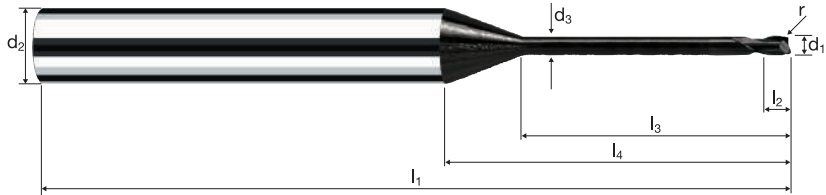


Corner radius end mills MicroX

Shank \varnothing 6mm, cylindrical neck, 12xd



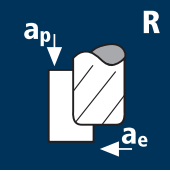


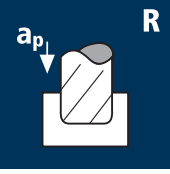


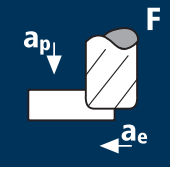





HM	λ 30°
XA	γ 15°



				C								CF/GF Fiber Reinforced Plastics
				Graphite								

IV

Example: Order-N°.											DIAPLUS	
											B6040	
\varnothing Code	d_1 0/-0.01	d_2 h4	d_3	l_1	l_2	l_3	l_4	r ± 0.005	α	z		
028	0.30	6.00	0.25	57	0.30	3.60	20.34	0.050	11.3°	2	●	
040	0.40	6.00	0.35	57	0.40	4.80	21.26	0.050	7.8°	2	●	
048	0.50	6.00	0.45	57	0.50	6.00	17.01	0.050	9.6°	2	●	
058	0.60	6.00	0.55	57	0.60	7.20	18.03	0.050	8.9°	2	●	
078	0.80	6.00	0.75	57	0.80	9.60	20.05	0.050	7.7°	2	●	
096	1.00	6.00	0.95	61	1.00	12.00	22.08	0.050	6.7°	2	●	
050	0.50	6.00	0.45	57	0.50	6.00	17.01	0.100	9.7°	2	●	
060	0.60	6.00	0.55	57	0.60	7.20	18.03	0.100	8.9°	2	●	
080	0.80	6.00	0.75	57	0.80	9.60	20.05	0.100	7.7°	2	●	
098	1.00	6.00	0.95	61	1.00	12.00	22.08	0.100	6.7°	2	●	
138	2.00	6.00	1.90	69	2.00	24.00	32.31	0.100	3.7°	2	●	
082	0.80	6.00	0.75	57	0.80	9.60	20.05	0.200	7.8°	2	●	
100	1.00	6.00	0.95	61	1.00	12.00	22.08	0.200	6.7°	2	●	
120	1.50	6.00	1.40	66	1.50	18.00	27.24	0.200	4.9°	2	●	
140	2.00	6.00	1.90	69	2.00	24.00	32.31	0.200	3.7°	2	●	
180	3.00	6.00	2.80	80	3.00	36.00	42.63	0.200	2.1°	2	●	
185	3.00	6.00	2.80	80	3.00	36.00	42.63	0.500	2.1°	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	0.30	2	0.003	0.100	0.100	90	150	180	270
		0.40	2	0.004	0.100	0.150	120	200	240	360
		0.50	2	0.005	0.150	0.200	150	250	300	450
		0.60	2	0.006	0.200	0.250	180	300	360	540
		0.80	2	0.008	0.250	0.300	240	400	480	720
		1.00	2	0.009	0.300	0.400	270	450	540	810
		1.50	2	0.014	0.450	0.600	420	700	840	1260
		2.00	2	0.019	0.600	0.800	570	950	1140	1710
		3.00	2	0.028	0.900	1.200	840	1400	1680	2520
			Graphite  B  B	0.30	2	0.002	0.050	0.300	60	100
0.40	2			0.003	0.100	0.400	90	150	180	270
0.50	2			0.004	0.100	0.500	120	200	240	360
0.60	2			0.004	0.100	0.600	120	200	240	360
0.80	2			0.006	0.150	0.800	180	300	360	540
1.00	2			0.007	0.200	1.000	210	350	420	630
1.50	2			0.011	0.300	1.500	330	550	660	990
2.00	2			0.015	0.400	2.000	450	750	900	1350
3.00	2			0.022	0.600	3.000	660	1100	1320	1980
	Graphite  B  B			0.30	2	0.003	0.030	0.040	90	150
		0.40	2	0.004	0.040	0.060	120	200	240	360
		0.50	2	0.005	0.050	0.070	150	250	300	450
		0.60	2	0.006	0.060	0.080	180	300	360	540
		0.80	2	0.009	0.080	0.110	270	450	540	810
		1.00	2	0.011	0.100	0.140	330	550	660	990
		1.50	2	0.016	0.150	0.210	480	800	960	1440
		2.00	2	0.021	0.200	0.280	630	1050	1260	1890
		3.00	2	0.032	0.300	0.420	960	1600	1920	2880
			Graphite  B  B	0.30	2	0.003	0.030	0.030	90	150
0.40	2			0.004	0.040	0.040	120	200	240	360
0.50	2			0.005	0.050	0.050	150	250	300	450
0.60	2			0.006	0.060	0.060	180	300	360	540
0.80	2			0.009	0.080	0.080	270	450	540	810
1.00	2			0.011	0.100	0.100	330	550	660	990
1.50	2			0.016	0.150	0.150	480	800	960	1440
2.00	2			0.021	0.200	0.200	630	1050	1260	1890
3.00	2			0.032	0.300	0.300	960	1600	1920	2880