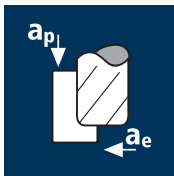


Application

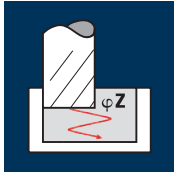


Material

Steel
850 - 1100 N/mm²



d1 [mm]	z	v _c [m/min]	f _s [mm]	a _p [mm]	a _e [mm]	n [min ⁻¹]	v _r [mm/min]	Q [cm ³ /min]	φZ [°]
4.00	4	150	0.030	7.200	1.600	11935	1430	16.5	16°
5.00	4	150	0.035	9.000	2.000	9550	1335	24.1	16°
6.00	4	150	0.040	10.800	2.400	7960	1275	33.0	16°
8.00	4	150	0.050	14.400	3.200	5970	1195	55.0	16°
10.00	4	150	0.065	18.000	4.000	4775	1240	89.4	16°
12.00	4	150	0.075	21.600	4.800	3980	1195	123.8	16°
16.00	4	150	0.085	24.000	6.400	2985	1015	155.9	16°



Steel
1100 - 1300 N/mm²



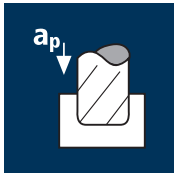
d1 [mm]	z	v _c [m/min]	f _s [mm]	a _p [mm]	a _e [mm]	n [min ⁻¹]	v _r [mm/min]	Q [cm ³ /min]	φZ [°]
4.00	4	115	0.025	7.200	1.600	9150	915	10.5	14°
5.00	4	115	0.030	9.000	2.000	7320	880	15.8	14°
6.00	4	115	0.035	10.800	2.400	6100	855	22.1	14°
8.00	4	115	0.045	14.400	3.200	4575	825	38.0	14°
10.00	4	115	0.055	18.000	4.000	3660	805	58.0	14°
12.00	4	115	0.065	21.600	4.800	3050	795	82.2	14°
16.00	4	115	0.075	24.000	6.400	2290	685	105.2	14°

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



d1 [mm]	z	v _c [m/min]	f _s [mm]	a _p [mm]	a _e [mm]	n [min ⁻¹]	v _r [mm/min]	Q [cm ³ /min]	φZ [°]
4.00	4	90	0.020	7.200	1.600	7160	575	6.6	11°
5.00	4	90	0.025	9.000	2.000	5730	575	10.3	11°
6.00	4	90	0.030	10.800	2.400	4775	575	14.9	11°
8.00	4	90	0.035	14.400	3.200	3580	500	23.1	11°
10.00	4	90	0.045	18.000	4.000	2865	515	37.1	11°
12.00	4	90	0.055	21.600	4.800	2385	525	54.5	11°
16.00	4	90	0.065	24.000	6.400	1790	465	71.4	11°

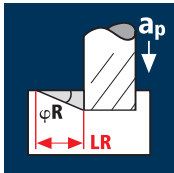
Application



Steel
850 - 1100 N/mm²



d1 [mm]	z	v _c [m/min]	f _s [mm]	a _p [mm]	a _e [mm]	n [min ⁻¹]	v _r [mm/min]	Q [cm ³ /min]	φR [°]	LR [mm]
4.00	4	120	0.020	6.000	4.000	9550	765	18.3	18°	18.5
5.00	4	120	0.023	7.500	5.000	7640	705	26.4	18°	23.1
6.00	4	120	0.026	9.000	6.000	6365	660	35.8	18°	27.7
8.00	4	120	0.033	12.000	8.000	4775	630	60.5	18°	36.9
10.00	4	120	0.042	15.000	10.000	3820	640	96.3	18°	46.2
12.00	4	120	0.049	18.000	12.000	3185	625	134.8	18°	55.4
16.00	4	120	0.055	24.000	16.000	2385	525	201.6	18°	73.9



