Cylindrical end mills E-Cut

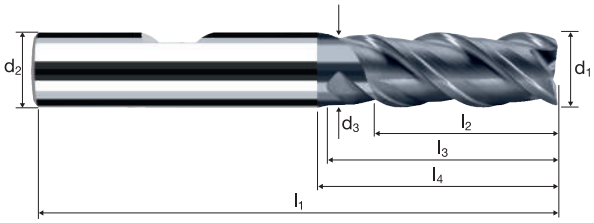
Smooth-edged, normal version, short neck

HM
MG10

λ 45°
γ 10°

r

Vario

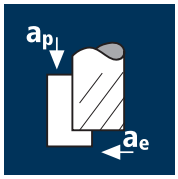
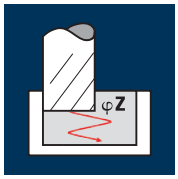


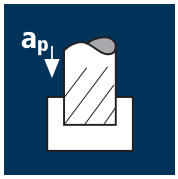
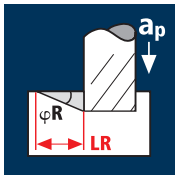
Roughing HPC | Roughing HDC | Finishing

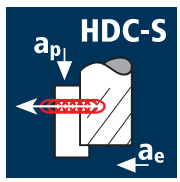
Rm < 850	Rm 850-1100	Rm 1100-1300	Rm 1300-1500	HRC 48-56			Inox Stainless	Ti Titanium	GG(G) Tool Steel

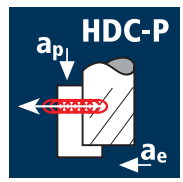
Example: **Order-N°.** Coating **P** Article-N°. **8403** ø-Code **100**

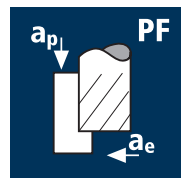
Ø Code	d_1 e8	d_2 h6	d_3	l_1	l_2	l_3	l_4	r	α	z	POLYCHROM P8403	P8303
100	1.00	6.00	0.95	57	3.00	5.00	14.82	0.050	10.0°	3		●
140	2.00	6.00	1.90	57	5.00	8.00	16.05	0.050	7.5°	3		●
160	2.50	6.00	2.30	57	7.00	10.00	17.30	0.050	6.5°	3		●
180	3.00	6.00	2.80	57	8.00	14.00	20.37	0.050	4.5°	3		●
200	3.50	6.00	3.20	57	9.00	14.00	19.69	0.050	4.0°	3		●
220	4.00	6.00	3.70	57	11.00	16.00	20.82	0.100	3.0°	3		●
240	4.50	6.00	4.10	57	12.00	17.00	21.14	0.100	2.5°	3		●
260	5.00	6.00	4.60	57	13.00	18.00	21.27	0.100	1.5°	3		●
280	5.50	6.00	5.00	57	13.00	18.00	20.59	0.100	1.0°	3		●
300	6.00	6.00	5.50	57	13.00	18.15	20.00	0.100	0.0°	3		●
391	8.00	8.00	7.40	63	19.00	23.63	26.00	0.150	0.0°	3		●
450	10.00	10.00	9.20	72	23.00	27.99	31.00	0.200	0.0°	3		●
501	12.00	12.00	11.00	83	27.00	33.29	37.00	0.200	0.0°	3		●
570	14.00	14.00	13.00	83	28.00	32.97	37.00	0.200	0.0°	3		●
610	16.00	16.00	15.00	92	32.00	38.73	43.00	0.200	0.0°	3		●
682	20.00	20.00	19.00	104	40.00	48.23	53.00	0.250	0.0°	3		●

