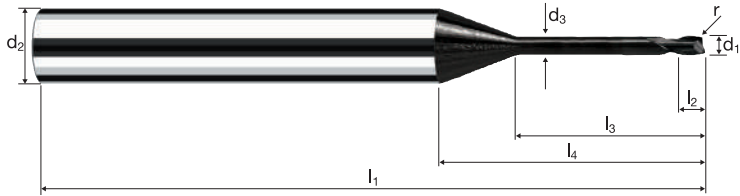
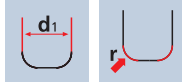


# Corner radius end mills MicroX (MicrotoroXG)

Shank  $\varnothing$  6mm, cylindrical neck, 8xd



HM	$\lambda$ 30°
XA	$\gamma$ 15°



				C Graphite							CF / GF Fiber Reinforced Plastics
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IV

Example: Order-N°.											DIAPLUS	
											B6036	
$\varnothing$ Code	$d_1$ 0/-0.01	$d_2$ h4	$d_3$	$l_1$	$l_2$	$l_3$	$l_4$	$r$ $\pm 0.005$	$\alpha$	$z$		
	Coating: <b>B</b>			Article-N°: <b>6036</b>			ø-Code: <b>020</b>					
<b>020</b>	0.20	6.00	0.18	57	0.20	1.60	18.54	-	13.2°	2	●	
<b>030</b>	0.30	6.00	0.25	57	0.30	2.40	19.14	-	12.5°	2	●	
<b>018</b>	0.20	6.00	0.18	57	0.20	1.60	18.54	0.050	13.2°	2	●	
<b>028</b>	0.30	6.00	0.25	57	0.30	2.40	19.14	0.050	12.3°	2	●	
<b>040</b>	0.40	6.00	0.35	57	0.40	3.20	19.66	0.050	11.6°	2	●	
<b>048</b>	0.50	6.00	0.45	57	0.50	4.00	15.01	0.050	11.0°	2	●	
<b>058</b>	0.60	6.00	0.55	57	0.60	4.80	15.63	0.050	10.3°	2	●	
<b>078</b>	0.80	6.00	0.75	57	0.80	6.40	16.85	0.050	9.2°	2	●	
<b>096</b>	1.00	6.00	0.95	57	1.00	8.00	18.08	0.050	8.2°	2	●	
<b>050</b>	0.50	6.00	0.45	57	0.50	4.00	15.01	0.100	11.0°	2	●	
<b>060</b>	0.60	6.00	0.55	57	0.60	4.80	15.63	0.100	10.3°	2	●	
<b>080</b>	0.80	6.00	0.75	57	0.80	6.40	16.85	0.100	9.2°	2	●	
<b>098</b>	1.00	6.00	0.95	57	1.00	8.00	18.08	0.100	8.2°	2	●	
<b>138</b>	2.00	6.00	1.90	61	2.00	16.00	24.31	0.100	4.9°	2	●	

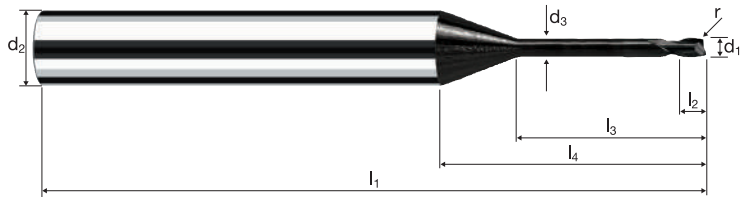
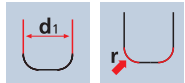
Application	Material	d1 [mm]	z	f <sub>z</sub> [mm]	a <sub>p</sub> [mm]	a <sub>e</sub> [mm]	n=15000 min vf [mm/min]	n=25000 min vf [mm/min]	n=30000 min vf [mm/min]	n=45000 min vf [mm/min]
	Graphite <b>B</b> <b>B</b>	0.20	2	0.002	0.100	0.100	60	100	120	180
		0.30	2	0.004	0.100	0.200	120	200	240	360
		0.40	2	0.005	0.150	0.250	150	250	300	450
		0.50	2	0.006	0.200	0.300	180	300	360	540
		0.60	2	0.007	0.250	0.350	210	350	420	630
		0.80	2	0.009	0.300	0.500	270	450	540	810
		1.00	2	0.012	0.400	0.600	360	600	720	1080
		2.00	2	0.024	0.800	1.200	720	1200	1440	2160
			Graphite <b>B</b> <b>B</b>	0.20	2	0.002	0.100	0.200	60	100
0.30	2			0.003	0.100	0.300	90	150	180	270
0.40	2			0.004	0.150	0.400	120	200	240	360
0.50	2			0.005	0.200	0.500	150	250	300	450
0.60	2			0.005	0.250	0.600	150	250	300	450
0.80	2			0.007	0.300	0.800	210	350	420	630
1.00	2			0.009	0.400	1.000	270	450	540	810
2.00	2			0.018	0.800	2.000	540	900	1080	1620
	Graphite <b>B</b> <b>B</b>			0.20	2	0.003	0.020	0.040	90	150
		0.30	2	0.004	0.040	0.050	120	200	240	360
		0.40	2	0.005	0.050	0.070	150	250	300	450
		0.50	2	0.007	0.060	0.090	210	350	420	630
		0.60	2	0.008	0.070	0.110	240	400	480	720
		0.80	2	0.011	0.100	0.140	330	550	660	990
		1.00	2	0.013	0.120	0.180	390	650	780	1170
		2.00	2	0.027	0.240	0.360	810	1350	1620	2430
			Graphite <b>B</b> <b>B</b>	0.20	2	0.003	0.030	0.030	90	150
0.30	2			0.004	0.050	0.050	120	200	240	360
0.40	2			0.005	0.060	0.060	150	250	300	450
0.50	2			0.007	0.080	0.080	210	350	420	630
0.60	2			0.008	0.100	0.100	240	400	480	720
0.80	2			0.011	0.130	0.130	330	550	660	990
1.00	2			0.013	0.160	0.160	390	650	780	1170
2.00	2			0.027	0.320	0.320	810	1350	1620	2430

