

## Flat Bottom Plunge



**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
- Ideal for relieving corners in a pocket
- Same insert used with end mills and face mills

**PRODUCT  
ANNOUNCEMENT**

**UPDATE**

**2018**



Multi-Purpose

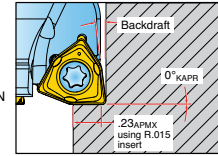
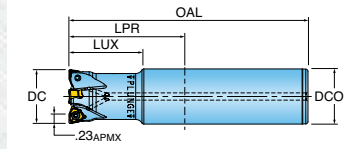


Non-Ferrous



**SERIES FHU (STRAIGHT SHANK) (04 INSERTS)**

FLAT BOTTOM PLUNGE ROUGH MILL

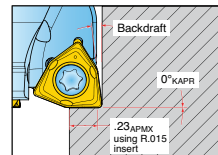
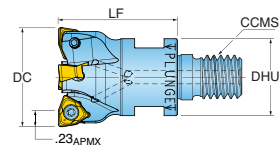


Part Number	DC Cutting Dia.	LUX Usable Length Max.	LPR Protruding Length	OAL Overall Length	ZEFF Effective Teeth	DCON Shank Dia.
FHU-07030S7R01	0.750	1.50	3.00	5.00	3	0.750
FHU-10032S1R01	1.000	1.50	3.25	5.50	4	1.000

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

**SERIES FHU (TOP-ON STYLE) (04 INSERTS)**

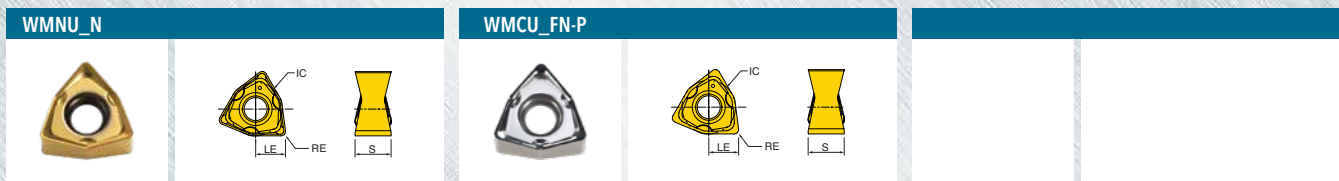
FLAT BOTTOM PLUNGE ROUGH MILL



Part Number	DC Cutting Dia.	LF Functional Length	ZEFF Effective Teeth	CCMS Connection Code Machine Side	DHUB Hub Dia.
FHU-07012X6R01	0.750	1.25	3	TopOn M10	0.69
FHU-10015X7R01	1.000	1.50	4	TopOn M12	0.81



## 04 INSERTS



Part Number	Application	RE/BCH Corner Radius/ Chamfer	LE Cutting Edge Length	IC Inscribed Circle Dia.	S Thickness (To Cutting Edge)	NOI Number of Indexes	IH Insert Hand	Grade	IN10K	IN6535	IN2035	IN2504	IN2505	IN2530	IN4030
WNMU04T304N	Multi-Purpose	0.015 R	0.150	0.248	0.157	6	Neutral		•	•	•	•	•	•	•
WNCU04T304FN-P	Non-Ferrous	0.015 R	0.150	0.248	0.157	6	Neutral	•							

## 04 HARDWARE

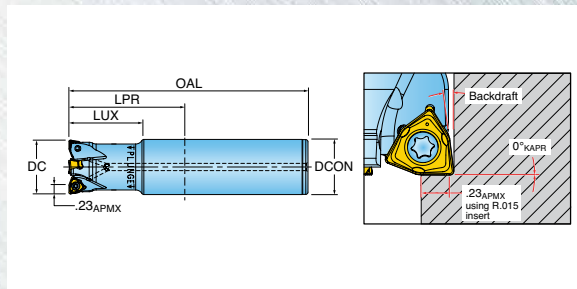


FHU-07012X6R01	SM25-064-00	DS-T08W	615MM
FHU-07030S7R01	SM25-064-00	DS-T08W	-
FHU-10015X7R01	SM25-064-00	DS-T08W	617MM
FHU-10032S1R01	SM25-064-00	DS-T08W	-



