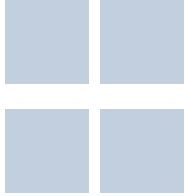
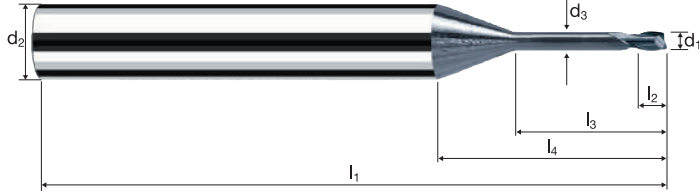
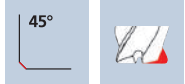


# Cylindrical end mills MicroX

Shank  $\varnothing$  6mm, cylindrical neck, 6xd



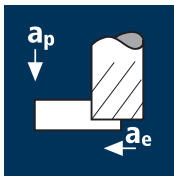
HM  
XA  $\lambda$  25°  
 $\gamma$  -10°



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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Example: Order-N°.											X-AL		
											X6505		
$\varnothing$ Code	Coating			Article-N°.				ø-Code		45°	$\alpha$	z	
	$d_1$ 0/-0.01	$d_2$ h4	$d_3$	$l_1$	$l_2$	$l_3$	$l_4$						
020	0.20	6.00	0.18	57	0.12	1.20	17.82	-	14.0°	2	●		
030	0.30	6.00	0.25	57	0.18	1.80	18.04	-	13.0°	2	●		
040	0.40	6.00	0.35	57	0.24	2.40	18.36	-	12.5°	2	●		
050	0.50	6.00	0.45	57	0.30	3.00	13.51	-	12.0°	2	●		
060	0.60	6.00	0.55	57	0.36	3.60	13.93	-	11.5°	2	●		
080	0.80	6.00	0.75	57	0.48	4.80	14.75	-	10.5°	2	●		
100	1.00	6.00	0.95	57	1.00	6.00	16.08	0.07	9.5°	2	●		
120	1.50	6.00	1.40	61	1.50	9.00	18.24	0.07	7.5°	2	●		
140	2.00	6.00	1.90	66	2.00	12.00	20.31	0.10	6.0°	2	●		

