



Cutter Series
FHU

Insert Series
WN*U

Diameters
.750" - 1.500"

Radial Stepover
WNMU04 - .15"
WNMU06 - .23"

Materials
Steel, Iron, Stainless Steel,
Hi-Temp Alloy, Aluminum



Flat Bottom Plunge Mills with 6 Positive & Economical Cutting Edges!

Features & Benefits

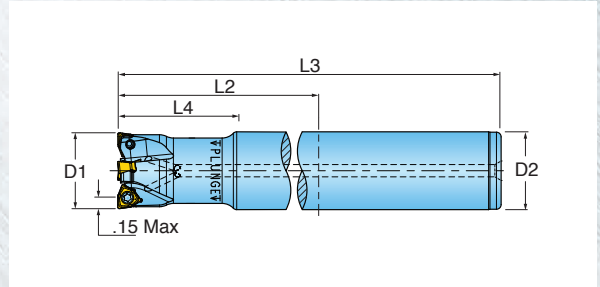
- 6 smooth cutting edges (3+3)
- Geometry produces a Flat Bottom on the piece part
- Multiple corner radii, grades and geometries for all materials
- Ideal for roughing in unstable conditions and light duty machines
- Same insert used with end mills and face mills

AHB Tooling & Machinery, Inc.
Complete Metalworking Solutions
Roseville Saginaw & Jackson, MI

ISO Certified
(800) 991-4225
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SERIES FHU (4MM) (STRAIGHT SHANK)

FLAT BOTTOM PLUNGE ROUGHING MILLS WITH 6 INDEXES

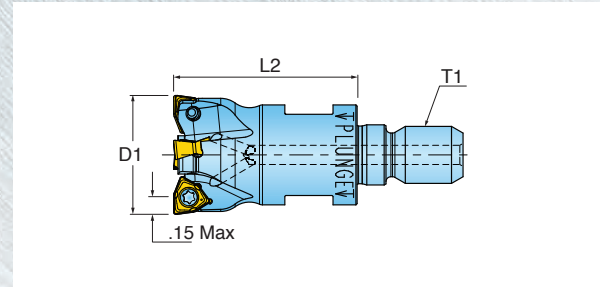


| Cutter Number | D1 Effective Diameter | L2 Extension Length | L3 Overall Length | L4 Projection Length | D2 Shank Size/Style | Number of Inserts |
|----------------|-----------------------|---------------------|-------------------|----------------------|---------------------|-------------------|
| FHU-07030S7R01 | 0.750 | 3.00 | 5.00 | 1.50 | .750" Cyland. | 3 |
| FHU-10032S1R01 | 1.000 | 3.25 | 5.50 | 1.50 | 1.000" Cyland. | 4 |

Note: Cutter body can be modified; shorten by cutting off back end or add projection length by turning back neck diameter.

SERIES FHU (4MM) (TOP-ON STYLE)

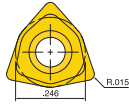
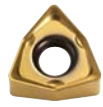
FLAT BOTTOM MODULAR PLUNGE ROUGHING MILLS WITH 6 INDEXES



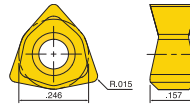
| Cutter Number | D1 Effective Diameter | Number of Inserts | T1 Thread Size | L2 Length | Wrench Size |
|----------------|-----------------------|-------------------|----------------|-----------|-------------|
| FHU-07012X6R01 | 0.750 | 3 | M10 | 1.250 | 15mm |
| FHU-10015X7R01 | 1.000 | 4 | M12 | 1.500 | 17mm |