**SERIES FHU (STRAIGHT SHANK) (06 INSERTS)**

**FLAT BOTTOM PLUNGE ROUGH MILL**

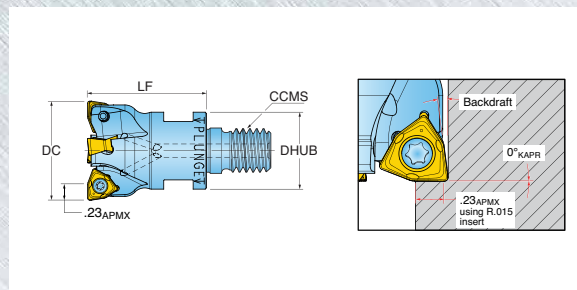


Part Number	DC Cutting Dia.	LUX Usable Length Max.	LPR Protruding Length	OAL Overall Length	ZEFF Effective Teeth	DCON Shank Dia.
FHU-12037S9R01	1.250	2.00	3.75	6.00	3	1.250
FHU-15038S5R01	1.500	2.00	3.84	6.50	4	1.500

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

**SERIES FHU (TOP-ON STYLE) (06 INSERTS)**


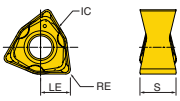

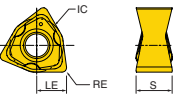
**FLAT BOTTOM PLUNGE ROUGH MILL**







Part Number	DC Cutting Dia.	LF Functional Length	ZEFF Effective Teeth	CCMS Connection Code Machine Side	DHUB Hub Dia.
FHU-12017X8R01	1.250	1.75	3	TopOn M16	1.13
FHU-15017X8R01	1.500	1.75	4	TopOn M16	1.13



## 06 INSERTS

WMNU_N		WMCU_FN-P												
														
Part Number	Application	RE/BCH Corner Radius/ Chamfer	LE Cutting Edge Length	IC Inscribed Circle Dia.	S Thickness (To Cutting Edge)	NOI Number of Indexes	IH Insert Hand	Grade	IN10K	IN6535	IN2035	IN2504	IN2505	IN2530
WNMU060604N	Multi-Purpose	0.015 R	0.230	0.370	0.254	6	Neutral		•	•	•	•	•	•
WNMU060608N	Multi-Purpose	0.031 R	0.230	0.370	0.244	6	Neutral		•	•	•	•	•	•
WNCU060608FN-P	Non-Ferrous	0.031 R	0.230	0.370	0.249	6	Neutral	•						

## 06 HARDWARE

				
	Insert Screw	Driver Handle	Driver Blade	Wrench
FHU-12017X8R01	SM35-088-60	DS-A00T	DS-T106B	622MM
FHU-12037S9R01	SM35-088-60	DS-A00T	DS-T106B	-
FHU-15017X8R01	SM35-088-60	DS-A00T	DS-T106B	622MM
FHU-15038S5R01	SM35-088-60	DS-A00T	DS-T106B	-

## OPERATING GUIDELINES

DiPos Hexa - Series FHU					IN10K	IN6535 IN2035	IN2504	IN2505	IN2530	Coolant
Material	Material	Brinnell Hardness	SFM	Feed per Insert						
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			3	2	1	No
	High Carbon F-6180, Nitralloy 52100	250 - 400	350 - 500	.003 - .007						
	Alloyed Steel 4140, 4340, 6150	150 - 300	300 - 700	.003 - .008						
Stainless Steel	Tool Steel A-6, D-1, D-2, P20	Up to 300								
	300 Series, 304, 316	-	300 - 550	.003 - .008						May not be required at high speeds
	400 Series 15-5PH, 17-4 PH	Up to 320	350 - 600		1		3	2		
13-8PH	-	200 - 400						Yes		
Nickel Alloys	Inconel 600, 706, 718, 903, Hastelloy, Waspalloy	-	75 - 120	.003 - .006		1		2	3	Yes
Titanium	6AL-4V	-	100 - 150	.003 - .006		1		3	2	Yes
Hard Steel	All	375-650	150 - 350	.003 - .005			1	2		No