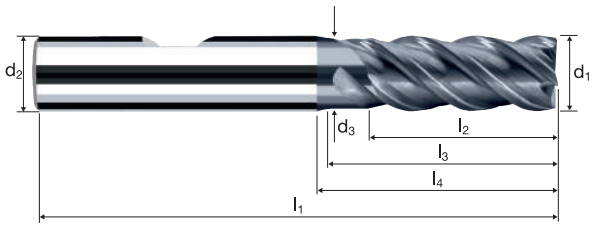
Cylindrical end mills E-Cut

Smooth-edged, normal version, short neck

HM MG10	λ 45° γ 10°

r

Vario

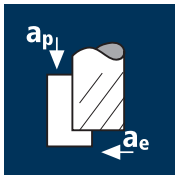
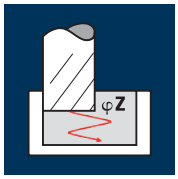


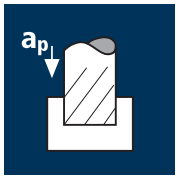
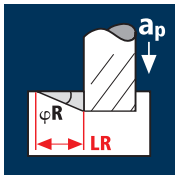
Roughing HPC | Roughing HDC | Finishing

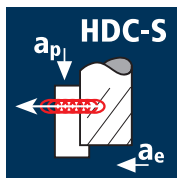
Rm < 850	Rm 850-1100	Rm 1100-1300	Rm 1300-1500	HRC 48-56			Inox Stainless	Ti Titanium	GG(G) Tool Steel

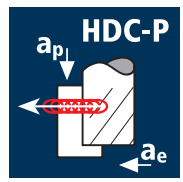
Example: **Order-N°.** Coating **P** Article-N°. **8400** ø-Code **100**

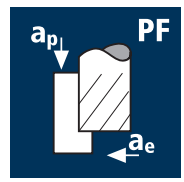
Ø Code	d_1 e8	d_2 h6	d_3	l_1	l_2	l_3	l_4	r	α	z	POLYCHROM P8400	POLYCHROM P8300
100	1.00	6.00	0.95	57	3.00	5.00	14.82	0.050	10.0°	4		●
140	2.00	6.00	1.90	57	5.00	8.00	16.05	0.050	7.5°	4		●
160	2.50	6.00	2.30	57	7.00	10.00	17.30	0.050	6.5°	4		●
180	3.00	6.00	2.80	57	8.00	14.00	20.37	0.050	4.5°	4		●
220	4.00	6.00	3.70	57	11.00	16.00	20.82	0.100	3.0°	4		●
260	5.00	6.00	4.60	57	13.00	18.00	21.27	0.100	1.5°	4		●
300	6.00	6.00	5.50	57	13.00	18.15	20.00	0.100	0.0°	4		●
391	8.00	8.00	7.40	63	19.00	23.63	26.00	0.150	0.0°	4		●
450	10.00	10.00	9.20	72	23.00	27.99	31.00	0.200	0.0°	4		●
501	12.00	12.00	11.00	83	27.00	33.29	37.00	0.200	0.0°	4		●
570	14.00	14.00	13.00	83	28.00	32.97	37.00	0.200	0.0°	4		●
610	16.00	16.00	15.00	92	32.00	38.73	43.00	0.200	0.0°	4		●
682	20.00	20.00	19.00	104	40.00	48.23	53.00	0.250	0.0°	4		●

