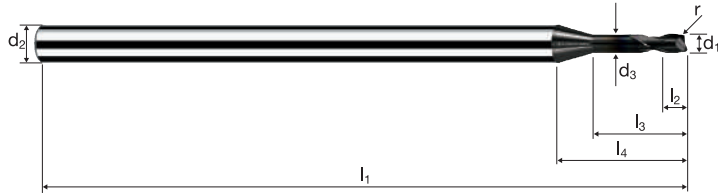
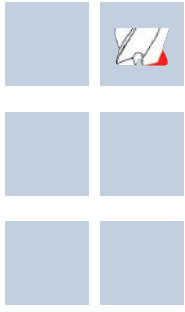


Corner radius end mills Microcut

Shank \varnothing 3mm, cylindrical neck, 5xd



HM λ 25°
MG10 γ 6°



C Graphite CF / GF Fiber Reinforced Plastics

IV

Ø Code	d ₁ ±0.01	d ₂ h6	d ₃	l ₁	l ₂	l ₃	l ₄	r 0/+0.03	α	z	DIAMANT
											Example: Order-N°.
100	1.00	3.00	0.95	50	1.20	5.00	9.22	0.200	6.6°	2	●
108	1.20	3.00	1.10	50	1.44	6.00	9.94	0.200	5.5°	2	●
120	1.50	3.00	1.40	50	1.80	7.50	10.88	0.200	4.2°	2	●
140	2.00	3.00	1.90	50	2.40	10.00	12.45	0.200	2.5°	2	●
160	2.50	3.00	2.30	50	3.00	12.50	14.20	0.200	1.1°	2	●
180	3.00	3.00	2.80	50	3.60	14.56	15.00	0.200	0.0°	2	●

Application	Material	d1 [mm]	z	f _z [mm]	a _p [mm]	a _e [mm]	n=15000 min ⁻¹ vf [mm/min]	n=25000 min ⁻¹ vf [mm/min]	n=30000 min ⁻¹ vf [mm/min]	n=45000 min ⁻¹ vf [mm/min]
	Graphite B B	1.00	2	0.009	0.450	0.600	270	450	540	810
		1.20	2	0.011	0.550	0.700	330	550	660	990
		1.50	2	0.014	0.700	0.900	420	700	840	1260
		2.00	2	0.019	0.900	1.200	570	950	1140	1710
		2.50	2	0.024	1.150	1.500	720	1200	1440	2160
		3.00	2	0.028	1.350	1.800	840	1400	1680	2520
	Graphite B B	1.00	2	0.007	0.450	1.000	210	350	420	630
		1.20	2	0.009	0.550	1.200	270	450	540	810
		1.50	2	0.011	0.700	1.500	330	550	660	990
		2.00	2	0.015	0.900	2.000	450	750	900	1350
		2.50	2	0.018	1.150	2.500	540	900	1080	1620
		3.00	2	0.022	1.350	3.000	660	1100	1320	1980
	Graphite B B	1.00	2	0.011	0.140	0.200	330	550	660	990
		1.20	2	0.013	0.170	0.240	390	650	780	1170
		1.50	2	0.016	0.210	0.300	480	800	960	1440
		2.00	2	0.021	0.280	0.400	630	1050	1260	1890
		2.50	2	0.027	0.350	0.500	810	1350	1620	2430
		3.00	2	0.032	0.420	0.600	960	1600	1920	2880
	Graphite B B	1.00	2	0.011	0.180	0.180	330	550	660	990
		1.20	2	0.013	0.220	0.220	390	650	780	1170
		1.50	2	0.016	0.270	0.270	480	800	960	1440
		2.00	2	0.021	0.360	0.360	630	1050	1260	1890
		2.50	2	0.027	0.450	0.450	810	1350	1620	2430
		3.00	2	0.032	0.540	0.540	960	1600	1920	2880