20	5°	72	Weldon
TECK120H4M-24C12CF-R06	●	12	12	4	0.6	24	5°	83	Cylindrical
TECK120H4M-24W12CF-R06	●	12	12	4	0.6	24	5°	83	Weldon
TECK160H4M-32C16CF-R08	●	16	16	4	0.8	32	5°	92	Cylindrical
TECK160H4M-32W16CF-R08	●	16	16	4	0.8	32	5°	92	Weldon
TECK200H4M-40C20CF-R10	●	20	20	4	1	40	5°	104	Cylindrical
TECK200H4M-40W20CF-R10	●	20	20	4	1	40	5°	104	Weldon

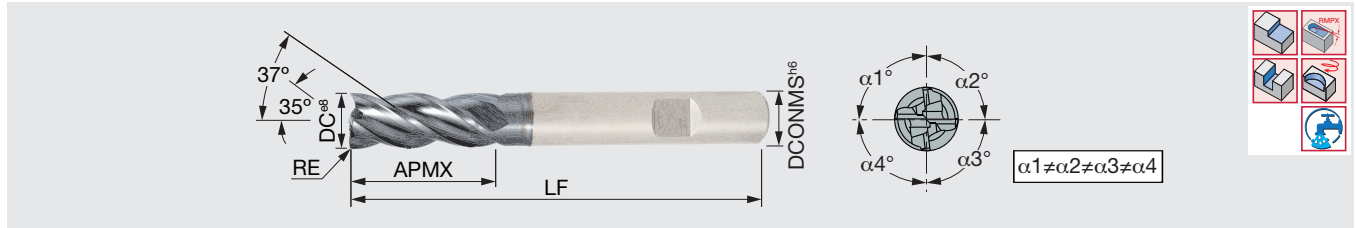
●: Line up

Reference pages: Standard cutting conditions → [I024](#)

# VARIABLEMEISTER

## TECK\*\*H4M\*\*CF-R\*\*C

4 flute chatter dampening endmill, variable helix and variable pitch, for titanium machining



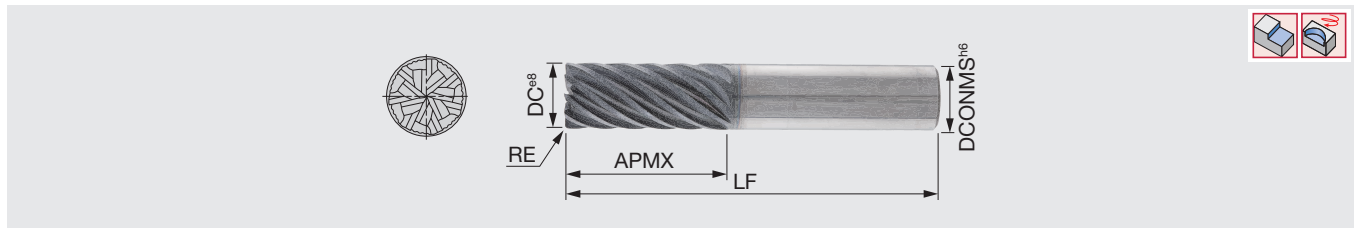
Designation	GH730	DC	DCONMS	NOF	RE	APMX	RMPX	LF	Coolant hole	Shank
TECK060H4M-12C06CF-R02C	●	6	6	4	0.2	12	5°	57	With	Cylindrical
TECK080H4M-16W08CF-R04C	●	8	8	4	0.4	16	5°	63	With	Weldon
TECK100H4M-20W10CF-R05C	●	10	10	4	0.5	20	5°	72	With	Weldon
TECK120H4M-24W12CF-R06C	●	12	12	4	0.6	24	5°	83	With	Weldon
TECK160H4M-32W16CF-R08C	●	16	16	4	0.8	32	5°	92	With	Weldon

●: Line up

# VARIABLEMEISTER

## TECK\*\*H7/9M\*\*CF-R

7 or 9 flute chatter dampening endmill, variable helix and variable pitch, for titanium machining



Designation	AH725	DC	DCONMS	NOF	RE	APMX	RMPX	LF	Shank
TECK060H7-13C06CF-R02T57	●	6	6	7	0.2	13	5°	57	Cylindrical
TECK060H7-13W06CF-R02T57	●	6	6	7	0.2	13	5°	57	Weldon
TECK080H7-19C08CF-R04T63	●	8	8	7	0.4	19	5°	63	Cylindrical
TECK080H7-19W08CF-R04T63	●	8	8	7	0.4	19	5°	63	Weldon
TECK100H7-22C10CF-R05T72	●	10	10	7	0.5	22	5°	72	Cylindrical
TECK100H7-22W10CF-R05T72	●	10	10	7	0.5	22	5°	72	Weldon
TECK120H7-26C12CF-R06T83	●	12	12	7	0.6	26	5°	83	Cylindrical
TECK120H7-26W12CF-R06T83	●	12	12	7	0.6	26	5°	83	Weldon
TECK160H9-32C16CF-R08T92	●	16	16	9	0.8	32	5°	92	Cylindrical
TECK160H9-32W16CF-R08T92	●	16	16	9	0.8	32	5°	92	Weldon
TECK200H9-38C20CF-R10T104	●	20	20	9	1	38	5°	104	Cylindrical
TECK200H9-38W20CF-R10T104	●	20	20	9	1	38	5°	104	Weldon

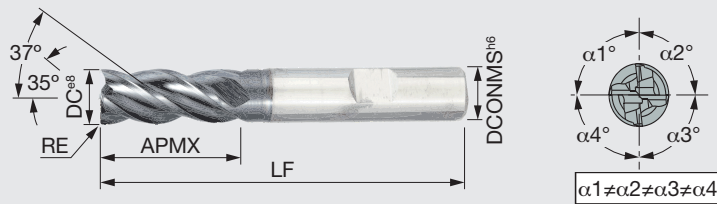
●: Line up

Reference pages: Standard cutting conditions → [I024](#)

**VARIABLEMEISTER**

TEC\*\*H4M\*\*CF-R

7 or 9 flute chatter dampening endmill, variable helix and variable pitch, for titanium machining



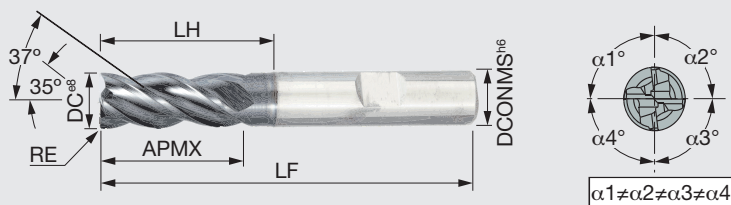
Designation	AH725	DC	DCONMS	NOF	RE	APMX	RMPX	LF	Shank
TEC060H4M-12C06CF-R02-57	●	6	6	4	0.2	12	5°	57	Cylindrical
TEC060H4M-12W06CF-R02-57	●	6	6	4	0.2	12	5°	57	Weldon
TEC080H4M-16C08CF-R04-63	●	8	8	4	0.4	16	5°	63	Cylindrical
TEC080H4M-16W08CF-R04-63	●	8	8	4	0.4	16	5°	63	Weldon
TEC100H4M-20C10CF-R05-72	●	10	10	4	0.5	20	5°	72	Cylindrical
TEC100H4M-20W10CF-R05-72	●	10	10	4	0.5	20	5°	72	Weldon
TEC120H4M-24C12CF-R06-83	●	12	12	4	0.6	24	5°	83	Cylindrical
TEC120H4M-24W12CF-R06-83	●	12	12	4	0.6	24	5°	83	Weldon
TEC140H4M-28C14CFR0.7-83	●	14	14	4	0.7	28	5°	83	Cylindrical
TEC140H4M-28W14CFR0.7-83	●	14	14	4	0.7	28	5°	83	Weldon
TEC160H4M-32C16CF-R08-92	●	16	16	4	0.8	32	5°	92	Cylindrical
TEC160H4M-32W16CF-R08-92	●	16	16	4	0.8	32	5°	92	Weldon
TEC200H4M-40C20CF-R10-104	●	20	20	4	1	40	5°	104	Cylindrical
TEC200H4M-40W20CF-R10-104	●	20	20	4	1	40	5°	104	Weldon
TEC250H4M-50C25CF-R12-121	●	25	25	4	1.2	50	5°	121	Cylindrical
TEC250H4M-50W25CF-R12-121	●	25	25	4	1.2	50	5°	121	Weldon

● : Line up

**VARIABLEMEISTER**

TEC\*\*H4L\*\*CF-R

4 flute chatter dampening endmill, variable helix and variable pitch, long neck type



Designation	AH725	DC	DCONMS	NOF	RE	APMX	RMPX	LH	LF	Shank
TEC010H4L-02/3C4CF-R.05	●	1	4	4	0.1	2	5°	3	50	Cylindrical
TEC020H4L-04/6C4CF-R01	●	2	4	4	0.1	4	5°	6	50	Cylindrical
TEC030H4L-06/9C4CF-R015	●	3	6	4	0.2	6	5°	9	57	Cylindrical
TEC040H4L-08/12C6CF-R02	●	4	6	4	0.2	8	5°	12	57	Cylindrical
TEC050H4L-10/15C6CF-R02	●	5	6	4	0.2	10	5°	15	57	Cylindrical
TEC060H4L-12/20C6CF-R02	●	6	6	4	0.2	12	5°	20	57	Cylindrical
TEC060H4L-12/20W6CF-R02	●	6	6	4	0.2	12	5°	20	57	Weldon
TEC080H4L-16/26C8CF-R04	●	8	8	4	0.4	16	5°	26	63	Cylindrical
TEC100H4L-20/32C10CF-R05	●	10	10	4	0.5	20	5°	32	72	Cylindrical
TEC100H4L-20/32W10CF-R05	●	10	10	4	0.5	20	5°	32	72	Weldon
TEC120H4L-24/38C12CF-R06	●	12	12	4	0.6	24	5°	38	83	Cylindrical
TEC120H4L-24/38W12CF-R06	●	12	12	4	0.6	24	5°	38	83	Weldon
TEC160H4L-32/50C16CF-R08	●	16	16	4	0.8	32	5°	50	100	Cylindrical
TEC160H4L-32/50W16CF-R08	●	16	16	4	0.8	32	5°	50	100	Weldon
TEC200H4L-40/60C20CF-R10	●	20	20	4	1	40	5°	60	110	Cylindrical
TEC200H4L-40/60W20CF-R10	●	20	20	4	1	40	5°	60	110	Weldon

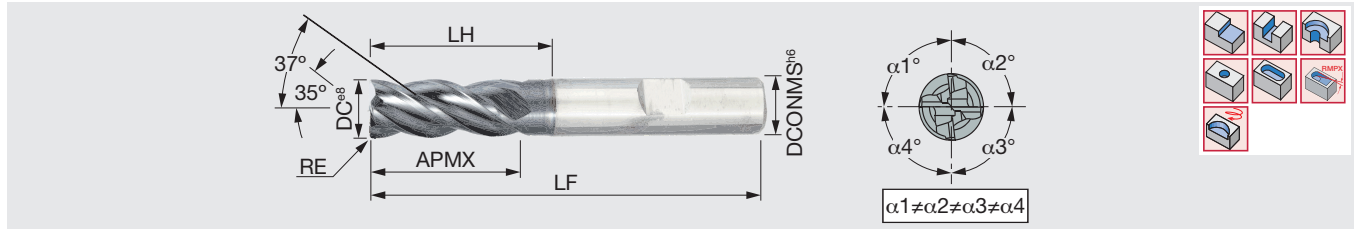
● : Line up

Reference pages: Standard cutting conditions → I024

# VARIABLEMEISTER

## TEC\*\*H4X\*\*CF-R

4 flute chatter dampening endmill, variable helix and variable pitch, extra long neck type



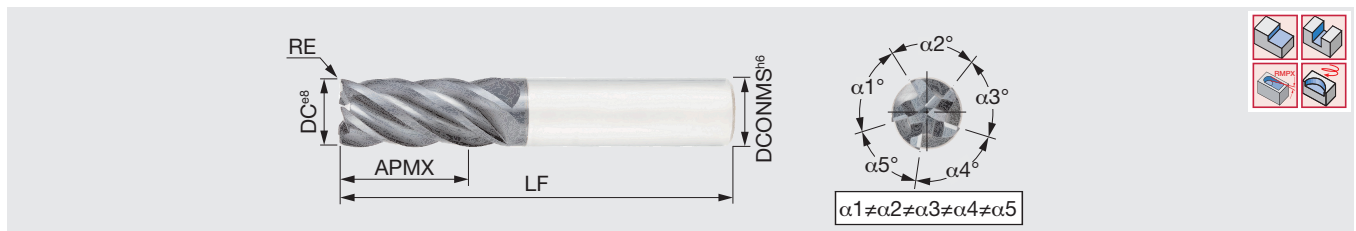
Designation	AH725	DC	DCONMS	NOF	RE	APMX	RMPX	LH	LF	Shank
TEC060H4X-12/25C06CF-R02	●	6	6	4	0.2	12	5°	25	61	Cylindrical
TEC060H4X-12/25W06CF-R02	●	6	6	4	0.2	12	5°	25	61	Weldon
TEC080H4X-16/32C08CF-R04	●	8	8	4	0.4	16	5°	32	68	Cylindrical
TEC080H4X-16/32W08CF-R04	●	8	8	4	0.4	16	5°	32	68	Weldon
TEC100H4X-20/40C10CF-R05	●	10	10	4	0.5	20	5°	40	80	Cylindrical
TEC100H4X-20/40W10CF-R05	●	10	10	4	0.5	20	5°	40	80	Weldon
TEC120H4X-24/50C12CF-R06	●	12	12	4	0.6	24	5°	50	95	Cylindrical
TEC120H4X-24/50W12CF-R06	●	12	12	4	0.6	24	5°	50	95	Weldon
TEC160H4X-32/64C16CF-R08	●	16	16	4	0.8	32	5°	64	115	Cylindrical
TEC160H4X-32/64W16CF-R08	●	16	16	4	0.8	32	5°	64	115	Weldon
TEC200H4X-40/75C20CF-R10	●	20	20	4	1	40	5°	75	125	Cylindrical
TEC200H4X-40/75W20CF-R10	●	20	20	4	1	40	5°	75	125	Weldon

● : Line up

# VARIABLEMEISTER

## TEC\*\*H5M\*\*CF-R

5 flute chatter dampening endmill, variable helix and variable pitch



Designation	AH725	DC	DCONMS	NOF	RE	APMX	RMPX	LF	Shank
TEC040H5M-09C06CF-R02-57	●	4	6	5	0.2	9	5°	57	Cylindrical
TEC050H5M-11C06CF-R02-57	●	5	6	5	0.2	11	5°	57	Cylindrical
TEC060H5M-13W06CF-R02-57	●	6	6	5	0.2	13	5°	57	Weldon
TEC080H5M-19C08CF-R04-63	●	8	8	5	0.4	19	5°	63	Cylindrical
TEC080H5M-19W08CF-R04-63	●	8	8	5	0.4	19	5°	63	Weldon
TEC100H5M-22C10CF-R05-72	●	10	10	5	0.5	22	5°	72	Cylindrical
TEC100H5M-22W10CF-R05-72	●	10	10	5	0.5	22	5°	72	Weldon
TEC160H5M-32W16CF-R08-92	●	16	16	5	0.8	32	5°	92	Weldon
TEC200H5M-38C20CF-R10-104	●	20	20	5	1	38	5°	104	Cylindrical
TEC200H5M-38W20CF-R10-104	●	20	20	5	1	38	5°	104	Weldon

● : Line up

Reference pages: Standard cutting conditions → [I024](#)

**Slotting / Roughing ( $a_e = 0.4 \times D$  or over)**

ISO	Workpiece material	Vc (m/min)	fz (mm/t)			ap (Slotting)
			$\phi 6 - \phi 8$	$\phi 10 - \phi 12$	$\phi 16 - \phi 20$	
<b>P</b>	Carbon steel	140 - 180	0.03 - 0.045	0.035 - 0.055	0.05 - 0.07	2xD
	Alloy steel	70 - 150	0.025 - 0.04	0.035 - 0.055	0.05 - 0.07	2xD
<b>M</b>	Stainless steel	60 - 100	0.025 - 0.045	0.035 - 0.05	0.04 - 0.065	1xD
<b>K</b>	Cast iron	80 - 180	0.025 - 0.05	0.035 - 0.065	0.05 - 0.075	2xD
<b>N</b>	Aluminium alloy	300 - 750	0.025 - 0.05	0.035 - 0.065	0.035 - 0.09	2xD
<b>S</b>	Titanium alloy	20 - 50	0.025 - 0.04	0.03 - 0.05	0.035 - 0.085	1xD
<b>H</b>	Hardened steel	20 - 30	0.01 - 0.02	0.02 - 0.04	0.03 - 0.06	0.5xD

**Semi-finishing / Shouldering ( $a_e = 0.1 \sim 0.4 \times D$ )**

ISO	Workpiece material	Vc (m/min)	fz (mm/t)			ap
			$\phi 6 - \phi 8$	$\phi 10 - \phi 12$	$\phi 16 - \phi 20$	
<b>P</b>	Carbon steel	150 - 220	0.035 - 0.075	0.075 - 0.09	0.085 - 0.1	2xD
	Alloy steel	70 - 160	0.025 - 0.065	0.05 - 0.09	0.055 - 0.09	2xD
<b>M</b>	Stainless steel	80 - 130	0.03 - 0.05	0.04 - 0.06	0.05 - 0.065	2xD
<b>K</b>	Cast iron	130 - 220	0.035 - 0.065	0.05 - 0.075	0.075 - 0.09	2xD
<b>N</b>	Aluminium alloy	350 - 850	0.05 - 0.075	0.075 - 0.1	0.1 - 0.125	2xD
<b>S</b>	Titanium alloy	40 - 60	0.035 - 0.05	0.04 - 0.065	0.06 - 0.1	2xD
<b>H</b>	Hardened steel	30 - 70	0.015 - 0.045	0.03 - 0.05	0.05 - 0.075	2xD

