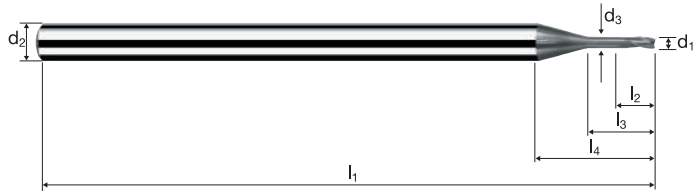
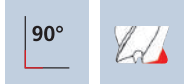


Cylindrical end mills Microcut

Shank \varnothing 3mm, cylindrical neck, 5xd

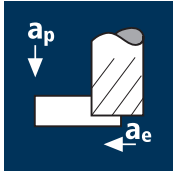












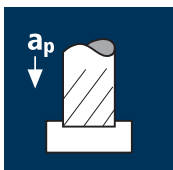














HM λ 25°
XA γ -10°



Rm < 850 Rm 850-1100 Rm 1100-1300 Rm 1300-1500 **Inox** Stainless **Ti** Titanium **Cobalt-Chrome** Gold / Platinum Copper

Example: Order-N°.										MICRO	
		Coating	Article-N°.		ø-Code						M15754
		M	15754		050						
Ø Code	d ₁ ±0.01	d ₂ h6	d ₃	l ₁	l ₂	l ₃	l ₄	α	z		
050	0.50	3.00	0.45	40	0.60	2.50	7.65	10.0°	3	●	
060	0.60	3.00	0.55	40	0.72	3.00	7.97	9.5°	3	●	
080	0.80	3.00	0.75	40	0.96	4.00	8.59	8.0°	3	●	
100	1.00	3.00	0.95	50	1.20	5.00	9.22	7.0°	3	●	
108	1.20	3.00	1.10	50	1.44	6.00	9.94	5.5°	3	●	
120	1.50	3.00	1.40	60	1.80	7.50	10.88	4.5°	3	●	
140	2.00	3.00	1.90	60	2.40	10.00	12.45	2.5°	3	●	
160	2.50	3.00	2.30	60	3.00	12.50	14.20	1.5°	3	●	
180	3.00	3.00	2.80	60	3.60	14.56	15.00	0.0°	3	●	

