

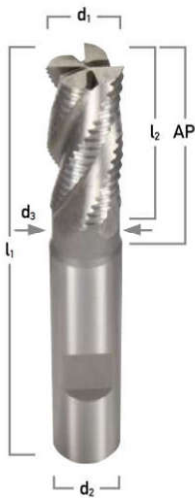


# AG 632-2

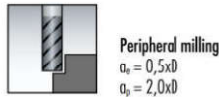


DIN 844

## HSS Roughing End Mill



d <sub>1</sub>	d <sub>2</sub>	l <sub>2</sub>	AP	l <sub>1</sub>	d <sub>3</sub>	Z	Uncoated Part No.	Coated Part No.	f <sub>r</sub> Roughing mm/Z	f <sub>f</sub> Finishing mm/Z
6,0	6	13	21	57	5,5	3	AG632206	AG632206A	0,008 – 0,015	0,006 – 0,013
8,0	10	19	–	63	–	3	AG632208	AG632208A	0,012 – 0,021	0,010 – 0,019



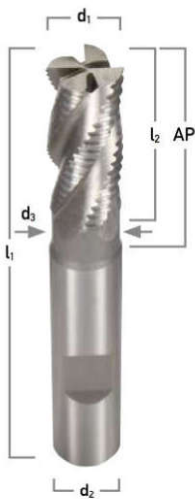
d <sub>1</sub>	d <sub>2</sub>
js14	h6

# AG 642-2



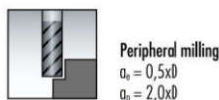
DIN 844

## HSS Roughing End Mill



d <sub>1</sub>	d <sub>2</sub>	l <sub>2</sub>	AP	l <sub>1</sub>	d <sub>3</sub>	Z	Uncoated Part No.	Coated Part No.	f <sub>r</sub> Roughing mm/Z	f <sub>f</sub> Finishing mm/Z
4,0	6	11	–	55	–	4	AG642204	AG642204A	0,005 – 0,010	0,003 – 0,008
5,0	6	13	–	57	–	4	AG642205	AG642205A	0,007 – 0,012	0,005 – 0,010
6,0	6	13	21	57	5,5	4	AG642206	AG642206A	0,008 – 0,015	0,006 – 0,013
7,0	8	16	–	60	–	4	AG642207	AG642207A	0,010 – 0,018	0,008 – 0,016
8,0	8	19	33	69	7,5	4	AG642208	AG642208A	0,012 – 0,021	0,010 – 0,019
9,0	10	19	–	69	–	4	AG642209	AG642209A	0,014 – 0,025	0,012 – 0,022
10,0	10	22	32	72	9,0	4	AG642210	AG642210A	0,015 – 0,027	0,013 – 0,025
11,0	12	22	–	79	–	4	AG642211	AG642211A	0,018 – 0,032	0,016 – 0,030
12,0	12	26	38	83	11,0	4	AG642212	AG642212A	0,020 – 0,036	0,018 – 0,034
13,0	12	26	–	83	–	4	AG642213	AG642213A	0,022 – 0,040	0,020 – 0,038
14,0	12	26	–	83	–	4	AG642214	AG642214A	0,020 – 0,036	0,018 – 0,034
15,0	16	32	–	92	–	4	AG642215	AG642215A	0,021 – 0,038	0,019 – 0,036
16,0	16	32	44	92	15,0	4	AG642216	AG642216A	0,022 – 0,040	0,020 – 0,038
17,0	16	32	–	92	–	4	AG642217	AG642217A	0,023 – 0,043	0,021 – 0,041
18,0	16	32	–	92	–	4	AG642218	AG642218A	0,023 – 0,043	0,021 – 0,041
19,0	20	38	–	104	–	4	AG642219	AG642219A	0,025 – 0,047	0,023 – 0,045
20,0	20	38	54	104	19,0	4	AG642220	AG642220A	0,025 – 0,047	0,023 – 0,045
22,0	20	38	–	104	–	4	AG642222	AG642222A	0,027 – 0,051	0,025 – 0,049

d <sub>1</sub>	d <sub>2</sub>
js14	h6



Material	Steel	Stainless	Cast	Alu
Tensile strength/ Hardness	< 850 N/mm <sup>2</sup>	< 850 N/mm <sup>2</sup>	< 800 N/mm <sup>2</sup>	< 600 N/mm <sup>2</sup>
V <sub>f</sub> (m/min) Finishing	75	60	70	135
V <sub>r</sub> (m/min) Roughing	55	40	50	115