**Finishing (feed rate depending on required accuracy) / High feed machining at low depth of cut ( $a_e = 0.05 \sim 0.1 \times D$ )**

ISO	Workpiece material	Vc (m/min)	fz (mm/t)			ap
			$\phi 6 - \phi 8$	$\phi 10 - \phi 12$	$\phi 16 - \phi 20$	
<b>P</b>	Carbon steel	170 - 280	0.06 - 0.09	0.085 - 0.1	0.1 - 0.125	apmax
	Alloy steel	110 - 220	0.06 - 0.09	0.085 - 0.1	0.1 - 0.125	apmax
<b>M</b>	Stainless steel	100 - 160	0.035 - 0.055	0.05 - 0.065	0.055 - 0.075	apmax
<b>K</b>	Cast iron	180 - 280	0.04 - 0.075	0.075 - 0.08	0.08 - 0.1	apmax
<b>N</b>	Aluminium alloy	350 - 900	0.055 - 0.09	0.085 - 0.125	0.125 - 0.18	apmax
<b>S</b>	Titanium alloy	50 - 70	0.04 - 0.065	0.05 - 0.075	0.075 - 0.11	apmax
<b>H</b>	Hardened steel	40 - 80	0.025 - 0.05	0.04 - 0.065	0.06 - 0.08	apmax

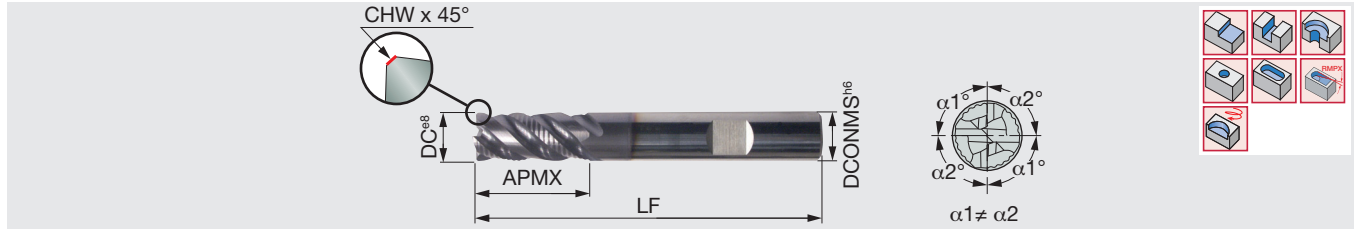
- When the depth of cut ( $a_e$ ) is closer to the upper limit, please start with a lower limit value of cutting speed (Vc).
- Please set the cutting speed and the feed rate lower for the items with long slot according to how chattering occurs.
- While air blow is recommended, water-soluble coolant will be good for stainless steel, titanium alloy, and heat-resistant alloy.
- When chattering occurs with low rigid machines or settings, reduce cutting speed and feed at an equal rate.
- When chattering occurs with long tool overhang, reduce cutting speed and feed by 20 to 40%.



# FINISHMEISTER VARIABLEMEISTER

TEFS\*\*E44\*\*CF

4 flute endmill, 38° helix angle, variable pitch, roughing and finishing combination type



Designation	AH725	DC	DCONMS	NOF	CHW	APMX	LF	Shank
TEFS060E44-14C06CF57	●	6	6	4	0.25	14	57	Cylindrical
TEFS060E44-14W06CF-57	●	6	6	4	0.25	14	57	Weldon
TEFS080E44-18C08CF63	●	8	8	4	0.3	18	63	Cylindrical
TEFS080E44-18W08CF-63	●	8	8	4	0.3	18	63	Weldon
TEFS100E44-22C10CF72	●	10	10	4	0.4	22	72	Cylindrical
TEFS100E44-22W10CF-72	●	10	10	4	0.4	22	72	Weldon
TEFS120E44-26C12CF83	●	12	12	4	0.5	26	83	Cylindrical
TEFS120E44-26W12CF-83	●	12	12	4	0.5	26	83	Weldon
TEFS140E44-30C14CF83	●	14	14	4	0.5	30	83	Cylindrical
TEFS140E44-30W14CF-83	●	14	14	4	0.5	30	83	Weldon
TEFS160E44-34C16CF92	●	16	16	4	0.6	34	92	Cylindrical
TEFS160E44-34W16CF-92	●	16	16	4	0.6	34	92	Weldon
TEFS200E44-42C20CF104	●	20	20	4	0.6	42	104	Cylindrical
TEFS200E44-42W20CF-104	●	20	20	4	0.6	42	104	Weldon
TEFS250E44-52C25CF121	●	25	25	4	0.6	52	121	Cylindrical
TEFS250E44-52W25CF-121	●	25	25	4	0.6	52	121	Weldon

●: Line up

Reference pages: Standard cutting conditions → I031

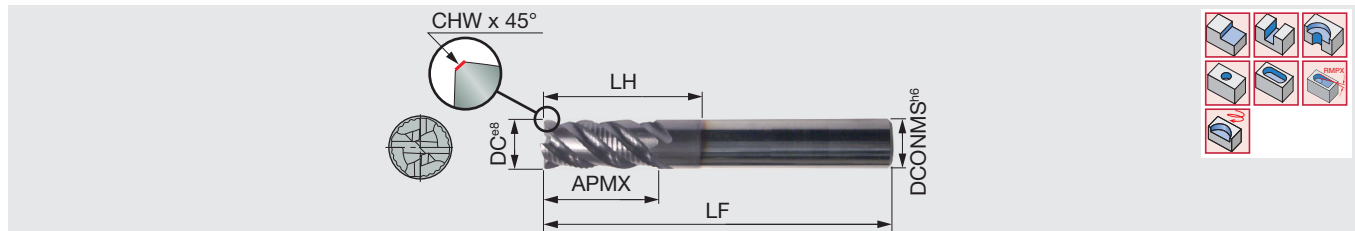
Grade  
Insert  
Toolholder  
Ext. Toolholder  
Int. Toolholder  
Threading  
Grooving  
Miniature tool  
Milling cutter  
Endmill  
Drilling tool  
Tooling System  
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# FINISHMEISTER

## TEFS\*\*B44

4 flute endmill, 45° helix angle, roughing and finishing combination type



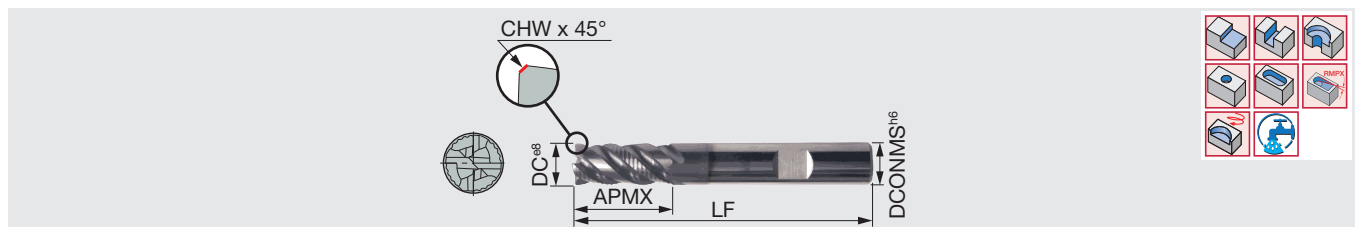
Designation	AH725	DC	DCONMS	NOF	CHW	APMX	LH	LF	Shank
TEFS040B44-10C06-57	●	4	6	4	0.12	10	-	57	Cylindrical
TEFS050B44-12C06-57	●	5	6	4	0.18	12	-	57	Cylindrical
TEFS060B44-14/20C06-57	●	6	6	4	0.25	14	20	57	Cylindrical
TEFS060B4414/20W06-57	●	6	6	4	0.25	14	20	57	Weldon
TEFS060B44-14C06-57	●	6	6	4	0.25	14	-	57	Cylindrical
TEFS060B44-14W06-57	●	6	6	4	0.25	14	-	57	Weldon
TEFS080B44-18/26C08-63	●	8	8	4	0.3	18	26	63	Cylindrical
TEFS080B44-18/26W08-63	●	8	8	4	0.3	18	26	63	Weldon
TEFS080B44-18C08-63	●	8	8	4	0.3	18	-	63	Cylindrical
TEFS080B44-18W08-63	●	8	8	4	0.3	18	-	63	Weldon
TEFS100B44-22/32C10-72	●	10	10	4	0.3	22	32	72	Cylindrical
TEFS100B44-22/32W10-72	●	10	10	4	0.3	22	32	72	Weldon
TEFS100B44-22C10-72	●	10	10	4	0.3	22	-	72	Cylindrical
TEFS100B44-22W10-72	●	10	10	4	0.3	22	-	72	Weldon
TEFS120B44-26/38C12-83	●	12	12	4	0.4	26	38	83	Cylindrical
TEFS120B44-26/38W12-83	●	12	12	4	0.4	26	38	83	Weldon
TEFS120B44-26C12-83	●	12	12	4	0.4	26	-	83	Cylindrical
TEFS120B44-26W12-83	●	12	12	4	0.4	26	-	83	Weldon
TEFS140B44-30C14-83	●	14	14	4	0.4	30	-	83	Cylindrical
TEFS140B44-30W14-83	●	14	14	4	0.4	30	-	83	Weldon
TEFS160B44-34/50C16-100	●	16	16	4	0.6	34	50	100	Cylindrical
TEFS160B44-34/50W16-100	●	16	16	4	0.6	34	50	100	Weldon
TEFS160B44-34C16-92	●	16	16	4	0.6	34	-	92	Cylindrical
TEFS160B44-34W16-92	●	16	16	4	0.6	34	-	92	Weldon
TEFS200B44-42/62C20-125	●	20	20	4	0.6	42	62	125	Cylindrical
TEFS200B44-42/62W20-125	●	20	20	4	0.6	42	62	125	Weldon
TEFS200B44-42C20-104	●	20	20	4	0.6	42	-	104	Cylindrical
TEFS200B44-42W20-104	●	20	20	4	0.6	42	-	104	Weldon
TEFS250B44-52C25-121	●	25	25	4	0.6	52	-	121	Cylindrical
TEFS250B44-52W25-121	●	25	25	4	0.6	52	-	121	Weldon

●: Line up

# FINISHMEISTER

## TEFS\*\*B44\*\*C

4 flute endmill, 45° helix angle, roughing and finishing combination type

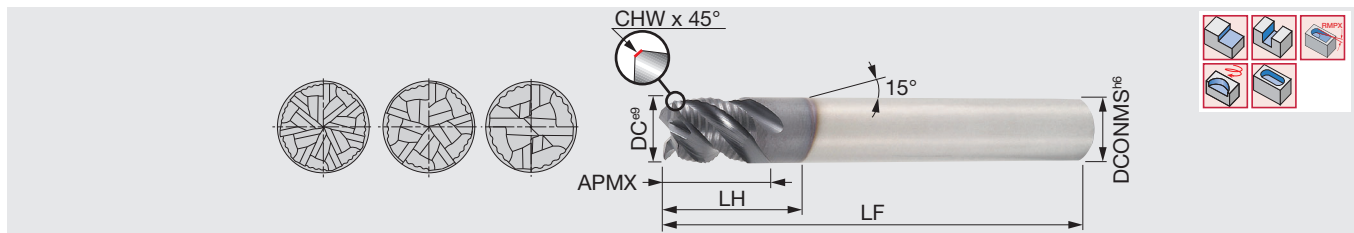


Designation	GH730	DC	DCONMS	NOF	CHW	APMX	LF	Coolant hole	Shank
TEFS060B44-14C06-57C	●	6	6	4	0.25	14	57	With	Cylindrical
TEFS080B44-18W08-63C	●	8	8	4	0.3	18	63	With	Cylindrical
TEFS100B44-22W10-72C	●	10	10	4	0.3	22	72	With	Cylindrical
TEFS120B44-26W12-83C	●	12	12	4	0.4	26	83	With	Cylindrical
TEFS160B44-34W16-92C	●	16	16	4	0.6	34	92	With	Cylindrical

●: Line up

Reference pages: Standard cutting conditions → **I031**

### 4-7 flute roughing endmill, 45° helix angle, short type

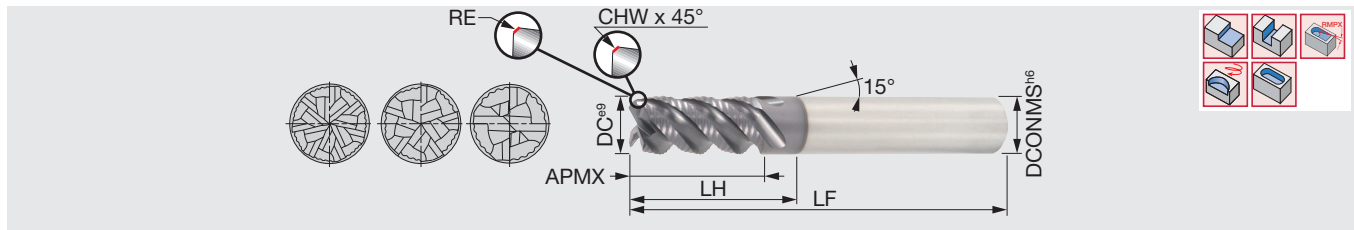


Designation	AH725	DC	DCONMS	NOF	CHW	APMX	LH	LF		Shank
TECR050B4S-05W06-57	●	5	6	4	0.2	5	10	57	●	Weldon
TECR060B4S-06W06-57	●	6	6	4	0.25	6	-	57	●	Weldon
TECR080B4S-08W08-63	●	8	8	4	0.25	8	-	63	●	Weldon
TECR100B4S-10W10-72	●	10	10	4	0.3	10	-	72	●	Weldon
TECR120B4S-12W12-83	●	12	12	4	0.35	12	-	83	●	Weldon
TECR160B5S-16W16-92	●	16	16	5	0.4	16	-	92		Weldon
TECR200B7S-20W20-104	●	20	20	7	0.4	20	-	104		Weldon

●: Line up

## TECR\*\*B\*M

### 4-7 flute roughing endmill, 45° helix angle

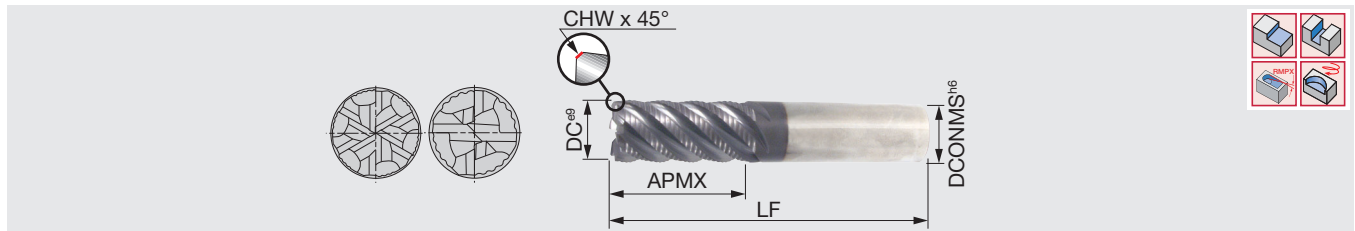


Designation	AH725	DC	DCONMS	NOF	CHW	RE	APMX	LH	LF		Shank
TECR050B4M-10C06-57	●	5	6	4	0.2	-	10	15	57	●	Cylindrical
TECR050B4M-10W06-57	●	5	6	4	0.2	-	10	15	57	●	Weldon
TECR060B4M-12C06-57	●	6	6	4	0.25	-	12	-	57	●	Cylindrical
TECR060B4M-12W06-57	●	6	6	4	0.25	-	12	-	57	●	Weldon
TECR080B4M-16C08-63	●	8	8	4	0.25	-	16	-	63	●	Cylindrical
TECR080B4M-16W08-63	●	8	8	4	0.25	-	16	-	63	●	Weldon
TECR100B4M-20C10-72	●	10	10	4	0.3	-	20	-	72	●	Cylindrical
TECR100B4M-20C10-72R10	●	10	10	4	-	1	20	-	72	●	Cylindrical
TECR100B4M-20W10-72	●	10	10	4	0.3	-	20	-	72	●	Weldon
TECR120B4M-24C12-83	●	12	12	4	0.35	-	24	-	83	●	Cylindrical
TECR120B4M-24C12-83R12	●	12	12	4	-	1.2	24	-	83	●	Cylindrical
TECR120B4M-24W12-83	●	12	12	4	0.35	-	24	-	83	●	Weldon
TECR120B4M-24W12-83R12	●	12	12	4	-	1.2	24	-	83	●	Weldon
TECR160B5M-32C16-92	●	16	16	5	0.4	-	32	-	92		Cylindrical
TECR160B5M-32C16-92R16	●	16	16	5	-	1.6	32	-	92		Cylindrical
TECR160B5M-32W16-92	●	16	16	5	0.4	-	32	-	92		Weldon
TECR160B5M-32W16-92R16	●	16	16	5	-	1.6	32	-	92		Weldon
TECR200B7M-40C20-104	●	20	20	7	0.4	-	40	-	104		Cylindrical
TECR200B7M-40W20-104	●	20	20	7	0.4	-	40	-	104		Weldon

