Corner radius end mills E-Cut

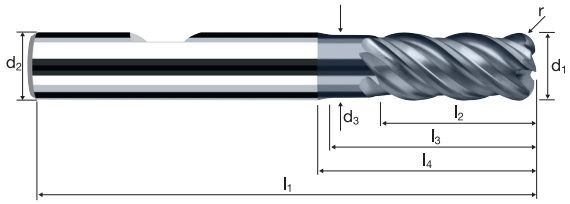
Smooth-edged, normal version, short neck

$l_2 = 2.2 \times d_1$

$l_3 = 3.0 \times d_1$

HM MG10 | λ 43° γ 6°

Vario



new!

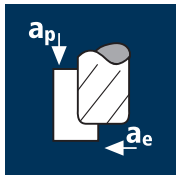
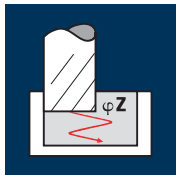
Roughing HDC | Roughing HPC | Finishing

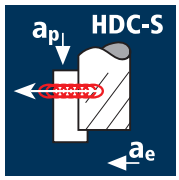
ReTool®

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

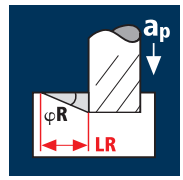
Example: **Order-N°.** Coating **P** Article-N°. **8407** ø-Code **178**

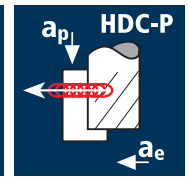
Ø Code	d_1 e8	d_2 h6	d_3	l_1	l_2	l_3	l_4	r 0/+0.03	α	z	POLYCHROM P8407	P8307
178	3.00	6.00	2.80	54	6.60	9.00	15.37	0.200	5.8°	4		●
218	4.00	6.00	3.70	54	9.00	12.00	16.82	0.200	3.9°	4		●
258	5.00	6.00	4.60	57	11.00	15.00	18.27	0.200	2.1°	4		●
297	6.00	6.00	5.50	57	13.50	18.00	19.85	0.200	0.0°	4		●
385	8.00	8.00	7.40	63	18.00	24.00	26.37	0.200	0.0°	4		●
445	10.00	10.00	9.20	74	22.00	30.00	33.01	0.200	0.0°	4		●
496	12.00	12.00	11.00	85	27.00	36.00	39.71	0.200	0.0°	4		●
180	3.00	6.00	2.80	54	6.60	9.00	15.37	0.500	5.8°	4		●
220	4.00	6.00	3.70	54	9.00	12.00	16.82	0.500	3.9°	4		●
260	5.00	6.00	4.60	57	11.00	15.00	18.27	0.500	2.1°	4		●
300	6.00	6.00	5.50	57	13.50	18.00	19.85	0.500	0.0°	4		●
388	8.00	8.00	7.40	63	18.00	24.00	26.35	0.500	0.0°	4		●
448	10.00	10.00	9.20	74	22.00	30.00	33.00	0.500	0.0°	4		●
498	12.00	12.00	11.00	85	27.00	36.00	39.70	0.500	0.0°	4		●
301	6.00	6.00	5.50	57	13.50	18.00	19.85	0.800	0.0°	4		●
389	8.00	8.00	7.40	63	18.00	24.00	26.35	0.800	0.0°	4		●
449	10.00	10.00	9.20	74	22.00	30.00	33.00	0.800	0.0°	4		●
499	12.00	12.00	11.00	85	27.00	36.00	39.70	0.800	0.0°	4		●

