

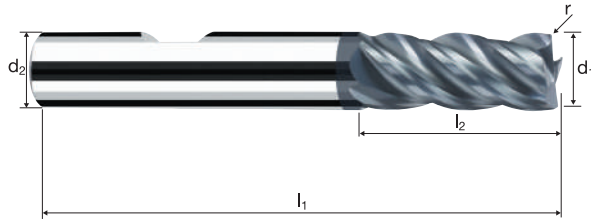
Corner radius end mills

Smooth-edged, normal version



HM
MG10

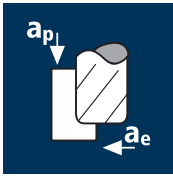
λ 40°
 γ 0°



Rm < 850 Rm 850-1100 Rm 1100-1300 Rm 1300-1500 Inox Stainless Ti Titanium GG(G) Tool Steel Nickel-Alloys

Example: Order-N°.										POLYCHROM
										P15326
										P15226
\emptyset Code	d_1 e8	d_2 h6	l_1	l_2	l_4	r 0/+0.03	α	z		
180	3.00	6.00	57	8.00	15.56	0.500	6.0°	4	●	
220	4.00	6.00	57	11.00	16.89	0.500	4.0°	4	●	
260	5.00	6.00	57	13.00	17.22	0.500	2.0°	4	●	
300	6.00	6.00	57	13.00	-	0.500	0.0°	4	●	
388	8.00	8.00	63	19.00	-	0.500	0.0°	4	●	
448	10.00	10.00	72	22.00	-	0.500	0.0°	4	●	
498	12.00	12.00	83	26.00	-	0.500	0.0°	4	●	
302	6.00	6.00	57	13.00	-	1.000	0.0°	4	●	
391	8.00	8.00	63	19.00	-	1.000	0.0°	4	●	
450	10.00	10.00	72	22.00	-	1.000	0.0°	4	●	
501	12.00	12.00	83	26.00	-	1.000	0.0°	4	●	
608	16.00	16.00	92	32.00	-	1.000	0.0°	4	●	
680	20.00	20.00	104	38.00	-	1.000	0.0°	4	●	
453	10.00	10.00	72	22.00	-	1.500	0.0°	4	●	
503	12.00	12.00	83	26.00	-	1.500	0.0°	4	●	
610	16.00	16.00	92	32.00	-	1.500	0.0°	4	●	

Application



Material

Steel
< 850 N/mm²



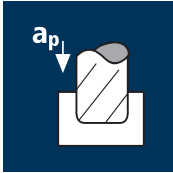
Steel
850 - 1100 N/mm²



Cold work tool steel
(12% Cr),
high alloyed
[1.2379]



Inox normal
[Cr-Ni/1.4301]
[Cr-Ni-Mo/1.4571]



Steel
< 850 N/mm²



Steel
850 - 1100 N/mm²



Cold work tool steel
(12% Cr),
high alloyed
[1.2379]



Inox normal
[Cr-Ni/1.4301]
[Cr-Ni-Mo/1.4571]