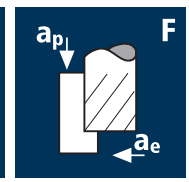
Application	Material	d1 [mm]	z	v_c [m/min]	f_z [mm]	a_p [mm]	a_e [mm]	n [min-1]	v_f [mm/min]	Q [cm³/min]	φZ [°]
	Steel < 850 N/mm²	3.00	4	155	0.024	3.750	1.200	16445	1580	7.1	1.5°
		4.00	4	155	0.034	5.000	1.600	12335	1675	13.4	1.5°
		5.00	4	155	0.042	6.250	2.000	9870	1660	20.7	1.5°
		6.00	4	155	0.045	9.000	2.400	8225	1480	32.0	1.5°
		8.00	4	155	0.060	12.000	3.200	6165	1480	56.8	1.5°
		10.00	4	155	0.075	15.000	4.000	4935	1480	88.8	1.5°
		12.00	4	155	0.084	18.000	4.800	4110	1380	119.4	1.5°
		16.00	4	155	0.096	24.000	6.400	3085	1185	181.9	1.5°
		20.00	4	155	0.110	30.000	8.000	2465	1085	260.5	1.5°
	Steel 850 - 1100 N/mm²	3.00	4	140	0.022	3.750	1.200	14855	1305	5.9	2°
		4.00	4	140	0.032	5.000	1.600	11140	1425	11.4	2°
		5.00	4	140	0.040	6.250	2.000	8915	1425	17.8	2°
		6.00	4	140	0.039	9.000	2.400	7425	1160	25.0	2°
		8.00	4	140	0.052	12.000	3.200	5570	1160	44.5	2°
		10.00	4	140	0.065	15.000	4.000	4455	1160	69.5	2°
		12.00	4	140	0.078	18.000	4.800	3715	1160	100.1	2°
		16.00	4	140	0.088	24.000	6.400	2785	980	150.6	2°
		20.00	4	140	0.100	30.000	8.000	2230	890	213.9	2°
	Inox normal [Cr-Ni/1.4301] [Cr-Ni-Mo/1.4571]	3.00	4	90	0.015	3.750	1.200	9550	575	2.6	1.5°
		4.00	4	90	0.022	5.000	1.600	7160	630	5.0	1.5°
		5.00	4	90	0.027	6.250	2.000	5730	620	7.7	1.5°
		6.00	4	90	0.027	9.000	2.400	4775	515	11.1	1.5°
		8.00	4	90	0.036	12.000	3.200	3580	515	19.8	1.5°
		10.00	4	90	0.045	15.000	4.000	2865	515	30.9	1.5°
		12.00	4	90	0.054	18.000	4.800	2385	515	44.6	1.5°
		16.00	4	90	0.056	24.000	6.400	1790	400	61.6	1.5°
		20.00	4	90	0.070	30.000	8.000	1430	400	96.3	1.5°

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]	φR [°]
	Steel < 850 N/mm²	3.00	4	125	0.012	2.250	3.000	13265	635	4.3	1.5°
		4.00	4	125	0.017	4.000	4.000	9945	675	10.8	1.5°
		5.00	4	125	0.021	5.000	5.000	7960	670	16.7	1.5°
		6.00	4	125	0.029	7.500	6.000	6630	770	34.6	1.5°
		8.00	4	125	0.039	10.000	8.000	4975	775	62.1	1.5°
		10.00	4	125	0.049	12.500	10.000	3980	780	97.5	1.5°
		12.00	4	125	0.055	15.000	12.000	3315	730	131.3	1.5°
		16.00	4	125	0.062	20.000	16.000	2485	615	197.4	1.5°
		20.00	4	125	0.072	25.000	20.000	1990	575	286.5	1.5°
	Steel 850 - 1100 N/mm²	3.00	4	110	0.011	2.250	3.000	11670	515	3.5	2°
		4.00	4	110	0.016	4.000	4.000	8755	560	9.0	2°
		5.00	4	110	0.020	5.000	5.000	7005	560	14.0	2°
		6.00	4	110	0.025	7.500	6.000	5835	585	26.3	2°
		8.00	4	110	0.034	10.000	8.000	4375	595	47.6	2°
		10.00	4	110	0.042	12.500	10.000	3500	590	73.5	2°
		12.00	4	110	0.051	15.000	12.000	2920	595	107.1	2°
		16.00	4	110	0.057	20.000	16.000	2190	500	159.7	2°
		20.00	4	110	0.065	25.000	20.000	1750	455	227.6	2°
	Inox normal [Cr-Ni/1.4301] [Cr-Ni-Mo/1.4571]	3.00	4	70	0.008	2.250	3.000	7425	240	1.6	1.5°
		4.00	4	70	0.011	4.000	4.000	5570	245	3.9	1.5°
		5.00	4	70	0.014	5.000	5.000	4455	250	6.2	1.5°
		6.00	4	70	0.018	7.500	6.000	3715	265	12.0	1.5°
		8.00	4	70	0.023	10.000	8.000	2785	255	20.5	1.5°
		10.00	4	70	0.029	12.500	10.000	2230	260	32.3	1.5°
		12.00	4	70	0.035	15.000	12.000	1855	260	46.8	1.5°
		16.00	4	70	0.036	20.000	16.000	1395	200	64.2	1.5°
		20.00	4	70	0.046	25.000	20.000	1115	205	102.5	1.5°









Suitable cutting data for other applications and materials can be found in the cutting data software **ToolExpert E-Cut**