



36380



Alcrona Pro

Z 4

HB



VHM

Type N



HPC

Manufacturer standard

Solid Carbide HPC End Mill

Short version with protective chamfer



d ₁ mm	d ₂ mm	Corner chamfer	l ₂ mm	l ₁ mm	Z	Coated Part No.
2,0	6	0,02	4	54	4	36380020
2,5	6	0,02	4	54	4	36380025
3,0	6	0,03	6	54	4	36380030
4,0	6	0,04	8	54	4	36380040
5,0	6	0,05	9	54	4	36380050
6,0	6	0,06	10	54	4	36380060
7,0	8	0,07	12	58	4	36380070
8,0	8	0,08	12	58	4	36380080
9,0	10	0,09	14	66	4	36380090
10,0	10	0,10	14	66	4	36380100
11,0	12	0,11	16	73	4	36380110
12,0	12	0,12	16	73	4	36380120
14,0	14	0,14	18	75	4	36380140
16,0	16	0,15	22	82	4	36380160
18,0	18	0,15	24	84	4	36380180
20,0	20	0,15	26	92	4	36380200

f _r Roughing mm/Z		f _f Finishing mm/Z	
0,007	– 0,022	0,007	– 0,019
0,007	– 0,022	0,007	– 0,019
0,007	– 0,031	0,007	– 0,027
0,011	– 0,031	0,010	– 0,027
0,016	– 0,039	0,015	– 0,033
0,026	– 0,044	0,025	– 0,038
0,032	– 0,050	0,029	– 0,043
0,032	– 0,055	0,029	– 0,048
0,037	– 0,066	0,034	– 0,057
0,037	– 0,066	0,034	– 0,057
0,053	– 0,088	0,049	– 0,076
0,063	– 0,099	0,059	– 0,086
0,074	– 0,121	0,069	– 0,105
0,095	– 0,143	0,088	– 0,124
0,095	– 0,143	0,088	– 0,124
0,137	– 0,187	0,127	– 0,162



Peripheral milling
α_s = 0,5xD
α_p = 1,3xD



Full slot milling
α_s = 1,0xD

- Universal high-performance end mill for roughing and finishing
- Ultra-micro grain solid carbide with high-performance coating Alcrona Pro
- High machining performance up to 1xD into solid
- Smooth running due to axial and radial unequal spacing
- With the minimum protective chamfer best suitable for low cutting depths (finishing)

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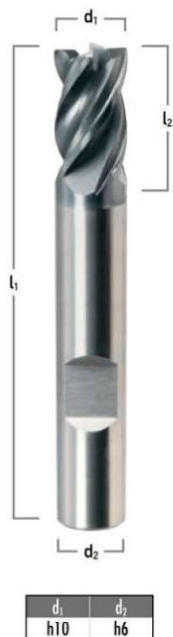


HPC

Manufacturer standard

Solid Carbide HPC End Mill

Short version with edge chamfer



d ₁ mm	d ₂ mm	Corner chamfer	l ₂ mm	l ₁ mm	Z	Coated Part No.
3,0	6	0,13	6	54	4	35380030A
4,0	6	0,18	8	54	4	35380040A
5,0	6	0,20	9	54	4	35380050A
6,0	6	0,20	10	54	4	35380060A
7,0	8	0,20	12	58	4	35380070A
8,0	8	0,20	12	58	4	35380080A
9,0	10	0,30	14	66	4	35380090A
10,0	10	0,30	14	66	4	35380100A
11,0	12	0,30	16	73	4	35380110A
12,0	12	0,30	16	73	4	35380120A
13,0	14	0,30	18	75	4	35380130A
14,0	14	0,30	18	75	4	35380140A
16,0	16	0,40	22	82	4	35380160A
18,0	18	0,40	24	84	4	35380180A
20,0	20	0,50	26	92	4	35380200A

f _r Roughing mm/Z		f _f Finishing mm/Z	
0,007	– 0,031	0,007	– 0,027
0,007	– 0,039	0,007	– 0,033
0,011	– 0,039	0,010	– 0,033
0,016	– 0,044	0,015	– 0,038
0,026	– 0,044	0,025	– 0,038
0,032	– 0,055	0,029	– 0,048
0,032	– 0,055	0,029	– 0,048
0,037	– 0,077	0,034	– 0,067
0,037	– 0,088	0,034	– 0,076
0,053	– 0,099	0,049	– 0,086
0,053	– 0,099	0,049	– 0,086
0,063	– 0,121	0,059	– 0,105
0,074	– 0,143	0,069	– 0,124
0,095	– 0,143	0,088	– 0,124
0,095	– 0,165	0,088	– 0,143



Peripheral milling
α_s = 0,5xD
α_p = 1,3xD



Full slot milling
α_s = 1,0xD

- Universal high-performance end mill for roughing and finishing
- Ultra-micro grain solid carbide with high-performance coating Alcrona Pro
- High machining performance up to 1xD into solid
- Smooth running due to axial and radial unequal spacing
- With edge chamfer 45° for a maximum tool life

Material	Steel	Stainless	Cast iron (gray, ductile, malleable)	Special and titanium alloys
Tensile strength/Hardness	< 850 N/mm ²	< 700 N/mm ²	> 260 HB	< 1200 N/mm ²
V _c (m/min) Finishing	200	70	110	50
V _c (m/min) Roughing	180	50	90	40