## Application



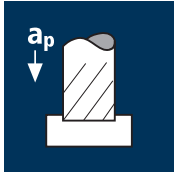
## Material

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 <sub>r</sub> [m/min]	f <sub>s</sub> [mm]	a <sub>p</sub> [mm]	a <sub>e</sub> [mm]	n [min <sup>-1</sup> ]	v <sub>r</sub> [mm/min]	Q [mm <sup>3</sup> /min]
0.20	2	26	0.001	0.005	0.040	41380	105	0.0
0.30	2	40	0.003	0.008	0.060	42440	215	0.1
0.40	2	53	0.003	0.011	0.080	42175	215	0.2
0.50	2	66	0.004	0.013	0.100	42015	320	0.4
0.60	2	79	0.004	0.016	0.120	41910	315	0.6
0.80	2	106	0.005	0.021	0.160	42175	425	1.4
1.00	2	132	0.006	0.027	0.200	42015	530	2.9
1.50	2	140	0.010	0.040	0.300	29710	600	7.2
2.00	2	140	0.013	0.053	0.400	22280	560	11.9
0.20	2	26	0.001	0.005	0.040	41380	100	0.0
0.30	2	40	0.002	0.008	0.060	42440	205	0.1
0.40	2	53	0.002	0.011	0.080	42175	200	0.2
0.50	2	66	0.004	0.013	0.100	42015	305	0.4
0.60	2	79	0.004	0.016	0.120	41910	300	0.6
0.80	2	106	0.005	0.021	0.160	42175	405	1.4
1.00	2	120	0.006	0.027	0.200	38195	460	2.5
1.50	2	120	0.010	0.040	0.300	25465	490	5.9
2.00	2	120	0.012	0.053	0.400	19100	460	9.7
0.20	2	26	0.001	0.005	0.040	41380	85	0.0
0.30	2	40	0.002	0.008	0.060	42440	170	0.1
0.40	2	53	0.002	0.011	0.080	42175	170	0.1
0.50	2	66	0.003	0.013	0.100	42015	250	0.3
0.60	2	79	0.003	0.016	0.120	41910	250	0.5
0.80	2	100	0.004	0.021	0.160	39790	320	1.1
1.00	2	100	0.005	0.027	0.200	31830	320	1.7
1.50	2	100	0.008	0.040	0.300	21220	340	4.1
2.00	2	100	0.010	0.053	0.400	15915	320	6.7
0.20	2	26	0.001	0.005	0.040	41380	75	0.0
0.30	2	40	0.002	0.008	0.060	42440	155	0.1
0.40	2	53	0.002	0.011	0.080	42175	150	0.1
0.50	2	60	0.003	0.013	0.100	38195	205	0.3
0.60	2	60	0.003	0.016	0.120	31830	170	0.3
0.80	2	60	0.004	0.021	0.160	23875	170	0.6
1.00	2	60	0.004	0.027	0.200	19100	170	0.9
1.50	2	60	0.007	0.040	0.300	12730	185	2.2
2.00	2	60	0.009	0.053	0.400	9550	170	3.6
0.20	2	26	0.001	0.002	0.200	41380	90	0.0
0.30	2	40	0.002	0.003	0.300	42440	185	0.2
0.40	2	53	0.002	0.004	0.400	42175	185	0.3
0.50	2	66	0.003	0.005	0.500	42015	275	0.7
0.60	2	79	0.003	0.006	0.600	41910	275	1.0
0.80	2	106	0.004	0.009	0.800	42175	370	2.5
1.00	2	120	0.005	0.010	1.000	38195	420	4.2
1.50	2	120	0.009	0.016	1.500	25465	450	10.8
2.00	2	120	0.011	0.021	2.000	19100	420	17.6
0.20	2	26	0.001	0.002	0.200	41380	90	0.0
0.30	2	40	0.002	0.003	0.300	42440	185	0.2
0.40	2	53	0.002	0.004	0.400	42175	185	0.3
0.50	2	66	0.003	0.005	0.500	42015	275	0.7
0.60	2	79	0.003	0.006	0.600	41910	275	1.0
0.80	2	100	0.004	0.009	0.800	39790	350	2.4
1.00	2	100	0.005	0.010	1.000	31830	350	3.5
1.50	2	100	0.009	0.016	1.500	21220	375	9.0
2.00	2	100	0.011	0.021	2.000	15915	350	14.7
0.20	2	26	0.001	0.002	0.200	41380	85	0.0
0.30	2	40	0.002	0.003	0.300	42440	170	0.2
0.40	2	53	0.002	0.004	0.400	42175	170	0.3
0.50	2	66	0.003	0.005	0.500	42015	250	0.6
0.60	2	79	0.003	0.006	0.600	41910	250	0.9
0.80	2	80	0.004	0.009	0.800	31830	255	1.7
1.00	2	80	0.005	0.010	1.000	25465	255	2.5
1.50	2	80	0.008	0.016	1.500	16975	270	6.5
2.00	2	80	0.010	0.021	2.000	12730	255	10.7
0.20	2	26	0.001	0.002	0.200	41380	75	0.0
0.30	2	40	0.002	0.003	0.300	42440	155	0.1
0.40	2	40	0.002	0.004	0.400	31830	115	0.2
0.50	2	40	0.003	0.005	0.500	25465	140	0.3
0.60	2	40	0.003	0.006	0.600	21220	115	0.4
0.80	2	40	0.004	0.009	0.800	15915	115	0.8
1.00	2	40	0.004	0.010	1.000	12730	115	1.1
1.50	2	40	0.007	0.016	1.500	8490	120	2.9
2.00	2	40	0.009	0.021	2.000	6365	115	4.8