

New Cutline VC range of high-performance variable helix end mills



Price List GBP

Excellent tools backed by excellent service



Capable of machining most common materials:

- Steels, stainless, cast iron, non-ferrous and machining of exotic alloys



Save up to 70% on future solid carbide end mill replacements with our as-new regrind service



Developed and tested by Rubix Cutting & Machining application engineers



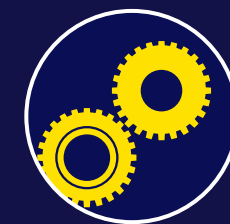
Customer-tested with various material groups and manufacturing environments over a long period



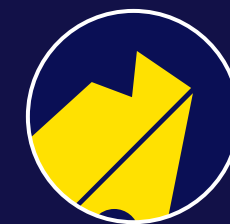
Manufactured in the UK, with same / next day availability



> Your first choice in cutting and machining



Engineered solutions



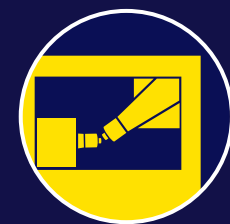
Bespoke special solutions



Modification of standard tooling



As-new regrind services



Product proving

uk.rubix.com/cutting-and-machining

To find out how Cutline offers exceptional quality across a comprehensive range of rotary cutting tools, contact your Brammer Buck & Hickman branch or account manager.

 uk.rubix.com/cutline

 0870 240 2100

New Cutline VC range of high-performance variable helix end mills



Order code	Description	Diameter (mm)	Shank diameter (mm)	Length of cut (mm)	Overall length (mm)	Radius (mm)	List price
226A5419	Cutline Vari-Cut 3.00mm with cnr chamfer	3	6	8	57	N/A	£16.69
226A5420	Cutline Vari-Cut 3.00mm - 0.25R					0.25	£16.69
226A5421	Cutline Vari-Cut 3.00mm - 0.50R					0.5	£16.69

226A5422	Cutline Vari-Cut 4.00mm with cnr chamfer	4	6	11	57	N/A	£16.69
226A5423	Cutline Vari-Cut 4.00mm - 0.25R					0.25	£16.69
226A5424	Cutline Vari-Cut 4.00mm - 0.50R					0.5	£16.69

226A5428	Cutline Vari-Cut 5.00mm with cnr chamfer	5	6	13	57	N/A	£16.69
226A5429	Cutline Vari-Cut 5.00mm - 0.25R					0.25	£16.69
226A5430	Cutline Vari-Cut 5.00mm - 0.50R					0.5	£16.69

226A5431	Cutline Vari-Cut 6.00mm with cnr chamfer	6	6	13	57	N/A	£16.69
226A5433	Cutline Vari-Cut 6.00mm - 0.25R					0.25	£16.69
226A5435	Cutline Vari-Cut 6.00mm - 0.50R					0.5	£16.69
226A5436	Cutline Vari-Cut 6.00mm - 1.0R					1	£16.69
226A5439	Cutline Vari-Cut 6.00mm - 1.5R					1.5	£16.69
226A5441	Cutline Vari-Cut 6.00mm - 2.0R					2	£18.20

226A5442	Cutline Vari-Cut 8.00mm with cnr chamfer	8	8	19	63	N/A	£23.20
226A5445	Cutline Vari-Cut 8.00mm - 0.50R					0.5	£23.20
226A5446	Cutline Vari-Cut 8.00mm - 1.0R					1	£23.20
226A5447	Cutline Vari-Cut 8.00mm - 1.5R					1.5	£23.20
226A5448	Cutline Vari-Cut 8.00mm - 2.0R					2	£23.20
226A5449	Cutline Vari-Cut 8.00mm - 3.0R					3	£26.37

226A5451	Cutline Vari-Cut 10.0mm with cnr chamfer	10	10	22	72	N/A	£36.53
226A5452	Cutline Vari-Cut 10.0mm - 0.50R					0.5	£36.54
226A5453	Cutline Vari-Cut 10.0mm - 1.0R					1	£36.54
226A5454	Cutline Vari-Cut 10.0mm - 1.5R					1.5	£36.54
226A5456	Cutline Vari-Cut 10.0mm - 2.0R					2	£36.54
226A5457	Cutline Vari-Cut 10.0mm - 3.0R					3	£40.15

Order code	Description	Diameter (mm)	Shank diameter (mm)	Length of cut (mm)	Overall length (mm)	Radius (mm)	List price
226A5459	Cutline Vari-Cut 12.0mm cnr chamfer	12	12	26	83	N/A	£49.84
226A5460	Cutline Vari-Cut 12.0mm - 0.50R					0.5	£49.84
226A5461	Cutline Vari-Cut 12.0mm - 0.75R					0.75	£49.84
226A5462	Cutline Vari-Cut 12.0mm - 1.0R					1	£49.84
226A5463	Cutline Vari-Cut 12.0mm - 1.5R					1.5	£49.84
226A5465	Cutline Vari-Cut 12.0mm - 2.0R					2	£49.84
226A5466	Cutline Vari-Cut 12.0mm - 2.5R					2.5	£49.84
226A5467	Cutline Vari-Cut 12.0mm - 3.0R					3	£49.84
226A5469	Cutline Vari-Cut 12.0mm - 4.0R					4	£54.51

