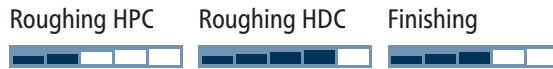
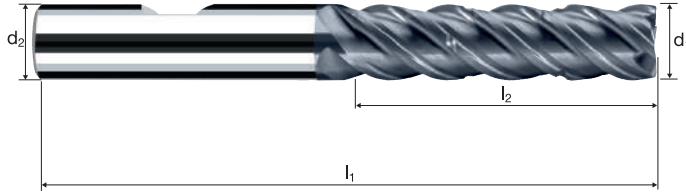
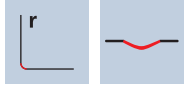


Cylindrical end mills E-Cut

Smooth-edged, chip breaker, medium length version



HM
MG10 λ 45°
 γ 10°



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

										POLYCHROM	
Example: Order-N°.										P8410	
										P8310	
\emptyset Code	d_1 e8	d_2 h6	l_1	l_2	l_4	r	α	z			
140*	2.00	6.00	63	7.00	17.12	0.050	7.0°	4	●		
180*	3.00	6.00	63	11.00	20.26	0.050	4.5°	4	●		
220*	4.00	6.00	63	13.00	21.39	0.100	3.5°	4	●		
260*	5.00	6.00	63	16.00	23.52	0.100	1.5°	4	●		
300	6.00	6.00	63	21.00	-	0.100	0.0°	4	●		
391	8.00	8.00	72	31.00	-	0.150	0.0°	4	●		
450	10.00	10.00	84	37.00	-	0.200	0.0°	4	●		
501	12.00	12.00	97	44.00	-	0.200	0.0°	4	●		
610	16.00	16.00	108	53.00	-	0.200	0.0°	4	●		
682	20.00	20.00	122	62.00	-	0.250	0.0°	4	●		
* without chip breaker only											

Application	Material	d1 [mm]	z	v _c [m/min]	f _s [mm]	a _s [mm]	a _e [mm]	n [min ⁻¹]	v _r [mm/min]	Q [cm ³ /min]	φZ [°]
	Steel < 850 N/mm ² 	3.00	4	130	0.020	3.750	1.200	13795	1105	5.0	1.5°
		4.00	4	130	0.030	5.000	1.600	10345	1240	9.9	1.5°
		5.00	4	130	0.037	6.250	2.000	8275	1225	15.3	1.5°
		6.00	4	130	0.039	9.000	2.400	6895	1075	23.2	1.5°
		8.00	4	130	0.052	12.000	3.200	5175	1075	41.3	1.5°
		10.00	4	130	0.065	15.000	4.000	4140	1075	64.6	1.5°
		12.00	4	130	0.072	18.000	4.800	3450	995	85.8	1.5°
		16.00	4	130	0.088	24.000	6.400	2585	910	139.8	1.5°
		20.00	4	130	0.099	30.000	8.000	2070	820	196.6	1.5°
			Steel 850 - 1100 N/mm ² 	3.00	4	120	0.019	3.750	1.200	12730	970
4.00	4			120	0.028	5.000	1.600	9550	1070	8.6	2°
5.00	4			120	0.035	6.250	2.000	7640	1070	13.4	2°
6.00	4			120	0.033	9.000	2.400	6365	840	18.2	2°
8.00	4			120	0.044	12.000	3.200	4775	840	32.3	2°
10.00	4			120	0.055	15.000	4.000	3820	840	50.4	2°
12.00	4			120	0.066	18.000	4.800	3185	840	72.6	2°
16.00	4			120	0.080	24.000	6.400	2385	765	117.3	2°
20.00	4			120	0.090	30.000	8.000	1910	690	165.0	2°
	Inox normal [Cr-Ni/1.4301] [Cr-Ni-Mo/1.4571] 			3.00	4	75	0.013	3.750	1.200	7960	415
		4.00	4	75	0.019	5.000	1.600	5970	455	3.6	1.5°
		5.00	4	75	0.024	6.250	2.000	4775	460	5.7	1.5°
		6.00	4	75	0.023	9.000	2.400	3980	365	7.9	1.5°
		8.00	4	75	0.030	12.000	3.200	2985	360	13.8	1.5°
		10.00	4	75	0.038	15.000	4.000	2385	365	21.8	1.5°
		12.00	4	75	0.046	18.000	4.800	1990	365	31.6	1.5°
		16.00	4	75	0.050	24.000	6.400	1490	300	45.8	1.5°
		20.00	4	75	0.063	30.000	8.000	1195	300	72.2	1.5°
			Steel < 850 N/mm ² 	3.00	4	105	0.009	2.250	3.000	11140	400
4.00	4			105	0.014	4.000	4.000	8355	470	7.5	1.5°
5.00	4			105	0.017	5.000	5.000	6685	455	11.4	1.5°
6.00	4			105	0.023	7.500	6.000	5570	510	23.1	1.5°
8.00	4			105	0.031	10.000	8.000	4180	520	41.4	1.5°
10.00	4			105	0.039	12.500	10.000	3340	520	65.2	1.5°
12.00	4			105	0.043	15.000	12.000	2785	480	86.2	1.5°
16.00	4			105	0.053	20.000	16.000	2090	445	141.7	1.5°
20.00	4			105	0.059	25.000	20.000	1670	395	197.2	1.5°
	Steel 850 - 1100 N/mm ² 			3.00	4	95	0.009	2.250	3.000	10080	365
		4.00	4	95	0.013	4.000	4.000	7560	395	6.3	2°
		5.00	4	95	0.016	5.000	5.000	6050	385	9.7	2°
		6.00	4	95	0.020	7.500	6.000	5040	405	18.1	2°
		8.00	4	95	0.026	10.000	8.000	3780	395	31.4	2°
		10.00	4	95	0.033	12.500	10.000	3025	400	49.9	2°
		12.00	4	95	0.040	15.000	12.000	2520	405	72.6	2°
		16.00	4	95	0.048	20.000	16.000	1890	365	116.1	2°
		20.00	4	95	0.054	25.000	20.000	1510	325	163.3	2°
			Inox normal [Cr-Ni/1.4301] [Cr-Ni-Mo/1.4571] 	3.00	4	60	0.006	2.250	3.000	6365	155
4.00	4			60	0.009	4.000	4.000	4775	170	2.8	1.5°
5.00	4			60	0.011	5.000	5.000	3820	170	4.2	1.5°
6.00	4			60	0.014	7.500	6.000	3185	180	8.0	1.5°
8.00	4			60	0.018	10.000	8.000	2385	170	13.8	1.5°
10.00	4			60	0.023	12.500	10.000	1910	175	22.0	1.5°
12.00	4			60	0.028	15.000	12.000	1590	180	32.1	1.5°
16.00	4			60	0.030	20.000	16.000	1195	145	45.8	1.5°
20.00	4			60	0.038	25.000	20.000	955	145	72.6	1.5°



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

