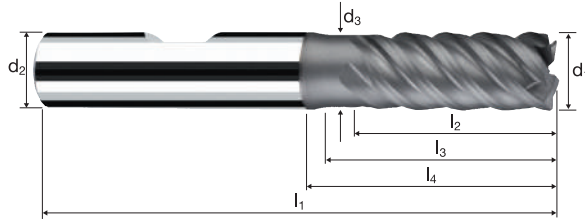
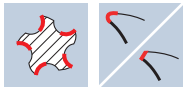
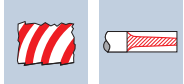
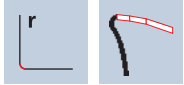


Cylindrical end mills ZX

Smooth-edged, normal version, short neck



HM
MG10 λ 40°
 γ 5°



Roughing

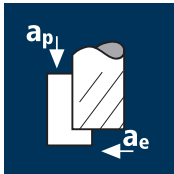


Finishing



Ø Code	d ₁ e8	d ₂ h6	d ₃	l ₁	l ₂	l ₃	l ₄	r	z	Coating	
										TICUT	POLYCHROM
Example: Order-N°: Coating: P Article-N°: 8805 ø-Code: 300										I8805	P8805
										I8705	P8705
300	6.00	6.00	5.50	57	13.00	18.15	20.00	0.150	5	●	■
391	8.00	8.00	7.40	63	19.00	23.63	26.00	0.150	5	●	■
450	10.00	10.00	9.20	72	22.00	27.99	31.00	0.200	5	●	■
501	12.00	12.00	11.00	83	26.00	33.29	37.00	0.200	5	●	■
610	16.00	16.00	15.00	92	32.00	38.73	43.00	0.300	5	●	■
682	20.00	20.00	19.00	104	38.00	48.23	53.00	0.300	5	●	■
I Availability and delivery dates on request											

Application



Material

Nickel-based alloys
annealed
Rm <1000 N/mm²
[Inconel 718]



d1 [mm]	z	v _c [m/min]	f _s [mm]	a _p [mm]	a _e [mm]	n [min ⁻¹]	v _r [mm/min]	Q [cm ³ /min]
6.00	5	45	0.020	10.800	1.200	2385	240	3.1
8.00	5	45	0.030	14.400	1.600	1790	270	6.2
10.00	5	45	0.035	18.000	2.000	1430	250	9.0
12.00	5	45	0.045	21.600	2.400	1195	270	13.9
16.00	5	45	0.050	28.800	3.200	895	225	20.6
20.00	5	45	0.060	36.000	4.000	715	215	30.9

Nickel-based alloys
precipitation hardened
Rm > 1000 N/mm²
[Inconel 718]



6.00	5	30	0.015	10.800	1.200	1590	120	1.5
8.00	5	30	0.025	14.400	1.600	1195	150	3.4
10.00	5	30	0.030	18.000	2.000	955	145	5.2
12.00	5	30	0.035	21.600	2.400	795	140	7.2
16.00	5	30	0.040	28.800	3.200	595	120	11.0
20.00	5	30	0.050	36.000	4.000	475	120	17.2

Manganese steel
Mn >5%
[1.3964 / Nitronic]
[1.3401 / X120Mn12]



6.00	5	50	0.020	10.800	1.200	2655	265	3.4
8.00	5	50	0.030	14.400	1.600	1990	300	6.9
10.00	5	50	0.035	18.000	2.000	1590	280	10.0
12.00	5	50	0.045	21.600	2.400	1325	300	15.5
16.00	5	50	0.050	28.800	3.200	995	250	22.9
20.00	5	50	0.060	36.000	4.000	795	240	34.4

Inox difficult
[Cr-Ni-Mo++/1.4529]
Heat resistant steel
[1.4841]



6.00	5	60	0.035	10.800	1.200	3185	555	7.2
8.00	5	60	0.045	14.400	1.600	2385	535	12.4
10.00	5	60	0.055	18.000	2.000	1910	525	18.9
12.00	5	60	0.065	21.600	2.400	1590	515	26.8
16.00	5	60	0.070	28.800	3.200	1195	420	38.5
20.00	5	60	0.085	36.000	4.000	955	405	58.4

PM high-speed steel
annealed
[Böhler S390]
[ASP 2023]



6.00	5	90	0.020	10.800	1.200	4775	475	6.2
8.00	5	90	0.030	14.400	1.600	3580	535	12.4
10.00	5	90	0.035	18.000	2.000	2865	500	18.0
12.00	5	90	0.045	21.600	2.400	2385	535	27.8
16.00	5	90	0.050	28.800	3.200	1790	450	41.3
20.00	5	90	0.060	36.000	4.000	1430	430	61.9

Titanium alloys
> 300 HB
[Ti6Al4V]



6.00	5	85	0.020	10.800	1.200	4510	450	5.8
8.00	5	85	0.025	14.400	1.600	3380	425	9.7
10.00	5	85	0.035	18.000	2.000	2705	475	17.0
12.00	5	85	0.040	21.600	2.400	2255	450	23.4
16.00	5	85	0.045	28.800	3.200	1690	380	35.1
20.00	5	85	0.055	36.000	4.000	1355	370	53.6