Application	Material	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]
	Inox normal [Cr-Ni/1.4301] [Cr-Ni-Mo/1.4571]  	0.50	3	66	0.010	0.400	0.070	42015	1260	35.3
		0.60	3	79	0.010	0.480	0.080	41910	1255	48.3
		0.80	3	80	0.014	0.640	0.100	31830	1335	85.6
		1.00	3	80	0.018	0.800	0.130	25465	1375	143.0
		1.20	3	80	0.022	0.960	0.160	21220	1400	215.1
		1.50	3	80	0.028	1.200	0.200	16975	1425	342.2
		2.00	3	80	0.036	1.600	0.260	12730	1375	572.0
		2.50	3	80	0.046	2.000	0.330	10185	1405	927.7
		3.00	3	80	0.054	2.400	0.390	8490	1375	1287.1
		Titanium alloys up to 300 HB [Ti5Al2.5Sn]  	0.50	3	50	0.008	0.400	0.070	31830	765
0.60	3		50	0.008	0.480	0.080	26525	635	24.4	
0.80	3		50	0.012	0.640	0.100	19895	715	45.8	
1.00	3		50	0.014	0.800	0.130	15915	670	69.5	
1.20	3		50	0.018	0.960	0.160	13265	715	110.0	
1.50	3		50	0.022	1.200	0.200	10610	700	168.1	
2.00	3		50	0.028	1.600	0.260	7960	670	278.1	
2.50	3		50	0.036	2.000	0.330	6365	690	453.8	
3.00	3		50	0.044	2.400	0.390	5305	700	655.5	
Gold    	0.50		3	180	0.012	0.400	0.070	114590	4125	115.5
	0.60	3	180	0.012	0.480	0.080	95495	3440	132.0	
	0.80	3	180	0.016	0.640	0.100	71620	3440	220.0	
	1.00	3	180	0.022	0.800	0.130	57295	3780	393.3	
	1.20	3	180	0.026	0.960	0.160	47745	3725	572.0	
	1.50	3	180	0.034	1.200	0.200	38195	3895	935.1	
	2.00	3	180	0.044	1.600	0.260	28650	3780	1573.1	
	2.50	3	180	0.056	2.000	0.330	22920	3850	2541.2	
	3.00	3	180	0.064	2.400	0.390	19100	3665	3432.2	
	Steel850 - 1300 N/mm ²    	0.50	3	66	0.010	0.400	0.070	42015	1260	35.3
0.60		3	79	0.010	0.480	0.080	41910	1255	48.3	
0.80		3	106	0.014	0.640	0.100	42175	1770	113.4	
1.00		3	120	0.018	0.800	0.130	38195	2065	214.5	
1.20		3	120	0.022	0.960	0.160	31830	2100	322.7	
1.50		3	120	0.028	1.200	0.200	25465	2140	513.4	
2.00		3	120	0.036	1.600	0.260	19100	2065	858.1	
2.50		3	120	0.046	2.000	0.330	15280	2110	1391.6	
3.00		3	120	0.054	2.400	0.390	12730	2065	1930.6	
		Inox normal [Cr-Ni/1.4301] [Cr-Ni-Mo/1.4571]  	0.50	3	60	0.006	0.050	0.500	38195	690
	0.60		3	60	0.008	0.060	0.600	31830	765	27.5
	0.80		3	60	0.010	0.080	0.800	23875	715	45.8
	1.00		3	60	0.014	0.100	1.000	19100	800	80.2
	1.20		3	60	0.016	0.120	1.200	15915	765	110.0
	1.50		3	60	0.020	0.150	1.500	12730	765	171.9
	2.00		3	60	0.026	0.200	2.000	9550	745	297.9
	2.50		3	60	0.034	0.250	2.500	7640	780	487.0
	3.00		3	60	0.040	0.300	3.000	6365	765	687.5
	Titanium alloys up to 300 HB [Ti5Al2.5Sn]  		0.50	3	40	0.004	0.050	0.500	25465	305
0.60		3	40	0.006	0.060	0.600	21220	380	13.8	
0.80		3	40	0.008	0.080	0.800	15915	380	24.4	
1.00		3	40	0.012	0.100	1.000	12730	460	45.8	
1.20		3	40	0.012	0.120	1.200	10610	380	55.0	
1.50		3	40	0.016	0.150	1.500	8490	405	91.7	
2.00		3	40	0.020	0.200	2.000	6365	380	152.8	
2.50		3	40	0.028	0.250	2.500	5095	430	267.4	
3.00		3	40	0.032	0.300	3.000	4245	405	366.7	
Gold    		0.50	3	160	0.008	0.050	0.500	101860	2445	61.1
	0.60	3	160	0.010	0.060	0.600	84885	2545	91.7	
	0.80	3	160	0.012	0.080	0.800	63660	2290	146.7	
	1.00	3	160	0.016	0.100	1.000	50930	2445	244.5	
	1.20	3	160	0.020	0.120	1.200	42440	2545	366.7	
	1.50	3	160	0.024	0.150	1.500	33955	2445	550.0	
	2.00	3	160	0.032	0.200	2.000	25465	2445	977.8	
	2.50	3	160	0.040	0.250	2.500	20370	2445	1527.9	
	3.00	3	160	0.048	0.300	3.000	16975	2445	2200.2	
	Steel850 - 1300 N/mm ²    	0.50	3	66	0.006	0.050	0.500	42015	755	18.9
0.60		3	79	0.008	0.060	0.600	41910	1005	36.2	
0.80		3	100	0.010	0.080	0.800	39790	1195	76.4	
1.00		3	100	0.014	0.100	1.000	31830	1335	133.7	
1.20		3	100	0.016	0.120	1.200	26525	1275	183.3	
1.50		3	100	0.020	0.150	1.500	21220	1275	286.5	
2.00		3	100	0.026	0.200	2.000	15915	1240	496.6	
2.50		3	100	0.034	0.250	2.500	12730	1300	811.7	
3.00		3	100	0.040	0.300	3.000	10610	1275	1145.9	