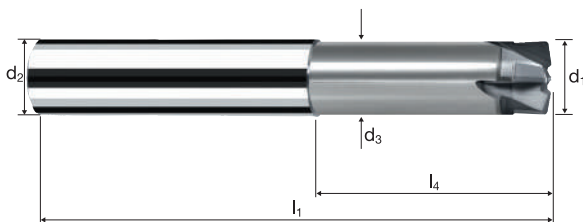
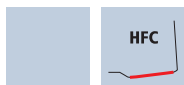


High feed end mills XFeed

Cylindrical neck, 3xd



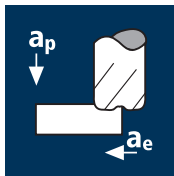
HM	λ	0°
XT	γ	0°



Rm < 850	Rm 850-1100	Rm 1100-1300	Rm 1300-1500	HRC 48-56	HRC 56-60	HRC > 60	Ti Titanium	HSS GG(G)
-------------	----------------	-----------------	-----------------	--------------	--------------	-------------	----------------	--------------

												X-AL
Example: Order-N°.												
Coating: X Article-N°: 7600 ø-Code: 100												
												X7600
Ø Code	d ₁ e8	d ₂ h6	d ₃	l ₁	l ₃	l ₄	ap _{max}	R _{theo.}	α	z		
100	1.00	6.00	0.95	57	3.00	13.08	0.04	0.09	11.5°	4		●
140	2.00	6.00	1.90	57	6.00	14.31	0.08	0.18	8.5°	4		●
180	3.00	6.00	2.80	57	9.00	15.63	0.12	0.27	6.0°	4		●
220	4.00	6.00	3.70	57	12.00	16.95	0.16	0.36	3.8°	4		●
260	5.00	6.00	4.60	57	15.00	18.27	0.20	0.45	1.8°	4		●
300	6.00	6.00	5.50	57	19.34	20.00	0.25	0.54	0.0°	4		●
391	8.00	8.00	7.40	63	25.29	26.00	0.33	0.72	0.0°	4		●
450	10.00	10.00	9.20	72	30.20	31.00	0.41	0.90	0.0°	4		●
501	12.00	12.00	11.00	83	36.13	37.00	0.50	1.08	0.0°	4		●
610	16.00	16.00	15.00	92	42.13	43.00	0.69	1.44	0.0°	4		●

Application






Material





Steel
850 - 1100 N/mm²



Steel
1100 - 1300 N/mm²


Steel
1300 - 1500 N/mm²


Hardened tool steel
48 - 52 HRC

Hardened tool steel
52 - 56 HRC





Hardened tool steel
56 - 60 HRC

Hardened tool steel
> 60 HRC

Cast iron
(lamellar / spheroidal)

