

High feed end mills XFeed

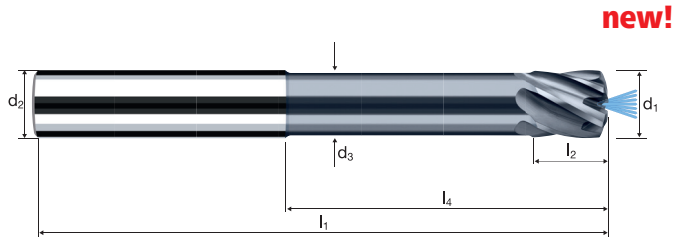
Cylindrical neck, 4.5xd, central air/cooling channel



HM
MG10

λ **30°**
 γ **0°**

HFC

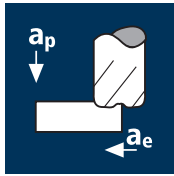


ReTool®

Rm < 850 **Rm** 850-1100 **Rm** 1100-1300 **Rm** 1300-1500 **HRC** 48-56 **GG(G) Tool Steel**

Ø Code	d ₁ e8	d ₂ h5	d ₃	l ₁	l ₂	l ₃	l ₄	ap _{max}	R _{theo.}	α	z	X-AL
												X7632
100*	1.00	6.00	0.95	61	1.00	4.50	14.58	0.09	0.13	10.0°	3	●
140*	2.00	6.00	1.90	61	2.00	9.00	17.31	0.17	0.25	6.8°	3	●
180*	3.00	6.00	2.80	61	3.00	13.50	20.13	0.26	0.38	4.5°	3	●
220*	4.00	6.00	3.70	66	4.00	18.00	22.95	0.34	0.51	2.7°	4	●
260*	5.00	6.00	4.60	66	5.00	22.50	25.77	0.43	0.64	1.3°	4	●
300	6.00	6.00	5.50	69	6.00	30.34	31.00	0.52	0.76	0.0°	4	●
391	8.00	8.00	7.30	80	8.00	39.29	40.00	0.69	1.02	0.0°	4	●
450	10.00	10.00	9.20	90	10.00	47.20	48.00	0.86	1.27	0.0°	4	●
453	10.00	10.00	9.20	90	10.00	47.20	48.00	0.86	1.27	0.0°	6	●
501	12.00	12.00	11.00	105	12.00	54.13	55.00	1.03	1.52	0.0°	4	●
503	12.00	12.00	11.00	105	12.00	54.13	55.00	1.03	1.52	0.0°	6	●
610	16.00	16.00	15.00	125	16.00	74.13	75.00	1.37	2.03	0.0°	4	●
612	16.00	16.00	15.00	125	16.00	74.13	75.00	1.37	2.03	0.0°	6	●
* without internal cooling												

Application





Material

Steel
500 - 850 N/mm²

d_1 [mm]	z	v_c [m/min]	f_z [mm]	a_p [mm]	a_e [mm]	n [min ⁻¹]	v_f [mm/min]	Q [cm ² /min]
2.00	3	130	0.100	0.120	1.500	20690	6207	1.1
3.00	3	130	0.150	0.180	2.250	13795	6208	2.5
4.00	4	155	0.200	0.220	3.000	12335	9868	6.5
5.00	4	155	0.250	0.275	3.750	9870	9870	10.2
6.00	4	160	0.300	0.330	4.500	8490	10188	15.1
8.00	4	160	0.400	0.440	6.000	6365	10184	26.9
10.00	4	160	0.500	0.550	7.500	5095	10190	42.0
12.00	4	160	0.540	0.660	9.000	4245	9169	54.5
16.00	4	160	0.560	0.880	12.000	3185	7134	75.3

Steel
850 - 1100 N/mm²



2.00	3	130	0.100	0.120	1.500	20690	6207	1.1
3.00	3	130	0.150	0.180	2.250	13795	6208	2.5
4.00	4	135	0.200	0.220	3.000	10745	8596	5.7
5.00	4	135	0.250	0.275	3.750	8595	8595	8.9
6.00	4	145	0.300	0.330	4.500	7690	9228	13.7
8.00	4	145	0.400	0.440	6.000	5770	9232	24.4
10.00	4	145	0.500	0.550	7.500	4615	9230	38.1
12.00	4	145	0.540	0.660	9.000	3845	8305	49.3
16.00	4	145	0.560	0.880	12.000	2885	6462	68.2

Steel
1100 - 1300 N/mm²

2.00	3	120	0.100	0.120	1.500	19100	5730	1.0
3.00	3	120	0.150	0.180	2.250	12730	5729	2.3
4.00	4	125	0.200	0.220	3.000	9945	7956	5.3
5.00	4	125	0.250	0.275	3.750	7960	7960	8.2
6.00	4	135	0.300	0.330	4.500	7160	8592	12.8
8.00	4	135	0.400	0.440	6.000	5370	8592	22.7
10.00	4	135	0.500	0.550	7.500	4295	8590	35.4
12.00	4	135	0.540	0.660	9.000	3580	7733	45.9
16.00	4	135	0.560	0.880	12.000	2685	6014	63.5

Hardened tool steel
42 - 48 HRC

2.00	3	120	0.085	0.120	1.500	19100	4871	0.9
3.00	3	120	0.128	0.180	2.250	12730	4869	2.0
4.00	4	125	0.150	0.220	3.000	9945	5967	3.9
5.00	4	125	0.188	0.275	3.750	7960	5970	6.2
6.00	4	135	0.225	0.330	4.500	7160	6444	9.6
8.00	4	135	0.300	0.440	6.000	5370	6444	17.0
10.00	4	135	0.325	0.550	7.500	4295	5584	23.0
12.00	4	135	0.330	0.660	9.000	3580	4726	28.1
16.00	4	135	0.400	0.880	12.000	2685	4296	45.4

Hardened tool steel
48 - 52 HRC

2.00	3	120	0.085	0.140	1.500	19100	4871	1.0
3.00	3	120	0.128	0.210	2.250	12730	4869	2.3
4.00	4	110	0.150	0.240	3.000	8755	5253	3.8
5.00	4	110	0.188	0.300	3.750	7005	5254	5.9
6.00	4	100	0.225	0.360	4.500	5305	4775	7.7
8.00	4	100	0.300	0.480	6.000	3980	4776	13.8
10.00	4	90	0.325	0.500	7.500	2865	3725	14.0
12.00	4	90	0.330	0.600	9.000	2385	3148	17.0
16.00	4	90	0.400	0.480	12.000	1790	2864	16.5

Hardened tool steel
52 - 56 HRC

2.00	3	120	0.075	0.140	1.500	19100	4298	0.9
3.00	3	120	0.113	0.210	2.250	12730	4316	2.0
4.00	4	110	0.130	0.240	3.000	8755	4553	3.3
5.00	4	110	0.163	0.300	3.750	7005	4567	5.1
6.00	4	100	0.195	0.360	4.500	5305	4138	6.7
8.00	4	100	0.260	0.480	6.000	3980	4139	11.9
10.00	4	90	0.275	0.500	7.500	2865	3152	11.8
12.00	4	90	0.300	0.600	9.000	2385	2862	15.5
16.00	4	90	0.320	0.480	12.000	1790	2291	13.2