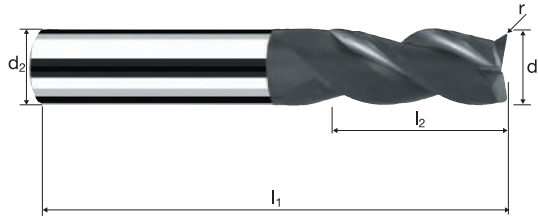


Corner radius end mills

Tolerance r 0/+0.03



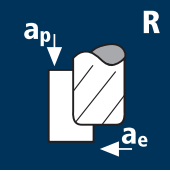


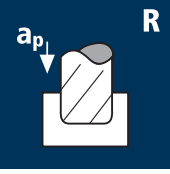


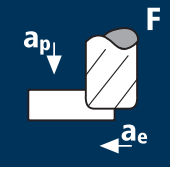





HM	λ 40°
XA	γ 15°



				C Graphite					CF / GF Fiber Reinforced Plastics
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IV

Example: Order-N°.										DIAMANT
Coating: B Article-N°: 5640 ø-Code: 140										B5640
Ø Code	d ₁ e8	d ₂ h6	l ₁	l ₂	l ₄	r 0/+0.03	α	z		
140	2.00	3.00	40	6.00	9.06	0.150	3.4°	3		●
180	3.00	3.00	40	12.00	-	0.150	0.0°	3		●
220	4.00	4.00	50	14.00	-	0.200	0.0°	3		●
260	5.00	5.00	50	16.00	-	0.300	0.0°	3		●
300	6.00	6.00	63	19.00	-	0.300	0.0°	3		●
391	8.00	8.00	63	19.00	-	0.500	0.0°	3		●
450	10.00	10.00	72	22.00	-	0.500	0.0°	3		●
501	12.00	12.00	75	25.00	-	0.500	0.0°	3		●

Application	Material	d1 [mm]	z	f _z [mm]	a _p [mm]	a _e [mm]	n=10000 min ⁻¹ vf [mm/min]	n=15000 min ⁻¹ vf [mm/min]	n=20000 min ⁻¹ vf [mm/min]	n=30000 min ⁻¹ vf [mm/min]
	Graphite  B  B	2.00	3	0.024	4.000	0.500	720	1080	1440	2160
		3.00	3	0.035	6.000	0.750	1050	1575	2100	3150
		4.00	3	0.047	8.000	1.000	1410	2115	2820	4230
		5.00	3	0.059	10.000	1.250	1770	2655	3540	5310
		6.00	3	0.071	12.000	1.500	2130	3195	4260	6390
		8.00	3	0.094	16.000	2.000	2820	4230	5640	8460
		10.00	3	0.118	20.000	2.500	3540	5310	7080	10620
12.00	3	0.141	24.000	3.000	4230	6345	8460	12690		
	Graphite  B  B	2.00	3	0.018	0.600	2.000	540	810	1080	1620
		3.00	3	0.027	0.900	3.000	810	1215	1620	2430
		4.00	3	0.036	1.200	4.000	1080	1620	2160	3240
		5.00	3	0.045	1.500	5.000	1350	2025	2700	4050
		6.00	3	0.055	1.800	6.000	1650	2475	3300	4950
		8.00	3	0.073	2.400	8.000	2190	3285	4380	6570
		10.00	3	0.091	3.000	10.000	2730	4095	5460	8190
12.00	3	0.109	3.600	12.000	3270	4905	6540	9810		
	Graphite  B  B	2.00	3	0.027	0.200	0.800	810	1215	1620	2430
		3.00	3	0.040	0.300	1.200	1200	1800	2400	3600
		4.00	3	0.053	0.400	1.600	1590	2385	3180	4770
		5.00	3	0.067	0.500	2.000	2010	3015	4020	6030
		6.00	3	0.080	0.600	2.400	2400	3600	4800	7200
		8.00	3	0.107	0.800	3.200	3210	4815	6420	9630
		10.00	3	0.133	1.000	4.000	3990	5985	7980	11970
12.00	3	0.160	1.200	4.800	4800	7200	9600	14400		
	Graphite  B  B	2.00	3	0.027	4.000	0.300	810	1215	1620	2430
		3.00	3	0.040	6.000	0.450	1200	1800	2400	3600
		4.00	3	0.053	8.000	0.600	1590	2385	3180	4770
		5.00	3	0.067	10.000	0.750	2010	3015	4020	6030
		6.00	3	0.080	12.000	0.900	2400	3600	4800	7200
		8.00	3	0.107	16.000	1.200	3210	4815	6420	9630
		10.00	3	0.133	20.000	1.500	3990	5985	7980	11970
12.00	3	0.160	24.000	1.800	4800	7200	9600	14400		