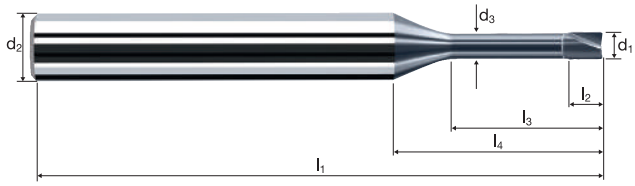
Cylindrical end mills Microcut

Shank ø 4mm, cylindrical neck, 8xd

HM XA	λ 0° γ 0°
45°	

new!

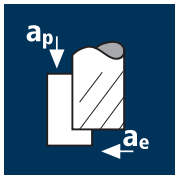


Rm < 850	Rm 850-1100	Rm 1100-1300	Rm 1300-1500	HRC 48-56	HRC 56-60		Inox Stainless	Ti Titanium	Cobalt-Chrome Gold / Platinum Copper

Example: **Order-N°.** Coating **X** Article-N°. **6807** ø-Code **050**

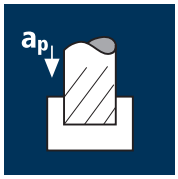
Ø Code	d_1 0/-0.01	d_2 h4	d_3	l_1	l_2	l_3	l_4	45°	α	z	X-AL **X6807**
050	0.50	4.00	0.45	50	0.40	4.00	10.78	-	9.4°	2	●
060	0.60	4.00	0.55	50	0.48	4.80	11.40	-	8.7°	2	●
080	0.80	4.00	0.75	50	0.64	6.40	12.62	-	7.4°	2	●
100	1.00	4.00	0.95	50	1.20	8.00	13.85	0.04	6.4°	2	●
108	1.20	4.00	1.10	50	1.44	9.60	14.96	0.04	5.5°	2	●
120	1.50	4.00	1.40	50	1.80	12.00	16.80	0.04	4.5°	2	●
140	2.00	4.00	1.90	50	2.40	16.00	19.87	0.07	3.1°	2	●
160	2.50	4.00	2.30	57	3.00	20.00	22.84	0.07	2.1°	2	●
180	3.00	4.00	2.80	57	3.60	24.00	25.91	0.07	1.3°	2	●

Application



Material	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 [mm^3/min]
Steel 850 - 1100 N/mm²	0.50	2	66	0.004	0.100	0.050	42015	294	1.5
	0.60	2	73	0.004	0.120	0.060	38730	325	2.4
	0.80	2	73	0.006	0.160	0.080	29045	325	4.2
	1.00	2	73	0.007	0.200	0.100	23235	325	6.5
	1.20	2	73	0.008	0.360	0.120	19365	325	14.1
	1.50	2	73	0.011	0.450	0.150	15490	325	22.0
	2.00	2	73	0.014	0.600	0.200	11620	325	39.1
	2.50	2	73	0.018	0.750	0.250	9295	325	61.0
	3.00	2	73	0.021	0.900	0.300	7745	325	87.9
Steel 1100 - 1300 N/mm²	0.50	2	56	0.003	0.100	0.050	35650	214	1.1
	0.60	2	56	0.004	0.120	0.060	29710	214	1.6
	0.80	2	56	0.005	0.160	0.080	22280	214	2.8
	1.00	2	56	0.006	0.200	0.100	17825	214	4.3
	1.20	2	56	0.007	0.360	0.120	14855	214	9.3
	1.50	2	56	0.009	0.450	0.150	11885	214	14.5
	2.00	2	56	0.012	0.600	0.200	8915	214	25.7
	2.50	2	56	0.015	0.750	0.250	7130	214	40.1
	3.00	2	56	0.018	0.900	0.300	5940	214	57.8
Inox normal [Cr-Ni/1.4301] [Cr-Ni-Mo/1.4571]	0.50	2	45	0.002	0.100	0.050	28650	129	0.7
	0.60	2	45	0.003	0.120	0.060	23875	129	1.0
	0.80	2	45	0.004	0.160	0.080	17905	129	1.7
	1.00	2	45	0.005	0.200	0.100	14325	129	2.6
	1.20	2	45	0.005	0.360	0.120	11935	129	5.6
	1.50	2	45	0.007	0.450	0.150	9550	129	8.7
	2.00	2	45	0.009	0.600	0.200	7160	129	15.5
	2.50	2	45	0.011	0.750	0.250	5730	129	24.2
	3.00	2	45	0.014	0.900	0.300	4775	129	34.8
Titanium alloys > 300 HB [Ti6Al4V]	0.50	2	28	0.002	0.100	0.050	17825	80	0.4
	0.60	2	28	0.003	0.120	0.060	14855	80	0.6
	0.80	2	28	0.004	0.160	0.080	11140	80	1.1
	1.00	2	28	0.005	0.200	0.100	8915	80	1.6
	1.20	2	28	0.005	0.360	0.120	7425	80	3.5
	1.50	2	28	0.007	0.450	0.150	5940	80	5.4
	2.00	2	28	0.009	0.600	0.200	4455	80	9.6
	2.50	2	28	0.011	0.750	0.250	3565	80	15.1
	3.00	2	28	0.014	0.900	0.300	2970	80	21.7