●: Line up

**SHREDMEISTER**  
TECR\*\*B\*MF

4 or 6 flute roughing endmill, 45° helix angle

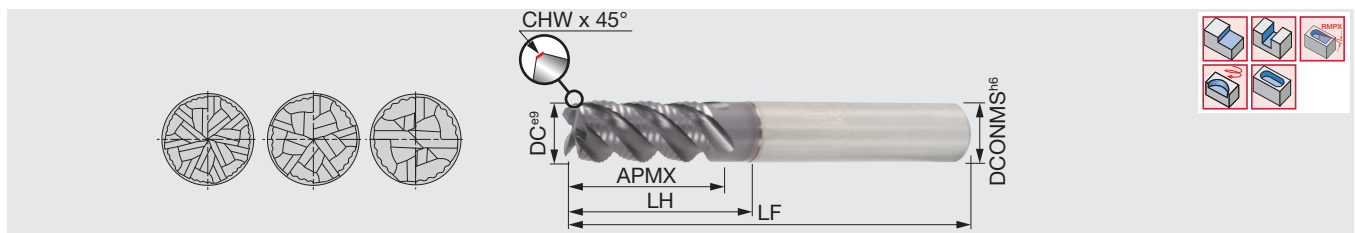


Designation	AH725	DC	DCONMS	NOF	CHW	APMX	LF	Shank
TECR060B4MF-14W06-57	●	6	6	4	0.25	14	57	Weldon
TECR080B4MF-18W08-63	●	8	8	4	0.3	18	63	Weldon
TECR100B4MF-22W10-72	●	10	10	4	0.3	22	72	Weldon
TECR120B4MF-26W12-83	●	12	12	4	0.4	26	83	Weldon
TECR140B4MF-30W14-83	●	14	14	4	0.4	30	83	Weldon
TECR160B6MF-34W16-92	●	16	16	6	0.5	34	92	Weldon
TECR200B6MF-42W20-104	●	20	20	6	0.7	42	104	Weldon
TECR250B6MF-52W25-121	●	25	25	6	0.9	52	121	Weldon

●: Line up

**SHREDMEISTER**  
TECR\*\*B\*L

4-7 flute roughing endmill, 45° helix angle, long neck type (3xD)

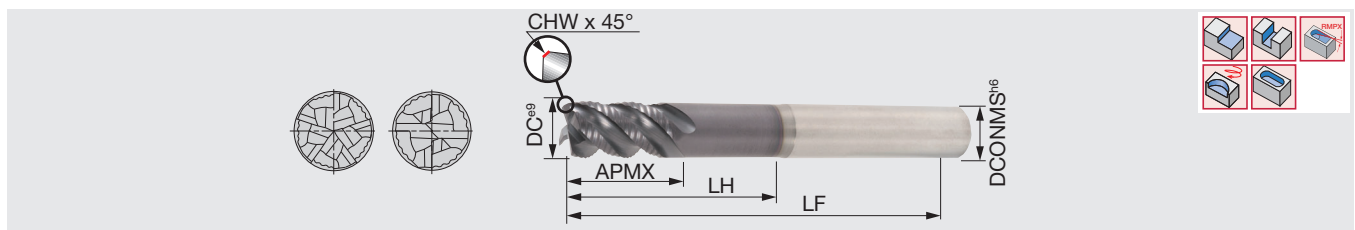


Designation	AH725	DC	DCONMS	NOF	CHW	APMX	LH	LF	Shank
TECR060B4L-12/18W06-57	●	6	6	4	0.25	12	18	57	● Weldon
TECR080B4L-16/24W08-63	●	8	8	4	0.25	16	24	63	● Weldon
TECR100B4L-20/30W10-72	●	10	10	4	0.3	20	30	72	● Weldon
TECR120B4L-24/36W12-83	●	12	12	4	0.35	24	36	83	● Weldon
TECR160B5L-32/48W16-100	●	16	16	5	0.4	32	48	100	Weldon
TECR200B7L-40/60W20-110	●	20	20	7	0.4	40	60	110	Weldon

●: Line up

**TECR\*\*B\*X**

4-5 flute roughing endmill, 45° helix angle, long neck type (4xD)

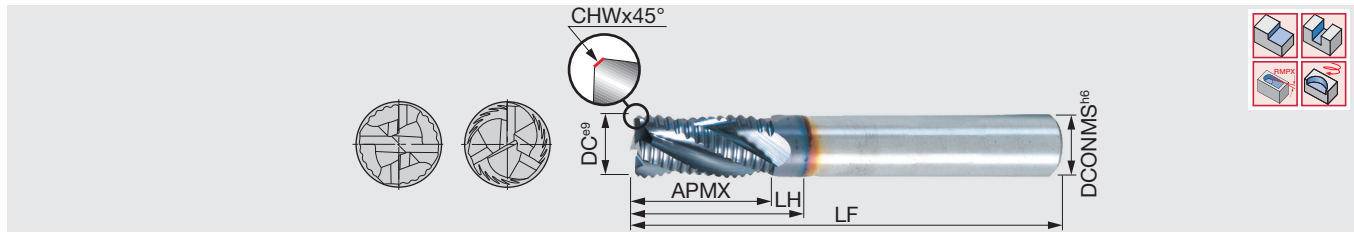


Designation	AH725	DC	DCONMS	NOF	CHW	APMX	LH	LF	Shank
TECR080B4X-12/32W08-68	●	8	8	4	0.25	12	32	68	● Weldon
TECR100B4X-15/40W10-80	●	10	10	4	0.3	15	40	80	● Weldon
TECR120B4X-18/48W12-100	●	12	12	4	0.35	18	48	100	● Weldon
TECR160B5X-24/64W16-115	●	16	16	5	0.4	24	64	115	Weldon

●: Line up

Reference pages: Standard cutting conditions → **I031**

3-4 flute roughing endmill, 30° or 38 helix angle, for alloy steel and stainless steel

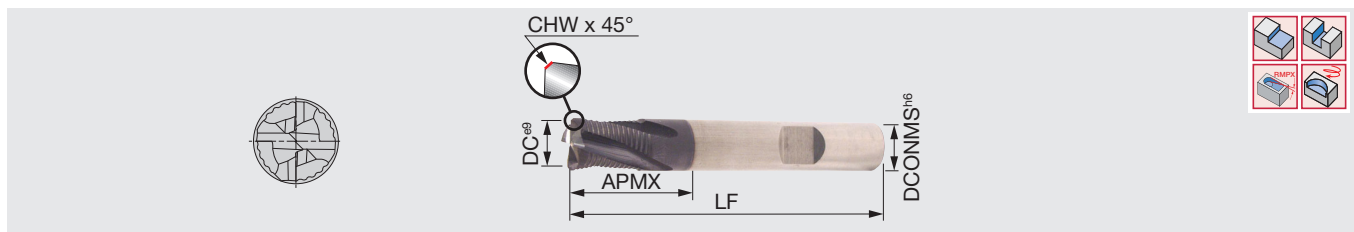


Designation	AH725	DC	DCONMS	NOF	CHW	APMX	LH	LF	FHA	Shank
TERF040E3-08C06-57	●	4	6	3	0.25	8	13	57	38°	Cylindrical
TERF050E3-10C06-57	●	5	6	3	0.3	10	17	57	38°	Cylindrical
TERF060E3-13C06-57	●	6	6	3	0.3	13	21	57	38°	Cylindrical
TERF070E3-20C08-63	●	7	8	3	0.3	20	26	63	38°	Cylindrical
TERF080E3-20C08-63	●	8	8	3	0.3	20	28	63	38°	Cylindrical
TERF090A4-22C10-72	●	9	10	4	0.3	22	30	72	30°	Cylindrical
TERF100A4-22C10-72	●	10	10	4	0.3	22	30	72	30°	Cylindrical
TERF110A4-25C12-83	●	11	12	4	0.3	25	32	83	30°	Cylindrical
TERF120A4-25C12-83	●	12	12	4	0.4	25	37	83	30°	Cylindrical
TERF140A4-25C14-83	●	14	14	4	0.5	25	37	83	30°	Cylindrical
TERF160A4-32C16-92	●	16	16	4	0.5	32	44	92	30°	Cylindrical
TERF180A4-32C18-92	●	18	18	4	0.5	32	44	92	30°	Cylindrical
TERF200A4-38C20-104	●	20	20	4	0.6	38	55	104	30°	Cylindrical

●: Line up

## TECR\*\*T4M

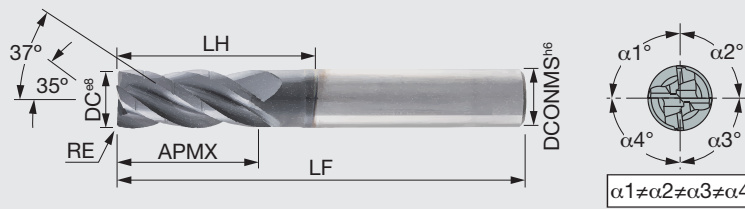
4 flute roughing endmill, 20° helix angle



Designation	AH725	DC	DCONMS	NOF	CHW	APMX	LF	Shank
TECR060T4M-10W06-57	●	6	6	4	0.3	10	57	Weldon
TECR080T4M-16W08-63	●	8	8	4	0.4	16	63	Weldon
TECR100T4M-20W10-72	●	10	10	4	0.4	20	72	Weldon
TECR120T4M-24W12-83	●	12	12	4	0.4	24	83	Weldon
TECR160T4M-32W16-92	●	16	16	4	0.5	32	92	Weldon
TECR200T4M-40W20-104	●	20	20	4	0.5	40	104	Weldon

●: Line up

4 flute roughing endmill, variable helix and variable pitch, with chip splitter, long overhang



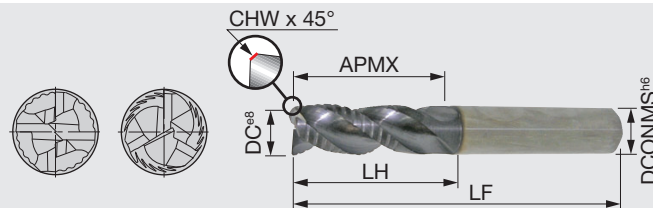
Designation	AH725	DC	DCONMS	NOF	RE	APMX	LH	LF	Shank
TECP060H4L-12/20C6CF-R02	●	6	6	4	0.2	12	20	57	Cylindrical
TECP080H4L-16/26C8CF-R04	●	8	8	4	0.4	16	26	63	Cylindrical
TECP080H4L-16/26W8CF-R04	●	8	8	4	0.4	16	26	63	Weldon
TECP100H4L-20/32C10CF-R05	●	10	10	4	0.5	20	32	72	Cylindrical
TECP100H4L-20/32W10CF-R05	●	10	10	4	0.5	20	32	72	Weldon
TECP120H4L-24/38C12CF-R06	●	12	12	4	0.6	24	38	83	Cylindrical
TECP120H4L-24/38W12CF-R06	●	12	12	4	0.6	24	38	83	Weldon
TECP160H4L-32/50C16CF-R08	●	16	16	4	0.8	32	50	100	Cylindrical
TECP160H4L-32/50W16CF-R08	●	16	16	4	0.8	32	50	100	Weldon
TECP200H4L-40/60C20CF-R10	●	20	20	4	1	40	60	110	Cylindrical
TECP200H4L-40/60W20CF-R10	●	20	20	4	1	40	60	110	Weldon

● : Line up

# SHREDMEISTER

## TECP\*\*E\*L

3 flute roughing endmill, 38° helix angle, with chip splitter



Designation	AH725	DC	DCONMS	NOF	CHW	APMX	LH	LF	Shank
TECP050E3L-12/17W06S57	●	5	6	3	0.3	12	17	57	Weldon
TECP060E3L-14/20W06S57	●	6	6	3	0.4	14	20	57	Weldon
TECP080E3L-18/26W08S63	●	8	8	3	0.4	18	26	63	Weldon
TECP100E3L-22/32W10S72	●	10	10	3	0.4	22	32	72	Weldon
TECP120E3L-26/38W12S83	●	12	12	3	0.4	26	38	83	Weldon
TECP140E3L-30/44W14S100	●	14	14	3	0.6	30	44	100	Weldon
TECP160E3L-34/50W16S100	●	16	16	3	0.5	34	50	100	Weldon
TECP200E3L-42/62W20S125	●	20	20	3	0.5	42	62	125	Weldon

4 flute roughing endmill, 38° helix angle, with chip splitter

Designation	AH725	DC	DCONMS	NOF	CHW	APMX	LH	LF	Shank
TECP050E4L-12/17W06S57	●	5	6	4	0.3	12	17	57	Weldon
TECP060E4L-14/20W06S57	●	6	6	4	0.4	14	20	57	Weldon
TECP080E4L-18/26W08S63	●	8	8	4	0.4	18	26	63	Weldon
TECP100E4L-22/32W10S72	●	10	10	4	0.4	22	32	72	Weldon
TECP120E4L-26/38W12S83	●	12	12	4	0.4	26	38	83	Weldon
TECP140E4L-30/44W14S100	●	14	14	4	0.6	30	44	100	Weldon
TECP160E4L-34/50W16S100	●	16	16	4	0.5	34	50	100	Weldon
TECP200E4L-42/62W20S125	●	20	20	4	0.5	42	62	125	Weldon

● : Line up

Reference pages: Standard cutting conditions → **I031**

# FINISHMEISTER SHREDMEISTER

## STANDARD CUTTING CONDITIONS

### Slotting / Roughing ( $a_e = 0.4 \times D$ or over)

ISO	Material	Vc (m/min)	fz (mm/t)			ap (Slotting)
			ø6 - ø8	ø10 - ø12	ø16 - ø20	
<b>P</b>	Carbon steel	140 - 180	0.035 - 0.055	0.045 - 0.07	0.06 - 0.0825	2xD
	Alloy steel	70 - 150	0.03 - 0.045	0.045 - 0.07	0.06 - 0.0825	2xD
<b>M</b>	Stainless steel	60 - 100	0.03 - 0.055	0.045 - 0.06	0.05 - 0.0675	1xD
<b>K</b>	Cast iron	80 - 180	0.03 - 0.06	0.045 - 0.08	0.06 - 0.09	2xD
<b>N</b>	Aluminium alloy	300 - 750	0.03 - 0.06	0.045 - 0.08	0.04 - 0.105	2xD
<b>S</b>	Titanium alloy	20 - 50	0.03 - 0.045	0.04 - 0.06	0.04 - 0.105	1xD
<b>H</b>	Hardened steel	20 - 30	0.015 - 0.025	0.025 - 0.07	0.06 - 0.075	0.5xD

### Semi-finishing / Shouldering ( $a_e = 0.1 \sim 0.4 \times D$ )

ISO	Material	Vc (m/min)	fz (mm/t)			ap
			ø6 - ø8	ø10 - ø12	ø16 - ø20	
<b>P</b>	Carbon steel	150 - 220	0.045 - 0.09	0.09 - 0.11	0.1 - 0.12	2xD
	Alloy steel	70 - 160	0.03 - 0.075	0.06 - 0.1	0.065 - 0.105	2xD
<b>M</b>	Stainless steel	80 - 130	0.035 - 0.06	0.055 - 0.07	0.06 - 0.075	2xD
<b>K</b>	Cast iron	130 - 220	0.045 - 0.075	0.06 - 0.09	0.09 - 0.105	2xD
<b>N</b>	Aluminium alloy	350 - 850	0.06 - 0.09	0.09 - 0.12	0.12 - 0.15	2xD
<b>S</b>	Titanium alloy	40 - 60	0.045 - 0.06	0.055 - 0.07	0.075 - 0.12	2xD
<b>H</b>	Hardened steel	30 - 70	0.02 - 0.055	0.045 - 0.07	0.06 - 0.09	2xD

### Finishing (feed rate depending on required accuracy) / High feed machining at small width of cut ( $a_e = 0.05 \sim 0.1 \times D$ )

ISO	Material	Vc (m/min)	fz (mm/t)			ap
			ø6 - ø8	ø10 - ø12	ø16 - ø20	
<b>P</b>	Carbon steel	170 - 280	0.075 - 0.11	0.11 - 0.12	0.12 - 0.15	apmax
	Alloy steel	110 - 220	0.075 - 0.11	0.11 - 0.12	0.12 - 0.15	apmax
<b>M</b>	Stainless steel	100 - 160	0.045 - 0.07	0.06 - 0.075	0.065 - 0.09	apmax
<b>K</b>	Cast iron	180 - 280	0.05 - 0.09	0.09 - 0.1	0.09 - 0.12	apmax
<b>N</b>	Aluminium alloy	350 - 900	0.065 - 0.11	0.11 - 0.15	0.15 - 0.22	apmax
<b>S</b>	Titanium alloy	50 - 70	0.055 - 0.075	0.06 - 0.09	0.09 - 0.12	apmax
<b>H</b>	Hardened steel	40 - 80	0.03 - 0.06	0.05 - 0.09	0.075 - 0.105	apmax

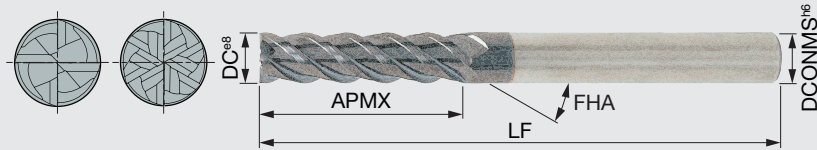
- When the depth of cut ( $a_e$ ) is closer to the upper limit, please start with a lower limit value of cutting speed (Vc).
- While air blow is recommended, water-soluble coolant will be good for stainless steel, titanium alloy, and heat-resistant alloy.
- When chattering occurs with low rigid machines or settings, reduce cutting speed and feed at an equal rate.
- When chattering occurs with long tool overhang, reduce cutting speed and feed by 20 to 40%.