4MM INSERTS

WNMU04T304N








WNCU04T304FN-P



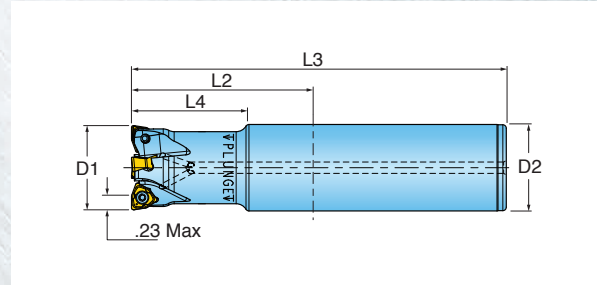
| Part Number | Corner | Application | Grades | | | | |
|----------------|---------|---------------|--------|--------|--------|--------|--------|
| | | | IN10K | IN2504 | IN2505 | IN2530 | IN6535 |
| WNMU04T304N | 0.015 R | Multi-Purpose | | • | • | • | • |
| WNCU04T304FN-P | 0.015 R | Aluminum | • | | | | |

4MM HARDWARE

| Cutter Number |  Insert Screw |  Driver |  Optional Torque Driver Handle |  Optional Torque Driver Bit |  Wrench |
|----------------|---|---|--|---|---|
| FHU-07012X6R01 | SM25-064-00 | DS-T08W | DTQ-11WK | DTQ-11W | 615MM |
| FHU-07030S7R01 | SM25-064-00 | DS-T08W | DTQ-11WK | DTQ-11W | - |
| FHU-10015X7R01 | SM25-064-00 | DS-T08W | DTQ-11WK | DTQ-11W | 617MM |
| FHU-10032S1R01 | SM25-064-00 | DS-T08W | DTQ-11WK | DTQ-11W | - |

SERIES FHU (6MM) (STRAIGHT SHANK)

FLAT BOTTOM PLUNGE ROUGHING MILLS WITH 6 INDEXES

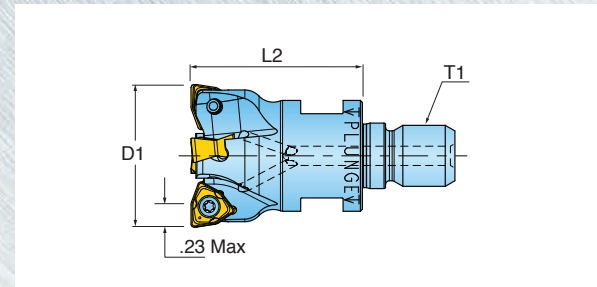


| Cutter Number | D1 Effective Diameter | L2 Extension Length | L3 Overall Length | L4 Projection Length | D2 Shank Size/Style | Number of Inserts |
|----------------|-----------------------|---------------------|-------------------|----------------------|---------------------|-------------------|
| FHU-1203759R01 | 1.250 | 3.75 | 6.00 | 2.00 | 1.250" Cylind. | 3 |
| FHU-1503855R01 | 1.500 | 3.84 | 6.50 | 2.00 | 1.500" Cylind. | 4 |

Note: Cutter body can be modified; shorten by cutting off back end or add projection length by turning back neck diameter.

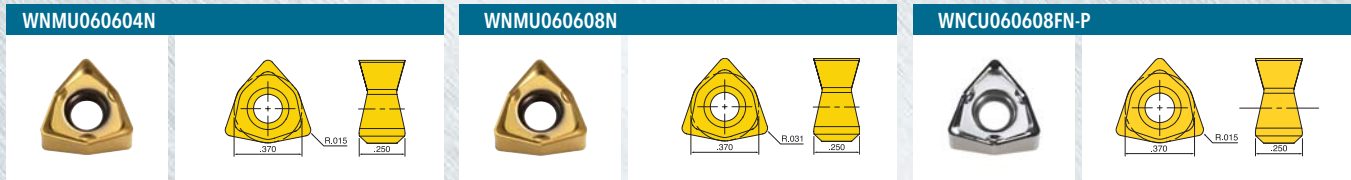
SERIES FHU (6MM) (TOP-ON STYLE)

