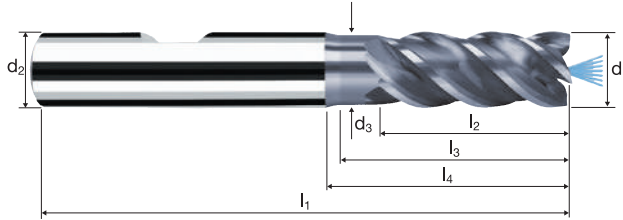
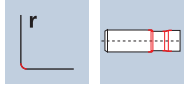


Cylindrical end mills MFC

Smooth-edged, normal version, short neck
High-performance penetration edge, central air/cooling channel



HM
MG10 λ 45°
 γ 0°

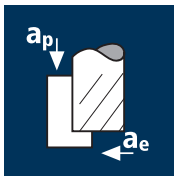


Roughing HPC Roughing HDC Finishing

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

Example: Order-N°.											POLYCHROM	
											P8202	
											P8102	
\emptyset Code	d_1 e8	d_2 h5	d_3	l_1	l_2	l_3	l_4	r	α	z		
220	4.00	6.00	3.70	57	8.00	16.00	20.82	0.100	3.0°	4	●	
260	5.00	6.00	4.60	57	10.00	18.00	21.27	0.100	1.5°	4	●	
300	6.00	6.00	5.50	57	12.00	18.15	20.00	0.100	0.0°	4	●	
391	8.00	8.00	7.40	63	19.00	23.63	26.00	0.150	0.0°	4	●	
450	10.00	10.00	9.20	72	23.00	27.99	31.00	0.200	0.0°	4	●	
501	12.00	12.00	11.00	83	27.00	33.29	37.00	0.200	0.0°	4	●	
610	16.00	16.00	15.00	92	32.00	38.73	43.00	0.200	0.0°	4	●	
612*	16.00	16.00	15.00	92	32.00	38.73	43.00	0.200	0.0°	4	●	
682	20.00	20.00	19.00	104	39.00	48.23	53.00	0.200	0.0°	4	●	
684*	20.00	20.00	19.00	104	39.00	48.23	53.00	0.200	0.0°	4	●	
* with chip breaker												

Application

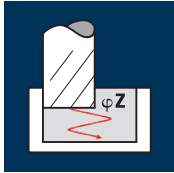


Material

Steel
850 - 1100 N/mm²



d1 [mm]	z	v _c [m/min]	f _s [mm]	a _p [mm]	a _e [mm]	n [min ⁻¹]	v _r [mm/min]	Q [cm ³ /min]	q _Z [°]
4.00	4	150	0.030	7.200	1.600	11935	1430	16.5	18°
5.00	4	150	0.035	9.000	2.000	9550	1335	24.1	18°
6.00	4	150	0.040	10.800	2.400	7960	1275	33.0	18°
8.00	4	150	0.050	14.400	3.200	5970	1195	55.0	18°
10.00	4	150	0.065	18.000	4.000	4775	1240	89.4	18°
12.00	4	150	0.075	21.600	4.800	3980	1195	123.8	18°
16.00	4	150	0.085	24.000	6.400	2985	1015	155.8	18°
20.00	4	150	0.100	30.000	8.000	2385	955	229.2	18°



Steel
1100 - 1300 N/mm²



d1 [mm]	z	v _c [m/min]	f _s [mm]	a _p [mm]	a _e [mm]	n [min ⁻¹]	v _r [mm/min]	Q [cm ³ /min]	q _Z [°]
4.00	4	115	0.025	7.200	1.600	9150	915	10.5	15°
5.00	4	115	0.030	9.000	2.000	7320	880	15.8	15°
6.00	4	115	0.035	10.800	2.400	6100	855	22.1	15°
8.00	4	115	0.045	14.400	3.200	4575	825	38.0	15°
10.00	4	115	0.055	18.000	4.000	3660	805	58.0	15°
12.00	4	115	0.065	21.600	4.800	3050	795	82.2	15°
16.00	4	115	0.075	24.000	6.400	2290	685	105.4	15°
20.00	4	115	0.090	30.000	8.000	1830	660	158.1	15°

