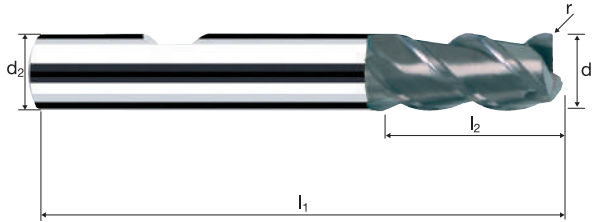


Corner radius end mills

Smooth-edged, normal version



HM	λ 45°
MG10	γ 15°



Roughing

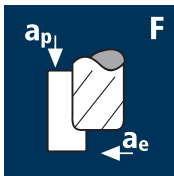
Finishing



Rm < 850	Rm 850-1100	Rm 1100-1300					Inox Stainless		GG(G) Copper
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Example: Order-N°.										POLYCHROM
										P5334
										P5234
\emptyset Code	d_1 e8	d_2 h6	l_1	l_2	l_4	r 0/+0.03	α	z		
178	3.00	6.00	57	7.00	14.96	0.200	6.0°	3		●
218	4.00	6.00	57	8.00	14.59	0.200	4.5°	3		●
258	5.00	6.00	57	10.00	14.72	0.200	2.5°	3		●
297	6.00	6.00	57	10.00	-	0.200	0.0°	3		●
388	8.00	8.00	63	16.00	-	0.200	0.0°	3		●
445	10.00	10.00	72	19.00	-	0.200	0.0°	3		●
496	12.00	12.00	83	22.00	-	0.200	0.0°	3		●
180	3.00	6.00	57	7.00	14.96	0.500	6.0°	3		●
220	4.00	6.00	57	8.00	14.59	0.500	4.5°	3		●
260	5.00	6.00	57	10.00	14.72	0.500	2.5°	3		●
300	6.00	6.00	57	10.00	-	0.500	0.0°	3		●
391	8.00	8.00	63	16.00	-	0.500	0.0°	3		●
450	10.00	10.00	72	19.00	-	0.500	0.0°	3		●
501	12.00	12.00	83	22.00	-	0.500	0.0°	3		●

Application



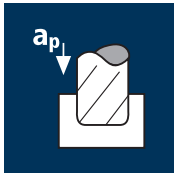
Material

Steel
< 850 N/mm²

Steel
850 - 1100 N/mm²

Cast iron
(lamellar / spheroidal)

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



Steel
< 850 N/mm²

Steel
850 - 1100 N/mm²

Cast iron
(lamellar / spheroidal)

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

d1 [mm]	z	v _c [m/min]	f _c [mm]	a _p [mm]	a _e [mm]	n [min ⁻¹]	v _r [mm/min]	Q [cm ³ /min]
3.00	3	115	0.010	4.500	0.300	12200	365	0.5
4.00	3	115	0.015	6.000	0.400	9150	410	1.0
5.00	3	115	0.015	7.500	0.500	7320	330	1.2
6.00	3	115	0.020	9.000	0.600	6100	365	2.0
8.00	3	115	0.025	12.000	0.800	4575	345	3.3
10.00	3	115	0.035	15.000	1.000	3660	385	5.8
12.00	3	115	0.040	18.000	1.200	3050	365	7.9

3.00	3	75	0.010	1.500	0.300	7960	240	0.1
4.00	3	75	0.015	6.000	0.400	5970	270	0.6
5.00	3	75	0.015	7.500	0.500	4775	215	0.8
6.00	3	75	0.020	9.000	0.600	3980	240	1.3
8.00	3	75	0.025	12.000	0.800	2985	225	2.1
10.00	3	75	0.035	15.000	1.000	2385	250	3.8
12.00	3	75	0.040	18.000	1.200	1990	240	5.2

3.00	3	150	0.010	4.500	0.300	15915	475	0.6
4.00	3	150	0.015	6.000	0.400	11935	535	1.3
5.00	3	150	0.015	7.500	0.500	9550	430	1.6
6.00	3	150	0.020	9.000	0.600	7960	475	2.6
8.00	3	150	0.025	12.000	0.800	5970	450	4.3
10.00	3	150	0.035	15.000	1.000	4775	500	7.5
12.00	3	150	0.040	18.000	1.200	3980	475	10.3

3.00	3	60	0.010	4.500	0.300	6365	190	0.3
4.00	3	60	0.015	6.000	0.400	4775	215	0.5
5.00	3	60	0.015	7.500	0.500	3820	170	0.6
6.00	3	60	0.020	9.000	0.600	3185	190	1.0
8.00	3	60	0.025	12.000	0.800	2385	180	1.7
10.00	3	60	0.035	15.000	1.000	1910	200	3.0
12.00	3	60	0.040	18.000	1.200	1590	190	4.1

3.00	3	85	0.010	1.500	3.000	9020	270	1.2
4.00	3	85	0.010	2.000	4.000	6765	205	1.6
5.00	3	85	0.015	2.500	5.000	5410	245	3.0
6.00	3	85	0.015	3.000	6.000	4510	205	3.7
8.00	3	85	0.020	4.000	8.000	3380	205	6.5
10.00	3	85	0.030	5.000	10.000	2705	245	12.2
12.00	3	85	0.035	6.000	12.000	2255	235	17.0

3.00	3	60	0.010	1.500	3.000	6365	190	0.9
4.00	3	60	0.010	2.000	4.000	4775	145	1.1
5.00	3	60	0.015	2.500	5.000	3820	170	2.1
6.00	3	60	0.015	3.000	6.000	3185	145	2.6
8.00	3	60	0.020	4.000	8.000	2385	145	4.6
10.00	3	60	0.025	5.000	10.000	1910	145	7.2
12.00	3	60	0.030	6.000	12.000	1590	145	10.3

3.00	3	105	0.010	1.500	3.000	11140	335	1.5
4.00	3	105	0.010	2.000	4.000	8355	250	2.0
5.00	3	105	0.015	2.500	5.000	6685	300	3.8
6.00	3	105	0.015	3.000	6.000	5570	250	4.5
8.00	3	105	0.020	4.000	8.000	4180	250	8.0
10.00	3	105	0.025	5.000	10.000	3340	250	12.5
12.00	3	105	0.030	6.000	12.000	2785	250	18.0

3.00	3	40	0.010	1.500	3.000	4245	125	0.6
4.00	3	40	0.010	2.000	4.000	3185	95	0.8
5.00	3	40	0.015	2.500	5.000	2545	115	1.4
6.00	3	40	0.015	3.000	6.000	2120	95	1.7
8.00	3	40	0.020	4.000	8.000	1590	95	3.1
10.00	3	40	0.025	5.000	10.000	1275	95	4.8
12.00	3	40	0.030	6.000	12.000	1060	95	6.9