Steel
1100 - 1300 N/mm²



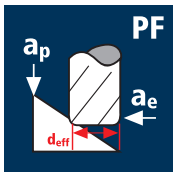
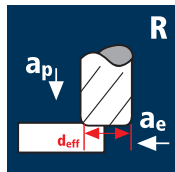
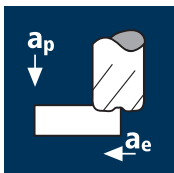
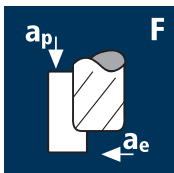
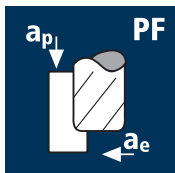
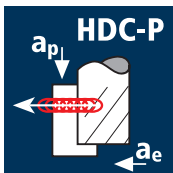
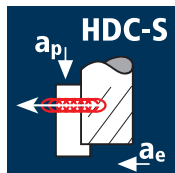
d1 [mm]	z	v _c [m/min]	f _s [mm]	a _p [mm]	a _e [mm]	n [min ⁻¹]	v _r [mm/min]	Q [cm ³ /min]	φR [°]	LR [mm]
4.00	4	90	0.016	6.000	4.000	7160	460	11.0	18°	18.5
5.00	4	90	0.020	7.500	5.000	5730	460	17.2	18°	23.1
6.00	4	90	0.023	9.000	6.000	4775	440	23.7	18°	27.7
8.00	4	90	0.029	12.000	8.000	3580	415	39.9	18°	36.9
10.00	4	90	0.036	15.000	10.000	2865	415	61.9	18°	46.2
12.00	4	90	0.042	18.000	12.000	2385	400	86.6	18°	55.4
16.00	4	90	0.049	24.000	16.000	1790	350	134.4	18°	73.9

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



d1 [mm]	z	v _c [m/min]	f _s [mm]	a _p [mm]	a _e [mm]	n [min ⁻¹]	v _r [mm/min]	Q [cm ³ /min]	φR [°]	LR [mm]
4.00	4	70	0.013	6.000	4.000	5570	290	7.0	13°	26.0
5.00	4	70	0.016	7.500	5.000	4455	285	10.7	13°	32.5
6.00	4	70	0.020	9.000	6.000	3715	295	16.0	13°	39.0
8.00	4	70	0.023	12.000	8.000	2785	255	24.6	13°	52.0
10.00	4	70	0.029	15.000	10.000	2230	260	38.8	13°	65.0
12.00	4	70	0.036	18.000	12.000	1855	265	57.8	13°	78.0
16.00	4	70	0.042	24.000	16.000	1395	235	90.2	13°	104.0

This way to the cutting data software
ToolExpert MFC.
Quick, easy, reliable.

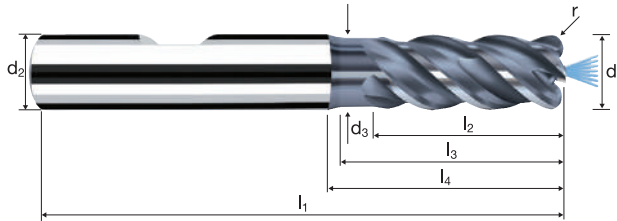
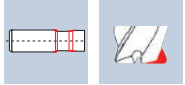


Corner radius end mills MFC

Smooth-edged, normal version, short neck
High-performance penetration edge, central air/cooling channel