# Corner radius end mills MicroX (MicrotoroXG)

Shank  $\varnothing$  6mm, cylindrical neck, 8xd



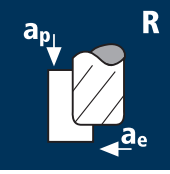


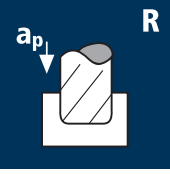


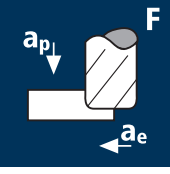





HM  $\lambda$  30°  
XA  $\gamma$  15°



				C Graphite						CF/GF Fiber Reinforced Plastics
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IV

Example: <b>Order-N°.</b>											DIAPLUS
											B6036
$\varnothing$ Code	$d_1$ 0/-0.01	$d_2$ h4	$d_3$	$l_1$	$l_2$	$l_3$	$l_4$	$r$ $\pm 0.005$	$\alpha$	$z$	
Coating: <b>B</b> Article-N°: <b>6036</b> $\varnothing$ -Code: <b>082</b>											
<b>082</b>	0.80	6.00	0.75	57	0.80	6.40	16.85	0.200	9.3°	2	●
<b>100</b>	1.00	6.00	0.95	57	1.00	8.00	18.08	0.200	8.3°	2	●
<b>120</b>	1.50	6.00	1.40	57	1.50	12.00	21.24	0.200	6.4°	2	●
<b>140</b>	2.00	6.00	1.90	61	2.00	16.00	24.31	0.200	4.9°	2	●
<b>180</b>	3.00	6.00	2.80	66	3.00	24.00	30.63	0.200	2.9°	2	●
<b>215</b>	4.00	6.00	3.70	75	4.00	32.00	36.95	0.200	1.7°	2	●
<b>255</b>	5.00	6.00	4.60	80	5.00	40.00	43.27	0.200	0.7°	2	●
<b>295</b>	6.00	6.00	5.50	87	6.00	47.34	48.00	0.200	0.0°	2	●
<b>185</b>	3.00	6.00	2.80	69	3.00	24.00	30.63	0.500	3.0°	2	●
<b>220</b>	4.00	6.00	3.70	75	4.00	32.00	36.95	0.500	1.7°	2	●
<b>260</b>	5.00	6.00	4.60	80	5.00	40.00	43.27	0.500	0.7°	2	●
<b>300</b>	6.00	6.00	5.50	87	6.00	47.34	48.00	0.500	0.0°	2	●

Application	Material	d1 [mm]	z	f <sub>z</sub> [mm]	a <sub>p</sub> [mm]	a <sub>e</sub> [mm]	n=15000 min <sup>-1</sup> vf [mm/min]	n=25000 min <sup>-1</sup> vf [mm/min]	n=30000 min <sup>-1</sup> vf [mm/min]	n=45000 min <sup>-1</sup> vf [mm/min]
	Graphite  	0.80	2	0.009	0.300	0.500	270	450	540	810
		1.00	2	0.012	0.400	0.600	360	600	720	1080
		1.50	2	0.018	0.600	0.900	540	900	1080	1620
		2.00	2	0.024	0.800	1.200	720	1200	1440	2160
		3.00	2	0.035	1.200	1.800	1050	1750	2100	3150
		4.00	2	0.047	1.600	2.400	1410	2350	2820	4230
		5.00	2	0.059	2.000	3.000	1770	2950	3540	5310
		6.00	2	0.071	2.400	3.600	2130	3550	4260	6390
	Graphite  	0.80	2	0.007	0.300	0.800	210	350	420	630
		1.00	2	0.009	0.400	1.000	270	450	540	810
		1.50	2	0.014	0.600	1.500	420	700	840	1260
		2.00	2	0.018	0.800	2.000	540	900	1080	1620
		3.00	2	0.027	1.200	3.000	810	1350	1620	2430
		4.00	2	0.036	1.600	4.000	1080	1800	2160	3240
		5.00	2	0.045	2.000	5.000	1350	2250	2700	4050
		6.00	2	0.055	2.400	6.000	1650	2750	3300	4950
	Graphite  	0.80	2	0.011	0.100	0.140	330	550	660	990
		1.00	2	0.013	0.120	0.180	390	650	780	1170
		1.50	2	0.020	0.180	0.270	600	1000	1200	1800
		2.00	2	0.027	0.240	0.360	810	1350	1620	2430
		3.00	2	0.040	0.360	0.540	1200	2000	2400	3600
		4.00	2	0.053	0.480	0.720	1590	2650	3180	4770
		5.00	2	0.067	0.600	0.900	2010	3350	4020	6030
		6.00	2	0.080	0.720	1.080	2400	4000	4800	7200
	Graphite  	0.80	2	0.011	0.130	0.130	330	550	660	990
		1.00	2	0.013	0.160	0.160	390	650	780	1170
		1.50	2	0.020	0.240	0.240	600	1000	1200	1800
		2.00	2	0.027	0.320	0.320	810	1350	1620	2430
		3.00	2	0.040	0.480	0.480	1200	2000	2400	3600
		4.00	2	0.053	0.640	0.640	1590	2650	3180	4770
		5.00	2	0.067	0.800	0.800	2010	3350	4020	6030
		6.00	2	0.080	0.960	0.960	2400	4000	4800	7200