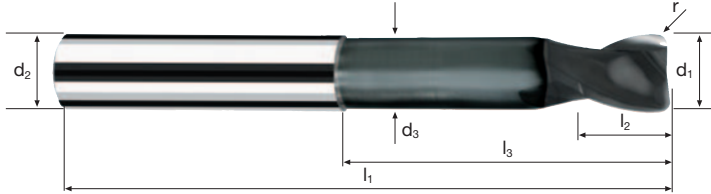


Corner radius end mills

Tolerance r 0/+0.03



HM	λ 30°
XA	γ 15°

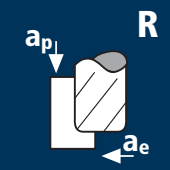

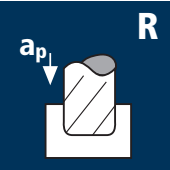



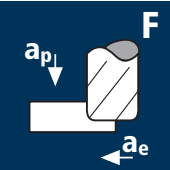



		C Graphite				CF/GF Fiber Reinforced Plastics
--	--	----------------------	--	--	--	---

IV

Example: Order-N°.		Coating	Article-N°.	ø-Code					DIAMANT		
		B	5630	.300					B5630		
ø Code	d1 e8	d2 h6	d3	l1	l2	l3	r 0/+0.03	z			
.300	6	6	5.5	70	7	33	1.0	2	●		
.391	8	8	7.4	80	9	43	1.0	2	●		
.450	10	10	9.2	84	11	43	1.5	2	●		
.501	12	12	11.0	97	13	51	1.5	2	●		

d1	Tolerance e8		Diameter		D
	Minimum	Maximum	Minimum	Maximum	
6	-0.038	-0.020	5.962	5.980	5.971
8	-0.047	-0.025	7.953	7.975	7.964
10			9.953	9.975	9.964
12	-0.059	-0.032	11.941	11.968	11.955

Application	Material	d1 [mm]	z	f _z [mm]	a _p [mm]	a _e [mm]	n=10000 min ⁻¹ vf [mm/min]	n=15000 min ⁻¹ vf [mm/min]	n=20000 min ⁻¹ vf [mm/min]	n=30000 min ⁻¹ vf [mm/min]
	Graphite 	6	2	0.071	4.80	2.40	1420	2130	2840	4260
		8	2	0.094	6.40	3.20	1880	2820	3760	5640
		10	2	0.118	8.00	4.00	2360	3540	4720	7080
		12	2	0.141	9.60	4.80	2820	4230	5640	8460
	Graphite 	6	2	0.055	3.0	6.0	1100	1650	2200	3300
		8	2	0.073	4.0	8.0	1460	2190	2920	4380
		10	2	0.091	5.0	10.0	1820	2730	3640	5460
		12	2	0.109	6.0	12.0	2180	3270	4360	6540

Application	Material	d1 [mm]	z	f _z [mm]	a _p [mm]	a _e [mm]	n=10000 min ⁻¹ vf [mm/min]	n=15000 min ⁻¹ vf [mm/min]	n=20000 min ⁻¹ vf [mm/min]	n=30000 min ⁻¹ vf [mm/min]
	Graphite 	6	2	0.080	0.60	2.70	1600	2400	3200	4800
		8	2	0.107	0.80	3.60	2140	3210	4280	6420
		10	2	0.133	1.00	4.50	2660	3990	5320	7980
		12	2	0.160	1.20	5.40	3200	4800	6400	9600
	Graphite 	6	2	0.080	1.08	1.08	1600	2400	3200	4800
		8	2	0.107	1.44	1.44	2140	3210	4280	6420
		10	2	0.133	1.80	1.80	2660	3990	5320	7980
		12	2	0.160	2.16	2.16	3200	4800	6400	9600