

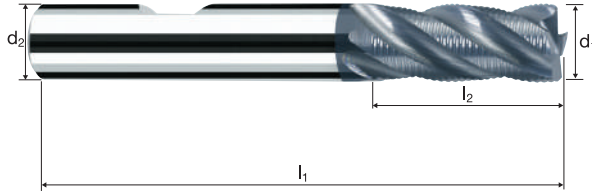
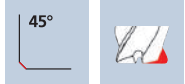
Cylindrical end mills

Profiled, normal version



HM
MG10

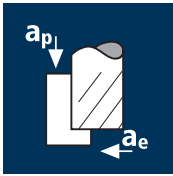
λ 38°
 γ 0°



Rm < 850	Rm 850-1100	Rm 1100-1300						Inox Stainless	Ti Titanium	GG(G)
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Example: Order-N°.										POLYCHROM	
										P45371	
										P45371	
Ø Code	d ₁ e8	d ₂ h6	l ₁	l ₂	l ₄	45°	α	z			
180	3.00	6.00	57	8.00	15.56	0.25	6.0°	3		●	
220	4.00	6.00	57	11.00	16.89	0.30	4.0°	3		●	
260	5.00	6.00	57	13.00	17.22	0.35	2.0°	4		●	
300	6.00	6.00	57	13.00	-	0.35	0.0°	4		●	
391	8.00	8.00	63	19.00	-	0.45	0.0°	4		●	
450	10.00	10.00	72	22.00	-	0.60	0.0°	4		●	
501	12.00	12.00	83	26.00	-	0.60	0.0°	4		●	
610	16.00	16.00	92	32.00	-	0.70	0.0°	4		●	
612	16.00	16.00	92	32.00	-	0.70	0.0°	6		●	
682	20.00	20.00	104	38.00	-	0.70	0.0°	4		●	
684	20.00	20.00	104	38.00	-	0.70	0.0°	6		●	

Application



Material

Steel
< 850 N/mm²



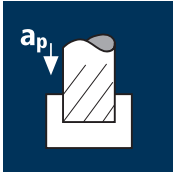
Steel
850 - 1100 N/mm²



Titanium alloys
> 300 HB
[Ti6Al4V]



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



Steel
< 850 N/mm²



Steel
850 - 1100 N/mm²



Titanium alloys
> 300 HB
[Ti6Al4V]



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]
3.00	3	180	0.015	3.600	1.800	19100	860	5.6
4.00	3	180	0.020	4.800	2.400	14325	860	9.9
5.00	4	180	0.025	6.000	3.000	11460	1145	20.6
6.00	4	180	0.030	7.200	3.600	9550	1145	29.7
8.00	4	180	0.040	9.600	4.800	7160	1145	52.8
10.00	4	180	0.050	12.000	6.000	5730	1145	82.5
12.00	4	180	0.055	14.400	7.200	4775	1050	108.9
16.00	4	180	0.055	19.200	9.600	3580	790	145.2
20.00	4	180	0.060	24.000	12.000	2865	690	198.0
3.00	3	130	0.015	3.600	1.800	13795	620	4.0
4.00	3	130	0.020	4.800	2.400	10345	620	7.2
5.00	4	130	0.025	6.000	3.000	8275	830	14.9
6.00	4	130	0.030	7.200	3.600	6895	830	21.5
8.00	4	130	0.040	9.600	4.800	5175	830	38.1
10.00	4	130	0.050	12.000	6.000	4140	830	59.6
12.00	4	130	0.055	14.400	7.200	3450	760	78.7
16.00	4	130	0.055	19.200	9.600	2585	570	104.9
20.00	4	130	0.060	24.000	12.000	2070	495	143.0
3.00	3	45	0.010	3.600	1.800	4775	145	0.9
4.00	3	45	0.015	4.800	2.400	3580	160	1.9
5.00	4	45	0.020	6.000	3.000	2865	230	4.1
6.00	4	45	0.025	7.200	3.600	2385	240	6.2
8.00	4	45	0.030	9.600	4.800	1790	215	9.9
10.00	4	45	0.040	12.000	6.000	1430	230	16.5
12.00	4	45	0.045	14.400	7.200	1195	215	22.3
16.00	4	45	0.045	19.200	9.600	895	160	29.7
20.00	4	45	0.050	24.000	12.000	715	145	41.3
3.00	3	55	0.010	3.600	1.800	5835	175	1.1
4.00	3	55	0.015	4.800	2.400	4375	195	2.3
5.00	4	55	0.020	6.000	3.000	3500	280	5.0
6.00	4	55	0.025	7.200	3.600	2920	290	7.6
8.00	4	55	0.030	9.600	4.800	2190	265	12.1
10.00	4	55	0.040	12.000	6.000	1750	280	20.2
12.00	4	55	0.045	14.400	7.200	1460	265	27.2
16.00	4	55	0.045	19.200	9.600	1095	195	36.3
20.00	4	55	0.050	24.000	12.000	875	175	50.4
3.00	3	150	0.015	3.000	3.000	15915	715	6.4
4.00	3	150	0.020	4.000	4.000	11935	715	11.5
5.00	4	150	0.025	5.000	5.000	9550	955	23.9
6.00	4	150	0.030	6.000	6.000	7960	955	34.4
8.00	4	150	0.040	8.000	8.000	5970	955	61.1
10.00	4	150	0.050	10.000	10.000	4775	955	95.5
12.00	4	150	0.055	12.000	12.000	3980	875	126.1
16.00	4	150	0.055	16.000	16.000	2985	655	168.1
20.00	4	150	0.060	20.000	20.000	2385	575	229.2
3.00	3	80	0.015	3.000	3.000	8490	380	3.4
4.00	3	80	0.020	4.000	4.000	6365	380	6.1
5.00	4	80	0.025	5.000	5.000	5095	510	12.7
6.00	4	80	0.030	6.000	6.000	4245	510	18.3
8.00	4	80	0.040	8.000	8.000	3185	510	32.6
10.00	4	80	0.050	10.000	10.000	2545	510	50.9
12.00	4	80	0.055	12.000	12.000	2120	465	67.2
16.00	4	80	0.055	16.000	16.000	1590	350	89.6
20.00	4	80	0.060	20.000	20.000	1275	305	122.2
3.00	3	35	0.010	3.000	3.000	3715	110	1.0
4.00	3	35	0.015	4.000	4.000	2785	125	2.0
5.00	4	35	0.020	5.000	5.000	2230	180	4.5
6.00	4	35	0.025	6.000	6.000	1855	185	6.7
8.00	4	35	0.030	8.000	8.000	1395	165	10.7
10.00	4	35	0.040	10.000	10.000	1115	180	17.8
12.00	4	35	0.045	12.000	12.000	930	165	24.1
16.00	4	35	0.045	16.000	16.000	695	125	32.1
20.00	4	35	0.050	20.000	20.000	555	110	44.6
3.00	3	45	0.010	3.000	3.000	4775	145	1.3
4.00	3	45	0.015	4.000	4.000	3580	160	2.6
5.00	4	45	0.020	5.000	5.000	2865	230	5.7
6.00	4	45	0.025	6.000	6.000	2385	240	8.6
8.00	4	45	0.030	8.000	8.000	1790	215	13.8
10.00	4	45	0.040	10.000	10.000	1430	230	22.9
12.00	4	45	0.045	12.000	12.000	1195	215	30.9
16.00	4	45	0.045	16.000	16.000	895	160	41.3
20.00	4	45	0.050	20.000	20.000	715	145	57.3