

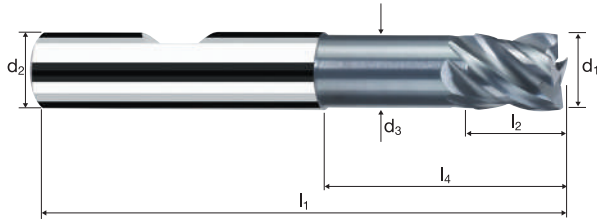
Cylindrical end mills NX

Smooth-edged, normal version, neck



HM
MG10

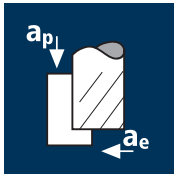
λ 45°
 γ -20°



Rm 850-1100	Rm 1100-1300	Rm 1300-1500	HRC 48-56	HRC 56-60		Ti Titanium	GG(G) Tool Steel
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Ø Code	d ₁ e8	d ₂ h6	d ₃	l ₁	l ₂	l ₃	l ₄	45°	α	z	POLYCHROM				
											Order-N°	Article-N°	ø-Code		
220	4.00	6.00	3.70	57	6.00	16.00	20.95	0.10	3.0°	4	P	15342	220	●	
260	5.00	6.00	4.60	57	8.00	18.00	21.27	0.15	1.5°	4	P	15342	220	●	
300	6.00	6.00	5.50	57	9.00	19.34	20.00	0.15	0.0°	4	P	15342	220	●	
391	8.00	8.00	7.40	63	12.00	25.29	26.00	0.15	0.0°	4	P	15342	220	●	
450	10.00	10.00	9.20	72	15.00	30.20	31.00	0.20	0.0°	4	P	15342	220	●	
501	12.00	12.00	11.00	83	18.00	36.13	37.00	0.20	0.0°	4	P	15342	220	●	
610	16.00	16.00	15.00	92	24.00	42.13	43.00	0.20	0.0°	4	P	15342	220	●	
682	20.00	20.00	19.00	104	30.00	52.13	53.00	0.20	0.0°	4	P	15342	220	●	

Application



Material

Steel
850 - 1100 N/mm²



Steel
1100 - 1300 N/mm²



Hardened tool steel
52 - 56 HRC



Titanium alloys
> 300 HB
[Ti6Al4V]



Steel
850 - 1100 N/mm²



Steel
1100 - 1300 N/mm²



Hardened tool steel
52 - 56 HRC



Titanium alloys
> 300 HB
[Ti6Al4V]



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]
4.00	4	150	0.030	4.000	2.600	11935	1430	14.9
5.00	4	150	0.040	5.000	3.250	9550	1530	24.8
6.00	4	150	0.045	6.000	3.900	7960	1430	33.5
8.00	4	150	0.060	8.000	5.200	5970	1430	59.6
10.00	4	150	0.075	10.000	6.500	4775	1430	93.1
12.00	4	150	0.090	12.000	7.800	3980	1430	134.1
16.00	4	150	0.100	16.000	10.400	2985	1195	198.6
20.00	4	150	0.125	20.000	13.000	2385	1195	310.4

4.00	4	115	0.025	4.000	2.600	9150	915	9.5
5.00	4	115	0.035	5.000	3.250	7320	1025	16.7
6.00	4	115	0.040	6.000	3.900	6100	975	22.8
8.00	4	115	0.055	8.000	5.200	4575	1005	41.9
10.00	4	115	0.065	10.000	6.500	3660	950	61.9
12.00	4	115	0.080	12.000	7.800	3050	975	91.4
16.00	4	115	0.090	16.000	10.400	2290	825	137.1
20.00	4	115	0.110	20.000	13.000	1830	805	209.4

4.00	4	50	0.015	4.000	2.600	3980	240	2.5
5.00	4	50	0.020	5.000	3.250	3185	255	4.1
6.00	4	50	0.020	6.000	3.900	2655	210	5.0
8.00	4	50	0.025	8.000	5.200	1990	200	8.3
10.00	4	50	0.035	10.000	6.500	1590	225	14.5
12.00	4	50	0.040	12.000	7.800	1325	210	19.9
16.00	4	50	0.050	16.000	10.400	995	200	33.1
20.00	4	50	0.060	20.000	13.000	795	190	49.7

4.00	4	60	0.015	4.000	1.600	4775	285	1.8
5.00	4	60	0.020	5.000	2.000	3820	305	3.1
6.00	4	60	0.020	6.000	2.300	3185	255	3.5
8.00	4	60	0.025	8.000	3.100	2385	240	5.9
10.00	4	60	0.035	10.000	3.900	1910	265	10.4
12.00	4	60	0.040	12.000	4.700	1590	255	14.4
16.00	4	60	0.050	16.000	6.200	1195	240	23.7
20.00	4	60	0.060	20.000	7.800	955	230	35.8

4.00	4	120	0.020	3.600	4.000	9550	765	11.0
5.00	4	120	0.025	4.500	5.000	7640	765	17.2
6.00	4	120	0.035	5.400	6.000	6365	890	28.9
8.00	4	120	0.045	7.200	8.000	4775	860	49.5
10.00	4	120	0.055	9.000	10.000	3820	840	75.6
12.00	4	120	0.065	10.800	12.000	3185	830	107.3
16.00	4	120	0.075	14.400	16.000	2385	715	165.0
20.00	4	120	0.095	18.000	20.000	1910	725	261.3

4.00	4	90	0.020	3.600	4.000	7160	575	8.3
5.00	4	90	0.025	4.500	5.000	5730	575	12.9
6.00	4	90	0.035	5.400	6.000	4775	670	21.7
8.00	4	90	0.045	7.200	8.000	3580	645	37.1
10.00	4	90	0.055	9.000	10.000	2865	630	56.7
12.00	4	90	0.065	10.800	12.000	2385	620	80.4
16.00	4	90	0.075	14.400	16.000	1790	535	123.8
20.00	4	90	0.095	18.000	20.000	1430	545	196.0

4.00	4	40	0.015	3.600	4.000	3185	190	2.8
5.00	4	40	0.020	4.500	5.000	2545	205	4.6
6.00	4	40	0.025	5.400	6.000	2120	210	6.9
8.00	4	40	0.030	7.200	8.000	1590	190	11.0
10.00	4	40	0.040	9.000	10.000	1275	205	18.3
12.00	4	40	0.045	10.800	12.000	1060	190	24.8
16.00	4	40	0.050	14.400	16.000	795	160	36.7
20.00	4	40	0.065	18.000	20.000	635	165	59.6

4.00	4	50	0.020	3.600	4.000	3980	320	4.6
5.00	4	50	0.025	4.500	5.000	3185	320	7.2
6.00	4	50	0.030	5.400	6.000	2655	320	10.3
8.00	4	50	0.040	7.200	8.000	1990	320	18.3
10.00	4	50	0.050	9.000	10.000	1590	320	28.6
12.00	4	50	0.060	10.800	12.000	1325	320	41.3
16.00	4	50	0.070	14.400	16.000	995	280	64.2
20.00	4	50	0.085	18.000	20.000	795	270	97.4