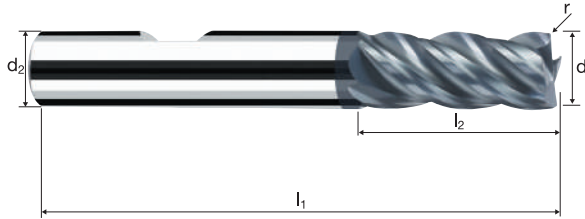
d1 [mm]	z	v _c [m/min]	f _s [mm]	a _p [mm]	a _e [mm]	n [min ⁻¹]	v _r [mm/min]	Q [cm ³ /min]
3.00	4	190	0.020	4.500	1.200	20160	1615	8.7
4.00	4	190	0.025	6.000	1.600	15120	1510	14.5
5.00	4	190	0.035	7.500	2.000	12095	1695	25.4
6.00	4	190	0.040	9.000	2.400	10080	1615	34.8
8.00	4	190	0.055	12.000	3.200	7560	1665	63.9
10.00	4	190	0.070	15.000	4.000	6050	1695	101.6
12.00	4	190	0.075	18.000	4.800	5040	1510	130.6
16.00	4	190	0.100	24.000	6.400	3780	1510	232.2
20.00	4	190	0.130	30.000	8.000	3025	1570	377.4
3.00	4	140	0.020	4.500	1.200	14855	1190	6.4
4.00	4	140	0.025	6.000	1.600	11140	1115	10.7
5.00	4	140	0.035	7.500	2.000	8915	1250	18.7
6.00	4	140	0.040	9.000	2.400	7425	1190	25.7
8.00	4	140	0.055	12.000	3.200	5570	1225	47.1
10.00	4	140	0.070	15.000	4.000	4455	1250	74.9
12.00	4	140	0.075	18.000	4.800	3715	1115	96.3
16.00	4	140	0.100	24.000	6.400	2785	1115	171.1
20.00	4	140	0.130	30.000	8.000	2230	1160	278.1
3.00	4	70	0.020	4.500	1.200	7425	595	3.2
4.00	4	70	0.025	6.000	1.600	5570	555	5.3
5.00	4	70	0.030	7.500	2.000	4455	535	8.0
6.00	4	70	0.040	9.000	2.400	3715	595	12.8
8.00	4	70	0.050	12.000	3.200	2785	555	21.4
10.00	4	70	0.065	15.000	4.000	2230	580	34.8
12.00	4	70	0.075	18.000	4.800	1855	555	48.1
16.00	4	70	0.095	24.000	6.400	1395	530	81.3
20.00	4	70	0.120	30.000	8.000	1115	535	128.3
3.00	4	90	0.015	4.500	1.200	9550	575	3.1
4.00	4	90	0.020	6.000	1.600	7160	575	5.5
5.00	4	90	0.020	7.500	2.000	5730	460	6.9
6.00	4	90	0.030	9.000	2.400	4775	575	12.4
8.00	4	90	0.035	12.000	3.200	3580	500	19.3
10.00	4	90	0.045	15.000	4.000	2865	515	30.9
12.00	4	90	0.055	18.000	4.800	2385	525	45.4
16.00	4	90	0.065	24.000	6.400	1790	465	71.5
20.00	4	90	0.085	30.000	8.000	1430	485	116.9
3.00	4	155	0.015	3.000	3.000	16445	985	8.9
4.00	4	155	0.020	4.000	4.000	12335	985	15.8
5.00	4	155	0.030	5.000	5.000	9870	1185	29.6
6.00	4	155	0.035	6.000	6.000	8225	1150	41.4
8.00	4	155	0.045	8.000	8.000	6165	1110	71.0
10.00	4	155	0.055	10.000	10.000	4935	1085	108.5
12.00	4	155	0.060	12.000	12.000	4110	985	142.1
16.00	4	155	0.075	8.000	16.000	3085	925	118.4
20.00	4	155	0.095	10.000	20.000	2465	935	187.5
3.00	4	105	0.015	3.000	3.000	11140	670	6.0
4.00	4	105	0.020	4.000	4.000	8355	670	10.7
5.00	4	105	0.030	5.000	5.000	6685	800	20.1
6.00	4	105	0.035	6.000	6.000	5570	780	28.1
8.00	4	105	0.045	8.000	8.000	4180	750	48.1
10.00	4	105	0.055	10.000	10.000	3340	735	73.5
12.00	4	105	0.060	12.000	12.000	2785	670	96.3
16.00	4	105	0.075	8.000	16.000	2090	625	80.2
20.00	4	105	0.095	10.000	20.000	1670	635	127.0
3.00	4	55	0.015	3.000	3.000	5835	350	3.2
4.00	4	55	0.020	4.000	4.000	4375	350	5.6
5.00	4	55	0.030	5.000	5.000	3500	420	10.5
6.00	4	55	0.035	6.000	6.000	2920	410	14.7
8.00	4	55	0.045	8.000	8.000	2190	395	25.2
10.00	4	55	0.055	10.000	10.000	1750	385	38.5
12.00	4	55	0.060	12.000	12.000	1460	350	50.4
16.00	4	55	0.075	8.000	16.000	1095	330	42.0
20.00	4	55	0.095	10.000	20.000	875	335	66.5
3.00	4	70	0.010	3.000	3.000	7425	295	2.7
4.00	4	70	0.015	4.000	4.000	5570	335	5.3
5.00	4	70	0.025	5.000	5.000	4455	445	11.1
6.00	4	70	0.030	6.000	6.000	3715	445	16.0
8.00	4	70	0.035	8.000	8.000	2785	390	25.0
10.00	4	70	0.045	10.000	10.000	2230	400	40.1
12.00	4	70	0.050	12.000	12.000	1855	370	53.5
16.00	4	70	0.060	8.000	16.000	1395	335	42.8
20.00	4	70	0.075	10.000	20.000	1115	335	66.8

