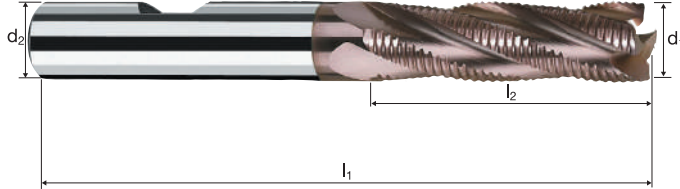


Cylindrical end mills

Profiled NRF, medium length version

HSS

HSS-E λ 25°
Co8 γ 10°



Roughing

Finishing



Rm

< 850

Rm

850-1100

Rm

1100-1300

Inox

Stainless

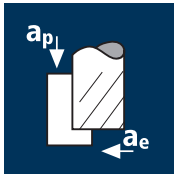
Ti

Titanium

GG(G)

Example: Order-N°.										UNICUT-4X	
										U0650	
Ø Code	d ₁ k12	d ₂ h6	l ₁	l ₂	l ₄	45°	α	z			
260	5.00	6.00	63	19.00	26.55	0.40	1.5°	3	●		
300	6.00	6.00	63	19.00	-	0.40	0.0°	3	●		
402	8.00	10.00	78	28.00	37.50	0.40	2.0°	4	●		
450	10.00	10.00	84	34.00	-	0.40	0.0°	4	●		
501	12.00	12.00	97	40.00	-	0.40	0.0°	4	●		
570	14.00	12.00	97	40.00	-	0.40	0.0°	4	●		
610	16.00	16.00	108	48.00	-	0.50	0.0°	4	●		
640	18.00	16.00	108	48.00	-	0.50	0.0°	4	●		
682	20.00	20.00	122	56.00	-	0.50	0.0°	4	●		
710	22.00	20.00	122	56.00	-	0.70	0.0°	4	●		
772	25.00	25.00	144	68.00	-	0.70	0.0°	4	●		
800	28.00	25.00	144	68.00	-	0.70	0.0°	6	●		
810	30.00	25.00	144	68.00	-	0.70	0.0°	6	●		
832	32.00	32.00	160	80.00	-	0.70	0.0°	6	●		

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	3	36	0.020	12.000	1.500	1910	115	2.1
8.00	4	36	0.030	16.000	2.000	1430	170	5.5
10.00	4	36	0.035	20.000	2.500	1145	160	8.0
12.00	4	36	0.055	24.000	3.000	955	210	15.1
16.00	4	36	0.075	32.000	4.000	715	215	27.5
20.00	4	36	0.095	40.000	5.000	575	220	43.5
25.00	4	36	0.115	50.000	6.250	460	210	65.9
30.00	6	36	0.095	60.000	7.500	380	220	98.0
32.00	6	36	0.105	64.000	8.000	360	225	115.5

Steel
850 - 1100 N/mm²



6.00	3	30	0.020	12.000	1.500	1590	95	1.7
8.00	4	30	0.030	16.000	2.000	1195	145	4.6
10.00	4	30	0.035	20.000	2.500	955	135	6.7
12.00	4	30	0.055	24.000	3.000	795	175	12.6
16.00	4	30	0.075	32.000	4.000	595	180	22.9
20.00	4	30	0.095	40.000	5.000	475	180	36.3
25.00	4	30	0.115	50.000	6.250	380	175	54.9
30.00	6	30	0.095	60.000	7.500	320	180	81.6
32.00	6	30	0.105	64.000	8.000	300	190	96.3

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



6.00	3	15	0.020	12.000	1.500	795	50	0.9
8.00	4	15	0.030	16.000	2.000	595	70	2.3
10.00	4	15	0.035	20.000	2.500	475	65	3.3
12.00	4	15	0.055	24.000	3.000	400	90	6.3
16.00	4	15	0.075	32.000	4.000	300	90	11.5
20.00	4	15	0.095	40.000	5.000	240	90	18.1
25.00	4	15	0.115	50.000	6.250	190	90	27.5
30.00	6	15	0.095	60.000	7.500	160	90	40.8
32.00	6	15	0.105	64.000	8.000	150	95	48.1

Cast iron
(lamellar / spheroidal)



6.00	3	28	0.020	12.000	1.500	1485	90	1.6
8.00	4	28	0.030	16.000	2.000	1115	135	4.3
10.00	4	28	0.035	20.000	2.500	890	125	6.2
12.00	4	28	0.055	24.000	3.000	745	165	11.8
16.00	4	28	0.075	32.000	4.000	555	165	21.4
20.00	4	28	0.095	40.000	5.000	445	170	33.9
25.00	4	28	0.115	50.000	6.250	355	165	51.2
30.00	6	28	0.095	60.000	7.500	295	170	76.2
32.00	6	28	0.105	64.000	8.000	280	175	89.8



Steel
< 850 N/mm²



6.00	3	30	0.020	4.200	6.000	1590	95	2.4
8.00	4	30	0.025	5.600	8.000	1195	120	5.3
10.00	4	30	0.035	7.000	10.000	955	135	9.4
12.00	4	30	0.055	8.400	12.000	795	175	17.6
16.00	4	30	0.070	11.200	16.000	595	165	29.9
20.00	4	30	0.090	14.000	20.000	475	170	48.1
25.00	4	30	0.110	17.500	25.000	380	170	73.5
30.00	6	30	0.090	21.000	30.000	320	170	108.3
32.00	6	30	0.095	22.400	32.000	300	170	121.9

Steel
850 - 1100 N/mm²



6.00	3	26	0.020	4.200	6.000	1380	85	2.1
8.00	4	26	0.025	5.600	8.000	1035	105	4.6
10.00	4	26	0.035	7.000	10.000	830	115	8.1
12.00	4	26	0.055	8.400	12.000	690	150	15.3
16.00	4	26	0.070	11.200	16.000	515	145	26.0
20.00	4	26	0.090	14.000	20.000	415	150	41.7
25.00	4	26	0.110	17.500	25.000	330	145	63.7
30.00	6	26	0.090	21.000	30.000	275	150	93.9
32.00	6	26	0.095	22.400	32.000	260	145	105.7

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



6.00	3	14	0.020	4.200	6.000	745	45	1.1
8.00	4	14	0.025	5.600	8.000	555	55	2.5
10.00	4	14	0.035	7.000	10.000	445	60	4.4
12.00	4	14	0.055	8.400	12.000	370	80	8.2
16.00	4	14	0.070	11.200	16.000	280	80	14.0
20.00	4	14	0.090	14.000	20.000	225	80	22.5
25.00	4	14	0.110	17.500	25.000	180	80	34.3
30.00	6	14	0.090	21.000	30.000	150	80	50.5
32.00	6	14	0.095	22.400	32.000	140	80	56.9

Cast iron
(lamellar / spheroidal)



6.00	3	22	0.020	4.200	6.000	1165	70	1.8
8.00	4	22	0.025	5.600	8.000	875	90	3.9
10.00	4	22	0.035	7.000	10.000	700	100	6.9
12.00	4	22	0.055	8.400	12.000	585	130	12.9
16.00	4	22	0.070	11.200	16.000	440	125	22.0
20.00	4	22	0.090	14.000	20.000	350	125	35.3
25.00	4	22	0.110	17.500	25.000	280	125	53.9
30.00	6	22	0.090	21.000	30.000	235	125	79.4
32.00	6	22	0.095	22.400	32.000	220	125	89.4