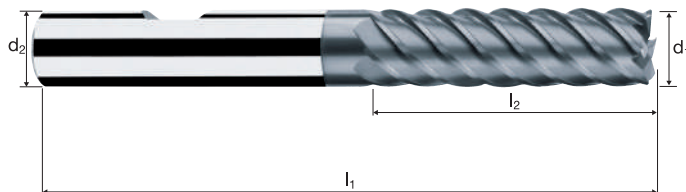


Cylindrical end mills

Finishing, medium length version



HM λ **45°**
MG10 γ **8°**



Roughing



Finishing

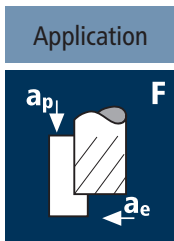


ToolSchool

P46210 / P46310
P8311

Rm < 850	Rm 850-1100	Rm 1100-1300					Ti Titanium	GG(G) Copper
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Ø Code	d ₁ e8	d ₂ h6	l ₁	l ₂	45°	z	POLYCHROM	
Example: Order-N°. Coating P Article-N° 45362 ø-Code 300								
								P45362
								P45262
300	6.00	6.00	63	19.00	0.15	6		●
391	8.00	8.00	72	28.00	0.15	6		●
450	10.00	10.00	84	34.00	0.20	6		●
501	12.00	12.00	97	40.00	0.20	6		●
610	16.00	16.00	108	48.00	0.20	6		●
682	20.00	20.00	122	56.00	0.20	6		●



Material

Steel
< 850 N/mm²

Steel
850 - 1100 N/mm²

Steel
1100 - 1300 N/mm²

Cast iron
(lamellar / spheroidal)

Titanium alloys
> 300 HB
[Ti6Al4V]

Unalloyed copper

d1 [mm]	z	v _c [m/min]	f _i [mm]	a _p [mm]	a _e [mm]	n [min ⁻¹]	v _r [mm/min]
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6.00	6	120	0.016	15.000	0.150	6365	610
8.00	6	120	0.020	20.000	0.150	4775	575
10.00	6	120	0.026	25.000	0.150	3820	595
12.00	6	120	0.030	30.000	0.150	3185	575
16.00	6	120	0.040	40.000	0.250	2385	575
20.00	6	120	0.050	50.000	0.250	1910	575

6.00	6	100	0.016	15.000	0.150	5305	510
8.00	6	100	0.020	20.000	0.150	3980	475
10.00	6	100	0.026	25.000	0.150	3185	495
12.00	6	100	0.030	30.000	0.150	2655	475
16.00	6	100	0.040	40.000	0.250	1990	475
20.00	6	100	0.050	50.000	0.250	1590	475

6.00	6	80	0.016	15.000	0.150	4245	405
8.00	6	80	0.020	20.000	0.150	3185	380
10.00	6	80	0.026	25.000	0.150	2545	395
12.00	6	80	0.030	30.000	0.150	2120	380
16.00	6	80	0.040	40.000	0.250	1590	380
20.00	6	80	0.050	50.000	0.250	1275	380

6.00	6	100	0.016	15.000	0.150	5305	510
8.00	6	100	0.020	20.000	0.150	3980	475
10.00	6	100	0.026	25.000	0.150	3185	495
12.00	6	100	0.030	30.000	0.150	2655	475
16.00	6	100	0.040	40.000	0.250	1990	475
20.00	6	100	0.050	50.000	0.250	1590	475

6.00	6	40	0.016	15.000	0.150	2120	205
8.00	6	40	0.020	20.000	0.150	1590	190
10.00	6	40	0.026	25.000	0.150	1275	200
12.00	6	40	0.030	30.000	0.150	1060	190
16.00	6	40	0.040	40.000	0.250	795	190
20.00	6	40	0.050	50.000	0.250	635	190

6.00	6	150	0.016	15.000	0.150	7960	765
8.00	6	150	0.020	20.000	0.150	5970	715
10.00	6	150	0.026	25.000	0.150	4775	745
12.00	6	150	0.030	30.000	0.150	3980	715
16.00	6	150	0.040	40.000	0.250	2985	715
20.00	6	150	0.050	50.000	0.250	2385	715