# SOLIDMEISTER

## TECL\*\*B4/6L

4 or 6 flute endmill, 45° helix angle, long neck type



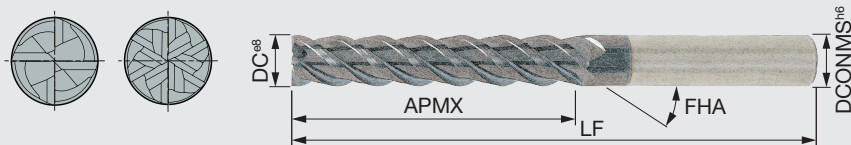
Designation	AH725	DC	DCONMS	NOF	APMX	FHA	LF		Shank
TEC060B4L-24C06-65	●	6	6	4	24	45°	65	●	Cylindrical
TEC060B4L-24W06-65	●	6	6	4	24	45°	65	●	Weldon
TEC080B4L-32C08-79	●	8	8	4	32	45°	79	●	Cylindrical
TEC080B4L-32W08-79	●	8	8	4	32	45°	79	●	Weldon
TEC100B4L-40C10-100	●	10	10	4	40	45°	100	●	Cylindrical
TEC100B4L-40W10-100	●	10	10	4	40	45°	100	●	Weldon
TEC120B4L-48C12-100	●	12	12	4	48	45°	100	●	Cylindrical
TEC120B4L-48W12-100	●	12	12	4	48	45°	100	●	Weldon
TEC140B4L-50C14-100	●	14	14	4	50	45°	100	●	Cylindrical
TEC140B4L-50W14-100	●	14	14	4	50	45°	100	●	Weldon
TEC160B6L-56C16-115	●	16	16	6	56	45°	115		Cylindrical
TEC160B6L-56W16-115	●	16	16	6	56	45°	115		Weldon
TEC200B6L-60C20-125	●	20	20	6	60	45°	125		Cylindrical
TEC200B6L-60W20-125	●	20	20	6	60	45°	125		Weldon

●: Line up

# SOLIDMEISTER

## TECX\*\*B4/6X

4 or 6 flute endmill, 45° helix angle, extra long neck type

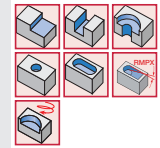
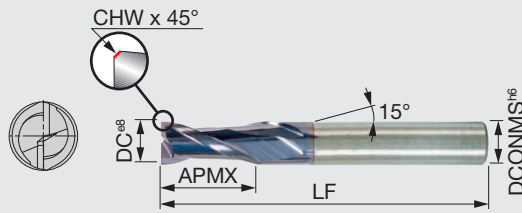


Designation	AH725	DC	DCONMS	NOF	APMX	FHA	LF		Shank
TEC100B4X-60C10-112	●	10	10	4	60	45°	112	●	Cylindrical
TEC100B4X-60W10-112	●	10	10	4	60	45°	112	●	Weldon
TEC120B4X-72C12-150	●	12	12	4	72	45°	150	●	Cylindrical
TEC120B4X-72W12-150	●	12	12	4	72	45°	150	●	Weldon
TEC160B6X-80C16-150	●	16	16	6	80	45°	150		Cylindrical
TEC160B6X-80W16-150	●	16	16	6	80	45°	150		Weldon
TEC200B6X-80C20-150	●	20	20	6	80	45°	150		Cylindrical

●: Line up

Reference pages: Standard cutting conditions → **I051**



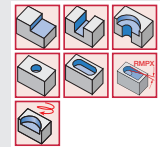
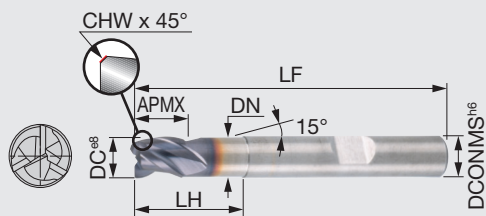


Designation	AH725	DC	DCONMS	NOF	CHW	APMX	LF	FHA	Shank
TECC020B2-07C03-38	●	2	3	2	0.1	7	38	45°	Cylindrical
TECC030A2-10C03-38	●	3	3	2	0.1	10	38	30°	Cylindrical
TECC040A2-12C04-50	●	4	4	2	0.1	12	50	30°	Cylindrical
TECC050A2-14C05-50	●	5	5	2	0.15	14	50	30°	Cylindrical
TECC060A2-16C06-57	●	6	6	2	0.15	16	57	30°	Cylindrical
TECC080A2-20C08-63	●	8	8	2	0.15	20	63	30°	Cylindrical
TECC100A2-22C10-72	●	10	10	2	0.15	22	72	30°	Cylindrical
TECC120A2-25C12-83	●	12	12	2	0.25	25	83	30°	Cylindrical
TECC160A2-32C16-92	●	16	16	2	0.25	32	92	30°	Cylindrical
TECC200A2-38C20-104	●	20	20	2	0.25	38	104	30°	Cylindrical

●: Line up

## TECS/TECCS\*\*E3

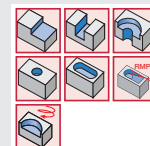
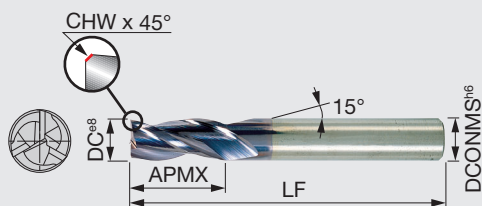
### 3 flute slotting endmill, 38° helix angle, short type



Designation	AH725	DC	DCONMS	NOF	CHW	DN	APMX	LH	LF	Shank
TECS020E3-03W06-57	●	2	6	3	0.1	1.9	3	7	57	Weldon
TECS030E3-04W06-57	●	3	6	3	0.1	2.9	4	10	57	Weldon
TECS040E3-05W06-57	●	4	6	3	0.1	3.9	5	12	57	Weldon
TECS050E3-06W06-57	●	5	6	3	0.15	4.9	6	14	57	Weldon
TECCS060E3-07W06-57	●	6	6	3	0.15	5.9	7	16	57	Weldon
TECCS080E3-09W08-63	●	8	8	3	0.15	7.6	9	20	63	Weldon
TECCS100E3-11W10-72	●	10	10	3	0.15	9.5	11	22	72	Weldon
TECCS120E3-12W12-83	●	12	12	3	0.25	11.3	12	25	83	Weldon
TECCS160E3-16W16-92	●	16	16	3	0.25	15.2	16	32	92	Weldon

●: Line up

3 flute slotting endmill, 38° or 45° helix angle

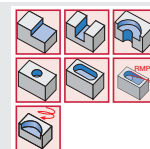
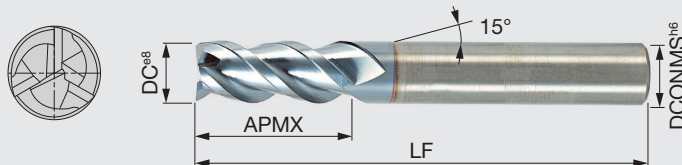


Designation	GH730	AH725	DC	DCONMS	NOF	CHW	APMX	LF	FHA	Shank
TECC020B3-07C03-38	●		2	3	3	0.1	7	38	45°	Cylindrical
TECC030E3-10C03-38	●		3	3	3	0.1	10	38	38°	Cylindrical
TECC040E3-12C04-50		●	4	4	3	0.1	12	50	38°	Cylindrical
TECC050E3-14C05-50		●	5	5	3	0.15	14	50	38°	Cylindrical
TECC060E3-16C06-57		●	6	6	3	0.15	16	57	38°	Cylindrical
TECC080E3-20C08-63		●	8	8	3	0.15	20	63	38°	Cylindrical
TECC100E3-22C10-72		●	10	10	3	0.15	22	72	38°	Cylindrical
TECC120E3-25C12-83		●	12	12	3	0.25	25	83	38°	Cylindrical
TECC160E3-32C16-92		●	16	16	3	0.25	32	92	38°	Cylindrical
TECC200E3-38C20-104		●	20	20	3	0.25	38	104	38°	Cylindrical

●: Line up

**SOLIDMEISTER**  
TEC\*\*B3

3 flute slotting endmill, 45° helix angle



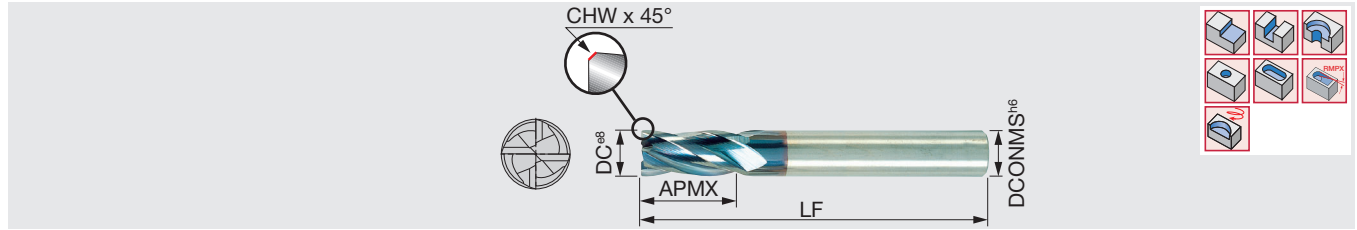
Designation	GH730	AH725	DC	NOF	DCONMS	APMX	LF	Shank
TEC030B3-10C06-57	●		3	3	6	10	57	Cylindrical
TEC040B3-12C06-57	●		4	3	6	12	57	Cylindrical
TEC050B3-14C06-57	●		5	3	6	14	57	Cylindrical
TEC060B3-16C06-57		●	6	3	6	16	57	Cylindrical
TEC070B3-16C07-60	●		7	3	7	16	60	Cylindrical
TEC080B3-20C08-63		●	8	3	8	20	63	Cylindrical
TEC090B3-20C09-67		●	9	3	9	20	67	Cylindrical
TEC100B3-22C10-72		●	10	3	10	22	72	Cylindrical
TEC120B3-25C12-83		●	12	3	12	25	83	Cylindrical
TEC140B3-25C14-75	●		14	3	14	25	75	Cylindrical
TEC180B3-32C18-92		●	18	3	18	32	92	Cylindrical

●: Line up

Reference pages: Standard cutting conditions → I051

## TECC\*\*A/B4

4 flute endmill, 30° or 45° helix angle



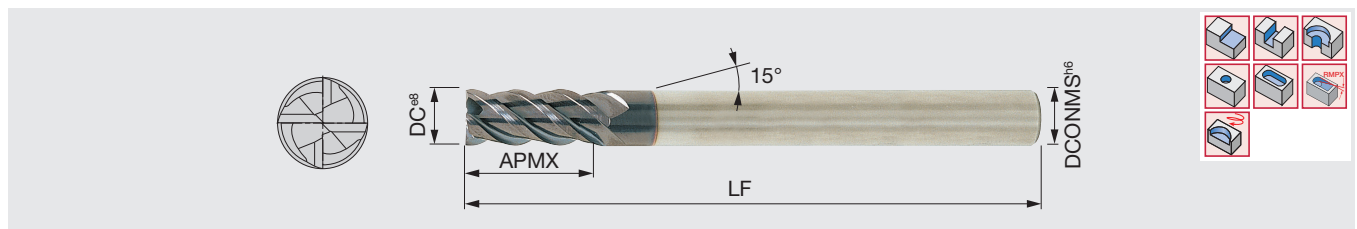
Designation	AH725	DC	DCONMS	NOF	CHW	APMX	LF	FHA	Shank
TECC020B4-07C03-38	●	2	3	4	0.1	7	38	45°	Cylindrical
TECC030A4-10C03-38	●	3	3	4	0.1	10	38	30°	Cylindrical
TECC040A4-12C04-50	●	4	4	4	0.1	12	50	30°	Cylindrical
TECC050A4-14C05-50	●	5	5	4	0.15	14	50	30°	Cylindrical
TECC060A4-16C06-57	●	6	6	4	0.15	16	57	30°	Cylindrical
TECC080A4-20C08-63	●	8	8	4	0.15	20	63	30°	Cylindrical
TECC100A4-22C10-72	●	10	10	4	0.15	22	72	30°	Cylindrical
TECC120A4-25C12-83	●	12	12	4	0.25	25	83	30°	Cylindrical
TECC160A4-32C16-92	●	16	16	4	0.25	32	92	30°	Cylindrical
TECC200A4-38C20-104	●	20	20	4	0.25	38	104	30°	Cylindrical

●: Line up

## SOLIDMEISTER

### TEC\*\*B4

4 flute endmill, 45° helix angle

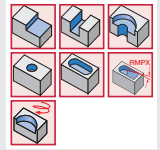
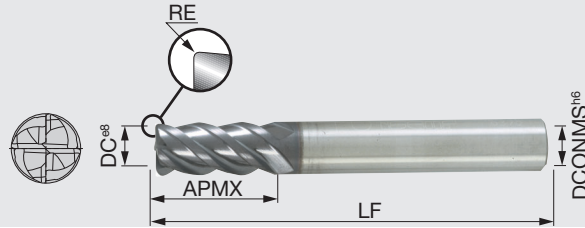


Designation	AH725	DC	DCONMS	NOF	APMX	LF	Shank
TEC020B4-07C06-57	●	2	6	4	7	57	Cylindrical
TEC030B4-10C06-57	●	3	6	4	10	57	Cylindrical
TEC040B4-12C06-57	●	4	6	4	12	57	Cylindrical
TEC050B4-14C06-57	●	5	6	4	14	57	Cylindrical
TEC060B4-16C06-57	●	6	6	4	16	57	Cylindrical
TEC080B4-20C08-63	●	8	8	4	20	63	Cylindrical
TEC100B4-22C10-72	●	10	10	4	22	72	Cylindrical
TEC120B4-25C12-83	●	12	12	4	25	83	Cylindrical
TEC140B4-25C14-83	●	14	14	4	25	83	Cylindrical
TEC160B4-32C16-92	●	16	16	4	32	92	Cylindrical
TEC180B4-32C18-92	●	18	18	4	32	92	Cylindrical
TEC200B4-38C20-104	●	20	20	4	38	104	Cylindrical

●: Line up

Reference pages: Standard cutting conditions → I051

4 flute radius endmill, 45° helix angle

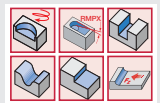
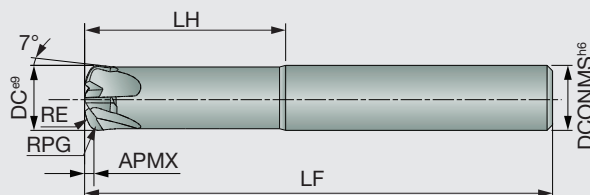


Designation	AH725	DC	DCONMS	NOF	RE	APMX	LF	Shank
TEC060B4-16C06R05-57	●	6	6	4	0.5	16	57	Cylindrical
TEC060B4-16C06R1-57	●	6	6	4	1	16	57	Cylindrical
TEC080B4-20C08R05-63	●	8	8	4	0.5	20	63	Cylindrical
TEC080B4-20C08R1-63	●	8	8	4	1	20	63	Cylindrical
TEC080B4-20C08R15-63	●	8	8	4	1.5	20	63	Cylindrical
TEC080B4-20C08R2-63	●	8	8	4	2	20	63	Cylindrical
TEC100B4-22C10R05-72	●	10	10	4	0.5	22	72	Cylindrical
TEC100B4-22C10R1-72	●	10	10	4	1	22	72	Cylindrical
TEC100B4-22C10R15-72	●	10	10	4	1.5	22	72	Cylindrical
TEC100B4-22C10R2-72	●	10	10	4	2	22	72	Cylindrical
TEC100B4-22C10R3-72	●	10	10	4	3	22	72	Cylindrical
TEC120B4-25C12R05-83	●	12	12	4	0.5	25	83	Cylindrical
TEC120B4-25C12R1-83	●	12	12	4	1	25	83	Cylindrical
TEC120B4-25C12R15-83	●	12	12	4	1.5	25	83	Cylindrical
TEC120B4-25C12R2-83	●	12	12	4	2	25	83	Cylindrical
TEC120B4-25C12R3-83	●	12	12	4	3	25	83	Cylindrical
TEC160B4-32C16R05-92	●	16	16	4	0.5	32	92	Cylindrical
TEC160B4-32C16R1-92	●	16	16	4	1	32	92	Cylindrical
TEC160B4-32C16R2-92	●	16	16	4	2	32	92	Cylindrical
TEC160B4-32C16R3-92	●	16	16	4	3	32	92	Cylindrical
TEC200B4-38C20R05-104	●	20	20	4	0.5	38	104	Cylindrical
TEC200B4-38C20R1-104	●	20	20	4	1	38	104	Cylindrical
TEC200B4-38C20R2-104	●	20	20	4	2	38	104	Cylindrical
TEC200B4-38C20R3-104	●	20	20	4	3	38	104	Cylindrical
TEC200B4-38C20R4-104	●	20	20	4	4	38	104	Cylindrical

●: Line up

**FEEDMEISTER**  
TEFF\*\*N4

4 flute high feed endmill

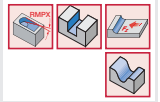
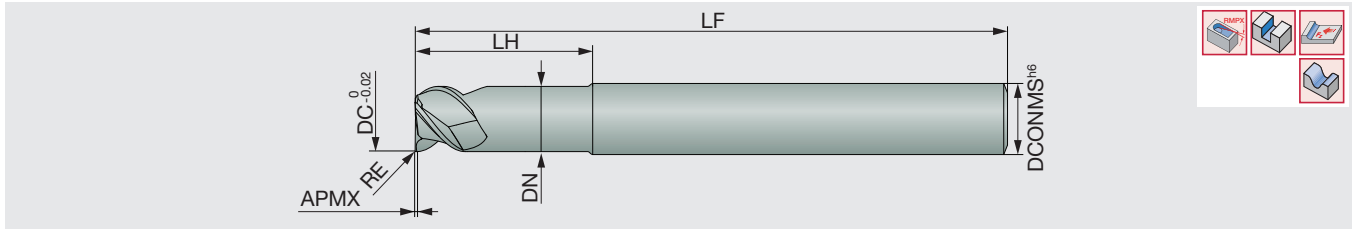


Designation	AH750	DC	DCONMS	NOF	RPG <sup>(1)</sup>	RE	APMX	LH	LF	Max. fz (mm/t)
TEFF060N4-030/20C06R10M	●	6	6	4	1.0	5.3	0.3	20	57	0.3
TEFF080N4-035/26C08R13M	●	8	8	4	1.3	7	0.4	26	63	0.4
TEFF100N4-040/30C10R16M	●	10	10	4	1.6	8.8	0.5	30	72	0.5
TEFF120N4-045/34C12R20M	●	12	12	4	2.0	10.6	0.6	34	83	0.5
TEFF160N4-055/42C16R26M	●	16	16	4	2.6	14	0.8	42	92	0.6
TEFF200N4-060/46C20R32M	●	20	20	4	3.2	17.7	1	46	104	0.7

(1) R0 should be used for programming.

