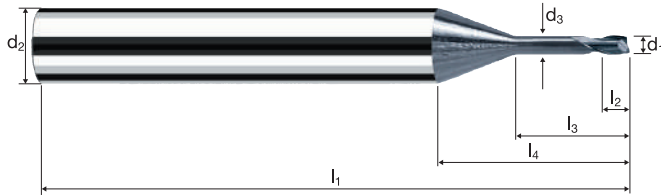
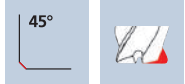


Cylindrical end mills MicroX

Shank \varnothing 6mm, cylindrical neck, 4xd



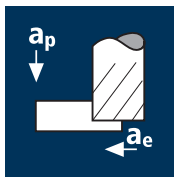
HM	λ 25°
XA	γ -10°



Rm < 850	Rm 850-1100	Rm 1100-1300	Rm 1300-1500	HRC 48-56	HRC 56-60	HRC > 60	Inox Stainless	Ti Titanium	Cobalt-Chrome Copper
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\varnothing Code	d ₁ 0/-0.01	d ₂ h4	d ₃	l ₁	l ₂	l ₃	l ₄	45°	α	z	Example: Order-N°.		X-AL
											Coating X	Article-N° 6503	\varnothing -Code 010
010	0.10	6.00	0.09	57	0.06	0.40	17.38	-	14.5°	2			●
020	0.20	6.00	0.18	57	0.12	0.80	17.42	-	14.5°	2			●
030	0.30	6.00	0.25	57	0.18	1.20	17.44	-	14.0°	2			●
040	0.40	6.00	0.35	57	0.24	1.60	17.56	-	13.5°	2			●
050	0.50	6.00	0.45	57	0.30	2.00	12.51	-	13.0°	2			●
060	0.60	6.00	0.55	57	0.36	2.40	12.73	-	12.5°	2			●
080	0.80	6.00	0.75	57	0.48	3.20	13.15	-	11.5°	2			●
100	1.00	6.00	0.95	57	1.00	4.00	14.08	0.07	11.0°	2			●
120	1.50	6.00	1.40	57	1.50	6.00	15.24	0.07	9.0°	2			●
140	2.00	6.00	1.90	61	2.00	8.00	16.31	0.10	7.5°	2			●