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]
2.00	4	250	0.135	0.050	1.200	39790	21485	1.3
3.00	4	250	0.200	0.080	1.800	26525	21220	3.1
4.00	4	250	0.265	0.120	2.400	19895	21090	6.1
5.00	4	250	0.335	0.160	3.000	15915	21325	10.2
6.00	4	250	0.400	0.200	3.600	13265	21220	15.3
8.00	4	250	0.535	0.250	4.800	9945	21285	25.5
10.00	4	250	0.665	0.320	6.000	7960	21170	40.6
12.00	4	250	0.800	0.400	7.200	6630	21220	61.1
16.00	4	250	1.065	0.480	9.600	4975	21190	97.6
2.00	4	220	0.115	0.050	1.200	35015	16105	1.0
3.00	4	220	0.170	0.080	1.800	23345	15875	2.3
4.00	4	220	0.225	0.120	2.400	17505	15755	4.5
5.00	4	220	0.285	0.160	3.000	14005	15965	7.7
6.00	4	220	0.340	0.200	3.600	11670	15875	11.4
8.00	4	220	0.455	0.250	4.800	8755	15930	19.1
10.00	4	220	0.565	0.320	6.000	7005	15825	30.4
12.00	4	220	0.680	0.400	7.200	5835	15875	45.7
16.00	4	220	0.905	0.480	9.600	4375	15845	73.0
2.00	4	200	0.105	0.050	1.200	31830	13370	0.8
3.00	4	200	0.155	0.070	1.800	21220	13155	1.7
4.00	4	200	0.205	0.110	2.400	15915	13050	3.4
5.00	4	200	0.260	0.140	3.000	12730	13240	5.6
6.00	4	200	0.310	0.180	3.600	10610	13155	8.5
8.00	4	200	0.415	0.230	4.800	7960	13210	14.6
10.00	4	200	0.520	0.290	6.000	6365	13240	23.0
12.00	4	200	0.625	0.360	7.200	5305	13265	34.4
16.00	4	200	0.830	0.430	9.600	3980	13210	54.5
2.00	4	160	0.060	0.070	1.200	25465	6110	0.5
3.00	4	160	0.090	0.110	1.800	16975	6110	1.2
4.00	4	160	0.120	0.140	2.400	12730	6110	2.1
5.00	4	160	0.150	0.180	3.000	10185	6110	3.3
6.00	4	160	0.180	0.210	3.600	8490	6110	4.6
8.00	4	160	0.240	0.280	4.800	6365	6110	8.2
10.00	4	160	0.300	0.350	6.000	5095	6110	12.8
12.00	4	160	0.360	0.420	7.200	4245	6110	18.5
16.00	4	160	0.480	0.560	9.600	3185	6110	32.9
2.00	4	140	0.050	0.070	1.200	22280	4455	0.4
3.00	4	140	0.075	0.110	1.800	14855	4455	0.9
4.00	4	140	0.100	0.140	2.400	11140	4455	1.5
5.00	4	140	0.125	0.180	3.000	8915	4455	2.4
6.00	4	140	0.150	0.210	3.600	7425	4455	3.4
8.00	4	140	0.200	0.280	4.800	5570	4455	6.0
10.00	4	140	0.250	0.350	6.000	4455	4455	9.4
12.00	4	140	0.300	0.420	7.200	3715	4455	13.5
16.00	4	140	0.400	0.560	9.600	2785	4455	24.0
2.00	4	100	0.030	0.060	1.200	15915	1910	0.1
3.00	4	100	0.045	0.090	1.800	10610	1910	0.3
4.00	4	100	0.060	0.120	2.400	7960	1910	0.6
5.00	4	100	0.075	0.150	3.000	6365	1910	0.9
6.00	4	100	0.090	0.180	3.600	5305	1910	1.2
8.00	4	100	0.120	0.240	4.800	3980	1910	2.2
10.00	4	100	0.150	0.300	6.000	3185	1910	3.4
12.00	4	100	0.180	0.360	7.200	2655	1910	5.0
16.00	4	100	0.240	0.480	9.600	1990	1910	8.8
2.00	4	60	0.020	0.050	1.200	9550	765	0.0
3.00	4	60	0.030	0.075	1.800	6365	765	0.1
4.00	4	60	0.040	0.100	2.400	4775	765	0.2
5.00	4	60	0.050	0.125	3.000	3820	765	0.3
6.00	4	60	0.060	0.150	3.600	3185	765	0.4
8.00	4	60	0.080	0.200	4.800	2385	765	0.7
10.00	4	60	0.100	0.250	6.000	1910	765	1.1
12.00	4	60	0.120	0.300	7.200	1590	765	1.7
16.00	4	60	0.160	0.400	9.600	1195	765	2.9
2.00	4	250	0.135	0.050	1.200	39790	21485	1.3
3.00	4	250	0.200	0.080	1.800	26525	21220	3.1
4.00	4	250	0.265	0.120	2.400	19895	21090	6.1
5.00	4	250	0.335	0.160	3.000	15915	21325	10.2
6.00	4	250	0.400	0.200	3.600	13265	21220	15.3
8.00	4	250	0.535	0.250	4.800	9945	21285	25.5
10.00	4	250	0.665	0.320	6.000	7960	21170	40.6
12.00	4	250	0.800	0.400	7.200	6630	21220	61.1
16.00	4	250	1.065	0.480	9.600	4975	21190	97.6