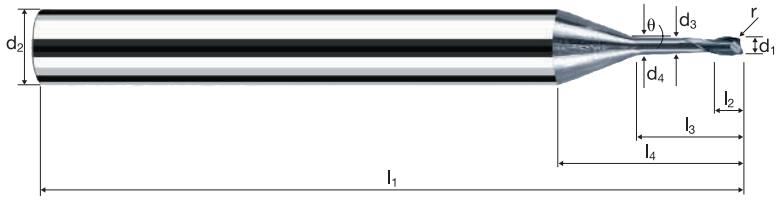
Corner radius end mills MicroX

Shank ø 6mm, conical neck 0.9°, 6xd

HM XA	λ 25° γ -10°

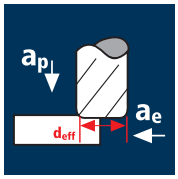


Rm < 850	Rm 850-1100	Rm 1100-1300	Rm 1300-1500	HRC 48-56	HRC 56-60	HRC > 60	Inox Stainless	Ti Titanium	Cobalt-Chrome Copper

Example: **Order-N°.** Coating **X** Article-N°. **6735** ø-Code **050**

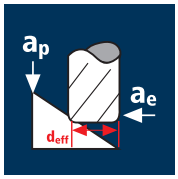
Ø Code	d_1 0/-0.01	d_2 h4	d_3	d_4	l_1	l_2	l_3	l_4	θ	r 0/+0.01	α	z	X-AL X6735
050	0.50	6.00	0.45	0.53	57	0.40	3.00	13.87	0.9°	0.100	11.8°	2	●
060	0.60	6.00	0.55	0.65	57	0.50	3.60	14.24	0.9°	0.100	11.1°	2	●
080	0.80	6.00	0.75	0.88	57	0.65	4.80	15.01	0.9°	0.100	10.2°	2	●
100	1.00	6.00	0.95	1.11	57	0.80	6.00	15.78	0.9°	0.200	9.4°	2	●
120	1.50	6.00	1.40	1.65	61	1.20	9.00	17.78	0.9°	0.200	7.4°	2	●
140	2.00	6.00	1.90	2.23	66	1.60	12.00	19.69	0.9°	0.200	5.9°	2	●
145	2.00	6.00	1.90	2.23	66	1.60	12.00	19.69	0.9°	0.500	6.0°	2	●

Application



Material	d1 [mm]	z	v_c [m/min]	f_z [mm]	a_p [mm]	a_e [mm]	d_{eff} [mm]	n [min^{-1}]	v_f [mm/min]	r [mm]
Hardened tool steel 42 - 48 HRC	0.50	2	53	0.008	0.013	0.100	0.40	42175	640	0.10
	0.60	2	67	0.009	0.016	0.120	0.51	41815	740	0.10
	0.80	2	95	0.013	0.021	0.160	0.72	42000	1060	0.10
	1.00	2	106	0.015	0.027	0.200	0.80	42175	1275	0.20
	1.50	2	140	0.023	0.040	0.300	1.34	33255	1510	0.20
	2.00	2	140	0.030	0.053	0.400	1.87	23830	1440	0.20
Hardened tool steel 48 - 52 HRC	0.50	2	53	0.007	0.013	0.100	0.40	42175	605	0.10
	0.60	2	67	0.008	0.016	0.120	0.51	41815	705	0.10
	0.80	2	95	0.012	0.021	0.160	0.72	42000	1010	0.10
	1.00	2	106	0.014	0.027	0.200	0.80	42175	1215	0.20
	1.50	2	120	0.022	0.040	0.300	1.34	28505	1230	0.20
	2.00	2	120	0.029	0.053	0.400	1.87	20425	1175	0.20
Hardened tool steel 52 - 56 HRC	0.50	2	53	0.006	0.013	0.100	0.40	42175	505	0.10
	0.60	2	67	0.007	0.016	0.120	0.51	41815	585	0.10
	0.80	2	95	0.010	0.021	0.160	0.72	42000	840	0.10
	1.00	2	100	0.012	0.027	0.200	0.80	39790	955	0.20
	1.50	2	100	0.018	0.040	0.300	1.34	23755	855	0.20
	2.00	2	100	0.024	0.053	0.400	1.87	17020	815	0.20
Hardened tool steel 56 - 60 HRC	0.50	2	53	0.005	0.013	0.100	0.40	42175	455	0.10
	0.60	2	60	0.006	0.016	0.120	0.51	37450	470	0.10
	0.80	2	60	0.009	0.021	0.160	0.72	26525	475	0.10
	1.00	2	60	0.011	0.027	0.200	0.80	23875	515	0.20
	1.50	2	60	0.016	0.040	0.300	1.34	14255	460	0.20
	2.00	2	60	0.022	0.053	0.400	1.87	10215	440	0.20

Application



Material	d1 [mm]	z	v_c [m/min]	f_z [mm]	a_p [mm]	a_e [mm]	d_{eff} [mm]	n [min^{-1}]	v_f [mm/min]	β [°]
Hardened tool steel 42 - 48 HRC	0.50	2	66	0.022	0.016	0.016	0.50	42015	1850	45°
	0.60	2	79	0.024	0.020	0.020	0.60	41910	2010	45°
	0.80	2	106	0.028	0.032	0.032	0.80	42175	2360	45°
	1.00	2	132	0.034	0.040	0.040	1.00	42015	2855	45°
	1.50	2	198	0.040	0.060	0.060	1.50	42015	3360	45°
	2.00	2	264	0.046	0.080	0.080	2.00	42015	3865	45°
Hardened tool steel 48 - 52 HRC	0.50	2	66	0.020	0.016	0.016	0.50	42015	1680	45°
	0.60	2	79	0.022	0.020	0.020	0.60	41910	1845	45°
	0.80	2	106	0.026	0.032	0.032	0.80	42175	2195	45°
	1.00	2	132	0.032	0.040	0.040	1.00	42015	2690	45°
	1.50	2	198	0.038	0.060	0.060	1.50	42015	3195	45°
	2.00	2	250	0.044	0.080	0.080	2.00	39790	3500	45°
Hardened tool steel 52 - 56 HRC	0.50	2	66	0.020	0.016	0.016	0.50	42015	1680	45°
	0.60	2	79	0.022	0.020	0.020	0.60	41910	1845	45°
	0.80	2	106	0.026	0.032	0.032	0.80	42175	2195	45°
	1.00	2	132	0.030	0.040	0.040	1.00	42015	2520	45°
	1.50	2	198	0.036	0.060	0.060	1.50	42015	3025	45°
	2.00	2	200	0.042	0.080	0.080	2.00	31830	2675	45°
Hardened tool steel 56 - 60 HRC	0.50	2	66	0.018	0.016	0.016	0.50	42015	1515	45°
	0.60	2	79	0.020	0.020	0.020	0.60	41910	1675	45°
	0.80	2	106	0.022	0.032	0.032	0.80	42175	1855	45°
	1.00	2	132	0.028	0.040	0.040	1.00	42015	2355	45°
	1.50	2	150	0.032	0.060	0.060	1.50	31830	2035	45°
	2.00	2	150	0.036	0.080	0.080	2.00	23875	1720	45°