

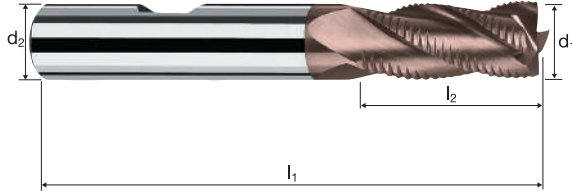
Cylindrical end mills

Profiled NRF, normal version

HSS

HSS-E
Co8

λ 30°
 γ 12°



Roughing

Finishing



Rm

< 850

Rm

850-1100

Rm

1100-1300

Inox

Stainless

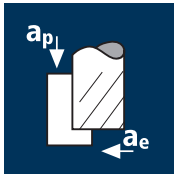
Ti

Titanium

GG(G)

Example: Order-N°.										UNICUT-4X	
										U0609	
\emptyset Code	d_1 k12	d_2 h6	l_1	l_2	l_4	45°	α	z			
300	6.00	6.00	57	13.00	-	0.40	0.0°	4	●		
342	7.00	10.00	66	16.00	25.50	0.40	3.0°	4	●		
402	8.00	10.00	69	19.00	28.50	0.40	2.5°	4	●		
420	9.00	10.00	69	19.00	28.50	0.40	1.5°	4	●		
450	10.00	10.00	72	22.00	-	0.40	0.0°	4	●		
470	11.00	12.00	79	22.00	33.50	0.40	1.0°	4	●		
501	12.00	12.00	83	26.00	-	0.40	0.0°	4	●		
540	13.00	12.00	83	26.00	-	0.40	0.0°	4	●		
570	14.00	12.00	83	26.00	-	0.40	0.0°	4	●		
592	15.00	16.00	86	26.00	37.50	0.50	1.0°	4	●		
610	16.00	16.00	92	32.00	-	0.50	0.0°	4	●		
640	18.00	16.00	92	32.00	-	0.50	0.0°	4	●		
682	20.00	20.00	104	38.00	-	0.50	0.0°	4	●		
686	20.00	20.00	104	38.00	-	0.50	0.0°	6	●		
710	22.00	20.00	104	38.00	-	0.70	0.0°	6	●		
772	25.00	25.00	121	45.00	-	0.70	0.0°	6	●		
832	32.00	32.00	133	53.00	-	0.70	0.0°	7	●		

Application



Material

Steel
< 850 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]
6.00	4	64	0.025	6.000	2.400	3395	340	4.9
8.00	4	64	0.035	8.000	3.200	2545	355	9.1
10.00	4	64	0.045	10.000	4.000	2035	365	14.7
12.00	4	64	0.070	12.000	4.800	1700	475	27.4
16.00	4	64	0.095	16.000	6.400	1275	485	49.5
18.00	4	64	0.105	18.000	7.200	1130	475	61.6
20.00	4	64	0.115	20.000	8.000	1020	470	75.0
25.00	6	64	0.145	25.000	10.000	815	710	177.2
32.00	7	64	0.130	32.000	12.800	635	580	237.3

Steel
850 - 1100 N/mm²



6.00	4	52	0.025	6.000	2.400	2760	275	4.0
8.00	4	52	0.035	8.000	3.200	2070	290	7.4
10.00	4	52	0.045	10.000	4.000	1655	300	11.9
12.00	4	52	0.070	12.000	4.800	1380	385	22.2
16.00	4	52	0.095	16.000	6.400	1035	395	40.3
18.00	4	52	0.105	18.000	7.200	920	385	50.1
20.00	4	52	0.115	20.000	8.000	830	380	60.9
25.00	6	52	0.145	25.000	10.000	660	575	144.0
32.00	7	52	0.130	32.000	12.800	515	470	192.8

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



6.00	4	26	0.025	6.000	2.400	1380	140	2.0
8.00	4	26	0.035	8.000	3.200	1035	145	3.7
10.00	4	26	0.045	10.000	4.000	830	150	6.0
12.00	4	26	0.070	12.000	4.800	690	195	11.1
16.00	4	26	0.095	16.000	6.400	515	195	20.1
18.00	4	26	0.105	18.000	7.200	460	195	25.0
20.00	4	26	0.115	20.000	8.000	415	190	30.5
25.00	6	26	0.145	25.000	10.000	330	290	72.0
32.00	7	26	0.130	32.000	12.800	260	235	96.4

Inox medium
[Cr-Ni-Mo+/1.4539]
Duplex steel
[17-4 PH]



6.00	4	22	0.025	6.000	2.400	1165	115	1.7
8.00	4	22	0.035	8.000	3.200	875	125	3.1
10.00	4	22	0.045	10.000	4.000	700	125	5.0
12.00	4	22	0.070	12.000	4.800	585	165	9.4
16.00	4	22	0.095	16.000	6.400	440	165	17.0
18.00	4	22	0.105	18.000	7.200	390	165	21.2
20.00	4	22	0.115	20.000	8.000	350	160	25.8
25.00	6	22	0.145	25.000	10.000	280	245	60.9
32.00	7	22	0.130	32.000	12.800	220	200	81.6



Steel
< 850 N/mm²



6.00	4	58	0.020	6.000	6.000	3075	245	8.9
8.00	4	58	0.025	8.000	8.000	2310	230	14.8
10.00	4	58	0.035	10.000	10.000	1845	260	25.8
12.00	4	58	0.055	12.000	12.000	1540	340	48.7
16.00	4	58	0.070	16.000	16.000	1155	325	82.7
18.00	4	58	0.080	18.000	18.000	1025	330	106.3
20.00	4	58	0.090	20.000	20.000	925	330	132.9

Steel
850 - 1100 N/mm²



6.00	4	48	0.020	6.000	6.000	2545	205	7.3
8.00	4	48	0.025	8.000	8.000	1910	190	12.2
10.00	4	48	0.035	10.000	10.000	1530	215	21.4
12.00	4	48	0.055	12.000	12.000	1275	280	40.3
16.00	4	48	0.070	16.000	16.000	955	265	68.4
18.00	4	48	0.080	18.000	18.000	850	270	88.0
20.00	4	48	0.090	20.000	20.000	765	275	110.0

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



6.00	4	23	0.020	6.000	6.000	1220	100	3.5
8.00	4	23	0.025	8.000	8.000	915	90	5.9
10.00	4	23	0.035	10.000	10.000	730	100	10.2
12.00	4	23	0.055	12.000	12.000	610	135	19.3
16.00	4	23	0.070	16.000	16.000	460	130	32.8
18.00	4	23	0.080	18.000	18.000	405	130	42.2
20.00	4	23	0.090	20.000	20.000	365	130	52.7

Inox medium
[Cr-Ni-Mo+/1.4539]
Duplex steel
[17-4 PH]



6.00	4	20	0.020	6.000	6.000	1060	85	3.1
8.00	4	20	0.025	8.000	8.000	795	80	5.1
10.00	4	20	0.035	10.000	10.000	635	90	8.9
12.00	4	20	0.055	12.000	12.000	530	115	16.8
16.00	4	20	0.070	16.000	16.000	400	110	28.5
18.00	4	20	0.080	18.000	18.000	355	115	36.7
20.00	4	20	0.090	20.000	20.000	320	115	45.8