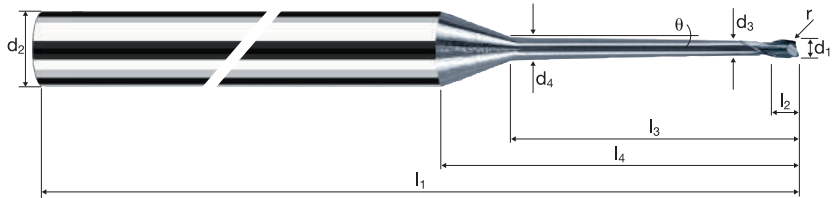


# Corner radius end mills MicroX

Shank  $\varnothing$  6mm, conical neck 0.9°, 15xd



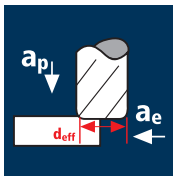
HM XA	$\lambda$ 25° $\gamma$ -10°



Rm < 850	Rm 850-1100	Rm 1100-1300	Rm 1300-1500	HRC 48-56	HRC 56-60	HRC > 60	Inox Stainless	Ti Titanium	Cobalt-Chrome Copper
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Ø Code	Example: Order-N°.												X-AL	
	d <sub>1</sub> 0/-0.01	d <sub>2</sub> h4	d <sub>3</sub>	d <sub>4</sub>	l <sub>1</sub>	l <sub>2</sub>	l <sub>3</sub>	l <sub>4</sub>	θ	r 0/+0.01	α	z	X6742	
050	0.50	6.00	0.45	0.67	61	0.40	7.50	18.10	0.9°	0.100	9.1°	2	●	●
060	0.60	6.00	0.55	0.82	61	0.50	9.00	19.32	0.9°	0.100	8.1°	2	●	●
080	0.80	6.00	0.75	1.11	66	0.65	12.00	21.78	0.9°	0.100	7.1°	2	●	●
100	1.00	6.00	0.95	1.40	66	0.80	15.00	24.24	0.9°	0.200	6.1°	2	●	●
108	1.20	6.00	1.10	1.63	69	1.00	18.00	26.81	0.9°	0.200	5.3°	2	●	●
120	1.50	6.00	1.40	2.07	75	1.20	22.50	30.49	0.9°	0.200	4.4°	2	●	●
140	2.00	6.00	1.90	2.79	80	1.60	30.00	36.65	0.9°	0.200	3.3°	2	●	●
160	2.50	6.00	2.30	3.42	87	2.00	37.50	42.97	0.9°	0.200	2.4°	2	●	●
180	3.00	6.00	2.80	4.14	100	2.40	45.00	49.13	0.9°	0.200	1.8°	2	●	●
145	2.00	6.00	1.90	2.79	80	1.60	30.00	36.65	0.9°	0.500	3.3°	2	●	●
165	2.50	6.00	2.30	3.42	87	2.00	37.50	42.97	0.9°	0.500	2.4°	2	●	●
185	3.00	6.00	2.80	4.14	100	2.40	45.00	49.13	0.9°	0.500	1.8°	2	●	●

## Application



## Material

Hardened tool steel  
42 - 48 HRC

Hardened tool steel  
48 - 52 HRC

Hardened tool steel  
52 - 56 HRC

Hardened tool steel  
56 - 60 HRC

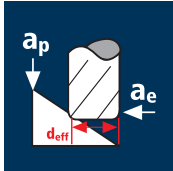
d1 [mm]	z	v <sub>c</sub> [m/min]	f <sub>z</sub> [mm]	a <sub>p</sub> [mm]	a <sub>e</sub> [mm]	d <sub>eff</sub> [mm]	n [min <sup>-1</sup> ]	v <sub>t</sub> [mm/min]	r [mm]
0.50	2	48	0.008	0.005	0.100	0.36	42440	640	0.10
0.60	2	62	0.009	0.006	0.120	0.47	41990	740	0.10
0.80	2	90	0.013	0.009	0.160	0.68	42130	1060	0.10
1.00	2	96	0.015	0.011	0.200	0.73	41860	1265	0.20
1.20	2	124	0.018	0.013	0.240	0.94	41990	1480	0.20
1.50	2	140	0.023	0.016	0.300	1.26	35370	1605	0.20
2.00	2	140	0.030	0.021	0.400	1.78	25035	1515	0.20
2.50	2	140	0.038	0.027	0.500	2.30	19375	1465	0.20
3.00	2	140	0.045	0.032	0.600	2.82	15805	1435	0.20

0.50	2	48	0.007	0.005	0.100	0.36	42440	610	0.10
0.60	2	62	0.008	0.006	0.120	0.47	41990	705	0.10
0.80	2	90	0.012	0.009	0.160	0.68	42130	1010	0.10
1.00	2	96	0.014	0.011	0.200	0.73	41860	1205	0.20
1.20	2	120	0.017	0.013	0.240	0.94	40635	1365	0.20
1.50	2	120	0.022	0.016	0.300	1.26	30315	1310	0.20
2.00	2	120	0.029	0.021	0.400	1.78	21460	1235	0.20
2.50	2	120	0.036	0.027	0.500	2.30	16605	1195	0.20
3.00	2	120	0.043	0.032	0.600	2.82	13545	1170	0.20