●: Line up

Reference pages: TEC\*\*B4\*\*R: Standard cutting conditions → **I051**TEFF\*\*N4: Standard cutting conditions → **I037**



Designation	FX510	DC	DCONMS	NOF	DN	RE	APMX	LH	LF
TCFF060A3-06/15C6-50	●	6	6	3	5.5	0.42	0.25	15	50
TCFF080A3-08/20C8-57	●	8	8	3	7.5	0.56	0.4	20	57
TCFF100A3-08/25C10-65	●	10	10	3	9.5	0.7	0.5	25	65
TCFF120A3-10/30C12-72	●	12	12	3	11.5	1.1	0.6	30	72
TCFF160A3-12/35C16-83	●	16	16	3	15.5	1.9	0.75	35	83
TCFF200A3-15/40C20-93	●	20	20	3	19.5	2.5	1	40	93

**Caution:**

High speed machining generates heat in the tool and chuck holder. Thermal expansion of the holder will often lead to tool damage. Use an air coolant during machining to cool the tool holder. Milling chucks are recommended for the toolholder to be used. \*Use the above corner radius values for programming.

●: Line up

## STANDARD CUTTING CONDITIONS

### Shape machining (roughing) TEFF\*\*N4...

ISO	Workpiece material	Vc (m/min)	fz (mm/t)		
			ø6 - ø8	ø10 - ø12	ø16 - ø20
<b>P</b>	Carbon steel	140 - 180	0.25 - 0.48	0.35 - 0.67	0.52 - 0.9
	Alloy steel (30-40HRC)	120 - 130	0.2 - 0.28	0.3 - 0.38	0.43 - 0.57
<b>M</b>	Stainless steel	120	0.25 - 0.3	0.35 - 0.43	0.52 - 0.6
<b>K</b>	Cast iron	160 - 180	0.3 - 0.45	0.45 - 0.6	0.6 - 0.8
<b>H</b>	Hardened steel (-49HRC)	100	0.16 - 0.2	0.25 - 0.33	0.4 - 0.48
	Hardened steel (50-60HRC)	60 - 80	0.1 - 0.16	0.16 - 0.3	0.2 - 0.45

- Please be aware that the maximum depth of cut (apmax) and the feed (fz) will depend on each tool diameter.
- While air blow is recommended, water-soluble coolant will be good for stainless steel, titanium alloy, and heat-resistant alloy.
- When chattering occurs with low rigid machines or settings, reduce cutting speed and feed at an equal rate.
- When chattering occurs with long tool overhang, reduce cutting speed and feed by 20 to 40%.

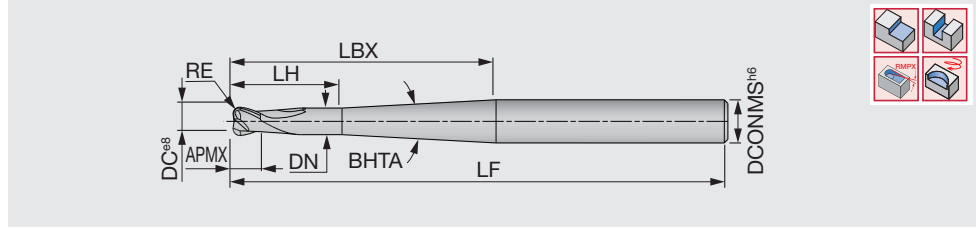
### Shape machining (roughing) TCFF\*\*A3...

ISO	Workpiece material	Vc (m/min)	fz (mm/t)		
			ø6 - ø8	ø10 - ø12	ø16 - ø20
<b>K</b>	Cast iron	250 - 1000	0.1 - 0.15	0.17 - 0.19	0.23 - 0.25
	Nodular cast iron	250 - 1000	0.1 - 0.15	0.17 - 0.19	0.23 - 0.25
	Malleable cast iron	250 - 1000	0.1 - 0.15	0.17 - 0.19	0.23 - 0.25
<b>N</b>	Non-ferrous metal / Graphite	500 - 1500	0.1 - 0.15	0.17 - 0.19	0.23 - 0.25
<b>S</b>	Nickel based alloy	250 - 1000	0.1 - 0.13	0.15 - 0.18	0.20 - 0.22

\*Dry cutting at the cutting speed more than 250m/min is recommended for machining nickel based alloy.



## 2 flute toroidal endmill

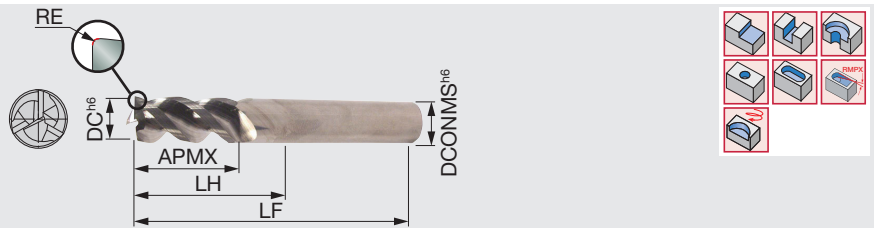


Designation	AH725	DC	DCONMS	NOF	DN	RE	APMX	LH	LBX	BHTA	LF	Shank
TETR020A2-2/08C06R05M80	●	2	6	2	1.9	0.5	2	8	40	3.6°	80	Cylindrical
TETR030A2-2/12C06R05M80	●	3	6	2	2.8	0.5	2	12	40	3.3°	80	Cylindrical
TETR040A2-3/16C06R1M80	●	4	6	2	3.7	1	3	16	40	2.8°	80	Cylindrical
TETR060A2-4/25C08R2M100	●	6	8	2	5.6	2	4	25	66	2.0°	100	Cylindrical

●: Line up

**VARIABLEMEISTER**  
TECA\*\*H3\*\*CF-R

## 3 flute endmill, 39°-41° variable helix, center cutting edge, for aluminium machining



Designation	KS15F	DC	DCONMS	NOF	RE	APMX	LH	LF	Shank
TECA010H3-04C06CF-R.05	●	1	6	3	0.05	4	6	57	Cylindrical
TECA015H3-04/06C06CF-R01	●	1.5	6	3	0.1	4	6	57	Cylindrical
TECA020H3-05/08C06CF-R01	●	2	6	3	0.1	5	8	57	Cylindrical
TECA025H3-05/08C06CF-R01	●	2.5	6	3	0.1	5	8	57	Cylindrical
TECA030H3-07/12C06CF-R01	●	3	6	3	0.1	7	12	57	Cylindrical
TECA040H3-10/16C06CF-R02	●	4	6	3	0.2	10	16	57	Cylindrical
TECA050H3-12/20C06CF-R02	●	5	6	3	0.2	12	20	57	Cylindrical
TECA060H3-09/18C06CF-R02	●	6	6	3	0.2	9	18	57	Cylindrical
TECA060H3-09/18C06CF-R04	●	6	6	3	0.4	9	18	57	Cylindrical
TECA060H3-09/18C06CF-R08	●	6	6	3	0.8	9	18	57	Cylindrical
TECA060H3-09/30C06CF-R02	●	6	6	3	0.2	9	30	65	Cylindrical
TECA060H3-09/30C06CF-R04	●	6	6	3	0.4	9	30	65	Cylindrical
TECA060H3-09/30C06CF-R08	●	6	6	3	0.8	9	30	65	Cylindrical
TECA060H3-14/24C06CF-R02	●	6	6	3	0.2	14	24	60	Cylindrical
TECA080H3-12/24C08CF-R02	●	8	8	3	0.2	12	24	63	Cylindrical
TECA080H3-12/24C08CF-R04	●	8	8	3	0.4	12	24	63	Cylindrical
TECA080H3-12/24C08CF-R08	●	8	8	3	0.8	12	24	63	Cylindrical
TECA080H3-12/24C08CF-R30	●	8	8	3	3	12	24	63	Cylindrical
TECA080H3-12/40C08CF-R02	●	8	8	3	0.2	12	40	79	Cylindrical
TECA080H3-12/40C08CF-R04	●	8	8	3	0.4	12	40	79	Cylindrical
TECA080H3-12/40C08CF-R08	●	8	8	3	0.8	12	40	79	Cylindrical
TECA080H3-18/32C08CF-R02	●	8	8	3	0.2	18	32	68	Cylindrical
TECA100H3-15/30C10CF-R02	●	10	10	3	0.2	15	30	72	Cylindrical
TECA100H3-15/30C10CF-R04	●	10	10	3	0.4	15	30	72	Cylindrical
TECA100H3-15/30C10CF-R08	●	10	10	3	0.8	15	30	72	Cylindrical
TECA100H3-15/30C10CF-R16	●	10	10	3	1.6	15	30	72	Cylindrical
TECA100H3-15/30C10CF-R30	●	10	10	3	3	15	30	72	Cylindrical
TECA100H3-15/50C10CF-R02	●	10	10	3	0.2	15	50	92	Cylindrical
TECA100H3-15/50C10CF-R04	●	10	10	3	0.4	15	50	92	Cylindrical
TECA100H3-15/50C10CF-R08	●	10	10	3	0.8	15	50	92	Cylindrical
TECA100H3-15/50C10CF-R16	●	10	10	3	1.6	15	50	92	Cylindrical

●: Line up

Reference pages: Standard cutting conditions → I051

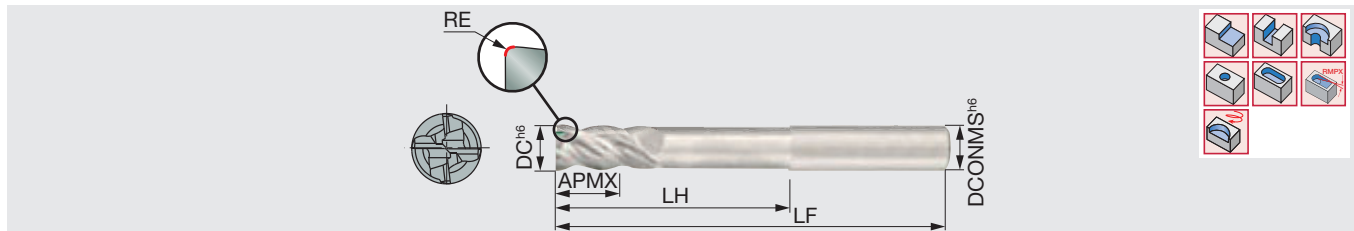
Designation	KS15F	DC	DCONMS	NOF	RE	APMX	LH	LF	Shank	Grade
TECA100H3-15/50C10CF-R20	●	10	10	3	2	15	50	92	Cylindrical	A
TECA100H3-15/50C10CF-R30	●	10	10	3	3	15	50	92	Cylindrical	A
TECA100H3-22/40C10CF-R02	●	10	10	3	0.2	22	40	80	Cylindrical	B
TECA100H3-22/40C10CF-R30	●	10	10	3	3	22	40	80	Cylindrical	B
TECA120H3-18/36C12CF-R02	●	12	12	3	0.2	18	36	83	Cylindrical	B
TECA120H3-18/36C12CF-R04	●	12	12	3	0.4	18	36	83	Cylindrical	B
TECA120H3-18/36C12CF-R08	●	12	12	3	0.8	18	36	83	Cylindrical	B
TECA120H3-18/36C12CF-R16	●	12	12	3	1.6	18	36	83	Cylindrical	B
TECA120H3-18/36C12CF-R20	●	12	12	3	2	18	36	83	Cylindrical	B
TECA120H3-18/36C12CF-R25	●	12	12	3	2.5	18	36	83	Cylindrical	B
TECA120H3-18/36C12CF-R30	●	12	12	3	3	18	36	57	Cylindrical	B
TECA120H3-18/60C12CF-R02	●	12	12	3	0.2	18	60	100	Cylindrical	C
TECA120H3-18/60C12CF-R04	●	12	12	3	0.4	18	60	100	Cylindrical	C
TECA120H3-18/60C12CF-R08	●	12	12	3	0.8	18	60	100	Cylindrical	C
TECA120H3-18/60C12CF-R16	●	12	12	3	1.6	18	60	100	Cylindrical	C
TECA120H3-18/60C12CF-R20	●	12	12	3	2	18	60	100	Cylindrical	C
TECA120H3-18/60C12CF-R25	●	12	12	3	2.5	18	60	100	Cylindrical	C
TECA120H3-18/60C12CF-R30	●	12	12	3	3	18	60	100	Cylindrical	C
TECA160H3-24/48C16CF-R02	●	16	16	3	0.2	24	48	92	Cylindrical	D
TECA160H3-24/48C16CF-R04	●	16	16	3	0.4	24	48	92	Cylindrical	D
TECA160H3-24/48C16CF-R08	●	16	16	3	0.8	24	48	92	Cylindrical	D
TECA160H3-24/48C16CF-R16	●	16	16	3	1.6	24	48	92	Cylindrical	D
TECA160H3-24/48C16CF-R20	●	16	16	3	2	24	48	92	Cylindrical	D
TECA160H3-24/48C16CF-R25	●	16	16	3	2.5	24	48	92	Cylindrical	D
TECA160H3-24/48C16CF-R30	●	16	16	3	3	24	48	92	Cylindrical	D
TECA160H3-24/48C16CF-R32	●	16	16	3	3.2	24	48	92	Cylindrical	D
TECA160H3-24/48C16CF-R40	●	16	16	3	4	24	48	92	Cylindrical	D
TECA160H3-24/48C16CF-R50	●	16	16	3	5	24	48	92	Cylindrical	D
TECA160H3-24/80C16CF-R02	●	16	16	3	0.2	24	80	128	Cylindrical	E
TECA160H3-24/80C16CF-R04	●	16	16	3	0.4	24	80	128	Cylindrical	E
TECA160H3-24/80C16CF-R08	●	16	16	3	0.8	24	80	128	Cylindrical	E
TECA160H3-24/80C16CF-R16	●	16	16	3	1.6	24	80	128	Cylindrical	E
TECA160H3-24/80C16CF-R20	●	16	16	3	2	24	80	128	Cylindrical	E
TECA160H3-24/80C16CF-R25	●	16	16	3	2.5	24	80	128	Cylindrical	E
TECA160H3-24/80C16CF-R30	●	16	16	3	3	24	80	128	Cylindrical	E
TECA160H3-24/80C16CF-R32	●	16	16	3	3.2	24	80	128	Cylindrical	E
TECA160H3-24/80C16CF-R40	●	16	16	3	4	24	80	128	Cylindrical	E
TECA160H3-24/80C16CF-R50	●	16	16	3	5	24	80	128	Cylindrical	E
TECA160H3-34/64C16CF-R02	●	16	16	3	0.2	34	64	115	Cylindrical	F
TECA200H3-30/100C20CF-R02	●	20	20	3	0.2	30	100	150	Cylindrical	F
TECA200H3-30/100C20CF-R04	●	20	20	3	0.4	30	100	150	Cylindrical	F
TECA200H3-30/100C20CF-R08	●	20	20	3	0.8	30	100	150	Cylindrical	F
TECA200H3-30/100C20CF-R32	●	20	20	3	3.2	30	100	150	Cylindrical	F
TECA200H3-30/100C20CF-R40	●	20	20	3	4	30	100	150	Cylindrical	F
TECA200H3-30/100C20CF-R50	●	20	20	3	5	30	100	150	Cylindrical	F
TECA200H3-30/60C20CF-R02	●	20	20	3	0.2	30	60	110	Cylindrical	G
TECA200H3-30/60C20CF-R04	●	20	20	3	0.4	30	60	110	Cylindrical	G
TECA200H3-30/60C20CF-R08	●	20	20	3	0.8	30	60	110	Cylindrical	G
TECA200H3-30/60C20CF-R16	●	20	20	3	1.6	30	60	110	Cylindrical	G
TECA200H3-30/60C20CF-R20	●	20	20	3	2	30	60	110	Cylindrical	G
TECA200H3-30/60C20CF-R32	●	20	20	3	3.2	30	60	110	Cylindrical	G
TECA200H3-30/60C20CF-R40	●	20	20	3	4	30	60	110	Cylindrical	G
TECA200H3-30/60C20CF-R50	●	20	20	3	5	30	60	110	Cylindrical	G
TECA200H3-42/80C20CF-R02	●	20	20	3	0.2	42	80	130	Cylindrical	H
TECA250H3-38/125C25CF-R02	●	25	25	3	0.2	38	125	185	Cylindrical	H
TECA250H3-38/125C25CF-R08	●	25	25	3	0.8	38	125	185	Cylindrical	H
TECA250H3-38/125C25CF-R16	●	25	25	3	1.6	38	125	185	Cylindrical	H
TECA250H3-38/125C25CF-R20	●	25	25	3	2	38	125	185	Cylindrical	H
TECA250H3-38/125C25CF-R40	●	25	25	3	4	38	125	185	Cylindrical	H
TECA250H3-38/125C25CF-R50	●	25	25	3	5	38	125	185	Cylindrical	H
TECA250H3-38/75C25CF-R02	●	25	25	3	0.2	38	75	130	Cylindrical	I
TECA250H3-38/75C25CF-R04	●	25	25	3	0.4	38	75	130	Cylindrical	I
TECA250H3-38/75C25CF-R16	●	25	25	3	1.6	38	75	130	Cylindrical	I
TECA250H3-38/75C25CF-R20	●	25	25	3	2	38	75	130	Cylindrical	I
TECA250H3-38/75C25CF-R32	●	25	25	3	3.2	38	75	130	Cylindrical	I
TECA250H3-38/75C25CF-R50	●	25	25	3	5	38	75	130	Cylindrical	I
TECA250H3-52/100C25CF-R02	●	25	25	3	0.2	52	100	156	Cylindrical	J

