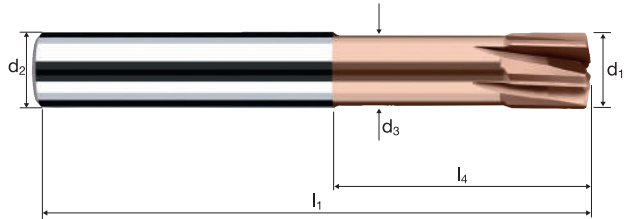


High feed end mills XFeed-H

Cylindrical neck, 3xd

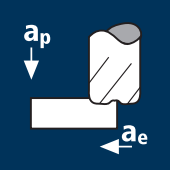







| | | |
|----|-----------|----|
| HM | λ | 0° |
| XA | γ | 0° |
| | HFC | |
| | | |
| | | |
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| | | | | | | | | | |
|--|--|--|--|--------------|--------------|-------------|--|--|-----|
| | | | | HRC 48-56 | HRC 56-60 | HRC > 60 | | | HSS |
|--|--|--|--|--------------|--------------|-------------|--|--|-----|

| Ø Code | d ₁ e8 | d ₂ h5 | d ₃ | l ₁ | l ₃ | l ₄ | ap _{max} | R _{theo.} | α | z | DURO-Si | |
|-----------|----------------------|----------------------|----------------|----------------|----------------|----------------|-------------------|--------------------|-------|---|---------|-------|
| | | | | | | | | | | | | H7610 |
| 100 | 1.00 | 6.00 | 0.95 | 57 | 3.00 | 13.08 | 0.04 | 0.09 | 11.5° | 4 | ● | |
| 140 | 2.00 | 6.00 | 1.90 | 57 | 6.00 | 14.31 | 0.08 | 0.18 | 8.5° | 4 | ● | |
| 180 | 3.00 | 6.00 | 2.80 | 57 | 9.00 | 15.63 | 0.12 | 0.27 | 6.0° | 4 | ● | |
| 220 | 4.00 | 6.00 | 3.70 | 57 | 12.00 | 16.95 | 0.16 | 0.36 | 3.8° | 4 | ● | |
| 260 | 5.00 | 6.00 | 4.60 | 57 | 15.00 | 18.27 | 0.20 | 0.45 | 1.8° | 4 | ● | |
| 300 | 6.00 | 6.00 | 5.50 | 57 | 19.34 | 20.00 | 0.25 | 0.54 | 0.0° | 6 | ● | |
| 391 | 8.00 | 8.00 | 7.40 | 63 | 25.29 | 26.00 | 0.33 | 0.72 | 0.0° | 6 | ● | |
| 450 | 10.00 | 10.00 | 9.20 | 72 | 30.20 | 31.00 | 0.41 | 0.90 | 0.0° | 6 | ● | |
| 501 | 12.00 | 12.00 | 11.00 | 83 | 36.13 | 37.00 | 0.50 | 1.08 | 0.0° | 6 | ● | |
| 610 | 16.00 | 16.00 | 15.00 | 92 | 42.13 | 43.00 | 0.69 | 1.44 | 0.0° | 6 | ● | |
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| 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 [cm ³ /min] |
|--|---|------------|---|---------------------------|------------------------|------------------------|------------------------|---------------------------|----------------------------|-----------------------------|
|  | Hardened tool steel 48 - 52 HRC  | 2.00 | 4 | 140 | 0.070 | 0.060 | 1.500 | 22280 | 6240 | 0.6 |
| | | 3.00 | 4 | 140 | 0.105 | 0.089 | 2.250 | 14855 | 6240 | 1.2 |
| | | 4.00 | 4 | 140 | 0.140 | 0.140 | 3.000 | 11140 | 6240 | 2.6 |
| | | 5.00 | 4 | 140 | 0.175 | 0.175 | 3.750 | 8915 | 6240 | 4.1 |
| | | 6.00 | 6 | 105 | 0.147 | 0.210 | 4.500 | 5570 | 4915 | 4.6 |
| | | 8.00 | 6 | 105 | 0.196 | 0.280 | 6.000 | 4180 | 4915 | 8.3 |
| | | 10.00 | 6 | 105 | 0.245 | 0.350 | 7.500 | 3340 | 4915 | 12.9 |
| | | 12.00 | 6 | 105 | 0.294 | 0.420 | 9.000 | 2785 | 4915 | 18.6 |