0.50	2	48	0.006	0.005	0.100	0.36	42440	510	0.10
0.60	2	62	0.007	0.006	0.120	0.47	41990	590	0.10
0.80	2	90	0.010	0.009	0.160	0.68	42130	845	0.10
1.00	2	96	0.012	0.011	0.200	0.73	41860	1005	0.20
1.20	2	100	0.014	0.013	0.240	0.94	33865	950	0.20
1.50	2	100	0.018	0.016	0.300	1.26	25265	910	0.20
2.00	2	100	0.024	0.021	0.400	1.78	17885	860	0.20
2.50	2	100	0.030	0.027	0.500	2.30	13840	830	0.20
3.00	2	100	0.036	0.032	0.600	2.82	11290	815	0.20

0.50	2	48	0.005	0.005	0.100	0.36	42440	460	0.10
0.60	2	60	0.006	0.006	0.120	0.47	40635	510	0.10
0.80	2	60	0.009	0.009	0.160	0.68	28085	505	0.10
1.00	2	60	0.011	0.011	0.200	0.73	26160	565	0.20
1.20	2	60	0.013	0.013	0.240	0.94	20320	510	0.20
1.50	2	60	0.016	0.016	0.300	1.26	15160	490	0.20
2.00	2	60	0.022	0.021	0.400	1.78	10730	465	0.20
2.50	2	60	0.027	0.027	0.500	2.30	8305	450	0.20
3.00	2	60	0.032	0.032	0.600	2.82	6775	440	0.20

## Application



## Material

Hardened tool steel  
42 - 48 HRC

Hardened tool steel  
48 - 52 HRC

Hardened tool steel  
52 - 56 HRC

Hardened tool steel  
56 - 60 HRC

d1 [mm]	z	v <sub>c</sub> [m/min]	f <sub>z</sub> [mm]	a <sub>p</sub> [mm]	a <sub>e</sub> [mm]	d <sub>eff</sub> [mm]	n [min <sup>-1</sup> ]	v <sub>t</sub> [mm/min]	β [°]
0.50	2	65	0.018	0.012	0.012	0.49	42225	1520	45°
0.60	2	78	0.018	0.012	0.012	0.59	42080	1515	45°
0.80	2	106	0.020	0.020	0.020	0.80	42175	1685	45°
1.00	2	131	0.026	0.026	0.026	0.99	42120	2190	45°
1.20	2	157	0.028	0.030	0.030	1.19	41995	2350	45°
1.50	2	197	0.030	0.038	0.038	1.49	42085	2525	45°
2.00	2	264	0.034	0.050	0.050	2.00	42015	2855	45°
2.50	2	300	0.036	0.062	0.062	2.50	38195	2750	45°
3.00	2	300	0.042	0.076	0.076	3.00	31830	2675	45°

0.50	2	65	0.018	0.012	0.012	0.49	42225	1520	45°
0.60	2	78	0.018	0.012	0.012	0.59	42080	1515	45°
0.80	2	106	0.020	0.020	0.020	0.80	42175	1685	45°
1.00	2	131	0.024	0.026	0.026	0.99	42120	2020	45°
1.20	2	157	0.026	0.030	0.030	1.19	41995	2185	45°
1.50	2	197	0.028	0.038	0.038	1.49	42085	2355	45°
2.00	2	250	0.032	0.050	0.050	2.00	39790	2545	45°
2.50	2	250	0.034	0.062	0.062	2.50	31830	2165	45°
3.00	2	250	0.040	0.076	0.076	3.00	26525	2120	45°

0.50	2	65	0.016	0.012	0.012	0.49	42225	1350	45°
0.60	2	78	0.016	0.012	0.012	0.59	42080	1345	45°
0.80	2	106	0.018	0.020	0.020	0.80	42175	1520	45°
1.00	2	131	0.024	0.026	0.026	0.99	42120	2020	45°
1.20	2	157	0.026	0.030	0.030	1.19	41995	2185	45°
1.50	2	197	0.028	0.038	0.038	1.49	42085	2355	45°
2.00	2	200	0.030	0.050	0.050	2.00	31830	1910	45°
2.50	2	200	0.032	0.062	0.062	2.50	25465	1630	45°
3.00	2	200	0.038	0.076	0.076	3.00	21220	1615	45°

0.50	2	65	0.014	0.012	0.012	0.49	42225	1180	45°
0.60	2	78	0.014	0.012	0.012	0.59	42080	1180	45°
0.80	2	106	0.016	0.020	0.020	0.80	42175	1350	45°
1.00	2	131	0.020	0.026	0.026	0.99	42120	1685	45°
1.20	2	150	0.022	0.030	0.030	1.19	40125	1765	45°
1.50	2	150	0.024	0.038	0.038	1.49	32045	1540	45°
2.00	2	150	0.028	0.050	0.050	2.00	23875	1335	45°
2.50	2	150	0.028	0.062	0.062	2.50	19100	1070	45°
3.00	2	150	0.034	0.076	0.076	3.00	15915	1080	45°