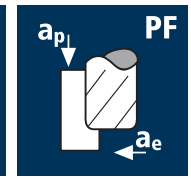
Application	Material	d_1 [mm]	z	v_c [m/min]	f_z [mm]	a_p [mm]	a_e [mm]	n [min⁻¹]	v_f [mm/min]	Q [cm³/min]	φZ [°]
	Steel < 850 N/mm²	3.00	4	155	0.024	3.750	1.200	16445	1579	7.1	1.5°
		4.00	4	155	0.034	5.000	1.600	12335	1678	13.4	1.5°
		5.00	4	155	0.042	6.250	2.000	9870	1658	20.7	1.5°
		6.00	4	155	0.045	9.000	2.400	8225	1481	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	1481	88.8	1.5°
		12.00	4	155	0.084	18.000	4.800	4110	1381	119.3	1.5°
	Steel 850 - 1100 N/mm²	3.00	4	135	0.022	3.750	1.200	14325	1261	5.7	2.0°
		4.00	4	135	0.028	5.000	1.600	10745	1203	9.6	2.0°
		5.00	4	135	0.037	6.250	2.000	8595	1272	15.9	2.0°
		6.00	4	135	0.039	9.000	2.400	7160	1117	24.1	2.0°
		8.00	4	135	0.052	12.000	3.200	5370	1117	42.9	2.0°
		10.00	4	135	0.065	15.000	4.000	4295	1117	67.0	2.0°
		12.00	4	135	0.078	18.000	4.800	3580	1117	96.5	2.0°
	Inox normal [Cr-Ni/1.4301] [Cr-Ni-Mo/1.4571]	3.00	4	90	0.014	3.750	1.200	9550	516	2.3	1.5°
		4.00	4	90	0.018	5.000	1.600	7160	516	4.1	1.5°
		5.00	4	90	0.023	6.250	2.000	5730	516	6.4	1.5°
		6.00	4	90	0.027	9.000	2.400	4775	516	11.1	1.5°
		8.00	4	90	0.036	12.000	3.200	3580	516	19.8	1.5°
		10.00	4	90	0.045	15.000	4.000	2865	516	30.9	1.5°
		12.00	4	90	0.054	18.000	4.800	2385	515	44.5	1.5°

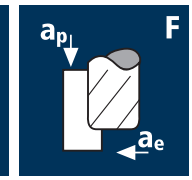
Application	Material	d_1 [mm]	z	v_c [m/min]	f_z [mm]	a_p [mm]	a_e [mm]	n [min⁻¹]	v_f [mm/min]	Q [cm³/min]
	Steel < 850 N/mm²	3.00	4	243	0.051	8.000	0.300	25785	5260	12.6
		4.00	4	243	0.069	11.000	0.400	19335	5337	23.5
		5.00	4	243	0.086	13.000	0.500	15470	5322	34.6
		6.00	4	243	0.103	13.000	0.600	12890	5311	41.4
		8.00	4	243	0.136	19.000	0.800	9670	5261	80.0
		10.00	4	243	0.171	23.000	1.000	7735	5291	121.7
		12.00	4	243	0.207	27.000	1.200	6445	5337	172.9
	Steel 850 - 1100 N/mm²	3.00	4	216	0.051	8.000	0.300	22920	4676	11.2
		4.00	4	216	0.069	11.000	0.400	17190	4744	20.9
		5.00	4	216	0.086	13.000	0.500	13750	4730	30.7
		6.00	4	216	0.103	13.000	0.600	11460	4722	36.8
		8.00	4	216	0.136	19.000	0.800	8595	4676	71.1
		10.00	4	216	0.171	23.000	1.000	6875	4703	108.2
		12.00	4	216	0.207	27.000	1.200	5730	4744	153.7
	Inox normal [Cr-Ni/1.4301] [Cr-Ni-Mo/1.4571]	3.00	4	132	0.038	8.000	0.225	14005	2129	3.8
		4.00	4	132	0.053	11.000	0.300	10505	2227	7.3
		5.00	4	132	0.066	13.000	0.375	8405	2219	10.8
		6.00	4	132	0.080	13.000	0.450	7005	2242	13.1
		8.00	4	132	0.106	19.000	0.600	5250	2226	25.4
		10.00	4	132	0.133	23.000	0.750	4200	2234	38.5
		12.00	4	132	0.159	27.000	0.900	3500	2226	54.1

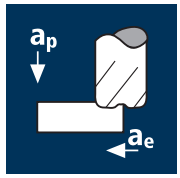
Precise cutting data for other applications and materials can be found in the cutting data software **ToolExpert**