●: Line up

Reference pages: Standard cutting conditions → I051

**SOLIDMEISTER VARIABLEMEISTER**  
TECA\*\*H4\*\*CF-R

4 flute endmill, variable helix and variable pitch, relieved neck type, for aluminium machining (1.5xD, 2xD)

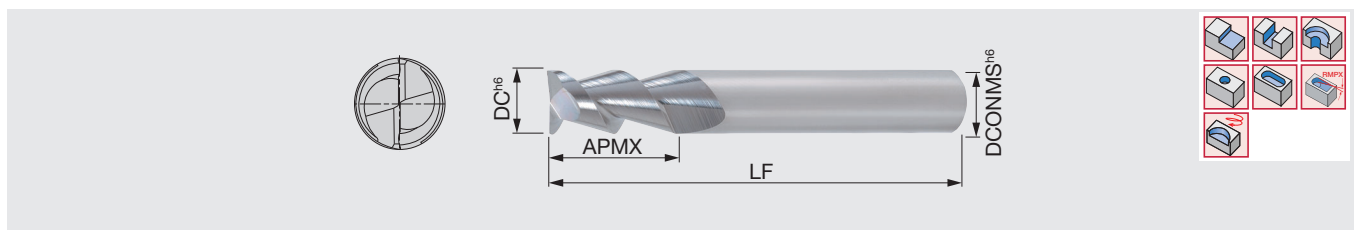


Designation	KS15F	DC	DCONMS	NOF	RE	APMX	LH	LF	Shank
TECA060H4-09/30C06CF-R02	●	6	6	4	0.2	9	30	65	Cylindrical
TECA060H4-12/18C06CF-R02	●	6	6	4	0.2	12	18	57	Cylindrical
TECA080H4-12/40C08CF-R02	●	8	8	4	0.2	12	40	79	Cylindrical
TECA080H4-16/24C08CF-R02	●	8	8	4	0.2	16	24	63	Cylindrical
TECA100H4-15/50C10CF-R02	●	10	10	4	0.2	15	50	92	Cylindrical
TECA100H4-20/30C10CF-R02	●	10	10	4	0.2	20	30	72	Cylindrical
TECA120H4-18/60C12CF-R02	●	12	12	4	0.2	18	60	100	Cylindrical
TECA120H4-24/36C12CF-R02	●	12	12	4	0.2	24	36	83	Cylindrical
TECA160H4-24/80C16CF-R02	●	16	16	4	0.2	24	80	128	Cylindrical
TECA160H4-32/48C16CF-R02	●	16	16	4	0.2	32	48	100	Cylindrical

●: Line up

**TECA\*\*B2**

2 flute slotting endmill, 45° helix angle, for aluminium machining



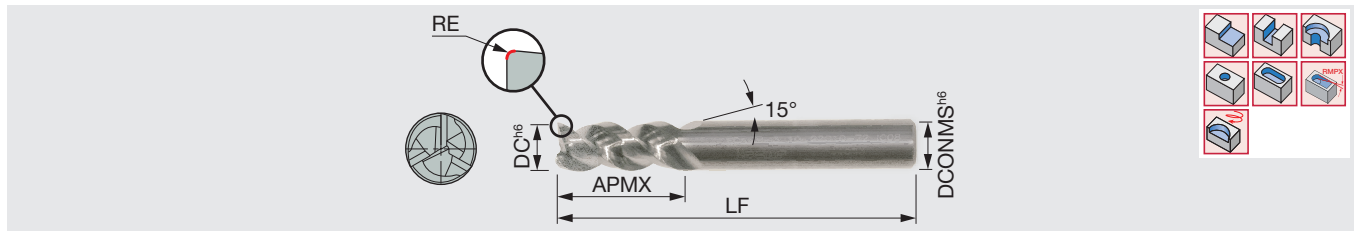
Designation	KS15F	DC	DCONMS	NOF	APMX	LF	Shank
TECA040B2-12C06-57	●	4	6	2	12	57	Cylindrical
TECA050B2-14C06-57	●	5	6	2	14	57	Cylindrical
TECA060B2-16C06-57	●	6	6	2	16	57	Cylindrical
TECA080B2-20C08-63	●	8	8	2	20	63	Cylindrical
TECA100B2-22C10-72	●	10	10	2	22	72	Cylindrical
TECA120B2-25C12-83	●	12	12	2	25	83	Cylindrical
TECA160B2-32C16-92	●	16	16	2	32	92	Cylindrical
TECA200B2-38C20-104	●	20	20	2	38	104	Cylindrical

●: Line up

Reference pages: Standard cutting conditions → **I051**



3 flute endmill, 45° helix angle, for aluminium machining



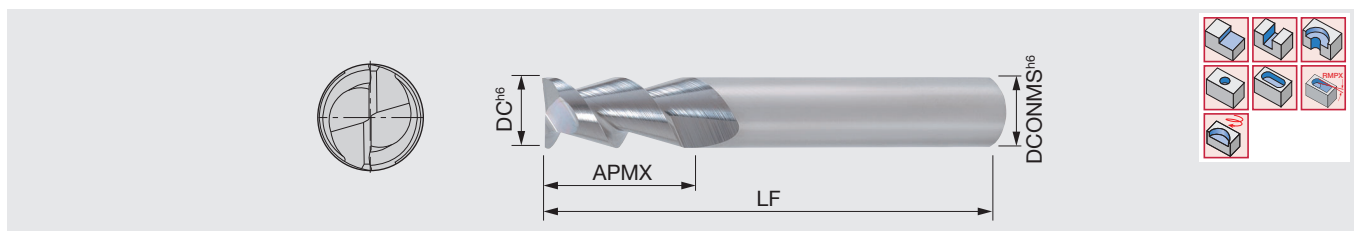
Designation	KS15F	DC	DCONMS	NOF	RE	APMX	LF	Shank
TECA040B3-12C06-57	●	4	6	3	0.1	12	57	Cylindrical
TECA040B3-12W06-57	●	4	6	3	0.1	12	57	Weldon
TECA050B3-14C06-57	●	5	6	3	0.2	14	57	Cylindrical
TECA050B3-14W06-57	●	5	6	3	0.2	14	57	Weldon
TECA060B3-16C06-57	●	6	6	3	0.2	16	57	Cylindrical
TECA060B3-16W06-57	●	6	6	3	0.2	16	57	Weldon
TECA080B3-20C08-63	●	8	8	3	0.2	20	63	Cylindrical
TECA080B3-20C08R30-63	●	8	8	3	3	20	63	Cylindrical
TECA080B3-20W08-63	●	8	8	3	0.2	20	63	Weldon
TECA100B3-22C10-72	●	10	10	3	0.2	22	72	Cylindrical
TECA100B3-22W10-72	●	10	10	3	0.2	22	72	Weldon
TECA100B3-25C10R30-72	●	10	10	3	3	25	72	Cylindrical
TECA100B3-25C10R40-72	●	10	10	3	4	25	72	Cylindrical
TECA120B3-25C12-83	●	12	12	3	0.2	25	83	Cylindrical
TECA120B3-25W12-83	●	12	12	3	0.2	25	83	Weldon
TECA120B3-30C12R30-83	●	12	12	3	3	30	83	Cylindrical
TECA120B3-30C12R40-83	●	12	12	3	4	30	83	Cylindrical
TECA140B3-30C14-83	●	14	14	3	0.2	30	83	Cylindrical
TECA140B3-30W14-83	●	14	14	3	0.2	30	83	Weldon
TECA160B3-32C16-92	●	16	16	3	0.2	32	92	Cylindrical
TECA160B3-32W16-92	●	16	16	3	0.2	32	92	Weldon
TECA200B3-38C20-104	●	20	20	3	0.2	38	104	Cylindrical
TECA200B3-38W20-104	●	20	20	3	0.2	38	104	Weldon

●: Line up

# SOLIDMEISTER

## TECA\*\*F2

2 flute slotting endmill, 55° helix angle, for aluminium machining



Designation	KS15F	DC	DCONMS	NOF	APMX	LF	Shank
TECA040F2-11C04-50	●	4	4	2	11	50	Cylindrical
TECA060F2-13C06-57	●	6	6	2	13	57	Cylindrical
TECA080F2-20C08-63	●	8	8	2	20	63	Cylindrical
TECA100F2-22C10-72	●	10	10	2	22	72	Cylindrical
TECA120F2-25C12-83	●	12	12	2	25	83	Cylindrical
TECA160F2-32C16-92	●	16	16	2	32	92	Cylindrical
TECA200F2-38C20-104	●	20	20	2	38	104	Cylindrical
TECA250F2-45C25-121	●	25	25	2	45	121	Cylindrical

●: Line up

Reference pages: Standard cutting conditions → **I051**

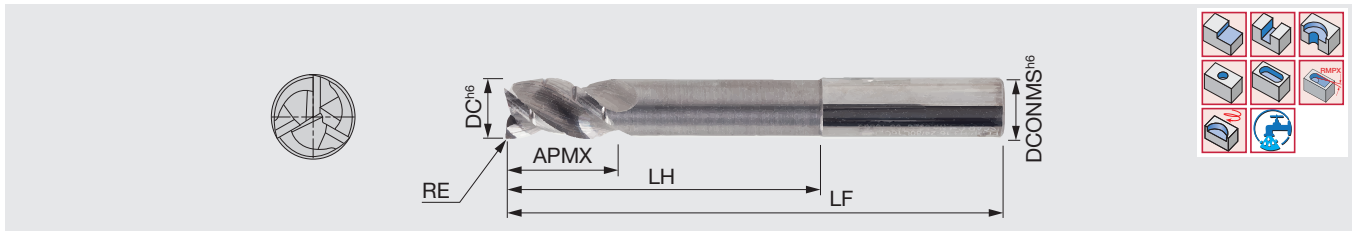
Grade  
Insert  
Toolholder  
Ext. Toolholder  
Int. Toolholder  
Threading  
Grooving  
Miniature tool  
Milling cutter  
Endmill  
Drilling tool  
Tooling System  
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**VARIABLEMEISTER SHREDMEISTER**

TEAP\*\*H3\*\*CFR\*\*C

3 flute endmill, variable helix, with chip splitter, relieved neck type, for aluminium machining



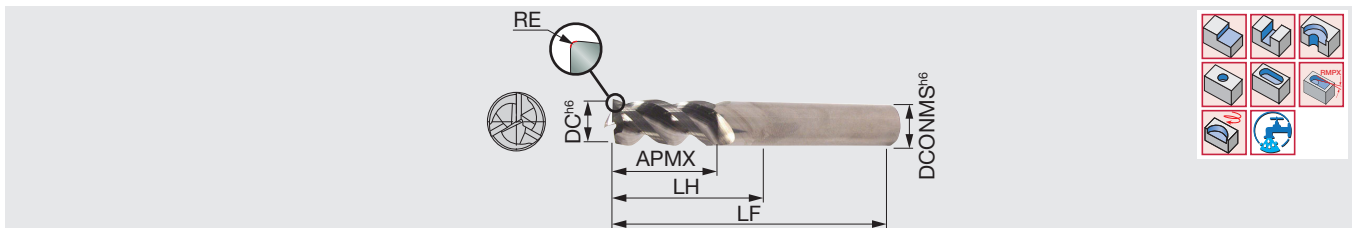
Designation	KS15F	DC	DCONMS	NOF	RE	APMX	LH	LF	Coolant hole	Shank
TEAP100H3-15/50C10CFR02C	●	10	10	3	0.2	15	50	92	With	Cylindrical
TEAP100H3-22/40C10CFR02C	●	10	10	3	0.2	22	40	80	With	Cylindrical
TEAP120H3-18/60C12CFR02C	●	12	12	3	0.2	18	60	100	With	Cylindrical
TEAP120H3-26/48C12CFR02C	●	12	12	3	0.2	26	48	93	With	Cylindrical
TEAP160H3-24/80C16CFR02C	●	16	16	3	0.2	24	80	128	With	Cylindrical
TEAP160H3-34/64C16CFR02C	●	16	16	3	0.2	34	64	115	With	Cylindrical
TEAP200H3-42/80C20CFR02C	●	20	20	3	0.2	42	80	130	With	Cylindrical
TEAP200H3-30/100C20CFR02C	●	20	20	3	0.2	30	100	150	With	Cylindrical

●: Line up

**VARIABLEMEISTER**

TECA\*\*H3\*\*CFR\*\*C

3 flute endmill, variable helix, center cutting edge, for aluminium machining

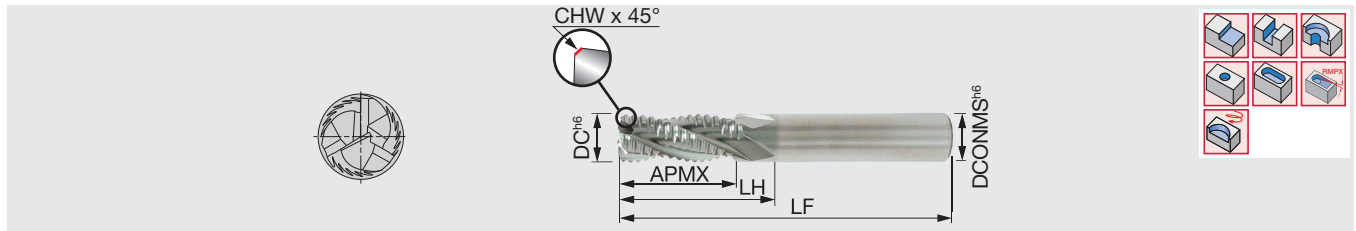


Designation	KS15F	DC	DCONMS	NOF	RE	APMX	LH	LF	Coolant hole	Shank
TECA060H3-12/18C06CF-R02C	●	6	6	3	0.2	12	18	57	With	Cylindrical
TECA060H3-12/30C06CF-R02C	●	6	6	3	0.2	12	30	65	With	Cylindrical
TECA080H3-16/24C08CF-R02C	●	8	8	3	0.2	16	24	63	With	Cylindrical
TECA080H3-16/40C08CF-R02C	●	8	8	3	0.2	16	40	79	With	Cylindrical
TECA100H3-20/30C10CF-R02C	●	10	10	3	0.2	20	30	72	With	Cylindrical
TECA100H3-20/50C10CF-R02C	●	10	10	3	0.2	20	50	100	With	Cylindrical
TECA120H3-24/36C12CF-R02C	●	12	12	3	0.2	24	36	83	With	Cylindrical
TECA120H3-24/60C12CF-R02C	●	12	12	3	0.2	24	60	100	With	Cylindrical
TECA160H3-32/48C16CF-R02C	●	16	16	3	0.2	32	48	92	With	Cylindrical
TECA160H3-32/80C16CF-R02C	●	16	16	3	0.2	32	80	128	With	Cylindrical
TECA250H3-50/75C25CF-R02C	●	25	25	3	0.2	50	75	130	With	Cylindrical

●: Line up

Reference pages: Standard cutting conditions → I051

3 flute roughing endmill, 38° helix angle, for aluminium alloy and non-ferrous metal



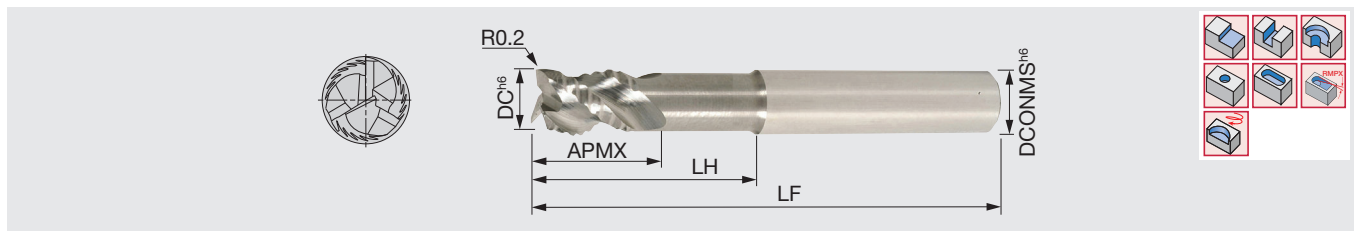
Designation	KS15F	DC	DCONMS	NOF	CHW	APMX	LH	LF	Shank
TERC060E3-13C06-57	●	6	6	3	0.5	13	21	57	Cylindrical
TERC080E3-20C08-63	●	8	8	3	0.5	20	28	63	Cylindrical
TERC100E3-22C10-72	●	10	10	3	0.6	22	30	72	Cylindrical
TERC120E3-25C12-83	●	12	12	3	0.6	25	37	83	Cylindrical
TERC140E3-25C14-83	●	14	14	3	0.6	25	37	83	Cylindrical
TERC160E3-32C16-92	●	16	16	3	0.6	32	44	92	Cylindrical
TERC200E3-38C20-104	●	20	20	3	0.7	38	55	104	Cylindrical
TERC250E3-45C25-121	●	25	25	3	0.7	45	64	121	Cylindrical

●: Line up

# SHREDMEISTER

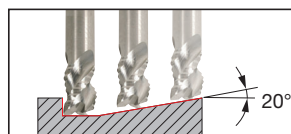
## TECR\*\*B3\*\*R

3 flute roughing endmill, 45° helix angle, relieved neck type, for aluminium machining