| | | 16.00 | 6 | 105 | 0.392 | 0.560 | 12.000 | 2090 | 4915 | 33.0 |
| | | | Hardened tool steel 52 - 56 HRC  | 2.00 | 4 | 120 | 0.070 | 0.060 | 1.500 | 19100 |
| 3.00 | 4 | | | 120 | 0.105 | 0.089 | 2.250 | 12730 | 5350 | 1.1 |
| 4.00 | 4 | | | 120 | 0.140 | 0.140 | 3.000 | 9550 | 5350 | 2.2 |
| 5.00 | 4 | | | 120 | 0.175 | 0.175 | 3.750 | 7640 | 5350 | 3.5 |
| 6.00 | 6 | | | 90 | 0.147 | 0.210 | 4.500 | 4775 | 4210 | 4.0 |
| 8.00 | 6 | | | 90 | 0.196 | 0.280 | 6.000 | 3580 | 4210 | 7.1 |
| 10.00 | 6 | | | 90 | 0.245 | 0.350 | 7.500 | 2865 | 4210 | 11.1 |
| 12.00 | 6 | | | 90 | 0.294 | 0.420 | 9.000 | 2385 | 4210 | 15.9 |
| 16.00 | 6 | | | 90 | 0.392 | 0.560 | 12.000 | 1790 | 4210 | 28.3 |
| | Hardened tool steel 56 - 60 HRC  | | | 2.00 | 4 | 90 | 0.054 | 0.051 | 1.500 | 14325 |
| | | 3.00 | 4 | 90 | 0.081 | 0.077 | 2.250 | 9550 | 3095 | 0.5 |
| | | 4.00 | 4 | 90 | 0.108 | 0.120 | 3.000 | 7160 | 3095 | 1.1 |
| | | 5.00 | 4 | 90 | 0.135 | 0.150 | 3.750 | 5730 | 3095 | 1.7 |
| | | 6.00 | 6 | 80 | 0.144 | 0.180 | 4.500 | 4245 | 3665 | 3.0 |
| | | 8.00 | 6 | 70 | 0.168 | 0.240 | 6.000 | 2785 | 2805 | 4.0 |
| | | 10.00 | 6 | 60 | 0.180 | 0.300 | 7.500 | 1910 | 2065 | 4.6 |
| | | 12.00 | 6 | 60 | 0.216 | 0.360 | 9.000 | 1590 | 2065 | 6.7 |
| | | 16.00 | 6 | 50 | 0.240 | 0.480 | 12.000 | 995 | 1430 | 8.3 |
| | | | Hardened tool steel > 60 HRC  | 2.00 | 4 | 70 | 0.045 | 0.050 | 1.500 | 11140 |
| 3.00 | 4 | | | 70 | 0.068 | 0.075 | 2.250 | 7425 | 2020 | 0.3 |
| 4.00 | 4 | | | 70 | 0.090 | 0.100 | 3.000 | 5570 | 2005 | 0.6 |
| 5.00 | 4 | | | 70 | 0.113 | 0.125 | 3.750 | 4455 | 2015 | 0.9 |
| 6.00 | 6 | | | 65 | 0.120 | 0.150 | 4.500 | 3450 | 2485 | 1.7 |
| 8.00 | 6 | | | 55 | 0.140 | 0.200 | 6.000 | 2190 | 1840 | 2.2 |
| 10.00 | 6 | | | 50 | 0.150 | 0.250 | 7.500 | 1590 | 1430 | 2.7 |
| 12.00 | 6 | | | 50 | 0.180 | 0.300 | 9.000 | 1325 | 1430 | 3.9 |
| 16.00 | 6 | | | 40 | 0.200 | 0.400 | 12.000 | 795 | 955 | 4.6 |
| | High speed steel, hardened 64 - 70 HRC  | | | 2.00 | 4 | 40 | 0.024 | 0.040 | 1.500 | 6365 |
| | | 3.00 | 4 | 40 | 0.036 | 0.060 | 2.250 | 4245 | 610 | 0.1 |
| | | 4.00 | 4 | 40 | 0.048 | 0.080 | 3.000 | 3185 | 610 | 0.1 |
| | | 5.00 | 4 | 40 | 0.060 | 0.100 | 3.750 | 2545 | 610 | 0.2 |
| | | 6.00 | 6 | 35 | 0.063 | 0.120 | 4.500 | 1855 | 700 | 0.4 |
| | | 8.00 | 6 | 30 | 0.072 | 0.160 | 6.000 | 1195 | 515 | 0.5 |
| | | 10.00 | 6 | 30 | 0.090 | 0.200 | 7.500 | 955 | 515 | 0.8 |
| | | 12.00 | 6 | 30 | 0.108 | 0.240 | 9.000 | 795 | 515 | 1.1 |
| | | 16.00 | 6 | 25 | 0.120 | 0.320 | 12.000 | 495 | 360 | 1.4 |