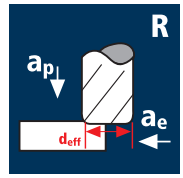


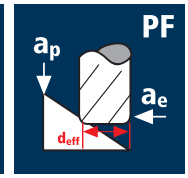












Corner radius end mills E-Cut

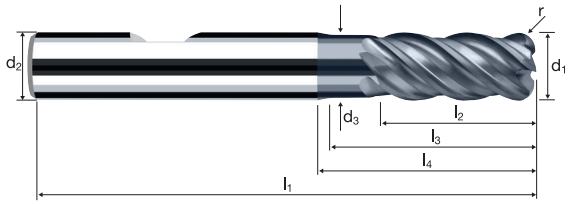
Smooth-edged, normal version, short neck

$l_2 = 2.2 \times d_1$

$l_3 = 3.0 \times d_1$

HM MG10 | λ 43° γ 6°

Vario



new!

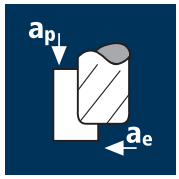
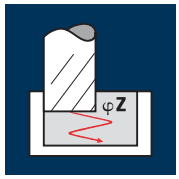
Roughing HDC | Roughing HPC | Finishing

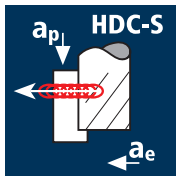
ReTool®

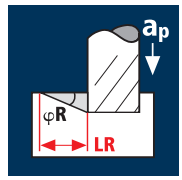
Rm < 850	Rm 850-1100	Rm 1100-1300	Rm 1300-1500	HRC 48-56			Inox Stainless	Ti Titanium	GG(G) Tool Steel

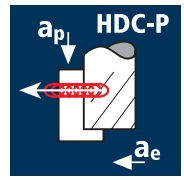
Example: **Order-N°.** Coating **P** Article-N°. **8407** ø-Code **302**

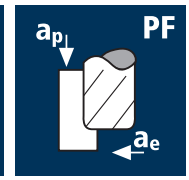
Ø Code	d_1 e8	d_2 h6	d_3	l_1	l_2	l_3	l_4	r 0/+0.03	α	z	POLYCHROM P8407	POLYCHROM P8307
302	6.00	6.00	5.50	57	13.50	18.00	19.85	1.000	0.0°	4	●	
391	8.00	8.00	7.40	63	18.00	24.00	26.35	1.000	0.0°	4	●	
450	10.00	10.00	9.20	74	22.00	30.00	33.00	1.000	0.0°	4	●	
501	12.00	12.00	11.00	85	27.00	36.00	39.70	1.000	0.0°	4	●	
608	16.00	16.00	15.00	102	36.00	48.00	52.27	1.000	0.0°	4	●	
304	6.00	6.00	5.50	57	13.50	18.00	19.85	1.500	0.0°	4	●	
393	8.00	8.00	7.40	63	18.00	24.00	26.35	1.500	0.0°	4	●	
453	10.00	10.00	9.20	74	22.00	30.00	33.00	1.500	0.0°	4	●	
503	12.00	12.00	11.00	85	27.00	36.00	39.70	1.500	0.0°	4	●	
610	16.00	16.00	15.00	102	36.00	48.00	52.25	1.500	0.0°	4	●	
306	6.00	6.00	5.50	57	13.50	18.00	19.85	2.000	0.0°	4	●	
395	8.00	8.00	7.40	63	18.00	24.00	26.35	2.000	0.0°	4	●	
455	10.00	10.00	9.20	74	22.00	30.00	33.00	2.000	0.0°	4	●	
505	12.00	12.00	11.00	85	27.00	36.00	39.70	2.000	0.0°	4	●	
611	16.00	16.00	15.00	102	36.00	48.00	52.25	2.000	0.0°	4	●	
683	20.00	20.00	19.00	115	44.00	60.00	64.77	2.000	0.0°	4	●	
457	10.00	10.00	9.20	74	22.00	30.00	33.00	2.500	0.0°	4	●	
506	12.00	12.00	11.00	85	27.00	36.00	39.70	2.500	0.0°	4	●	
612	16.00	16.00	15.00	102	36.00	48.00	52.25	2.500	0.0°	4	●	

