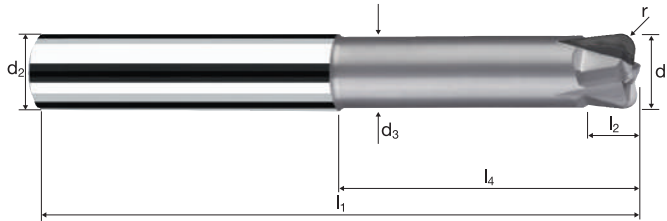


High feed end mills XFeed

Cylindrical neck, 6xd



HM XT	λ 0° γ -10°
	HFC

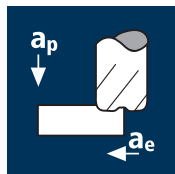


Rm	Rm	Rm	HRC	HRC	HRC		HSS
850-1100	1100-1300	1300-1500	48-56	56-60	> 60		GG(G)

Example: Order-N°.											X-AL
Coating: X Article-N°: 7624 ø-Code: 300											X7624
Ø Code	d ₁ e8	d ₂ h6	d ₃	l ₁	l ₂	l ₃	l ₄	r	α	z	
300	6.00	6.00	5.50	80	3.00	42.34	43.00	1.000	0.0°	4	●
391	8.00	8.00	7.40	90	4.00	52.29	53.00	1.500	0.0°	4	●
450	10.00	10.00	9.20	105	5.00	63.20	64.00	2.000	0.0°	4	●
501	12.00	12.00	11.00	120	6.00	73.13	74.00	2.500	0.0°	4	●
610	16.00	16.00	15.00	135	8.00	85.13	86.00	3.000	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



d1 [mm]	z	v _c [m/min]	f _f [mm]	a _p [mm]	a _e [mm]	n [min ⁻¹]	v _r [mm/min]	Q [cm ³ /min]
6.00	4	85	0.315	0.240	3.600	4510	5680	4.9
8.00	4	85	0.420	0.320	4.800	3380	5680	8.7
10.00	4	85	0.525	0.400	6.000	2705	5680	13.6
12.00	4	85	0.630	0.480	7.200	2255	5680	19.6
16.00	4	85	0.695	0.560	9.600	1690	4700	25.3
6.00	4	80	0.270	0.240	3.600	4245	4585	4.0
8.00	4	80	0.355	0.320	4.800	3185	4520	6.9
10.00	4	80	0.445	0.400	6.000	2545	4535	10.9
12.00	4	80	0.535	0.480	7.200	2120	4540	15.7
16.00	4	80	0.590	0.560	9.600	1590	3755	20.2
6.00	4	75	0.245	0.220	3.600	3980	3900	3.1
8.00	4	75	0.330	0.290	4.800	2985	3940	5.5
10.00	4	75	0.410	0.360	6.000	2385	3915	8.5
12.00	4	75	0.490	0.430	7.200	1990	3900	12.1
16.00	4	75	0.540	0.500	9.600	1490	3225	15.5
6.00	4	70	0.190	0.190	3.600	3715	2820	1.9
8.00	4	70	0.250	0.260	4.800	2785	2785	3.5
10.00	4	70	0.315	0.320	6.000	2230	2805	5.4
12.00	4	70	0.380	0.380	7.200	1855	2820	7.7
16.00	4	70	0.415	0.450	9.600	1395	2310	10.0
6.00	4	65	0.140	0.170	3.600	3450	1930	1.2
8.00	4	65	0.190	0.220	4.800	2585	1965	2.1
10.00	4	65	0.235	0.280	6.000	2070	1945	3.3
12.00	4	65	0.285	0.340	7.200	1725	1965	4.8
16.00	4	65	0.315	0.390	9.600	1295	1630	6.1
6.00	4	55	0.090	0.160	3.600	2920	1050	0.6
8.00	4	55	0.120	0.210	4.800	2190	1050	1.1
10.00	4	55	0.145	0.260	6.000	1750	1015	1.6
12.00	4	55	0.175	0.310	7.200	1460	1020	2.3
16.00	4	55	0.195	0.360	9.600	1095	855	2.9