Corner radius end mills

Smooth-edged, normal version



HM
MG10 λ 40°
 γ 0°



Roughing

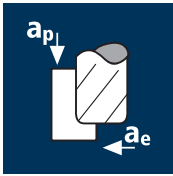
Finishing



Rm < 850	Rm 850-1100	Rm 1100-1300	Rm 1300-1500				Inox Stainless	Ti Titanium	GG(G) Tool Steel Nickel-Alloys
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										POLYCHROM				
Example: Order-N°.										P	15326	505		
Ø Code	d ₁ e8	d ₂ h6	l ₁	l ₂	l ₄	r 0/+0.03	α	z						
505	12.00	12.00	83	26.00	-	2.000	0.0°	4	●					
611	16.00	16.00	92	32.00	-	2.000	0.0°	4	●					
683	20.00	20.00	104	38.00	-	2.000	0.0°	4	●					
457	10.00	10.00	72	22.00	-	2.500	0.0°	4	●					
506	12.00	12.00	83	26.00	-	2.500	0.0°	4	●					
612	16.00	16.00	92	32.00	-	2.500	0.0°	4	●					
684	20.00	20.00	104	38.00	-	2.500	0.0°	4	●					
508	12.00	12.00	83	26.00	-	4.000	0.0°	4	●					
614	16.00	16.00	92	32.00	-	4.000	0.0°	4	●					
686	20.00	20.00	104	38.00	-	4.000	0.0°	4	●					

Application



Material

Steel
< 850 N/mm²



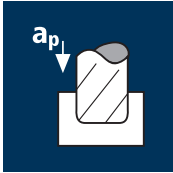
Steel
850 - 1100 N/mm²



Cold work tool steel
(12% Cr),
high alloyed
[1.2379]



Inox normal
[Cr-Ni/1.4301]
[Cr-Ni-Mo/1.4571]



Steel
< 850 N/mm²



Steel
850 - 1100 N/mm²



Cold work tool steel
(12% Cr),
high alloyed
[1.2379]



Inox normal
[Cr-Ni/1.4301]
[Cr-Ni-Mo/1.4571]



d1 [mm]	z	v _c [m/min]	f _t [mm]	a _p [mm]	a _e [mm]	n [min ⁻¹]	v _r [mm/min]	Q [cm ³ /min]
10.00	4	190	0.070	15.000	4.000	6050	1695	101.6
12.00	4	190	0.075	18.000	4.800	5040	1510	130.6
16.00	4	190	0.100	24.000	6.400	3780	1510	232.2
20.00	4	190	0.130	30.000	8.000	3025	1570	377.4
10.00	4	140	0.070	15.000	4.000	4455	1250	74.9
12.00	4	140	0.075	18.000	4.800	3715	1115	96.3
16.00	4	140	0.100	24.000	6.400	2785	1115	171.1
20.00	4	140	0.130	30.000	8.000	2230	1160	278.1
10.00	4	70	0.065	15.000	4.000	2230	580	34.8
12.00	4	70	0.075	18.000	4.800	1855	555	48.1
16.00	4	70	0.095	24.000	6.400	1395	530	81.3
20.00	4	70	0.120	30.000	8.000	1115	535	128.3
10.00	4	90	0.045	15.000	4.000	2865	515	30.9
12.00	4	90	0.055	18.000	4.800	2385	525	45.4
16.00	4	90	0.065	24.000	6.400	1790	465	71.5
20.00	4	90	0.085	30.000	8.000	1430	485	116.9
10.00	4	155	0.055	10.000	10.000	4935	1085	108.5
12.00	4	155	0.060	12.000	12.000	4110	985	142.1
16.00	4	155	0.075	8.000	16.000	3085	925	118.4
20.00	4	155	0.095	10.000	20.000	2465	935	187.5
10.00	4	105	0.055	10.000	10.000	3340	735	73.5
12.00	4	105	0.060	12.000	12.000	2785	670	96.3
16.00	4	105	0.075	8.000	16.000	2090	625	80.2
20.00	4	105	0.095	10.000	20.000	1670	635	127.0
10.00	4	55	0.055	10.000	10.000	1750	385	38.5
12.00	4	55	0.060	12.000	12.000	1460	350	50.4
16.00	4	55	0.075	8.000	16.000	1095	330	42.0
20.00	4	55	0.095	10.000	20.000	875	335	66.5
10.00	4	70	0.045	10.000	10.000	2230	400	40.1
12.00	4	70	0.050	12.000	12.000	1855	370	53.5
16.00	4	70	0.060	8.000	16.000	1395	335	42.8
20.00	4	70	0.075	10.000	20.000	1115	335	66.8