Application



Material	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 [mm^3/min]
Steel 850 - 1100 N/mm²	0.50	2	66	0.003	0.050	0.500	42015	235	5.9
	0.60	2	66	0.003	0.060	0.600	35015	235	8.5
	0.80	2	66	0.004	0.080	0.800	26260	235	15.1
	1.00	2	66	0.006	0.100	1.000	21010	235	23.6
	1.20	2	66	0.007	0.120	1.200	17505	235	33.9
	1.50	2	66	0.008	0.150	1.500	14005	235	53.0
	2.00	2	66	0.011	0.200	2.000	10505	235	94.1
	2.50	2	66	0.014	0.250	2.500	8405	235	147.1
	3.00	2	66	0.017	0.300	3.000	7005	235	211.9
Steel 1100 - 1300 N/mm²	0.50	2	50	0.002	0.050	0.500	31830	153	3.8
	0.60	2	50	0.003	0.060	0.600	26525	153	5.5
	0.80	2	50	0.004	0.080	0.800	19895	153	9.8
	1.00	2	50	0.005	0.100	1.000	15915	153	15.3
	1.20	2	50	0.006	0.120	1.200	13265	153	22.0
	1.50	2	50	0.007	0.150	1.500	10610	153	34.4
	2.00	2	50	0.010	0.200	2.000	7960	153	61.1
	2.50	2	50	0.012	0.250	2.500	6365	153	95.5
	3.00	2	50	0.014	0.300	3.000	5305	153	137.5
Inox normal [Cr-Ni/1.4301] [Cr-Ni-Mo/1.4571]	0.50	2	40	0.002	0.050	0.500	25465	92	2.3
	0.60	2	40	0.002	0.060	0.600	21220	92	3.3
	0.80	2	40	0.003	0.080	0.800	15915	92	5.9
	1.00	2	40	0.004	0.100	1.000	12730	92	9.2
	1.20	2	40	0.004	0.120	1.200	10610	92	13.2
	1.50	2	40	0.005	0.150	1.500	8490	92	20.7
	2.00	2	40	0.007	0.200	2.000	6365	92	36.7
	2.50	2	40	0.009	0.250	2.500	5095	92	57.3
	3.00	2	40	0.011	0.300	3.000	4245	92	82.6
Titanium alloys > 300 HB [Ti6Al4V]	0.50	2	25	0.002	0.050	0.500	15915	57	1.5
	0.60	2	25	0.002	0.060	0.600	13265	57	2.1
	0.80	2	25	0.003	0.080	0.800	9945	57	3.7
	1.00	2	25	0.004	0.100	1.000	7960	57	5.8
	1.20	2	25	0.004	0.120	1.200	6630	57	8.3
	1.50	2	25	0.005	0.150	1.500	5305	57	12.9
	2.00	2	25	0.007	0.200	2.000	3980	57	22.9
	2.50	2	25	0.009	0.250	2.500	3185	57	35.8
	3.00	2	25	0.011	0.300	3.000	2655	57	51.6