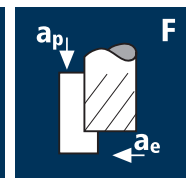
Application	Material	d1 [mm]	z	v_c [m/min]	f_z [mm]	a_p [mm]	a_e [mm]	n [min-1]	v_f [mm/min]	Q [cm³/min]	φZ [°]
	Steel < 850 N/mm²	3.00	3	145	0.021	3.750	1.950	15385	970	7.1	2°
		4.00	3	145	0.030	5.000	2.600	11540	1040	13.5	2°
		5.00	3	145	0.038	6.250	3.250	9230	1050	21.4	2°
		6.00	3	145	0.041	9.000	3.900	7690	945	33.2	2°
		8.00	3	145	0.054	12.000	5.200	5770	935	58.3	2°
		10.00	3	145	0.068	15.000	6.500	4615	940	91.8	2°
		12.00	3	145	0.076	18.000	7.800	3845	875	123.1	2°
		16.00	3	145	0.086	24.000	10.400	2885	745	185.8	2°
		20.00	3	145	0.099	30.000	13.000	2310	685	267.3	2°
	Steel 850 - 1100 N/mm²	3.00	3	130	0.020	3.750	1.950	13795	830	6.1	3°
		4.00	3	130	0.029	5.000	2.600	10345	900	11.7	3°
		5.00	3	130	0.036	6.250	3.250	8275	895	18.2	3°
		6.00	3	130	0.035	9.000	3.900	6895	725	25.4	3°
		8.00	3	130	0.047	12.000	5.200	5175	730	45.5	3°
		10.00	3	130	0.059	15.000	6.500	4140	730	71.4	3°
		12.00	3	130	0.070	18.000	7.800	3450	725	101.7	3°
		16.00	3	130	0.079	24.000	10.400	2585	615	153.0	3°
		20.00	3	130	0.099	30.000	13.000	2070	615	239.7	3°
	Inox normal [Cr-Ni/1.4301] [Cr-Ni-Mo/1.4571]	3.00	3	80	0.015	3.750	1.950	8490	380	2.8	2°
		4.00	3	80	0.022	5.000	2.600	6365	420	5.5	2°
		5.00	3	80	0.027	6.250	3.250	5095	415	8.4	2°
		6.00	3	80	0.027	9.000	3.900	4245	345	12.1	2°
		8.00	3	80	0.036	12.000	5.200	3185	345	21.5	2°
		10.00	3	80	0.045	15.000	6.500	2545	345	33.5	2°
		12.00	3	80	0.054	18.000	7.800	2120	345	48.3	2°
		16.00	3	80	0.056	24.000	10.400	1590	265	66.7	2°
		20.00	3	80	0.070	30.000	13.000	1275	265	104.3	2°

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]	Q [cm³/min]	φR [°]
	Steel < 850 N/mm²	3.00	3	125	0.017	3.000	3.000	13265	675	6.1	2°
		4.00	3	125	0.024	5.000	4.000	9945	715	14.3	2°
		5.00	3	125	0.030	6.250	5.000	7960	715	22.4	2°
		6.00	3	125	0.033	9.000	6.000	6630	655	35.5	2°
		8.00	3	125	0.043	12.000	8.000	4975	640	61.6	2°
		10.00	3	125	0.054	15.000	10.000	3980	645	96.7	2°
		12.00	3	125	0.061	18.000	12.000	3315	605	131.1	2°
		16.00	3	125	0.069	24.000	16.000	2485	515	197.7	2°
		20.00	3	125	0.079	30.000	20.000	1990	470	282.9	2°
	Steel 850 - 1100 N/mm²	3.00	3	110	0.016	3.000	3.000	11670	560	5.0	2°
		4.00	3	110	0.023	5.000	4.000	8755	605	12.1	2°
		5.00	3	110	0.029	6.250	5.000	7005	610	19.0	2°
		6.00	3	110	0.028	9.000	6.000	5835	490	26.5	2°
		8.00	3	110	0.038	12.000	8.000	4375	500	47.9	2°
		10.00	3	110	0.047	15.000	10.000	3500	495	74.1	2°
		12.00	3	110	0.056	18.000	12.000	2920	490	105.9	2°
		16.00	3	110	0.063	24.000	16.000	2190	415	158.8	2°
		20.00	3	110	0.079	30.000	20.000	1750	415	249.0	2°
	Inox normal [Cr-Ni/1.4301] [Cr-Ni-Mo/1.4571]	3.00	3	70	0.012	3.000	3.000	7425	265	2.4	2°
		4.00	3	70	0.018	5.000	4.000	5570	300	6.0	2°
		5.00	3	70	0.022	6.250	5.000	4455	295	9.2	2°
		6.00	3	70	0.022	9.000	6.000	3715	245	13.2	2°
		8.00	3	70	0.029	12.000	8.000	2785	240	23.3	2°
		10.00	3	70	0.036	15.000	10.000	2230	240	36.1	2°
		12.00	3	70	0.043	18.000	12.000	1855	240	51.7	2°
		16.00	3	70	0.045	24.000	16.000	1395	190	72.2	2°
		20.00	3	70	0.056	30.000	20.000	1115	185	112.3	2°









Suitable cutting data for other applications and materials can be found in the cutting data software **ToolExpert E-Cut**