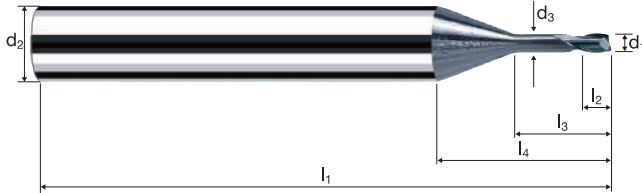


Cylindrical end mills MicroX

Shank \varnothing 6mm, cylindrical neck, 3xd



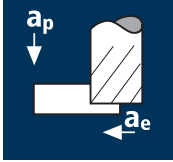
HM	λ 25°
XA	γ -10°



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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\varnothing Code	d_1 0/-0.01	d_2 h4	d_3	l_1	l_2	l_3	l_4	45°	α	z	Example: Order-N°.	X-AL
											Coating X	Article-N° 6502
010	0.10	6.00	0.09	57	0.06	0.30	17.30	-	15.0°	2		●
020	0.20	6.00	0.18	57	0.12	0.60	17.22	-	14.5°	2		●
030	0.30	6.00	0.25	57	0.18	0.90	17.14	-	14.0°	2		●
040	0.40	6.00	0.35	57	0.24	1.20	17.16	-	14.0°	2		●
050	0.50	6.00	0.45	57	0.30	1.50	12.01	-	13.5°	2		●
060	0.60	6.00	0.55	57	0.36	1.80	12.13	-	13.0°	2		●
080	0.80	6.00	0.75	57	0.48	2.40	12.35	-	12.5°	2		●
100	1.00	6.00	0.95	57	1.00	3.00	13.08	0.07	11.5°	2		●
108	1.20	6.00	1.10	57	1.20	3.60	13.40	0.07	11.0°	2		●
120	1.50	6.00	1.40	57	1.50	4.50	13.74	0.07	10.0°	2		●
140	2.00	6.00	1.90	57	2.00	6.00	14.31	0.10	8.5°	2		●
160	2.50	6.00	2.30	57	2.50	7.50	15.06	0.10	7.5°	2		●
180	3.00	6.00	2.80	57	3.00	9.00	15.63	0.10	6.0°	2		●

Application



Material

Hardened tool steel
42 - 48 HRC



d1 [mm]	z	v _c [m/min]	f _s [mm]	a _p [mm]	a _e [mm]	n [min ⁻¹]	v _r [mm/min]	Q [mm ³ /min]
0.20	2	26	0.001	0.011	0.040	41380	125	0.1
0.40	2	53	0.003	0.021	0.080	42175	250	0.4
0.50	2	66	0.004	0.027	0.100	42015	315	0.8
0.80	2	106	0.006	0.043	0.160	42175	530	3.7
1.00	2	132	0.008	0.054	0.200	42015	635	6.9
1.50	2	140	0.011	0.080	0.300	29710	675	16.2
2.00	2	140	0.015	0.107	0.400	22280	675	28.8
2.50	2	140	0.019	0.132	0.500	17825	675	44.5
3.00	2	140	0.023	0.161	0.600	14855	675	65.1

Hardened tool steel
48 - 52 HRC



0.20	2	26	0.001	0.011	0.040	41380	120	0.1
0.40	2	53	0.003	0.021	0.080	42175	240	0.4
0.50	2	66	0.004	0.027	0.100	42015	300	0.8
0.80	2	106	0.006	0.043	0.160	42175	505	3.5
1.00	2	120	0.007	0.054	0.200	38195	550	5.9
1.50	2	120	0.011	0.080	0.300	25465	550	13.2
2.00	2	120	0.014	0.107	0.400	19100	550	23.5
2.50	2	120	0.018	0.132	0.500	15280	550	36.3
3.00	2	120	0.022	0.161	0.600	12730	550	53.1