Designation	KS15F	DC	DCONMS	NOF	APMX	LH	LF	Shank
TECR060B3-09/21C06R02A57	●	6	6	3	9	21	57	Cylindrical
TECR060B3-09/21W06R02A57	●	6	6	3	9	21	57	Weldon
TECR060B3-09/30C06R02A65	●	6	6	3	9	30	65	Cylindrical
TECR060B3-09/30W06R02A65	●	6	6	3	9	30	65	Weldon
TECR080B3-12/27C08R02A63	●	8	8	3	12	27	63	Cylindrical
TECR080B3-12/27W08R02A63	●	8	8	3	12	27	63	Weldon
TECR080B3-12/40C08R02A78	●	8	8	3	12	40	78	Cylindrical
TECR080B3-12/40W08R02A78	●	8	8	3	12	40	78	Weldon
TECR100B3-12/31C10R02A72	●	10	10	3	12	31	72	Cylindrical
TECR100B3-12/31W10R02A72	●	10	10	3	12	31	72	Weldon
TECR100B3-12/50C10R02A100	●	10	10	3	12	50	100	Cylindrical
TECR100B3-12/50W10R02A100	●	10	10	3	12	50	100	Weldon
TECR120B3-12/37C12R02A83	●	12	12	3	12	37	83	Cylindrical
TECR120B3-12/37W12R02A83	●	12	12	3	12	37	83	Weldon
TECR120B3-14/55C12R02A100	●	12	12	3	14	55	100	Cylindrical
TECR120B3-14/55W12R02A100	●	12	12	3	14	55	100	Weldon
TECR160B3-14/43C16R02A92	●	16	16	3	14	43	92	Cylindrical
TECR160B3-14/43W16R02A92	●	16	16	3	14	43	92	Weldon
TECR160B3-18/80C16R02A150	●	16	16	3	18	80	150	Cylindrical
TECR160B3-18/80W16R02A150	●	16	16	3	18	80	150	Weldon
TECR200B3-17/53C20R02A104	●	20	20	3	17	53	104	Cylindrical
TECR200B3-17/53W20R02A104	●	20	20	3	17	53	104	Weldon
TECR200B3-22/80C20R02A150	●	20	20	3	22	80	150	Cylindrical
TECR200B3-22/80W20R02A150	●	20	20	3	22	80	150	Weldon

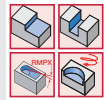
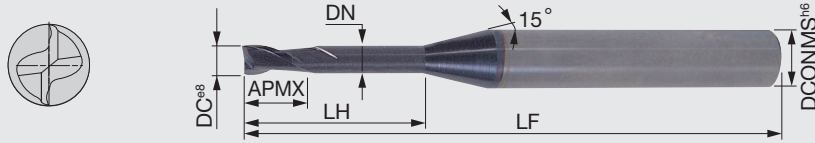
●: Line up



Rampdown angle

Reference pages: Standard cutting conditions → I051

2 flute rib processing endmill, 30° helix angle, for hardened steel up to 55 HRC



Designation	AH750	DC	DCONMS	NOF	DN	APMX	LH	LF	Shank
TEC004A2-006/02C4M45	●	0.4	4	2	0.37	0.6	2	45	Cylindrical
TEC004A2-006/04C4M45	●	0.4	4	2	0.37	0.6	4	45	Cylindrical
TEC005A2-007/02C4M45	●	0.5	4	2	0.45	0.7	2	45	Cylindrical
TEC005A2-007/04C4M45	●	0.5	4	2	0.45	0.7	4	45	Cylindrical
TEC005A2-007/06C4M45	●	0.5	4	2	0.45	0.7	6	45	Cylindrical
TEC006A2-009/02C4M45	●	0.6	4	2	0.55	0.9	2	45	Cylindrical
TEC006A2-009/04C4M45	●	0.6	4	2	0.55	0.9	4	45	Cylindrical
TEC006A2-009/06C4M45	●	0.6	4	2	0.55	0.9	6	45	Cylindrical
TEC007A2-010/02C4M45	●	0.7	4	2	0.65	1	2	45	Cylindrical
TEC008A2-012/04C4M45	●	0.8	4	2	0.75	1.2	4	45	Cylindrical
TEC008A2-012/06C4M45	●	0.8	4	2	0.75	1.2	6	45	Cylindrical
TEC008A2-012/08C4M45	●	0.8	4	2	0.75	1.2	8	45	Cylindrical
TEC009A2-0135/06C4M45	●	0.9	4	2	0.85	1.35	6	45	Cylindrical
TEC009A2-0135/08C4M45	●	0.9	4	2	0.85	1.35	8	45	Cylindrical
TEC009A2-0135/10C4M45	●	0.9	4	2	0.85	1.35	10	45	Cylindrical
TEC010A2-015/04C4M45	●	1	4	2	0.97	1.5	4	45	Cylindrical
TEC010A2-015/06C4M45	●	1	4	2	0.97	1.5	6	45	Cylindrical
TEC010A2-015/08C4M45	●	1	4	2	0.95	1.5	8	45	Cylindrical
TEC010A2-015/10C4M45	●	1	4	2	0.95	1.5	10	45	Cylindrical
TEC010A2-015/12C4M45	●	1	4	2	0.93	1.5	12	45	Cylindrical
TEC010A2-015/16C4M50	●	1	4	2	0.93	1.5	16	50	Cylindrical
TEC012A2-018/06C4M45	●	1.2	4	2	1.17	1.8	6	45	Cylindrical
TEC012A2-018/08C4M45	●	1.2	4	2	1.15	1.8	8	45	Cylindrical
TEC012A2-018/10C4M45	●	1.2	4	2	1.15	1.8	10	45	Cylindrical
TEC012A2-018/16C4M50	●	1.2	4	2	1.13	1.8	16	50	Cylindrical
TEC014A2-021/06C4M45	●	1.4	4	2	1.35	2.1	6	45	Cylindrical
TEC014A2-021/08C4M45	●	1.4	4	2	1.35	2.1	8	45	Cylindrical
TEC014A2-021/10C4M45	●	1.4	4	2	1.35	2.1	10	45	Cylindrical
TEC015A2-023/06C4M45	●	1.5	4	2	1.47	2.3	6	45	Cylindrical
TEC015A2-023/08C4M45	●	1.5	4	2	1.45	2.3	8	45	Cylindrical
TEC015A2-023/10C4M45	●	1.5	4	2	1.45	2.3	10	45	Cylindrical
TEC015A2-023/12C4M45	●	1.5	4	2	1.43	2.3	12	45	Cylindrical
TEC015A2-023/16C4M50	●	1.5	4	2	1.41	2.3	16	50	Cylindrical
TEC015A2-023/18C4M55	●	1.5	4	2	1.41	2.3	18	55	Cylindrical
TEC015A2-023/20C4M55	●	1.5	4	2	1.41	2.3	20	55	Cylindrical
TEC016A2-024/06C4M45	●	1.6	4	2	1.57	2.4	6	45	Cylindrical
TEC016A2-024/08C4M45	●	1.6	4	2	1.55	2.4	8	45	Cylindrical
TEC016A2-024/10C4M45	●	1.6	4	2	1.55	2.4	10	45	Cylindrical
TEC016A2-024/18C4M55	●	1.6	4	2	1.53	2.4	18	55	Cylindrical
TEC016A2-024/20C4M55	●	1.6	4	2	1.53	2.4	20	55	Cylindrical
TEC016A2-024/26C4M60	●	1.6	4	2	1.53	2.4	26	60	Cylindrical
TEC018A2-027/06C4M45	●	1.8	4	2	1.77	2.7	6	45	Cylindrical
TEC018A2-027/08C4M45	●	1.8	4	2	1.75	2.7	8	45	Cylindrical
TEC018A2-027/10C4M45	●	1.8	4	2	1.75	2.7	10	45	Cylindrical
TEC018A2-027/12C4M45	●	1.8	4	2	1.73	2.7	12	45	Cylindrical
TEC020A2-030/06C4M45	●	2	4	2	1.97	3	6	45	Cylindrical
TEC020A2-030/08C4M45	●	2	4	2	1.95	3	8	45	Cylindrical
TEC020A2-030/10C4M45	●	2	4	2	1.95	3	10	45	Cylindrical
TEC020A2-030/12C4M45	●	2	4	2	1.93	3	12	45	Cylindrical
TEC020A2-030/16C4M50	●	2	4	2	1.91	3	16	50	Cylindrical

●: Line up

Reference pages: Standard cutting conditions → **I051**

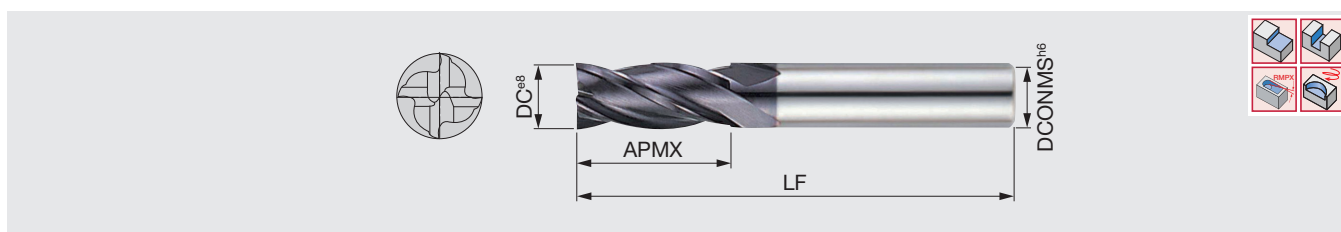
Designation	AH750	DC	DCONMS	NOF	DN	APMX	LH	LF	Shank
TEC020A2-030/20C4M55	●	2	4	2	1.89	3	20	55	Cylindrical
TEC020A2-030/30C4M70	●	2	4	2	1.89	3	30	70	Cylindrical
TEC025A2-037/08C4M45	●	2.5	4	2	2.4	3.7	8	45	Cylindrical
TEC025A2-037/10C4M45	●	2.5	4	2	2.4	3.7	10	45	Cylindrical
TEC025A2-037/12C4M45	●	2.5	4	2	2.4	3.7	12	45	Cylindrical
TEC025A2-037/16C4M55	●	2.5	4	2	2.4	3.7	16	55	Cylindrical
TEC025A2-037/20C4M60	●	2.5	4	2	2.4	3.7	20	60	Cylindrical
TEC025A2-037/30C4M80	●	2.5	4	2	2.4	3.7	30	80	Cylindrical
TEC030A2-045/08C6M45	●	3	6	2	2.85	4.5	8	45	Cylindrical
TEC030A2-045/10C6M45	●	3	6	2	2.85	4.5	10	45	Cylindrical
TEC030A2-045/12C6M45	●	3	6	2	2.85	4.5	12	45	Cylindrical
TEC030A2-045/16C6M55	●	3	6	2	2.85	4.5	16	55	Cylindrical
TEC030A2-045/20C6M60	●	3	6	2	2.85	4.5	20	60	Cylindrical
TEC030A2-045/30C6M70	●	3	6	2	2.85	4.5	30	70	Cylindrical
TEC030A2-045/40C6M90	●	3	6	2	2.85	4.5	40	90	Cylindrical

●: Line up

## SOLIDMEISTER

### TEC\*\*A4

4 flute endmill, 30° helix angle, for hardened steel up to 65 HRC



Designation	AH750	DC	DCONMS	NOF	APMX	LF	Shank
TEC040A4-11C06-50	●	4	6	4	11	50	Cylindrical
TEC050A4-13C06-50	●	5	6	4	13	50	Cylindrical
TEC060A4-13C06-50	●	6	6	4	13	50	Cylindrical
TEC070A4-16C08-63	●	7	8	4	16	63	Cylindrical
TEC080A4-19C08-63	●	8	8	4	19	63	Cylindrical
TEC090A4-19C10-72	●	9	10	4	19	72	Cylindrical
TEC100A4-22C10-72	●	10	10	4	22	72	Cylindrical
TEC120A4-26C12-73	●	12	12	4	26	73	Cylindrical
TEC140A4-26C14-83	●	14	14	4	26	83	Cylindrical
TEC160A4-32C16-92	●	16	16	4	32	92	Cylindrical
TEC180A4-32C18-100	●	18	18	4	32	100	Cylindrical
TEC200A4-38C20-104	●	20	20	4	38	104	Cylindrical

●: Line up

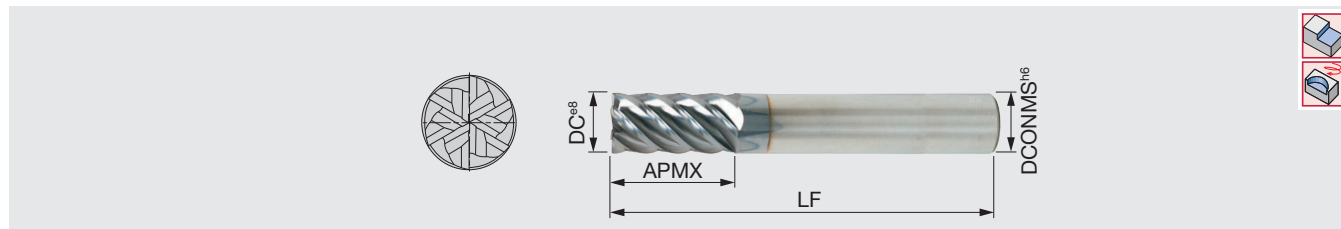
Reference pages: Standard cutting conditions → I051

Grade  
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**TECH\*\*B6**

6 flute endmill, 45° helix angle, for finishing operation

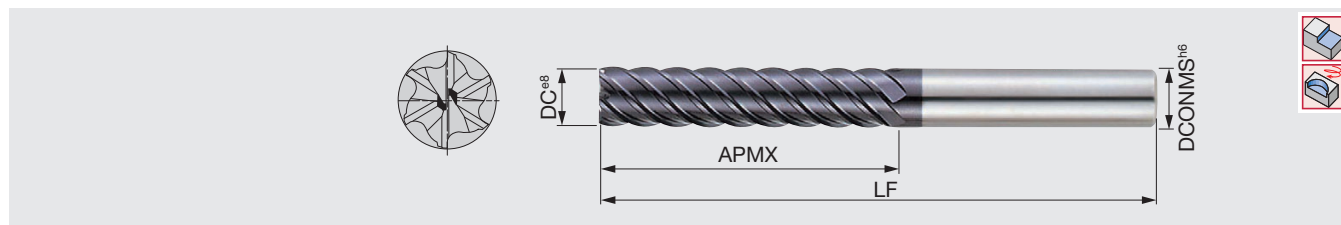


Designation	AH725	AH750	DC	DCONMS	NOF	APMX	LF	Shank
TECH060B6-16C06-57	●	●	6	6	6	16	57	Cylindrical
TECH060B6-16W06-57	●		6	6	6	16	57	Weldon
TECH080B6-20C08-63	●	●	8	8	6	20	63	Cylindrical
TECH080B6-20W08-63	●		8	8	6	20	63	Weldon
TECH100B6-22C10-72	●	●	10	10	6	22	72	Cylindrical
TECH100B6-22W10-72	●		10	10	6	22	72	Weldon
TECH120B6-25C12-83	●	●	12	12	6	25	83	Cylindrical
TECH120B6-25W12-83	●		12	12	6	25	83	Weldon
TECH160B6-32C16-92	●	●	16	16	6	32	92	Cylindrical
TECH160B6-32W16-92	●		16	16	6	32	92	Weldon
TECH200B6-38C20-104	●	●	20	20	6	38	104	Cylindrical
TECH200B6-38W20-104	●		20	20	6	38	104	Weldon

● : Line up

**SOLIDMEISTER**  
**TEC\*\*B6**

6 flute endmill, 45° helix angle, extra long neck type, for hardened steel up to 65 HRC



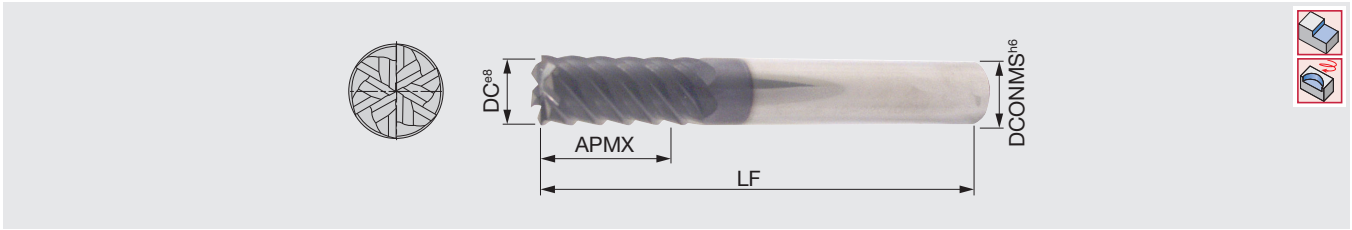
Designation	AH750	DC	DCONMS	NOF	APMX	LF	Shank
TEC060B6-26C06-70	●	6	6	6	26	70	Cylindrical
TEC080B6-36C08-90	●	8	8	6	36	90	Cylindrical
TEC100B6-46C10-100	●	10	10	6	46	100	Cylindrical
TEC120B6-56C12-110	●	12	12	6	56	110	Cylindrical
TEC160B6-66C16-130	●	16	16	6	66	130	Cylindrical
TEC200B6-76C20-140	●	20	20	6	76	140	Cylindrical
TEC250B6-92C25-180	●	25	25	6	92	180	Cylindrical

● : Line up

Reference pages: Standard cutting conditions → **I051**

## TEC\*\*D6

6 flute endmill, 50° helix angle, for hardened steel up to 65 HRC

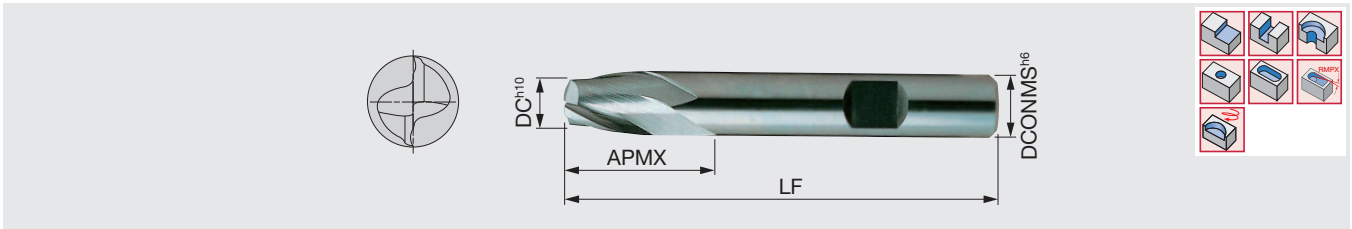


Designation	AH750	DC	DCONMS	NOF	APMX	LF	Shank
TEC060D6-13C06H57	●	6	6	6	13	57	Cylindrical
TEC080D6-20C08H63	●	8	8	6	20	63	Cylindrical
TEC100D6-22C10H72	●	10	10	6	22	72	Cylindrical
TEC120D6-25C12H83	●	12	12	6	25	83	Cylindrical
TEC140D6-30C14H83	●	14	14	6	30	83	Cylindrical
TEC160D6-32C16H92	●	16	16	6	32	92	Cylindrical
TEC200D6-38C20H104	●	20	20	6	38	104	Cylindrical