FLAT BOTTOM MODULAR PLUNGE ROUGHING MILLS WITH 6 INDEXES



| Cutter Number | D1 Effective Diameter | Number of Inserts | T1 Thread Size | L2 Length | Wrench Size |
|----------------|-----------------------|-------------------|----------------|-----------|-------------|
| FHU-12017X8R01 | 1.250 | 3 | M16 | 1.750 | 22mm |
| FHU-15017X8R01 | 1.500 | 4 | M16 | 1.750 | 22mm |

6MM INSERTS



| Part Number | Corner | Application | Grades | | | | |
|----------------|---------|---------------|--------|--------|--------|--------|--------|
| | | | IN10K | IN2504 | IN2505 | IN2530 | IN6535 |
| WNMU060604N | 0.015 R | Multi-Purpose | | | • | • | • |
| WNMU060608N | 0.031 R | Multi-Purpose | | • | • | • | • |
| WNCU060608FN-P | 0.031 R | Aluminum | • | | | | |

6MM HARDWARE

| Cutter Number | Insert Screw | Driver Handle | Driver Blade | Optional Torque Driver Handle | Optional Torque Driver Bit | Wrench |
|----------------|--------------|---------------|--------------|-------------------------------|----------------------------|--------|
| FHU-12017X8R01 | SM35-088-60 | DS-A00T | DS-T106B | DT-28-01 | DS-T10B | 622MM |
| FHU-12037S9R01 | SM35-088-60 | DS-A00T | DS-T106B | DT-28-01 | DS-T10B | - |
| FHU-15017X8R01 | SM35-088-60 | DS-A00T | DS-T106B | DT-28-01 | DS-T10B | 622MM |
| FHU-15038S5R01 | SM35-088-60 | DS-A00T | DS-T106B | DT-28-01 | DS-T10B | - |

OPERATING GUIDELINES

SERIES FHU

| Material | Material | Brinnell Hardness | SFM | Feed per Insert | Grades | | | | | Coolant | | | |
|-----------------|--|-------------------|-------------|-----------------|--------|--------|--------|--------|--------|---------|---|---|---|
| | | | | | IN10K | IN2504 | IN2505 | IN2530 | IN6535 | | | | |
| Aluminum | 7075-T6, 6061-T6, 2024 | - | 1500 - 5000 | .003 - .008 | 1 | | | | | Yes | | | |
| Cast Iron | Gray | 150-250 | 300 - 1000 | .003 - .008 | | 1 | 2 | | | No | | | |
| | Nodular | | 300 - 600 | | | | | | | | | | |
| Steel | Low Carbon 1018, 8620 | 150 - 250 | 400 - 1000 | .003 - .008 | | | | | | No | | | |
| | High Carbon F-6180, Nitralloy 52100 | 250 - 400 | 350 - 500 | .003 - .007 | | | | | | | | | |
| | Alloyed Steel 4140, 4340, 6150 | 150 - 300 | 300 - 700 | .003 - .008 | 3 | 2 | 1 | | | | | | |
| | Tool Steel A-6, D-1, D-2, P20 | Up to 300 | | | | | | | | | | | |
| Stainless Steel | 300 Series, 304, 316 | - | 300 - 550 | .003 - .008 | | | | | | | | | May not be required at high speeds Yes |
| | 400 Series 15-5PH, 17-4 PH | Up to 320 | 350 - 600 | | | | | | | 3 | 2 | 1 | |
| | 13-8PH | - | 200 - 400 | | | | | | | | | | |
| Nickel Alloys | Inconel 600, 706, 718, 903, Hastelloy, Waspalloy | - | 75 - 120 | .003 - .006 | | | 2 | 3 | 1 | Yes | | | |
| Titanium | 6AL-4V | - | 100 - 150 | .003 - .006 | | | 3 | 2 | 1 | Yes | | | |
| Hard Steel | All | 375-650 | 150 - 350 | .003 - .005 | | 1 | 2 | | | No | | | |