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



d1 [mm]	z	v _c [m/min]	f _s [mm]	a _p [mm]	a _e [mm]	n [min ⁻¹]	v _r [mm/min]	Q [cm ³ /min]	q _R [°]
4.00	4	90	0.020	7.200	1.600	7160	575	6.6	12°
5.00	4	90	0.025	9.000	2.000	5730	575	10.3	12°
6.00	4	90	0.030	10.800	2.400	4775	575	14.9	12°
8.00	4	90	0.035	14.400	3.200	3580	500	23.1	12°
10.00	4	90	0.045	18.000	4.000	2865	515	37.1	12°
12.00	4	90	0.055	21.600	4.800	2385	525	54.5	12°
16.00	4	90	0.065	24.000	6.400	1790	465	71.5	12°
20.00	4	90	0.080	30.000	8.000	1430	460	110.0	12°

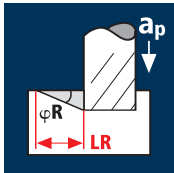
Application



Steel
850 - 1100 N/mm²



d1 [mm]	z	v _c [m/min]	f _s [mm]	a _p [mm]	a _e [mm]	n [min ⁻¹]	v _r [mm/min]	Q [cm ³ /min]	q _R [°]	LR [mm]
4.00	4	120	0.021	6.000	4.000	9550	800	19.3	20°	16.5
5.00	4	120	0.025	7.500	5.000	7640	765	28.6	20°	20.6
6.00	4	120	0.028	9.000	6.000	6365	715	38.5	20°	24.7
8.00	4	120	0.035	12.000	8.000	4775	670	64.2	20°	33.0
10.00	4	120	0.046	15.000	10.000	3820	705	105.4	20°	41.2
12.00	4	120	0.053	18.000	12.000	3185	675	145.8	20°	49.5
16.00	4	120	0.059	24.000	16.000	2385	565	216.3	20°	65.9
20.00	4	120	0.070	25.000	20.000	1910	535	267.4	20°	68.7



Steel
1100 - 1300 N/mm²



d1 [mm]	z	v _c [m/min]	f _s [mm]	a _p [mm]	a _e [mm]	n [min ⁻¹]	v _r [mm/min]	Q [cm ³ /min]	q _R [°]	LR [mm]
4.00	4	90	0.018	6.000	4.000	7160	515	12.4	20°	16.5
5.00	4	90	0.021	7.500	5.000	5730	480	18.0	20°	20.6
6.00	4	90	0.025	9.000	6.000	4775	475	25.8	20°	24.7
8.00	4	90	0.032	12.000	8.000	3580	460	44.0	20°	33.0
10.00	4	90	0.039	15.000	10.000	2865	445	67.0	20°	41.2
12.00	4	90	0.046	18.000	12.000	2385	440	94.9	20°	49.5
16.00	4	90	0.053	24.000	16.000	1790	380	145.8	20°	65.9
20.00	4	90	0.063	25.000	20.000	1430	360	180.5	20°	68.7

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



d1 [mm]	z	v _c [m/min]	f _s [mm]	a _p [mm]	a _e [mm]	n [min ⁻¹]	v _r [mm/min]	Q [cm ³ /min]	q _R [°]	LR [mm]
4.00	4	70	0.014	6.000	4.000	5570	310	7.5	14°	24.1
5.00	4	70	0.018	7.500	5.000	4455	320	12.0	14°	30.1
6.00	4	70	0.021	9.000	6.000	3715	310	16.8	14°	36.1
8.00	4	70	0.025	12.000	8.000	2785	280	26.7	14°	48.1
10.00	4	70	0.032	15.000	10.000	2230	285	42.8	14°	60.2
12.00	4	70	0.039	18.000	12.000	1855	290	62.6	14°	72.2
16.00	4	70	0.046	24.000	16.000	1395	255	98.4	14°	96.3
20.00	4	70	0.056	25.000	20.000	1115	250	124.8	14°	100.3

This way to the cutting data software
ToolExpert MFC.
Quick, easy, reliable.