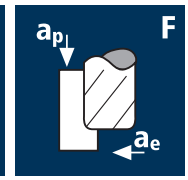
Application	Material	d_1 [mm]	z	v_c [m/min]	f_z [mm]	a_p [mm]	a_e [mm]	n [min⁻¹]	v_f [mm/min]	Q [cm³/min]	φZ [°]
	Steel < 850 N/mm²	6.00	4	155	0.045	9.000	2.400	8225	1481	32.0	1.5°
		8.00	4	155	0.060	12.000	3.200	6165	1480	56.8	1.5°
		10.00	4	155	0.075	15.000	4.000	4935	1481	88.8	1.5°
		12.00	4	155	0.084	18.000	4.800	4110	1381	119.3	1.5°
		16.00	4	155	0.096	24.000	6.400	3085	1185	182.0	1.5°
		20.00	4	155	0.110	30.000	8.000	2465	1085	260.3	1.5°
	Steel 850 - 1100 N/mm²	6.00	4	135	0.039	9.000	2.400	7160	1117	24.1	2.0°
		8.00	4	135	0.052	12.000	3.200	5370	1117	42.9	2.0°
		10.00	4	135	0.065	15.000	4.000	4295	1117	67.0	2.0°
		12.00	4	135	0.078	18.000	4.800	3580	1117	96.5	2.0°
		16.00	4	135	0.088	24.000	6.400	2685	945	145.2	2.0°
		20.00	4	135	0.100	30.000	8.000	2150	860	206.4	2.0°
	Inox normal [Cr-Ni/1.4301] [Cr-Ni-Mo/1.4571]	6.00	4	90	0.027	9.000	2.400	4775	516	11.1	1.5°
		8.00	4	90	0.036	12.000	3.200	3580	516	19.8	1.5°
		10.00	4	90	0.045	15.000	4.000	2865	516	30.9	1.5°
		12.00	4	90	0.054	18.000	4.800	2385	515	44.5	1.5°
		16.00	4	90	0.056	24.000	6.400	1790	401	61.6	1.5°
		20.00	4	90	0.070	30.000	8.000	1430	400	96.1	1.5°

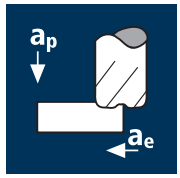
Application	Material	d_1 [mm]	z	v_c [m/min]	f_z [mm]	a_p [mm]	a_e [mm]	n [min⁻¹]	v_f [mm/min]	Q [cm³/min]
	Steel < 850 N/mm²	6.00	4	243	0.103	13.000	0.600	12890	5311	41.4
		8.00	4	243	0.136	19.000	0.800	9670	5261	80.0
		10.00	4	243	0.171	23.000	1.000	7735	5291	121.7
		12.00	4	243	0.207	27.000	1.200	6445	5337	172.9
		16.00	4	243	0.228	32.000	1.600	4835	4410	225.8
		20.00	4	243	0.286	40.000	2.000	3865	4422	353.7
	Steel 850 - 1100 N/mm²	6.00	4	216	0.103	13.000	0.600	11460	4722	36.8
		8.00	4	216	0.136	19.000	0.800	8595	4676	71.1
		10.00	4	216	0.171	23.000	1.000	6875	4703	108.2
		12.00	4	216	0.207	27.000	1.200	5730	4744	153.7
		16.00	4	216	0.228	32.000	1.600	4295	3917	200.6
		20.00	4	216	0.286	40.000	2.000	3440	3935	314.8
	Inox normal [Cr-Ni/1.4301] [Cr-Ni-Mo/1.4571]	6.00	4	132	0.080	13.000	0.450	7005	2242	13.1
		8.00	4	132	0.106	19.000	0.600	5250	2226	25.4
		10.00	4	132	0.133	23.000	0.750	4200	2234	38.5
		12.00	4	132	0.159	27.000	0.900	3500	2226	54.1
		16.00	4	132	0.173	32.000	1.200	2625	1817	69.8
		20.00	4	132	0.222	40.000	1.500	2100	1865	111.9

