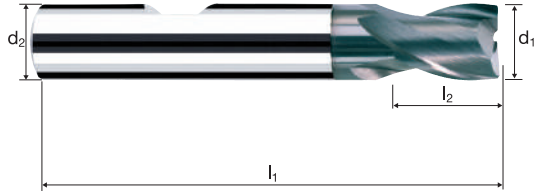


Cylindrical end mills

Smooth-edged, short version



HM	λ 30°
MG10	γ 12°

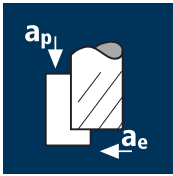


Roughing	Finishing

Rm	Rm	Rm						Inox		GG(G)	Copper
< 850	850-1100	1100-1300						Stainless			

Example:										POLYCHROM		
Order-N°.										P5400		
										P5299		
Ø Code	d ₁ e ₈	d ₂ h ₆	Coating		Article-N°.		ø-Code		45°	α	z	
			P	5400	100	100						
			l₁	l₂	l₄							
100	1.00	6.00	50	3.00	13.79	0.07	11.0°	2				●
120	1.50	6.00	50	3.00	12.86	0.07	10.5°	2				●
140	2.00	6.00	50	3.00	12.32	0.10	10.0°	2				●
160	2.50	6.00	50	3.00	11.39	0.10	9.5°	2				●
180	3.00	6.00	50	4.00	11.96	0.10	8.0°	2				●
220	4.00	6.00	54	5.00	11.59	0.10	5.5°	2				●
260	5.00	6.00	54	6.00	10.72	0.15	3.0°	2				●
300	6.00	6.00	54	7.00	-	0.15	0.0°	2				●

Application



Material

Steel
< 850 N/mm²



d1 [mm]	z	v _c [m/min]	f _t [mm]	a _p [mm]	a _e [mm]	n [min ⁻¹]	v _r [mm/min]
1.00	2	115	0.005	1.000	0.500	36605	365
2.00	2	115	0.005	2.000	0.900	18305	185
2.50	2	115	0.005	2.000	1.100	14640	145
3.00	2	115	0.010	3.000	1.400	12200	245
4.00	2	115	0.015	4.000	1.800	9150	275
5.00	2	115	0.020	5.000	2.300	7320	295
6.00	2	115	0.025	6.000	2.700	6100	305

Steel
850 - 1100 N/mm²



1.00	2	75	0.005	1.000	0.500	23875	240
2.00	2	75	0.005	2.000	0.900	11935	120
2.50	2	75	0.005	2.000	1.100	9550	95
3.00	2	75	0.010	3.000	1.400	7960	160
4.00	2	75	0.015	4.000	1.800	5970	180
5.00	2	75	0.020	5.000	2.300	4775	190
6.00	2	75	0.020	6.000	2.700	3980	160

Cast iron
(lamellar / spheroidal)



1.00	2	132	0.005	1.000	0.500	42015	420
2.00	2	150	0.005	2.000	0.900	23875	240
2.50	2	150	0.005	2.000	1.100	19100	190
3.00	2	150	0.015	3.000	1.400	15915	475
4.00	2	150	0.020	4.000	1.800	11935	475
5.00	2	150	0.020	5.000	2.300	9550	380
6.00	2	150	0.025	6.000	2.700	7960	400

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



1.00	2	40	0.005	1.000	0.500	12730	125
2.00	2	40	0.005	2.000	0.900	6365	65
2.50	2	40	0.005	2.000	1.100	5095	50
3.00	2	40	0.010	3.000	1.400	4245	85
4.00	2	40	0.015	4.000	1.800	3185	95
5.00	2	40	0.020	5.000	2.300	2545	100
6.00	2	40	0.020	6.000	2.700	2120	85



Steel
< 850 N/mm²



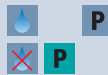
1.00	2	85	0.005	0.500	1.000	27055	270
2.00	2	85	0.005	1.000	2.000	13530	135
2.50	2	85	0.005	1.000	2.500	10825	110
3.00	2	85	0.010	1.500	3.000	9020	180
4.00	2	85	0.010	2.000	4.000	6765	135
5.00	2	85	0.015	2.500	5.000	5410	160
6.00	2	85	0.015	3.000	6.000	4510	135

Steel
850 - 1100 N/mm²



1.00	2	60	0.005	0.500	1.000	19100	190
2.00	2	60	0.005	1.000	2.000	9550	95
2.50	2	60	0.005	1.000	2.500	7640	75
3.00	2	60	0.010	1.500	3.000	6365	125
4.00	2	60	0.010	2.000	4.000	4775	95
5.00	2	60	0.015	2.500	5.000	3820	115
6.00	2	60	0.015	3.000	6.000	3185	95

Cast iron
(lamellar / spheroidal)



1.00	2	105	0.005	0.500	1.000	33425	335
2.00	2	105	0.005	1.000	2.000	16710	165
2.50	2	105	0.005	1.000	2.500	13370	135
3.00	2	105	0.010	1.500	3.000	11140	225
4.00	2	105	0.010	2.000	4.000	8355	165
5.00	2	105	0.015	2.500	5.000	6685	200
6.00	2	105	0.020	3.000	6.000	5570	225

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



1.00	2	30	0.005	0.500	1.000	9550	95
2.00	2	30	0.005	1.000	2.000	4775	50
2.50	2	30	0.005	1.000	2.500	3820	40
3.00	2	30	0.010	1.500	3.000	3185	65
4.00	2	30	0.010	2.000	4.000	2385	50
5.00	2	30	0.015	2.500	5.000	1910	55
6.00	2	30	0.015	3.000	6.000	1590	50