

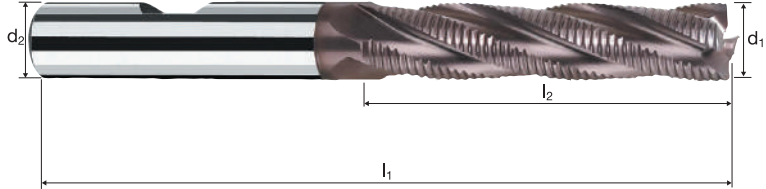
Cylindrical end mills

Profiled NRF, long version

HSS

HSS-E
Co8

λ 25°
 γ 10°



Roughing

Finishing



Rm
< 850

Rm
850-1100

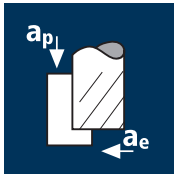
Rm
1100-1300

Inox
Stainless

GG(G)

Example: Order-N°.										UNICUT-4X	
										U0665	
\emptyset Code	d_1 k12	d_2 h6	l_1	l_2	l_4	45°	α	z			
260	5.00	6.00	68	24.00	31.55	0.40	1.0°	3	●		
300	6.00	6.00	68	24.00	-	0.40	0.0°	3	●		
342	7.00	10.00	80	30.00	39.50	0.40	2.5°	3	●		
391	8.00	8.00	82	38.00	-	0.40	0.0°	4	●		
402	8.00	10.00	88	38.00	47.50	0.40	1.0°	4	●		
420	9.00	10.00	88	38.00	47.50	0.40	0.0°	4	●		
450	10.00	10.00	95	45.00	-	0.40	0.0°	4	●		
470	11.00	12.00	102	45.00	56.50	0.40	0.0°	4	●		
501	12.00	12.00	110	53.00	-	0.40	0.0°	4	●		
540	13.00	12.00	110	53.00	-	0.40	0.0°	4	●		
570	14.00	12.00	110	53.00	-	0.40	0.0°	4	●		
610	16.00	16.00	123	63.00	-	0.50	0.0°	4	●		
640	18.00	16.00	123	63.00	-	0.50	0.0°	4	●		
682	20.00	20.00	141	75.00	-	0.50	0.0°	4	●		
710	22.00	20.00	141	75.00	-	0.70	0.0°	4	●		
772	25.00	25.00	166	90.00	-	0.70	0.0°	4	●		
800	28.00	25.00	166	90.00	-	0.70	0.0°	6	●		
810	30.00	25.00	166	90.00	-	0.70	0.0°	6	●		
832	32.00	32.00	186	106.00	-	0.70	0.0°	6	●		
860	36.00	32.00	186	106.00	-	0.90	0.0°	6	●		
892	40.00	40.00	217	125.00	-	0.90	0.0°	6	●		

Application



Material

Steel
< 850 N/mm²



d1 [mm]	z	v _r [m/min]	f _s [mm]	a _p [mm]	a _e [mm]	n [min ⁻¹]	v _r [mm/min]	Q [cm ³ /min]
6.00	3	28	0.020	15.000	2.400	1485	90	3.2
8.00	4	28	0.030	20.000	3.200	1115	135	8.6
10.00	4	28	0.035	25.000	4.000	890	125	12.5
12.00	4	28	0.055	30.000	4.800	745	165	23.5
16.00	4	28	0.075	40.000	6.400	555	165	42.8
20.00	4	28	0.095	50.000	8.000	445	170	67.7
25.00	4	28	0.115	62.500	10.000	355	165	102.5
32.00	6	28	0.105	80.000	12.800	280	175	179.7
40.00	6	28	0.130	100.000	16.000	225	175	278.1

Steel
850 - 1100 N/mm²



6.00	3	22	0.020	15.000	2.400	1165	70	2.5
8.00	4	22	0.030	20.000	3.200	875	105	6.7
10.00	4	22	0.035	25.000	4.000	700	100	9.8
12.00	4	22	0.055	30.000	4.800	585	130	18.5
16.00	4	22	0.075	40.000	6.400	440	130	33.6
20.00	4	22	0.095	50.000	8.000	350	135	53.2
25.00	4	22	0.115	62.500	10.000	280	130	80.5
32.00	6	22	0.105	80.000	12.800	220	140	141.2
40.00	6	22	0.130	100.000	16.000	175	135	218.5