HM
MG10 λ 45°
 γ 10°

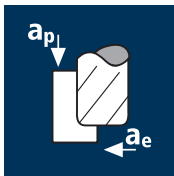


Roughing HPC Roughing HDC Finishing

Rm < 850	Rm 850-1100	Rm 1100-1300	Rm 1300-1500	HRC 48-56			Inox Stainless	Ti Titanium	GG(G) Tool Steel
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Ø Code	d ₁ e8	d ₂ h5	d ₃	l ₁	l ₂	l ₃	l ₄	r 0/+0.03	α	z	POLYCHROM		
											Coating	Article-N°	ø-Code
Example: Order-N°.													
<div style="display: flex; justify-content: space-around; align-items: center;"> Coating: P Article-N°: 8207 ø-Code: 393 </div>													
												P8207	
												P8107	
393	8.00	8.00	7.40	63	19.00	23.63	26.00	1.500	0.0°	4		●	
453	10.00	10.00	9.20	72	23.00	27.99	31.00	1.500	0.0°	4		●	
503	12.00	12.00	11.00	83	27.00	33.29	37.00	1.500	0.0°	4		●	
610	16.00	16.00	15.00	92	32.00	38.73	43.00	1.500	0.0°	4		●	
455	10.00	10.00	9.20	72	23.00	27.99	31.00	2.000	0.0°	4		●	
505	12.00	12.00	11.00	83	27.00	33.29	37.00	2.000	0.0°	4		●	
611	16.00	16.00	15.00	92	32.00	38.73	43.00	2.000	0.0°	4		●	
506	12.00	12.00	11.00	83	27.00	33.29	37.00	2.500	0.0°	4		●	

Application

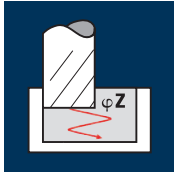


Material

Steel
850 - 1100 N/mm²



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]	φZ [°]
8.00	4	150	0.050	14.400	3.200	5970	1195	55.0	16°
10.00	4	150	0.065	18.000	4.000	4775	1240	89.4	16°
12.00	4	150	0.075	21.600	4.800	3980	1195	123.8	16°
16.00	4	150	0.085	24.000	6.400	2985	1015	155.8	16°



Steel
1100 - 1300 N/mm²



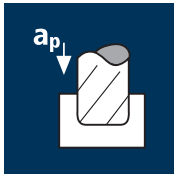
8.00	4	115	0.045	14.400	3.200	4575	825	38.0	14°
10.00	4	115	0.055	18.000	4.000	3660	805	58.0	14°
12.00	4	115	0.065	21.600	4.800	3050	795	82.2	14°
16.00	4	115	0.075	24.000	6.400	2290	685	105.4	14°

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



8.00	4	90	0.035	14.400	3.200	3580	500	23.1	11°
10.00	4	90	0.045	18.000	4.000	2865	515	37.1	11°
12.00	4	90	0.055	21.600	4.800	2385	525	54.5	11°
16.00	4	90	0.065	24.000	6.400	1790	465	71.5	11°

Application

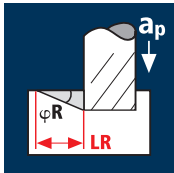


Material

Steel
850 - 1100 N/mm²



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]	φR [°]	LR [mm]
8.00	4	120	0.033	12.000	8.000	4775	630	60.5	18°	36.9
10.00	4	120	0.042	15.000	10.000	3820	640	96.3	18°	46.2
12.00	4	120	0.049	18.000	12.000	3185	625	134.8	18°	55.4
16.00	4	120	0.055	24.000	16.000	2385	525	201.7	18°	73.9



Steel
1100 - 1300 N/mm²



8.00	4	90	0.029	12.000	8.000	3580	415	39.9	18°	36.9
10.00	4	90	0.036	15.000	10.000	2865	415	61.9	18°	46.2
12.00	4	90	0.042	18.000	12.000	2385	400	86.6	18°	55.4
16.00	4	90	0.049	24.000	16.000	1790	350	134.8	18°	73.9

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



8.00	4	70	0.023	12.000	8.000	2785	255	24.6	13°	52.0
10.00	4	70	0.029	15.000	10.000	2230	260	38.8	13°	65.0
12.00	4	70	0.036	18.000	12.000	1855	265	57.8	13°	78.0
16.00	4	70	0.042	24.000	16.000	1395	235	89.8	13°	104.0

This way to the cutting data software
ToolExpert MFC.
Quick, easy, reliable.

