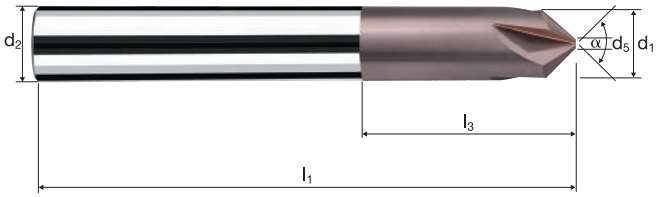
Deburring end mills

45° - Chamfer

Base-X **B**

HM	λ 0° γ 0°

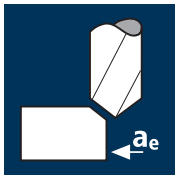


Rm < 850	Rm 850-1100	Rm 1100-1300					Inox Stainless	Ti Titanium	GG(G) Aluminium Copper

Example: **Order-N°.** Coating **U** Article-N°. **7942** ø-Code **140**

Ø Code	d_1 h6	d_2 h6	d_5 ±0.05	l_1	l_3	α	z		UNICUT-4X U7942
140	2.00	3.00	0.2	40	7.20	90.0°	3		●
180	3.00	3.00	0.3	40	-	90.0°	3		●
220	4.00	4.00	0.4	50	-	90.0°	3		●
300	6.00	6.00	0.6	57	-	90.0°	3		●

V

Application	Material	d1 [mm]	z	v_c [m/min]	f_z [mm]	a_p [mm]	a_e [mm]	n [min-1]	v_f [mm/min]
	Steel < 850 N/mm² U	2.00	3	150	0.005	0.050	0.050	23875	360
		3.00	3	150	0.010	0.100	0.100	15915	475
		4.00	3	150	0.015	0.150	0.150	11935	535
		6.00	3	150	0.020	0.200	0.200	7960	475
	Steel 850 - 1100 N/mm² U U	2.00	3	120	0.005	0.050	0.050	19100	285
		3.00	3	120	0.010	0.100	0.100	12730	380
		4.00	3	120	0.015	0.150	0.150	9550	430
		6.00	3	120	0.020	0.200	0.200	6365	380
	Steel 1100 - 1300 N/mm² U U	2.00	3	70	0.005	0.050	0.050	11140	165
		3.00	3	70	0.010	0.100	0.100	7425	225
		4.00	3	70	0.015	0.150	0.150	5570	250
		6.00	3	70	0.020	0.200	0.200	3715	225
	Stainless steel [Cr-Ni/1.4301] U	2.00	3	60	0.005	0.050	0.050	9550	145
		3.00	3	60	0.010	0.100	0.100	6365	190
		4.00	3	60	0.015	0.150	0.150	4775	215
		6.00	3	60	0.020	0.200	0.200	3185	190
	Cast iron (lamellar / spheroidal) U U	2.00	3	160	0.005	0.050	0.050	25465	380
		3.00	3	160	0.010	0.100	0.100	16975	510
		4.00	3	160	0.015	0.150	0.150	12730	575
		6.00	3	160	0.020	0.200	0.200	8490	510
	Unalloyed copper U	2.00	3	180	0.005	0.050	0.050	28650	430
		3.00	3	180	0.010	0.100	0.100	19100	575
		4.00	3	180	0.015	0.150	0.150	14325	645
		6.00	3	180	0.020	0.200	0.200	9550	575
	Titanium alloys up to 300 HB [Ti5Al2.5Sn] U	2.00	3	70	0.005	0.050	0.050	11140	165
		3.00	3	70	0.010	0.100	0.100	7425	225
		4.00	3	70	0.015	0.150	0.150	5570	250
		6.00	3	70	0.020	0.200	0.200	3715	225
	Wrought aluminium Si < 6% U	2.00	3	200	0.005	0.050	0.050	31830	475
		3.00	3	200	0.010	0.100	0.100	21220	635
		4.00	3	200	0.015	0.150	0.150	15915	715
		6.00	3	200	0.020	0.200	0.200	10610	635