Hardened tool steel
52 - 56 HRC

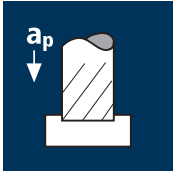


0.20	2	26	0.001	0.011	0.040	41380	100	0.0
0.40	2	53	0.002	0.021	0.080	42175	200	0.3
0.50	2	66	0.003	0.027	0.100	42015	250	0.7
0.80	2	100	0.005	0.043	0.160	39790	400	2.7
1.00	2	100	0.006	0.054	0.200	31830	380	4.1
1.50	2	100	0.009	0.080	0.300	21220	380	9.2
2.00	2	100	0.012	0.107	0.400	15915	380	16.3
2.50	2	100	0.015	0.132	0.500	12730	380	25.2
3.00	2	100	0.018	0.161	0.600	10610	380	36.9

Hardened tool steel
56 - 60 HRC



0.20	2	26	0.001	0.011	0.040	41380	90	0.0
0.40	2	53	0.002	0.021	0.080	42175	180	0.3
0.50	2	60	0.003	0.027	0.100	38195	205	0.6
0.80	2	60	0.004	0.043	0.160	23875	215	1.5
1.00	2	60	0.005	0.054	0.200	19100	205	2.2
1.50	2	60	0.008	0.080	0.300	12730	205	5.0
2.00	2	60	0.011	0.107	0.400	9550	205	8.8
2.50	2	60	0.014	0.132	0.500	7640	205	13.6
3.00	2	60	0.016	0.161	0.600	6365	205	19.9



Hardened tool steel
42 - 48 HRC



0.20	2	26	0.001	0.004	0.200	41380	90	0.1
0.40	2	53	0.002	0.008	0.400	42175	185	0.6
0.50	2	66	0.003	0.010	0.500	42015	275	1.4
0.80	2	106	0.004	0.017	0.800	42175	370	5.0
1.00	2	120	0.007	0.021	1.000	38195	505	10.6
1.50	2	120	0.009	0.031	1.500	25465	450	20.8
2.00	2	120	0.012	0.042	2.000	19100	460	38.8
2.50	2	120	0.015	0.052	2.500	15280	470	61.2
3.00	2	120	0.019	0.063	3.000	12730	475	90.0

Hardened tool steel
48 - 52 HRC



0.20	2	26	0.001	0.004	0.200	41380	90	0.1
0.40	2	53	0.002	0.008	0.400	42175	185	0.6
0.50	2	66	0.003	0.010	0.500	42015	275	1.4
0.80	2	100	0.004	0.017	0.800	39790	350	4.8
1.00	2	100	0.007	0.021	1.000	31830	420	8.8
1.50	2	100	0.009	0.031	1.500	21220	375	17.4
2.00	2	100	0.012	0.042	2.000	15915	385	32.4
2.50	2	100	0.015	0.052	2.500	12730	390	51.0
3.00	2	100	0.019	0.063	3.000	10610	395	75.0

Hardened tool steel
52 - 56 HRC



0.20	2	26	0.001	0.004	0.200	41380	85	0.1
0.40	2	53	0.002	0.008	0.400	42175	170	0.5
0.50	2	66	0.003	0.010	0.500	42015	250	1.3
0.80	2	80	0.004	0.017	0.800	31830	255	3.5
1.00	2	80	0.006	0.021	1.000	25465	305	6.4
1.50	2	80	0.008	0.031	1.500	16975	270	12.6
2.00	2	80	0.011	0.042	2.000	12730	280	23.5
2.50	2	80	0.014	0.052	2.500	10185	285	37.1
3.00	2	80	0.017	0.063	3.000	8490	290	54.5

Hardened tool steel
56 - 60 HRC



0.20	2	26	0.001	0.004	0.200	41380	75	0.1
0.40	2	40	0.002	0.008	0.400	31830	115	0.4
0.50	2	40	0.003	0.010	0.500	25465	140	0.7
0.80	2	40	0.004	0.017	0.800	15915	115	1.6
1.00	2	40	0.005	0.021	1.000	12730	140	2.9
1.50	2	40	0.007	0.031	1.500	8490	120	5.7
2.00	2	40	0.010	0.042	2.000	6365	125	10.6
2.50	2	40	0.013	0.052	2.500	5095	130	16.7
3.00	2	40	0.015	0.063	3.000	4245	130	24.5