

# Cylindrical end mills

Normal version, pushing cutting edge



HM  
MG6

$\lambda$  -8°  
 $\gamma$  18°



Wear resistance



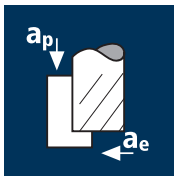
CFK  
GFK  
I

CFK  
GFK  
II

Example: Order-N°.										DIAMANT
Coating: <b>B</b> Article-N°: <b>20030</b> ø-Code: <b>220</b>										
Ø Code	d <sub>1</sub> h10	d <sub>2</sub> h6	l <sub>1</sub>	l <sub>2</sub>	l <sub>4</sub>	45°	α	z		<b>B20030</b>
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

CFC

 **B**

 **B**


GRP


 **B**

 **B**




CFC

 **B**

 **B**

GRP

 **B**

 **B**

d1 [mm]	z	v <sub>c</sub> [m/min]	f <sub>i</sub> [mm]	a <sub>p</sub> [mm]	a <sub>e</sub> [mm]	n [min <sup>-1</sup> ]	v <sub>r</sub> [mm/min]
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
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
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
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