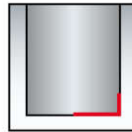




10409

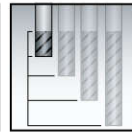


TiAlN

Z 4

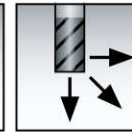
HB

30°



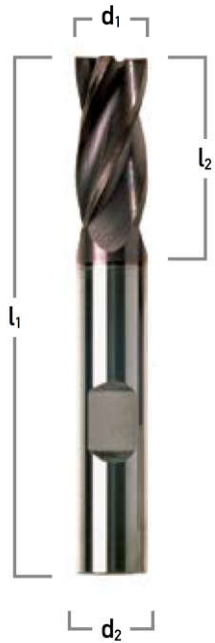
VHM

Type N

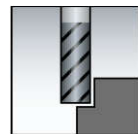


Manufacturer standard

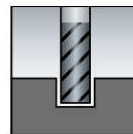
Solid Carbide End Mill



d ₁ mm	d ₂ mm	l ₂ mm	l ₁ mm	Z	Coated Part No.	f _z Roughing mm/Z	f _z Finishing mm/Z
1,0	6	5	50	4	10409010	0,003 – 0,010	0,002 – 0,005
2,0	6	7	50	4	10409020	0,004 – 0,014	0,003 – 0,010
3,0	6	8	50	4	10409030	0,003 – 0,010	0,002 – 0,005
4,0	6	11	50	4	10409040	0,005 – 0,019	0,003 – 0,010
5,0	6	13	50	4	10409050	0,006 – 0,020	0,005 – 0,015
6,0	6	16	50	4	10409060	0,008 – 0,025	0,006 – 0,020
8,0	8	20	60	4	10409080	0,012 – 0,032	0,010 – 0,025
10,0	10	22	70	4	10409100	0,015 – 0,039	0,013 – 0,030
12,0	12	22	70	4	10409120	0,018 – 0,048	0,015 – 0,040
16,0	16	25	75	4	10409160	0,023 – 0,058	0,021 – 0,050
20,0	20	32	100	4	10409200	0,028 – 0,073	0,025 – 0,060



Peripheral milling
 $a_e = 0,25xD$
 $a_p = 2,0xD$



Full slot milling
 $a_p = 1,0xD$

d ₁	d ₂
h10	h6

Material	Steel	Stainless	Cast	Alu	Titanium
Tensile strength/Hardness	< 1200 N/mm ²	< 850 N/mm ²	< 800 N/mm ²	< 600 N/mm ²	< 850 N/mm ²
V _c (m/min) Finishing	100	65	125	220	70
V _c (m/min) Roughing	85	45	105	200	50