226A5472	Cutline Vari-Cut 16.0mm with cnr chamfer	16	16	32	92	N/A	£82.71
226A5474	Cutline Vari-Cut 16.0mm - 0.50R					0.5	£82.71
226A5477	Cutline Vari-Cut 16.0mm - 1.0R					1	£82.71
226A5479	Cutline Vari-Cut 16.0mm - 1.5R					1.5	£82.71
226A5481	Cutline Vari-Cut 16.0mm - 2.0R					2	£82.71
226A5484	Cutline Vari-Cut 16.0mm - 2.5R					2.5	£82.71
226A5488	Cutline Vari-Cut 16.0mm - 3.0R					3	£82.71
226A5490	Cutline Vari-Cut 16.0mm - 4.0R					4	£82.71

226A5492	Cutline Vari-Cut 20.0mm with cnr chamfer	20	20	38	104	N/A	£148.44
226A5495	Cutline Vari-Cut 20.0mm - 1.0R					1	£148.45
226A5498	Cutline Vari-Cut 20.0mm - 1.5R					1.5	£148.45
226A5500	Cutline Vari-Cut 20.0mm - 2.0R					2	£148.45
226A5502	Cutline Vari-Cut 20.0mm - 3.0R					3	£148.45
226A5504	Cutline Vari-Cut 20.0mm - 4.0R					4	£148.45

Cutting parameters						
Material Roughing / Finishing	Vc (m/min)	ap (mm)	ae (mm)	fz (mm)		
				3mm	4-5mm	6mm
Steel <500 N/mm ² (<150 HB)	210	1xd	0,5xd.	0.009/0.018	0.012/0.025	0.030/0.060
Steel <700 N/mm ² (<205 HB)	180	1xd	0,5xd.	0.009/0.018	0.012/0.025	0.030/0.060
Steel <850 N/mm ² (<265 HB)	160	1xd	0,5xd.	0.009/0.018	0.012/0.025	0.030/0.060
Steel <1000 N/mm ² (<30 HRC)	130	1xd	0,5xd.	0.009/0.018	0.012/0.025	0.030/0.060
Steel <1400 N/mm ² (<44 HRC)	100	1xd	0,5xd.	0.009/0.018	0.012/0.025	0.030/0.060
Steel <1400 à 2000 N/mm ² (44/50 HRC)	80	1xd	0,5xd.	0.008/0.016	0.008/0.023	0.020/0.057
Steel > 2000 N/mm ² (<55/60 HRC)	50	1xd	0,5xd.	0.008/0.016	0.008/0.023	0.020/0.057
Steel > 60 HRC)	45	1xd	0,5xd.	0.008/0.016	0.008/0.023	0.020/0.057
Stainless Steel <700 N/mm ² (<205 HB)	100	1xd	0,5xd.	0.009/0.018	0.012/0.025	0.030/0.060
Stainless Steel >700 N/mm ² (>205 HB)	110	1xd	0,5xd.	0.009/0.018	0.012/0.025	0.030/0.060
Cast Iron <180HB	130	1xd	0,5xd.	0.009/0.018	0.013/0.025	0.030/0.060
Malleable Cast Iron >180HB	170	1xd	0,5xd.	0.009/0.018	0.013/0.025	0.030/0.060
Cast Iron with Graphite >180HB	180	1xd	0,5xd.	0.009/0.018	0.013/0.025	0.030/0.060
Titanium	30	1xd	0,5xd.	0.0045/0.018	0.008/0.023	0.016/0.060
Inconel, hard material	70	1xd	0,5xd.	0.0045/0.018	0.008/0.023	0.016/0.060

Material Roughing / Finishing	fz (mm)				
	8mm	10mm	12mm	16mm	20mm
Steel <500 N/mm ² (<150 HB)	0.040/0.080	0.050/0.100	0.060/0.120	0.080/0.160	0.125/0.250
Steel <700 N/mm ² (<205 HB)	0.040/0.080	0.050/0.100	0.060/0.120	0.080/0.160	0.125/0.250
Steel <850 N/mm ² (<265 HB)	0.040/0.080	0.050/0.100	0.060/0.120	0.080/0.160	0.125/0.250
Steel <1000 N/mm ² (<30 HRC)	0.040/0.080	0.050/0.100	0.060/0.120	0.080/0.160	0.125/0.250
Steel <1400 N/mm ² (<44 HRC)	0.040/0.080	0.050/0.100	0.060/0.120	0.080/0.160	0.125/0.250
Steel <1400 à 2000 N/mm ² (44/50 HRC)	0.025/0.069	0.028/0.080	0.042/0.114	0.050/0.137	0.060/0.160
Steel > 2000 N/mm ² (<55/60 HRC)	0.025/0.069	0.028/0.080	0.042/0.114	0.050/0.137	0.060/0.160
Steel > 60 HRC)	0.025/0.069	0.028/0.080	0.042/0.114	0.050/0.137	0.060/0.160
Stainless Steel <700 N/mm ² (<205 HB)	0.040/0.080	0.050/0.100	0.060/0.120	0.080/0.160	0.125/0.250
Stainless Steel >700 N/mm ² (>205 HB)	0.040/0.080	0.050/0.100	0.060/0.120	0.080/0.160	0.125/0.250
Cast Iron <180HB	0.040/0.080	0.050/0.100	0.060/0.120	0.080/0.160	0.125/0.250
Malleable Cast Iron >180HB	0.040/0.080	0.050/0.100	0.060/0.120	0.080/0.160	0.125/0.250
Cast Iron with Graphite >180HB	0.040/0.080	0.050/0.100	0.060/0.120	0.080/0.160	0.125/0.250
Titanium	0.019/0.080	0.022/0.100	0.032/0.120	0.060/0.130	0.065/0.250
Inconel, hard material	0.019/0.080	0.022/0.100	0.032/0.120	0.060/0.130	0.065/0.250