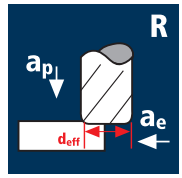


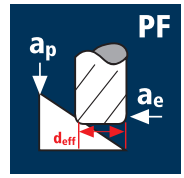












Precise cutting data for other applications and materials can be found in the cutting data software **ToolExpert**

Corner radius end mills E-Cut

Smooth-edged, normal version, short neck

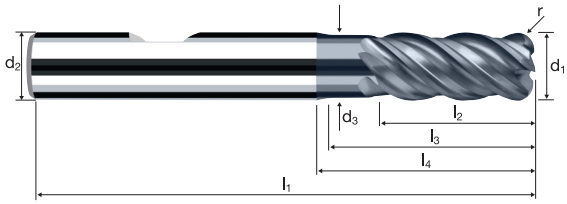
Base-X **B**

$l_2 = 2.2 \times d_1$

$l_3 = 3.0 \times d_1$

HM MG10 | λ 43° γ 6°

Vario



new!

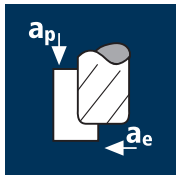
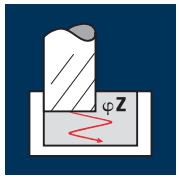
Roughing HDC | Roughing HPC | Finishing

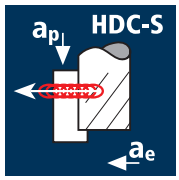
ReTool®

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°. **8407** ø-Code **508**

Ø Code	d_1 e8	d_2 h6	d_3	l_1	l_2	l_3	l_4	r 0/+0.03	α	z	POLYCHROM P8407	POLYCHROM P8307
508	12.00	12.00	11.00	85	27.00	36.00	39.70	4.000	0.0°	4		●
614	16.00	16.00	15.00	102	36.00	48.00	52.25	4.000	0.0°	4		●
686	20.00	20.00	19.00	115	44.00	60.00	64.75	4.000	0.0°	4		●

Application	Material	d_1 [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	12.00	4	155	0.084	18.000	4.800	4110	1381	119.3	1.5°
		16.00	4	155	0.096	24.000	6.400	3085	1185	182.0	1.5°
		20.00	4	155	0.110	30.000	8.000	2465	1085	260.3	1.5°
	Steel 850 - 1100 N/mm²	12.00	4	135	0.078	18.000	4.800	3580	1117	96.5	2.0°
		16.00	4	135	0.088	24.000	6.400	2685	945	145.2	2.0°
		20.00	4	135	0.100	30.000	8.000	2150	860	206.4	2.0°
	Inox normal [Cr-Ni/1.4301] [Cr-Ni-Mo/1.4571]	12.00	4	90	0.054	18.000	4.800	2385	515	44.5	1.5°
		16.00	4	90	0.056	24.000	6.400	1790	401	61.6	1.5°
		20.00	4	90	0.070	30.000	8.000	1430	400	96.1	1.5°

Application	Material	d_1 [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]
	Steel < 850 N/mm²	12.00	4	243	0.207	27.000	1.200	6445	5337	172.9
		16.00	4	243	0.228	32.000	1.600	4835	4410	225.8
		20.00	4	243	0.286	40.000	2.000	3865	4422	353.7
	Steel 850 - 1100 N/mm²	12.00	4	216	0.207	27.000	1.200	5730	4744	153.7
		16.00	4	216	0.228	32.000	1.600	4295	3917	200.6
		20.00	4	216	0.286	40.000	2.000	3440	3935	314.8
	Inox normal [Cr-Ni/1.4301] [Cr-Ni-Mo/1.4571]	12.00	4	132	0.159	27.000	0.900	3500	2226	54.1
		16.00	4	132	0.173	32.000	1.200	2625	1817	69.8
		20.00	4	132	0.222	40.000	1.500	2100	1865	111.9

Precise cutting data for other applications and materials can be found in the cutting data software **ToolExpert**