

Cylindrical end mills

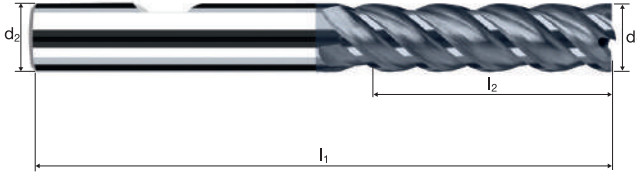
Smooth-edged, medium length version



HM
MG10 λ **43°**
 γ **3°**

45°

Vario

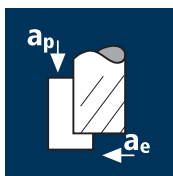


Roughing HPC Roughing HDC Finishing

Rm < 850 Rm 850-1100 Rm 1100-1300 Inox Stainless Ti Titanium GG(G) Tool Steel Nickel-Alloys

Example: Order-N°.								POLYCHROM	
		Coating	Article-N°	ϕ -Code				P45326	
		P	45326	300				P45226	
\emptyset Code	d_1 e8	d_2 h6	l_1	l_2	45°	z			
300	6.00	6.00	63	21.00	0.10	4			●
391	8.00	8.00	72	31.00	0.10	4			●
450	10.00	10.00	84	37.00	0.15	4			●
501	12.00	12.00	97	44.00	0.15	4			●
610	16.00	16.00	108	53.00	0.15	4			●
682	20.00	20.00	122	62.00	0.15	4			●

Application



Material

Steel
500 - 850 N/mm²



d ₁ [mm]	z	v _c [m/min]	f _z [mm]	a _p [mm]	a _e [mm]	n [min ⁻¹]	v _f [mm/min]	Q [cm ³ /min]
6.00	4	120	0.034	9.000	2.400	6365	877	18.9
8.00	4	120	0.046	12.000	3.200	4775	877	33.7
10.00	4	120	0.057	15.000	4.000	3820	877	52.6
12.00	4	120	0.064	18.000	4.800	3185	819	70.7
16.00	4	120	0.073	24.000	6.400	2385	701	107.6
20.00	4	120	0.084	30.000	8.000	1910	643	154.3

Steel
850 - 1100 N/mm²



6.00	4	105	0.030	9.000	2.400	5570	665	14.4
8.00	4	105	0.040	12.000	3.200	4180	665	25.5
10.00	4	105	0.050	15.000	4.000	3340	664	39.9
12.00	4	105	0.060	18.000	4.800	2785	665	57.4
16.00	4	105	0.067	24.000	6.400	2090	563	86.4
20.00	4	105	0.077	30.000	8.000	1670	511	122.6

Inox normal
[Cr-Ni/1.4301]
[Cr-Ni-Mo/1.4571]



6.00	4	70	0.021	9.000	2.400	3715	307	6.6
8.00	4	70	0.028	12.000	3.200	2785	307	11.8
10.00	4	70	0.034	15.000	4.000	2230	307	18.4
12.00	4	70	0.041	18.000	4.800	1855	307	26.5
16.00	4	70	0.043	24.000	6.400	1395	239	36.7
20.00	4	70	0.054	30.000	8.000	1115	239	57.3

Cast iron
(lamellar / spheroidal)



6.00	4	130	0.032	9.000	2.400	6895	886	19.1
8.00	4	130	0.043	12.000	3.200	5175	887	34.1
10.00	4	130	0.054	15.000	4.000	4140	887	53.2
12.00	4	130	0.064	18.000	4.800	3450	887	76.6
16.00	4	130	0.073	24.000	6.400	2585	759	116.6
20.00	4	130	0.084	30.000	8.000	2070	697	167.2

Application



Material

Steel
500 - 850 N/mm²



d ₁ [mm]	z	v _c [m/min]	f _z [mm]	a _p [mm]	a _e [mm]	n [min ⁻¹]	v _f [mm/min]	Q [cm ³ /min]
6.00	4	95	0.022	7.500	6.000	5040	444	20.0
8.00	4	95	0.030	10.000	8.000	3780	454	36.3
10.00	4	95	0.037	12.500	10.000	3025	448	56.0
12.00	4	95	0.042	15.000	12.000	2520	423	76.2
16.00	4	95	0.048	20.000	16.000	1890	363	116.1
20.00	4	95	0.055	25.000	20.000	1510	332	166.1

Steel
850 - 1100 N/mm²



6.00	4	85	0.019	7.500	6.000	4510	343	15.4
8.00	4	85	0.026	10.000	8.000	3380	352	28.1
10.00	4	85	0.032	12.500	10.000	2705	346	43.3
12.00	4	85	0.039	15.000	12.000	2255	352	63.3
16.00	4	85	0.044	20.000	16.000	1690	297	95.2
20.00	4	85	0.050	25.000	20.000	1355	271	135.5

Inox normal
[Cr-Ni/1.4301]
[Cr-Ni-Mo/1.4571]



6.00	4	55	0.013	7.500	6.000	2920	152	6.8
8.00	4	55	0.018	10.000	8.000	2190	158	12.6
10.00	4	55	0.022	12.500	10.000	1750	154	19.3
12.00	4	55	0.027	15.000	12.000	1460	158	28.4
16.00	4	55	0.028	20.000	16.000	1095	123	39.2
20.00	4	55	0.035	25.000	20.000	875	123	61.3

Cast iron
(lamellar / spheroidal)



6.00	4	105	0.021	7.500	6.000	5570	468	21.1
8.00	4	105	0.028	10.000	8.000	4180	468	37.5
10.00	4	105	0.035	12.500	10.000	3340	468	58.5
12.00	4	105	0.042	15.000	12.000	2785	468	84.2
16.00	4	105	0.048	20.000	16.000	2090	401	128.4
20.00	4	105	0.055	25.000	20.000	1670	367	183.7