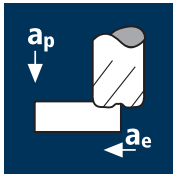


## Application



## Material

Steel  
500 - 850 N/mm<sup>2</sup>



Steel  
850 - 1100 N/mm<sup>2</sup>



Steel  
1100 - 1300 N/mm<sup>2</sup>



Hardened tool steel  
42 - 48 HRC



Hardened tool steel  
48 - 52 HRC



Hardened tool steel  
52 - 56 HRC



$d_1$ [mm]	$z$	$v_c$ [m/min]	$f_z$ [mm]	$a_p$ [mm]	$a_e$ [mm]	$n$ [min <sup>-1</sup> ]	$v_f$ [mm/min]	$Q$ [cm <sup>3</sup> /min]
3.00	3	105	0.150	0.090	2.250	11140	5013	1.0
4.00	4	125	0.200	0.100	3.000	9945	7956	2.4
5.00	4	125	0.250	0.125	3.750	7960	7960	3.7
6.00	4	130	0.300	0.150	4.500	6895	8274	5.6
8.00	4	130	0.400	0.200	6.000	5175	8280	9.9
10.00	6	125	0.275	0.250	7.500	3980	6567	12.3
12.00	6	125	0.270	0.300	9.000	3315	5370	14.5
16.00	6	125	0.280	0.400	12.000	2485	4175	20.0

3.00	3	105	0.150	0.090	2.250	11140	5013	1.0
4.00	4	110	0.200	0.100	3.000	8755	7004	2.1
5.00	4	110	0.250	0.125	3.750	7005	7005	3.3
6.00	4	115	0.300	0.150	4.500	6100	7320	4.9
8.00	4	115	0.400	0.200	6.000	4575	7320	8.8
10.00	6	110	0.275	0.250	7.500	3500	5775	10.8
12.00	6	110	0.270	0.300	9.000	2920	4730	12.8
16.00	6	110	0.280	0.400	12.000	2190	3679	17.7

3.00	3	95	0.150	0.090	2.250	10080	4536	0.9
4.00	4	100	0.200	0.100	3.000	7960	6368	1.9
5.00	4	100	0.250	0.125	3.750	6365	6365	3.0
6.00	4	110	0.300	0.150	4.500	5835	7002	4.7
8.00	4	110	0.400	0.200	6.000	4375	7000	8.4
10.00	6	100	0.275	0.250	7.500	3185	5255	9.9
12.00	6	100	0.270	0.300	9.000	2655	4301	11.6
16.00	6	100	0.280	0.400	12.000	1990	3343	16.0

3.00	3	95	0.128	0.090	2.250	10080	3856	0.8
4.00	4	100	0.150	0.100	3.000	7960	4776	1.4
5.00	4	100	0.188	0.125	3.750	6365	4774	2.2
6.00	4	110	0.225	0.150	4.500	5835	5252	3.5
8.00	4	110	0.300	0.200	6.000	4375	5250	6.3
10.00	6	100	0.275	0.250	7.500	3185	5255	9.9
12.00	6	100	0.270	0.300	9.000	2655	4301	11.6
16.00	6	100	0.280	0.400	12.000	1990	3343	16.0

3.00	3	100	0.128	0.120	2.250	10610	4058	1.1
4.00	4	90	0.150	0.140	3.000	7160	4296	1.8
5.00	4	90	0.188	0.175	3.750	5730	4298	2.8
6.00	4	90	0.225	0.210	4.500	4775	4298	4.1
8.00	4	90	0.300	0.280	6.000	3580	4296	7.2
10.00	6	80	0.275	0.300	7.500	2545	4199	9.4
12.00	6	80	0.270	0.360	9.000	2120	3434	11.1
16.00	6	80	0.280	0.400	12.000	1590	2671	12.8

3.00	3	100	0.113	0.120	2.250	10610	3597	1.0
4.00	4	90	0.130	0.140	3.000	7160	3723	1.6
5.00	4	90	0.163	0.175	3.750	5730	3736	2.5
6.00	4	90	0.195	0.210	4.500	4775	3725	3.5
8.00	4	90	0.260	0.280	6.000	3580	3723	6.3
10.00	6	80	0.220	0.300	7.500	2545	3359	7.6
12.00	6	80	0.240	0.360	9.000	2120	3053	9.9
16.00	6	80	0.256	0.400	12.000	1590	2442	11.7

# High feed end mills XFeed

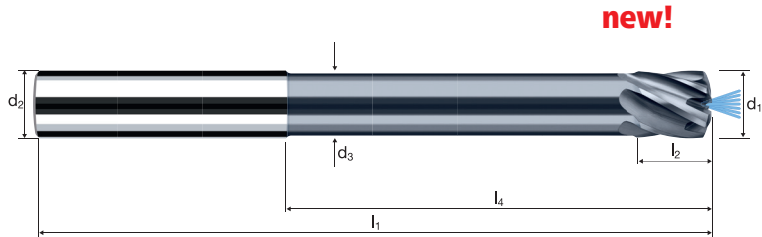
Cylindrical neck, 6xd, central air/cooling channel



**HM**  
**MG10**

$\lambda$  **30°**  
 $\gamma$  **0°**

**HFC**



**ReTool®**

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

Ø Code	d <sub>1</sub> e8	d <sub>2</sub> h5	d <sub>3</sub>	l <sub>1</sub>	l <sub>2</sub>	l <sub>3</sub>	l <sub>4</sub>	ap <sub>max</sub>	R <sub>theo.</sub>	α	z	X-AL
												X7634
180*	3.00	6.00	2.80	66	3.00	18.00	24.63	0.13	0.29	3.7°	3	●
220*	4.00	6.00	3.70	70	4.00	24.00	28.95	0.17	0.39	2.1°	4	●
260*	5.00	6.00	4.60	75	5.00	30.00	33.27	0.21	0.49	1.0°	4	●
300	6.00	6.00	5.50	80	6.00	42.34	43.00	0.26	0.59	0.0°	4	●
391	8.00	8.00	7.40	90	8.00	52.29	53.00	0.34	0.79	0.0°	4	●
453	10.00	10.00	9.20	105	10.00	63.20	64.00	0.43	0.98	0.0°	6	●
503	12.00	12.00	11.00	120	12.00	73.13	74.00	0.51	1.18	0.0°	6	●
612	16.00	16.00	15.00	135	16.00	85.13	86.00	0.68	1.57	0.0°	6	●
* without internal cooling												