Application



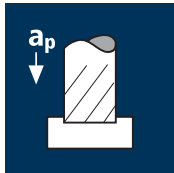
Material

Hardened tool steel
42 - 48 HRC

Hardened tool steel
48 - 52 HRC

Hardened tool steel
52 - 56 HRC

Hardened tool steel
56 - 60 HRC



Hardened tool steel
42 - 48 HRC

Hardened tool steel
48 - 52 HRC

Hardened tool steel
52 - 56 HRC

Hardened tool steel
56 - 60 HRC

d1 [mm]	z	v _c [m/min]	f _s [mm]	a _p [mm]	a _e [mm]	n [min ⁻¹]	v _r [mm/min]	Q [mm ³ /min]
0.20	2	26	0.001	0.008	0.040	41380	105	0.0
0.30	2	40	0.003	0.012	0.060	42440	215	0.2
0.40	2	53	0.004	0.016	0.080	42175	320	0.4
0.50	2	66	0.004	0.020	0.100	42015	320	0.6
0.60	2	79	0.004	0.024	0.120	41910	315	0.9
0.80	2	106	0.005	0.032	0.160	42175	425	2.2
1.00	2	132	0.006	0.040	0.200	42015	530	4.2
1.50	2	140	0.010	0.060	0.300	29710	600	10.8
2.00	2	140	0.014	0.080	0.400	22280	620	19.8
0.20	2	26	0.001	0.008	0.040	41380	100	0.0
0.30	2	40	0.002	0.012	0.060	42440	205	0.1
0.40	2	53	0.004	0.016	0.080	42175	305	0.4
0.50	2	66	0.004	0.020	0.100	42015	305	0.6
0.60	2	79	0.004	0.024	0.120	41910	300	0.9
0.80	2	106	0.005	0.032	0.160	42175	405	2.1
1.00	2	120	0.006	0.040	0.200	38195	460	3.7
1.50	2	120	0.010	0.060	0.300	25465	490	8.8
2.00	2	120	0.013	0.080	0.400	19100	505	16.1
0.20	2	26	0.001	0.008	0.040	41380	85	0.0
0.30	2	40	0.002	0.012	0.060	42440	170	0.1
0.40	2	53	0.003	0.016	0.080	42175	255	0.3
0.50	2	66	0.003	0.020	0.100	42015	250	0.5
0.60	2	79	0.003	0.024	0.120	41910	250	0.7
0.80	2	100	0.004	0.032	0.160	39790	320	1.6
1.00	2	100	0.005	0.040	0.200	31830	320	2.5
1.50	2	100	0.008	0.060	0.300	21220	340	6.1
2.00	2	100	0.011	0.080	0.400	15915	350	11.2
0.20	2	26	0.001	0.008	0.040	41380	75	0.0
0.30	2	40	0.002	0.012	0.060	42440	155	0.1
0.40	2	53	0.003	0.016	0.080	42175	230	0.3
0.50	2	60	0.003	0.020	0.100	38195	205	0.4
0.60	2	60	0.003	0.024	0.120	31830	170	0.5
0.80	2	60	0.004	0.032	0.160	23875	170	0.9
1.00	2	60	0.004	0.040	0.200	19100	170	1.4
1.50	2	60	0.007	0.060	0.300	12730	185	3.3
2.00	2	60	0.010	0.080	0.400	9550	190	6.1
0.20	2	26	0.001	0.003	0.200	41380	90	0.1
0.30	2	40	0.002	0.005	0.300	42440	185	0.3
0.40	2	53	0.002	0.006	0.400	42175	185	0.4
0.50	2	66	0.003	0.008	0.500	42015	275	1.1
0.60	2	79	0.003	0.009	0.600	41910	275	1.5
0.80	2	106	0.004	0.013	0.800	42175	370	3.9
1.00	2	120	0.005	0.016	1.000	38195	420	6.7
1.50	2	120	0.009	0.023	1.500	25465	450	15.5
2.00	2	120	0.011	0.031	2.000	19100	420	26.1
0.20	2	26	0.001	0.003	0.200	41380	90	0.1
0.30	2	40	0.002	0.005	0.300	42440	185	0.3
0.40	2	53	0.002	0.006	0.400	42175	185	0.4
0.50	2	66	0.003	0.008	0.500	42015	275	1.1
0.60	2	79	0.003	0.009	0.600	41910	275	1.5
0.80	2	100	0.004	0.013	0.800	39790	350	3.6
1.00	2	100	0.005	0.016	1.000	31830	350	5.6
1.50	2	100	0.009	0.023	1.500	21220	375	12.9
2.00	2	100	0.011	0.031	2.000	15915	350	21.7
0.20	2	26	0.001	0.003	0.200	41380	85	0.0
0.30	2	40	0.002	0.005	0.300	42440	170	0.3
0.40	2	53	0.002	0.006	0.400	42175	170	0.4
0.50	2	66	0.003	0.008	0.500	42015	250	1.0
0.60	2	79	0.003	0.009	0.600	41910	250	1.4
0.80	2	80	0.004	0.013	0.800	31830	255	2.6
1.00	2	80	0.005	0.016	1.000	25465	255	4.1
1.50	2	80	0.008	0.023	1.500	16975	270	9.4
2.00	2	80	0.010	0.031	2.000	12730	255	15.8
0.20	2	26	0.001	0.003	0.200	41380	75	0.0
0.30	2	40	0.002	0.005	0.300	42440	155	0.2
0.40	2	40	0.002	0.006	0.400	31830	115	0.3
0.50	2	40	0.003	0.008	0.500	25465	140	0.6
0.60	2	40	0.003	0.009	0.600	21220	115	0.6
0.80	2	40	0.004	0.013	0.800	15915	115	1.2
1.00	2	40	0.004	0.016	1.000	12730	115	1.8
1.50	2	40	0.007	0.023	1.500	8490	120	4.2
2.00	2	40	0.009	0.031	2.000	6365	115	7.1