Inox normal
[Cr-Ni/1.4301]
[Cr-Ni-Mo/1.4571]



6.00	3	11	0.020	15.000	2.400	585	35	1.3
8.00	4	11	0.030	20.000	3.200	440	55	3.4
10.00	4	11	0.035	25.000	4.000	350	50	4.9
12.00	4	11	0.055	30.000	4.800	290	65	9.2
16.00	4	11	0.075	40.000	6.400	220	65	16.8
20.00	4	11	0.095	50.000	8.000	175	65	26.6
25.00	4	11	0.115	62.500	10.000	140	65	40.3
32.00	6	11	0.105	80.000	12.800	110	70	70.6
40.00	6	11	0.130	100.000	16.000	90	70	109.2

Cast iron
(lamellar / spheroidal)



6.00	3	20	0.020	15.000	2.400	1060	65	2.3
8.00	4	20	0.030	20.000	3.200	795	95	6.1
10.00	4	20	0.035	25.000	4.000	635	90	8.9
12.00	4	20	0.055	30.000	4.800	530	115	16.8
16.00	4	20	0.075	40.000	6.400	400	120	30.6
20.00	4	20	0.095	50.000	8.000	320	120	48.4
25.00	4	20	0.115	62.500	10.000	255	115	73.2
32.00	6	20	0.105	80.000	12.800	200	125	128.3
40.00	6	20	0.130	100.000	16.000	160	125	198.6



Steel
< 850 N/mm²



6.00	3	25	0.020	3.000	6.000	1325	80	1.4
8.00	4	25	0.025	4.000	8.000	995	100	3.2
10.00	4	25	0.035	5.000	10.000	795	110	5.6
12.00	4	25	0.055	6.000	12.000	665	145	10.5
16.00	4	25	0.070	8.000	16.000	495	140	17.8
20.00	4	25	0.090	10.000	20.000	400	145	28.6
25.00	4	25	0.110	12.500	25.000	320	140	43.8
32.00	6	25	0.095	16.000	32.000	250	140	72.6
40.00	6	25	0.120	20.000	40.000	200	145	114.6

Steel
850 - 1100 N/mm²



6.00	3	18	0.020	3.000	6.000	955	55	1.0
8.00	4	18	0.025	4.000	8.000	715	70	2.3
10.00	4	18	0.035	5.000	10.000	575	80	4.0
12.00	4	18	0.055	6.000	12.000	475	105	7.6
16.00	4	18	0.070	8.000	16.000	360	100	12.8
20.00	4	18	0.090	10.000	20.000	285	105	20.6
25.00	4	18	0.110	12.500	25.000	230	100	31.5
32.00	6	18	0.095	16.000	32.000	180	100	52.3
40.00	6	18	0.120	20.000	40.000	145	105	82.5

Inox normal
[Cr-Ni/1.4301]
[Cr-Ni-Mo/1.4571]



6.00	3	10	0.020	3.000	6.000	530	30	0.6
8.00	4	10	0.025	4.000	8.000	400	40	1.3
10.00	4	10	0.035	5.000	10.000	320	45	2.2
12.00	4	10	0.055	6.000	12.000	265	60	4.2
16.00	4	10	0.070	8.000	16.000	200	55	7.1
20.00	4	10	0.090	10.000	20.000	160	55	11.5
25.00	4	10	0.110	12.500	25.000	125	55	17.5
32.00	6	10	0.095	16.000	32.000	100	55	29.0
40.00	6	10	0.120	20.000	40.000	80	55	45.8

Cast iron
(lamellar / spheroidal)



6.00	3	16	0.020	3.000	6.000	850	50	0.9
8.00	4	16	0.025	4.000	8.000	635	65	2.0
10.00	4	16	0.035	5.000	10.000	510	70	3.6
12.00	4	16	0.055	6.000	12.000	425	95	6.7
16.00	4	16	0.070	8.000	16.000	320	90	11.4
20.00	4	16	0.090	10.000	20.000	255	90	18.3
25.00	4	16	0.110	12.500	25.000	205	90	28.0
32.00	6	16	0.095	16.000	32.000	160	90	46.4
40.00	6	16	0.120	20.000	40.000	125	90	73.3