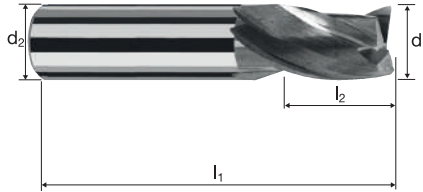
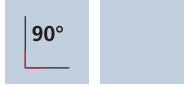


Cylindrical end mills

Smooth-edged, short-shank version



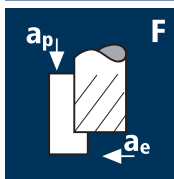
HM MG10	λ 30° γ 12°
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Rm < 850	Rm 850-1100	Rm 1100-1300					Inox Stainless	Ti Titanium	Nickel-Alloys Copper Platinum
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Example: Order-N°.									POLYCHROM
Coating Article-N° ø-Code									
P 15232 120									P15232
Ø Code	d ₁ e8	d ₂ h6	l ₁	l ₂	l ₄	α	z		
120	1.50	6.00	38	3.00	11.92	11.5°	3	●	
140	2.00	6.00	38	3.00	11.15	11.0°	3	●	
160	2.50	6.00	38	3.00	10.88	10.0°	3	●	
180	3.00	6.00	38	4.00	11.96	8.0°	3	●	
200	3.50	6.00	38	4.00	11.02	7.0°	3	●	
220	4.00	6.00	38	5.00	11.59	5.5°	3	●	
240	4.50	6.00	38	5.00	10.66	4.5°	3	●	
260	5.00	6.00	38	6.00	10.72	3.0°	3	●	
300	6.00	6.00	38	7.00	-	0.0°	3	●	
391	8.00	8.00	41	9.00	-	0.0°	3	●	
450	10.00	10.00	48	11.00	-	0.0°	3	●	

Application



Material

Steel
< 850 N/mm²

Steel
850 - 1100 N/mm²

Titanium alloys
up to 300 HB
[Ti5Al2.5Sn]

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

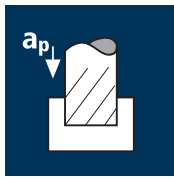
d1 [mm]	z	v _c [m/min]	f _f [mm]	a _p [mm]	a _e [mm]	n [min ⁻¹]	v _r [mm/min]
2.00	3	120	0.005	2.000	0.300	19100	285
3.00	3	120	0.010	3.000	0.500	12730	380
4.00	3	120	0.015	4.000	0.600	9550	430
5.00	3	120	0.015	5.000	0.800	7640	345
6.00	3	120	0.020	6.000	0.900	6365	380
8.00	3	120	0.025	8.000	1.200	4775	360
10.00	3	120	0.035	10.000	1.500	3820	400

2.00	3	75	0.005	2.000	0.300	11935	180
3.00	3	75	0.010	3.000	0.500	7960	240
4.00	3	75	0.015	4.000	0.600	5970	270
5.00	3	75	0.015	5.000	0.800	4775	215
6.00	3	75	0.020	6.000	0.900	3980	240
8.00	3	75	0.025	8.000	1.200	2985	225
10.00	3	75	0.035	10.000	1.500	2385	250

2.00	3	60	0.005	2.000	0.300	9550	145
3.00	3	60	0.010	3.000	0.500	6365	190
4.00	3	60	0.015	4.000	0.600	4775	215
5.00	3	60	0.015	5.000	0.800	3820	170
6.00	3	60	0.020	6.000	0.900	3185	190
8.00	3	60	0.025	8.000	1.200	2385	180
10.00	3	60	0.035	10.000	1.500	1910	200

2.00	3	80	0.005	2.000	0.300	12730	190
3.00	3	80	0.010	3.000	0.500	8490	255
4.00	3	80	0.015	4.000	0.600	6365	285
5.00	3	80	0.015	5.000	0.800	5095	230
6.00	3	80	0.020	6.000	0.900	4245	255
8.00	3	80	0.025	8.000	1.200	3185	240
10.00	3	80	0.035	10.000	1.500	2545	265

Application



Material

Steel
< 850 N/mm²

Steel
850 - 1100 N/mm²

Titanium alloys
up to 300 HB
[Ti5Al2.5Sn]

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

d1 [mm]	z	v _c [m/min]	f _f [mm]	a _p [mm]	a _e [mm]	n [min ⁻¹]	v _r [mm/min]	Q [cm ³ /min]
2.00	3	95	0.005	1.600	2.000	15120	225	0.7
3.00	3	95	0.010	2.400	3.000	10080	300	2.2
4.00	3	95	0.010	3.200	4.000	7560	225	2.9
5.00	3	95	0.015	4.000	5.000	6050	270	5.4
6.00	3	95	0.015	4.800	6.000	5040	225	6.5
8.00	3	95	0.020	6.400	8.000	3780	225	11.6
10.00	3	95	0.030	8.000	10.000	3025	270	21.8

2.00	3	60	0.005	1.600	2.000	9550	145	0.5
3.00	3	60	0.010	2.400	3.000	6365	190	1.4
4.00	3	60	0.010	3.200	4.000	4775	145	1.8
5.00	3	60	0.015	4.000	5.000	3820	170	3.4
6.00	3	60	0.015	4.800	6.000	3185	145	4.1
8.00	3	60	0.020	6.400	8.000	2385	145	7.3
10.00	3	60	0.025	8.000	10.000	1910	145	11.5

2.00	3	45	0.005	1.600	2.000	7160	105	0.3
3.00	3	45	0.010	2.400	3.000	4775	145	1.0
4.00	3	45	0.010	3.200	4.000	3580	105	1.4
5.00	3	45	0.015	4.000	5.000	2865	130	2.6
6.00	3	45	0.015	4.800	6.000	2385	105	3.1
8.00	3	45	0.020	6.400	8.000	1790	105	5.5
10.00	3	45	0.025	8.000	10.000	1430	105	8.6

2.00	3	55	0.005	1.600	2.000	8755	130	0.4
3.00	3	55	0.010	2.400	3.000	5835	175	1.3
4.00	3	55	0.010	3.200	4.000	4375	130	1.7
5.00	3	55	0.015	4.000	5.000	3500	160	3.2
6.00	3	55	0.015	4.800	6.000	2920	130	3.8
8.00	3	55	0.020	6.400	8.000	2190	130	6.7
10.00	3	55	0.025	8.000	10.000	1750	130	10.5