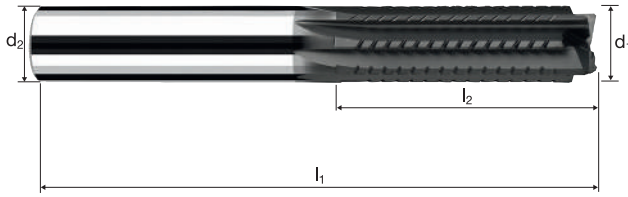
Cylindrical end mills

Normal version, straight cutting edge

HM
MG6

λ 0°
γ 18°

45°



Wear resistance

CFK GFK I

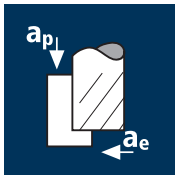
CFK GFK II

Example: **Order-N°.** Coating **B** Article-N°. **20020** ø-Code **220**

DIAMANT

B20020

Ø Code	d_1 h10	d_2 h6	l_1	l_2	l_4	45°	α	z		
220	4.00	6.00	60	16.00	24.00	0.10	2.9°	8		●
260	5.00	6.00	60	18.00	24.00	0.10	1.4°	8		●
300	6.00	6.00	60	20.00	24.00	0.10	0.0°	8		●
302	6.00	6.00	65	25.00	29.00	0.10	0.0°	8		●
304	6.00	6.00	75	28.00	39.00	0.10	0.0°	8		●
391	8.00	8.00	63	22.00	27.00	0.20	0.0°	8		●
393	8.00	8.00	75	32.00	39.00	0.20	0.0°	8		●
450	10.00	10.00	72	32.00	32.00	0.20	0.0°	8		●
501	12.00	12.00	83	32.00	38.00	0.20	0.0°	8		●

Application	Material	d1 [mm]	z	v_c [m/min]	f_z [mm]	a_p [mm]	a_e [mm]	n [min-1]	v_f [mm/min]
	CFC	4.00	8	200	0.025	7.200	1.600	15915	3185
		5.00	8	200	0.030	9.000	2.000	12730	3055
		6.00	8	200	0.040	10.800	2.400	10610	3395
		8.00	8	200	0.045	14.400	3.200	7960	2865
		10.00	8	200	0.050	18.000	4.000	6365	2545
		12.00	8	200	0.060	21.600	4.800	5305	2545
	GRP	4.00	8	150	0.030	7.200	1.600	11935	2865
		5.00	8	150	0.035	9.000	2.000	9550	2675
		6.00	8	150	0.040	10.800	2.400	7960	2545
		8.00	8	150	0.050	14.400	3.200	5970	2385
		10.00	8	150	0.055	18.000	4.000	4775	2100
		12.00	8	150	0.065	21.600	4.800	3980	2070
	CFC	4.00	8	150	0.020	3.200	4.000	11935	1910
		5.00	8	150	0.025	4.000	5.000	9550	1910
		6.00	8	150	0.030	4.800	6.000	7960	1910
		8.00	8	150	0.035	6.400	8.000	5970	1670
		10.00	8	150	0.040	8.000	10.000	4775	1530
		12.00	8	150	0.050	9.600	12.000	3980	1590
	GRP	4.00	8	100	0.025	3.200	4.000	7960	1590
		5.00	8	100	0.030	4.000	5.000	6365	1530
		6.00	8	100	0.030	4.800	6.000	5305	1275
		8.00	8	100	0.040	6.400	8.000	3980	1275
		10.00	8	100	0.045	8.000	10.000	3185	1145
		12.00	8	100	0.050	9.600	12.000	2655	1060