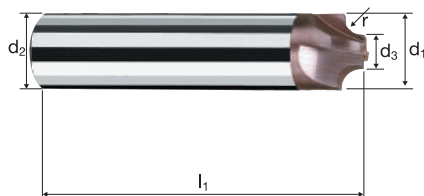


Quarter radius end mills



HM	λ	0°
MG10	γ	0°

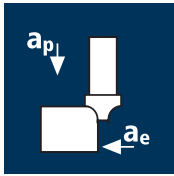


Rm < 850	Rm 850-1100	Rm 1100-1300	Rm 1300-1500				Inox Stainless	Ti Titanium	GG(G) Aluminium Copper
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Ø Code	d ₁	d ₂ h6	d ₃ ±0.1	l ₁	r J510	z	UNICUT-4X
Example: Order-Nº. Coating: U Article-Nº: 7920 ø-Code: 300							
							U7920
300	6.00	6.00	4.50	57	0.500	4	●
303	6.00	6.00	4.00	57	0.750	4	●
391	8.00	8.00	5.50	63	1.000	4	●
394	8.00	8.00	5.00	63	1.250	4	●
397	8.00	8.00	4.50	63	1.500	4	●
450	10.00	10.00	5.00	72	2.000	4	●
453	10.00	10.00	4.50	72	2.500	4	●
501	12.00	12.00	5.00	83	3.000	4	●



Application



Material

Steel
< 850 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]
6.00	4	120	0.025	0.500	0.500	6365	635
8.00	4	120	0.030	1.000	1.000	4775	575
10.00	4	120	0.040	2.000	2.000	3820	610
12.00	4	120	0.050	3.000	3.000	3185	635

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]
6.00	4	100	0.020	0.500	0.500	5305	425
8.00	4	100	0.025	1.000	1.000	3980	400
10.00	4	100	0.035	2.000	2.000	3185	445
12.00	4	100	0.040	3.000	3.000	2655	425

Steel
1100 - 1300 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]
6.00	4	60	0.015	0.500	0.500	3185	190
8.00	4	60	0.025	1.000	1.000	2385	240
10.00	4	60	0.030	2.000	2.000	1910	230
12.00	4	60	0.035	3.000	3.000	1590	225

Stainless steel
[Cr-Ni/1.4301]



d1 [mm]	z	v _c [m/min]	f _c [mm]	a _p [mm]	a _e [mm]	n [min ⁻¹]	v _r [mm/min]
6.00	4	50	0.015	0.500	0.500	2655	160
8.00	4	50	0.025	1.000	1.000	1990	200
10.00	4	50	0.030	2.000	2.000	1590	190
12.00	4	50	0.035	3.000	3.000	1325	185

Cast iron
(lamellar / spheroidal)



d1 [mm]	z	v _c [m/min]	f _c [mm]	a _p [mm]	a _e [mm]	n [min ⁻¹]	v _r [mm/min]
6.00	4	140	0.025	0.500	0.500	7425	745
8.00	4	140	0.030	1.000	1.000	5570	670
10.00	4	140	0.040	2.000	2.000	4455	715
12.00	4	140	0.050	3.000	3.000	3715	745

Unalloyed copper



d1 [mm]	z	v _c [m/min]	f _c [mm]	a _p [mm]	a _e [mm]	n [min ⁻¹]	v _r [mm/min]
6.00	4	160	0.020	0.500	0.500	8490	680
8.00	4	160	0.025	1.000	1.000	6365	635
10.00	4	160	0.035	2.000	2.000	5095	715
12.00	4	160	0.040	3.000	3.000	4245	680

Titanium alloys
up to 300 HB
[Ti5Al2.5Sn]



d1 [mm]	z	v _c [m/min]	f _c [mm]	a _p [mm]	a _e [mm]	n [min ⁻¹]	v _r [mm/min]
6.00	4	60	0.015	0.500	0.500	3185	190
8.00	4	60	0.025	1.000	1.000	2385	240
10.00	4	60	0.030	2.000	2.000	1910	230
12.00	4	60	0.035	3.000	3.000	1590	225

Wrought aluminium
Si < 6%



d1 [mm]	z	v _c [m/min]	f _c [mm]	a _p [mm]	a _e [mm]	n [min ⁻¹]	v _r [mm/min]
6.00	4	180	0.025	0.500	0.500	9550	955
8.00	4	180	0.030	1.000	1.000	7160	860
10.00	4	180	0.040	2.000	2.000	5730	915
12.00	4	180	0.050	3.000	3.000	4775	955