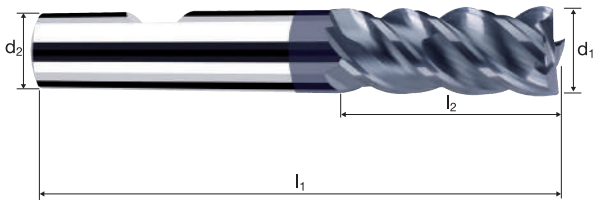
Cylindrical end mills NVD

Smooth-edged, normal version

HM MG10	λ 45° γ 0°

45°

Vario

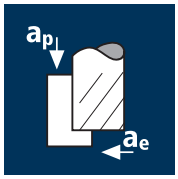


Roughing HPC | Roughing HDC | Finishing

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

Example: **Order-N°.** Coating **P** Article-N°. **15307** ø-Code **180**

Ø Code	d_1 e8	d_2 h6	l_1	l_2	l_4	45°	α	z	POLYCHROM P15307	POLYCHROM P15207
180	3.00	6.00	57	8.00	15.56	0.10	6.0°	4		●
220	4.00	6.00	57	8.00	14.59	0.10	4.5°	4		●
260	5.00	6.00	57	10.00	14.72	0.15	2.5°	4		●
300	6.00	6.00	57	12.00	-	0.15	0.0°	4		●
391	8.00	8.00	63	19.00	-	0.15	0.0°	4		●
450	10.00	10.00	72	23.00	-	0.20	0.0°	4		●
501	12.00	12.00	83	27.00	-	0.20	0.0°	4		●
610	16.00	16.00	92	32.00	-	0.20	0.0°	4		●
682	20.00	20.00	104	39.00	-	0.20	0.0°	4		●

Application	Material	d1 [mm]	z	v_c [m/min]	f_z [mm]	a_p [mm]	a_e [mm]	n [min⁻¹]	v_f [mm/min]	Q [cm³/min]
	Steel < 850 N/mm²	4.00	4	180	0.035	6.000	1.600	14325	2005	19.3
		5.00	4	180	0.040	7.500	2.000	11460	1835	27.5
		6.00	4	180	0.050	9.000	2.400	9550	1910	41.3
		8.00	4	180	0.060	12.000	3.200	7160	1720	66.0
		10.00	4	180	0.075	15.000	4.000	5730	1720	103.1
		12.00	4	180	0.085	18.000	4.800	4775	1625	140.3
		16.00	4	180	0.095	24.000	6.400	3580	1360	209.0
		20.00	4	180	0.110	30.000	8.000	2865	1260	302.5
	Steel 850 - 1100 N/mm²	4.00	4	150	0.030	6.000	1.600	11935	1430	13.8
		5.00	4	150	0.035	7.500	2.000	9550	1335	20.1
		6.00	4	150	0.040	9.000	2.400	7960	1275	27.5
		8.00	4	150	0.050	12.000	3.200	5970	1195	45.8
		10.00	4	150	0.065	15.000	4.000	4775	1240	74.5
		12.00	4	150	0.075	18.000	4.800	3980	1195	103.1
		16.00	4	150	0.085	24.000	6.400	2985	1015	155.8
		20.00	4	150	0.100	30.000	8.000	2385	955	229.2
	Cold work tool steel (12% Cr), high alloyed [1.2379]	4.00	4	70	0.030	6.000	1.600	5570	670	6.4
		5.00	4	70	0.035	7.500	2.000	4455	625	9.4
		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	0.060	15.000	4.000	2230	535	32.1
		12.00	4	70	0.075	18.000	4.800	1855	555	48.1
		16.00	4	70	0.085	24.000	6.400	1395	475	72.7
		20.00	4	70	0.095	30.000	8.000	1115	425	101.6
	Inox normal [Cr-Ni/1.4301] [Cr-Ni-Mo/1.4571]	4.00	4	90	0.020	6.000	1.600	7160	575	5.5
		5.00	4	90	0.025	7.500	2.000	5730	575	8.6
		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	0.080	30.000	8.000	1430	460	110.0
	Steel < 850 N/mm²	4.00	4	145	0.025	5.000	4.000	11540	1155	23.1
		5.00	4	145	0.030	6.250	5.000	9230	1110	34.6
		6.00	4	145	0.040	7.500	6.000	7690	1230	55.4
		8.00	4	145	0.045	10.000	8.000	5770	1040	83.1
		10.00	4	145	0.055	12.500	10.000	4615	1015	126.9
		12.00	4	145	0.065	15.000	12.000	3845	1000	180.0
		16.00	4	145	0.070	20.000	16.000	2885	810	258.5
		20.00	4	145	0.085	25.000	20.000	2310	785	392.3
	Steel 850 - 1100 N/mm²	4.00	4	120	0.020	5.000	4.000	9550	765	15.3
		5.00	4	120	0.025	6.250	5.000	7640	765	23.9
		6.00	4	120	0.030	7.500	6.000	6365	765	34.4
		8.00	4	120	0.040	10.000	8.000	4775	765	61.1
		10.00	4	120	0.050	12.500	10.000	3820	765	95.5
		12.00	4	120	0.055	15.000	12.000	3185	700	126.1
		16.00	4	120	0.065	20.000	16.000	2385	620	198.6
		20.00	4	120	0.075	25.000	20.000	1910	575	286.5
	Cold work tool steel (12% Cr), high alloyed [1.2379]	4.00	4	55	0.025	5.000	4.000	4375	440	8.8
		5.00	4	55	0.025	6.250	5.000	3500	350	10.9
		6.00	4	55	0.030	7.500	6.000	2920	350	15.8
		8.00	4	55	0.040	10.000	8.000	2190	350	28.0
		10.00	4	55	0.045	12.500	10.000	1750	315	39.4
		12.00	4	55	0.055	15.000	12.000	1460	320	57.8
		16.00	4	55	0.065	20.000	16.000	1095	285	91.0
		20.00	4	55	0.070	25.000	20.000	875	245	122.5
	Inox normal [Cr-Ni/1.4301] [Cr-Ni-Mo/1.4571]	4.00	4	70	0.015	5.000	4.000	5570	335	6.7
		5.00	4	70	0.020	6.250	5.000	4455	355	11.1
		6.00	4	70	0.025	7.500	6.000	3715	370	16.7
		8.00	4	70	0.025	10.000	8.000	2785	280	22.3
		10.00	4	70	0.035	12.500	10.000	2230	310	39.0
		12.00	4	70	0.040	15.000	12.000	1855	295	53.5
		16.00	4	70	0.050	20.000	16.000	1395	280	89.1
		20.00	4	70	0.060	25.000	20.000	1115	265	133.7