●: Line up

## ECOMEISTER TEC\*\*A2\*\*E

2 flute endmill, 30° helix angle, short type

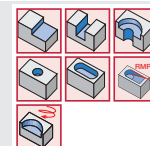
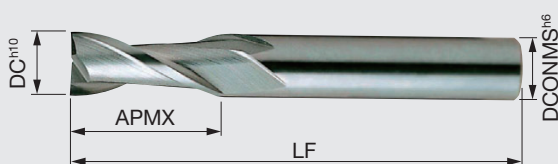


Designation	AH725	DC	DCONMS	NOF	APMX	LF	Shank
TEC020A2-03W06-E50	●	2	6	2	3	50	Weldon
TEC030A2-04W06-E50	●	3	6	2	4	50	Weldon
TEC040A2-05W06-E54	●	4	6	2	5	54	Weldon
TEC045A2-05W06-E54	●	4.5	6	2	5	54	Weldon
TEC050A2-06W06-E54	●	5	6	2	6	54	Weldon
TEC060A2-07W06-E54	●	6	6	2	7	54	Weldon
TEC080A2-09W08-E58	●	8	8	2	9	58	Weldon
TEC100A2-11W10-E66	●	10	10	2	11	66	Weldon
TEC180A2-18W18-E84	●	18	18	2	18	84	Weldon
TEC200A2-20W20-E92	●	20	20	2	20	92	Weldon

●: Line up

Reference pages: Standard cutting conditions → **I051**

2 flute endmill, 30° helix angle



Square



High feed



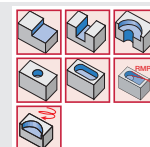
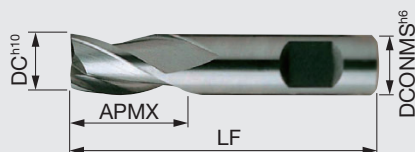
Ball

Designation	AH725	DC	DCONMS	NOF	APMX	LF	Shank
TEC010A2-03C04-E50	●	1	4	2	3	50	Cylindrical
TEC015A2-04C04-E50	●	1.5	4	2	4.5	50	Cylindrical
TEC020A2-08C02-E32	●	2	2	2	8	32	Cylindrical
TEC025A2-08C025-E32	●	2.5	2.5	2	8	32	Cylindrical
TEC030A2-12C03-E38	●	3	3	2	12	38	Cylindrical
TEC035A2-12C035-E32	●	3.5	3.5	2	12	32	Cylindrical
TEC040A2-12C04-E50	●	4	4	2	12	50	Cylindrical
TEC050A2-14C05-E50	●	5	5	2	14	50	Cylindrical
TEC055A2-16C055-E50	●	5.5	5.5	2	16	50	Cylindrical
TEC060A2-16C06-E50	●	6	6	2	16	50	Cylindrical
TEC070A2-20C07-E60	●	7	7	2	20	60	Cylindrical
TEC080A2-20C08-E63	●	8	8	2	20	63	Cylindrical
TEC090A2-20C09-E60	●	9	9	2	20	60	Cylindrical
TEC100A2-22C10-E72	●	10	10	2	22	72	Cylindrical
TEC120A2-22C12-E73	●	12	12	2	22	73	Cylindrical
TEC140A2-25C14-E75	●	14	14	2	25	75	Cylindrical
TEC160A2-25C16-E92	●	16	16	2	25	92	Cylindrical
TEC200A2-32C20-E100	●	20	20	2	32	100	Cylindrical

● : Line up

**ECOMEISTER**  
TEC\*\*A/E3\*\*E

3 flute endmill, 30° or 38° helix angle, short type



Designation	AH725	DC	DCONMS	NOF	APMX	LF	FHA	Shank
TEC020E3-04C06-E35	●	2	6	3	4	35	38°	Cylindrical
TEC025E3-05C06-E36	●	2.5	6	3	5	36	38°	Cylindrical
TEC030E3-05C06-E36	●	3	6	3	5	36	38°	Cylindrical
TEC035A3-06W06-E37	●	3.5	6	3	6	37	30°	Weldon
TEC040E3-07C06-E39	●	4	6	3	7	39	38°	Cylindrical
TEC045A3-08W06-E38	●	4.5	6	3	8	38	30°	Weldon
TEC050A3-08C06-E39	●	5	6	3	8	39	30°	Cylindrical
TEC055A3-08W06-E39	●	5.5	6	3	8	39	30°	Weldon
TEC060E3-08C06-E39	●	6	6	3	8	39	38°	Cylindrical
TEC070A3-10W08-E42	●	7	8	3	10	42	30°	Weldon
TEC080E3-11C08-E43	●	8	8	3	11	43	38°	Cylindrical
TEC090A3-11W10-E48	●	9	10	3	11	48	30°	Weldon
TEC100E3-13C10-E50	●	10	10	3	13	50	38°	Cylindrical

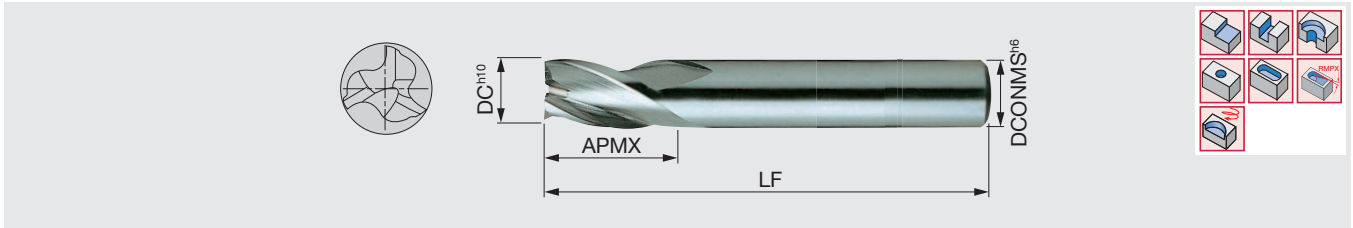
● : Line up

Reference pages: Standard cutting conditions → I051



## TEC\*\*A/E3\*\*E

3 flute endmill, 30° or 38° helix angle

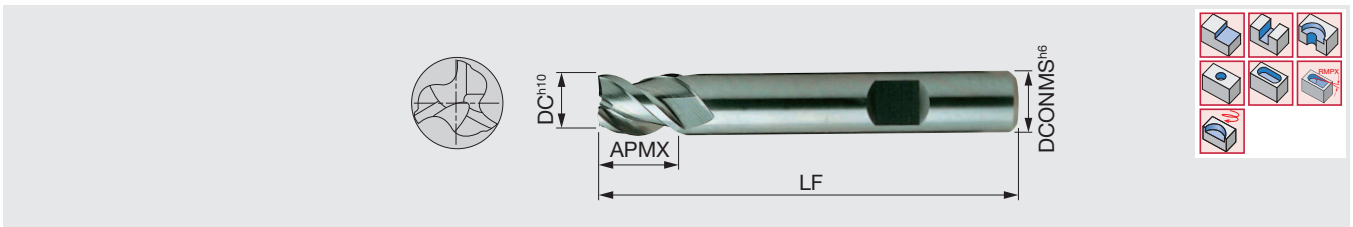


Designation	AH725	DC	DCONMS	NOF	APMX	LF	FHA	Shank
TEC020E3-08C02-E32	●	2	2	3	8	32	38°	Cylindrical
TEC030E3-12C03-E38	●	3	3	3	12	38	38°	Cylindrical
TEC040E3-12C04-E50	●	4	4	3	12	50	38°	Cylindrical
TEC050E3-14C05-E50	●	5	5	3	14	50	38°	Cylindrical
TEC060E3-16C06-E50	●	6	6	3	16	50	38°	Cylindrical
TEC070E3-20C07-E60	●	7	7	3	20	60	38°	Cylindrical
TEC080E3-20C08-E63	●	8	8	3	20	63	38°	Cylindrical
TEC090A3-20C09-E60	●	9	9	3	20	60	30°	Cylindrical
TEC100E3-22C10-E72	●	10	10	3	22	72	38°	Cylindrical
TEC120E3-22C12-E73	●	12	12	3	22	73	38°	Cylindrical
TEC140A3-25C14-E75	●	14	14	3	25	75	30°	Cylindrical
TEC160A3-25C16-E75	●	16	16	3	25	75	30°	Cylindrical

●: Line up

## ECOMEISTER TEC\*\*B3\*\*W

3 flute endmill, 45° helix angle, short type

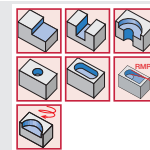
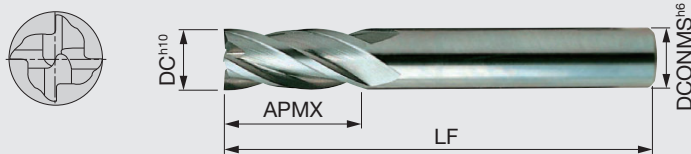


Designation	AH725	DC	DCONMS	NOF	APMX	LF	Shank
TEC020B3-03W06-50	●	2	6	3	3	50	Weldon
TEC030B3-04W06-50	●	3	6	3	4	50	Weldon
TEC040B3-05W06-54	●	4	6	3	5	54	Weldon
TEC050B3-06W06-54	●	5	6	3	6	54	Weldon
TEC060B3-07W06-54	●	6	6	3	7	54	Weldon
TEC080B3-09W08-58	●	8	8	3	9	58	Weldon
TEC100B3-11W10-66	●	10	10	3	11	66	Weldon
TEC120B3-12W12-73	●	12	12	3	12	73	Weldon
TEC140B3-14W14-75	●	14	14	3	14	75	Weldon
TEC160B3-16W16-82	●	16	16	3	16	82	Weldon
TEC200B3-20W20-92	●	20	20	3	20	92	Weldon

●: Line up

Reference pages: Standard cutting conditions → **I051**

4 flute endmill, 30° helix angle

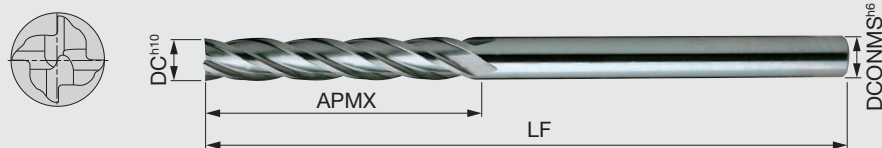


Designation	AH725	DC	DCONMS	NOF	APMX	LF	Shank
TEC020A4-08C02-E32	●	2	2	4	8	32	Cylindrical
TEC025A4-08C025-E32	●	2.5	2.5	4	8	32	Cylindrical
TEC030A4-12C03-E38	●	3	3	4	12	38	Cylindrical
TEC040A4-12C04-E50	●	4	4	4	12	50	Cylindrical
TEC050A4-14C05-E50	●	5	5	4	14	50	Cylindrical
TEC055A4-16C055-E50	●	5.5	5.5	4	16	50	Cylindrical
TEC060A4-16C06-E50	●	6	6	4	16	50	Cylindrical
TEC070A4-20C07-E60	●	7	7	4	20	60	Cylindrical
TEC080A4-20C08-E60	●	8	8	4	20	60	Cylindrical
TEC090A4-20C09-E60	●	9	9	4	20	60	Cylindrical
TEC100A4-22C10-E72	●	10	10	4	22	72	Cylindrical
TEC120A4-22C12-E73	●	12	12	4	22	73	Cylindrical
TEC140A4-25C14-E83	●	14	14	4	25	83	Cylindrical
TEC160A4-25C16-E82	●	16	16	4	25	82	Cylindrical
TEC200A4-32C20-E104	●	20	20	4	32	104	Cylindrical

● : Line up

**TEC\*\*A4\*\*E**

4 flute endmill, 30° helix angle, extra long neck type



Designation	AH725	DC	DCONMS	NOF	APMX	LF	Shank
TEC030A4-30C03-E75	●	3	3	4	30	75	Cylindrical
TEC040A4-30C04-E75	●	4	4	4	30	75	Cylindrical
TEC050A4-40C05-E100	●	5	5	4	40	100	Cylindrical
TEC060A4-50C06-E150	●	6	6	4	50	150	Cylindrical
TEC080A4-50C08-E150	●	8	8	4	50	150	Cylindrical
TEC100A4-60C10-E150	●	10	10	4	60	150	Cylindrical
TEC120A4-75C12-E150	●	12	12	4	75	150	Cylindrical
TEC140A4-65C14-E150	●	14	14	4	65	150	Cylindrical
TEC160A4-65C16-E150	●	16	16	4	65	150	Cylindrical
TEC200A4-65C20-E150	●	20	20	4	65	150	Cylindrical

● : Line up

Reference pages: Standard cutting conditions → **I051**

### Slotting / Roughing

ISO	Workpiece material	Vc (m/min)	fz (mm/t)			ap (Slotting)
			ø6 - ø8	ø10 - ø12	ø16 - ø20	
<b>P</b>	Carbon steel	140 - 180	0.025 - 0.035	0.03 - 0.045	0.04 - 0.055	1xD
	Alloy steel	70 - 150	0.02 - 0.03	0.03 - 0.045	0.04 - 0.055	1xD
<b>M</b>	Stainless steel	60 - 100	0.02 - 0.035	0.03 - 0.04	0.035 - 0.045	0.5xD
<b>K</b>	Cast iron	80 - 180	0.02 - 0.04	0.03 - 0.05	0.04 - 0.06	1xD
<b>N</b>	Aluminium alloy	300 - 750	0.02 - 0.04	0.03 - 0.05	0.03 - 0.07	1xD
<b>S</b>	Titanium alloy	20 - 50	0.02 - 0.03	0.025 - 0.04	0.03 - 0.07	0.25xD
<b>H</b>	Hardened steel	20 - 30	0.01 - 0.015	0.02 - 0.045	0.04 - 0.05	0.2xD

### Semi-finishing / Shouldering (ae = 0.1-0.4 x D)

ISO	Workpiece material	Vc (m/min)	fz (mm/t)			ap
			ø6 - ø8	ø10 - ø12	ø16 - ø20	
<b>P</b>	Carbon steel	150 - 220	0.03 - 0.06	0.06 - 0.07	0.07 - 0.08	2xD
	Alloy steel	70 - 160	0.02 - 0.05	0.04 - 0.065	0.045 - 0.07	2xD
<b>M</b>	Stainless steel	80 - 130	0.025 - 0.04	0.035 - 0.045	0.04 - 0.05	2xD
<b>K</b>	Cast iron	130 - 220	0.03 - 0.05	0.04 - 0.06	0.06 - 0.07	2xD
<b>N</b>	Aluminium alloy	350 - 850	0.04 - 0.06	0.06 - 0.08	0.08 - 0.1	2xD
<b>S</b>	Titanium alloy	40 - 60	0.03 - 0.04	0.035 - 0.05	0.05 - 0.08	2xD
<b>H</b>	Hardened steel	30 - 70	0.015 - 0.035	0.035 - 0.055	0.045 - 0.06	2xD

### Finishing (feed rate depending on required accuracy) / High feed machining at low depth of cut (ae = 0.05-0.1 x D)

ISO	Workpiece material	Vc (m/min)	fz (mm/t)			ap
			ø6 - ø8	ø10 - ø12	ø16 - ø20	
<b>P</b>	Carbon steel	170 - 280	0.05 - 0.07	0.07 - 0.08	0.08 - 0.1	apmax
	Alloy steel	110 - 220	0.05 - 0.07	0.07 - 0.08	0.08 - 0.1	apmax
<b>M</b>	Stainless steel	100 - 160	0.03 - 0.045	0.04 - 0.05	0.045 - 0.06	apmax
<b>K</b>	Cast iron	180 - 280	0.035 - 0.06	0.06 - 0.065	0.065 - 0.08	apmax
<b>N</b>	Aluminium alloy	350 - 900	0.045 - 0.07	0.07 - 0.1	0.1 - 0.15	apmax
<b>S</b>	Titanium alloy	50 - 70	0.035 - 0.05	0.04 - 0.06	0.06 - 0.085	apmax
<b>H</b>	Hardened steel	40 - 80	0.02 - 0.04	0.04 - 0.06	0.05 - 0.07	apmax

- When the depth of cut (ae) is closer to the upper limit, please start with a lower limit value of cutting speed (Vc).
- The items with long slot (2xD or over) and the items with 5 cutting edges or more are not suitable for slotting operation.
- When using AH750, reducing cutting speed by 20 to 30% is effective for extending tool life.
- While air blow is recommended, water-soluble coolant will be good for stainless steel, titanium alloy, and heat-resistant alloy.
- When chattering occurs with low rigid machines or settings, reduce cutting speed and feed at an equal rate.
- When chattering occurs with long tool overhang, reduce cutting speed and feed by 20 to 40% (Variable/FinishMeister is recommended for such operations).
- In slotting of high hardened steel, heat-resistant alloy, and some types of stainless steel, start with ap=0.2xD and increase the value gradually while checking the status of the operation.
- In shoulder milling of high hardened steel and heat-resistant alloy, the cutting width should be started at ae=0.05xD and increase the value gradually while checking the status of the operation.
- The items with many cutting edges are good for finishing and high feed machining of small width of cut.
- VariableMeister is suitable for machining large depth of cut.
- Low feed in finishing is recommended for good surface roughness.

