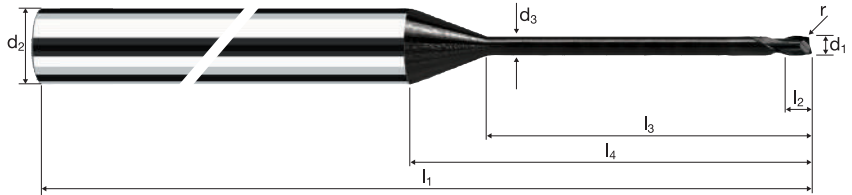


Corner radius end mills MicroX

Shank \varnothing 6mm, cylindrical neck, 15xd



HM	λ 30°
XA	γ 15°



				C Graphite							CF/GF Fiber Reinforced Plastics
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IV

Example: Order-N°.											DIAPLUS	
											B6042	
\varnothing Code	d_1 0/-0.01	d_2 h4	d_3	l_1	l_2	l_3	l_4	r ± 0.005	α	z		
040	0.40	6.00	0.35	61	0.40	6.00	22.46	0.050	9.7°	2	●	
048	0.50	6.00	0.45	57	0.50	7.50	18.51	0.050	8.8°	2	●	
058	0.60	6.00	0.55	57	0.60	9.00	19.83	0.050	8.1°	2	●	
078	0.80	6.00	0.75	61	0.80	12.00	22.45	0.050	6.9°	2	●	
096	1.00	6.00	0.95	66	1.00	15.00	25.08	0.050	5.9°	2	●	
050	0.50	6.00	0.45	57	0.50	7.50	18.51	0.100	8.8°	2	●	
060	0.60	6.00	0.55	57	0.60	9.00	19.83	0.100	8.1°	2	●	
080	0.80	6.00	0.75	61	0.80	12.00	22.45	0.100	6.9°	2	●	
098	1.00	6.00	0.95	66	1.00	15.00	25.08	0.100	5.9°	2	●	
138	2.00	6.00	1.90	75	2.00	30.00	38.31	0.100	3.1°	2	●	
082	0.80	6.00	0.75	61	0.80	12.00	22.45	0.200	6.9°	2	●	
100	1.00	6.00	0.95	66	1.00	15.00	25.08	0.200	5.9°	2	●	
120	1.50	6.00	1.40	69	1.50	22.50	31.74	0.200	4.2°	2	●	
140	2.00	6.00	1.90	75	2.00	30.00	38.31	0.200	3.1°	2	●	
180	3.00	6.00	2.80	100	3.00	45.00	51.63	0.200	1.7°	2	●	
185	3.00	6.00	2.80	100	3.00	45.00	51.63	0.500	1.7°	2	●	

Application	Material	d1 [mm]	z	f _z [mm]	a _p [mm]	a _e [mm]	n=15000 min ⁻¹ vf [mm/min]	n=25000 min ⁻¹ vf [mm/min]	n=30000 min ⁻¹ vf [mm/min]	n=45000 min ⁻¹ vf [mm/min]
	Graphite B B	0.40	2	0.003	0.080	0.100	90	150	180	270
		0.50	2	0.004	0.100	0.150	120	200	240	360
		0.60	2	0.005	0.100	0.200	150	250	300	450
		0.80	2	0.007	0.150	0.250	210	350	420	630
		1.00	2	0.008	0.200	0.300	240	400	480	720
		1.50	2	0.012	0.300	0.450	360	600	720	1080
		2.00	2	0.016	0.400	0.600	480	800	960	1440
		3.00	2	0.025	0.600	0.900	750	1250	1500	2250
			Graphite B B	0.40	2	0.003	0.040	0.400	90	150
0.50	2			0.003	0.050	0.500	90	150	180	270
0.60	2			0.004	0.060	0.600	120	200	240	360
0.80	2			0.005	0.080	0.800	150	250	300	450
1.00	2			0.006	0.100	1.000	180	300	360	540
1.50	2			0.010	0.150	1.500	300	500	600	900
2.00	2			0.013	0.200	2.000	390	650	780	1170
3.00	2			0.019	0.300	3.000	570	950	1140	1710
	Graphite B B			0.40	2	0.004	0.030	0.040	120	200
		0.50	2	0.005	0.040	0.050	150	250	300	450
		0.60	2	0.006	0.050	0.060	180	300	360	540
		0.80	2	0.007	0.060	0.080	210	350	420	630
		1.00	2	0.009	0.080	0.100	270	450	540	810
		1.50	2	0.014	0.120	0.150	420	700	840	1260
		2.00	2	0.019	0.160	0.200	570	950	1140	1710
		3.00	2	0.028	0.240	0.300	840	1400	1680	2520
			Graphite B B	0.40	2	0.004	0.030	0.030	120	200
0.50	2			0.005	0.040	0.040	150	250	300	450
0.60	2			0.006	0.050	0.050	180	300	360	540
0.80	2			0.007	0.060	0.060	210	350	420	630
1.00	2			0.009	0.080	0.080	270	450	540	810
1.50	2			0.014	0.120	0.120	420	700	840	1260
2.00	2			0.019	0.160	0.160	570	950	1140	1710
3.00	2			0.028	0.240	0.240	840	1400	1680	2520