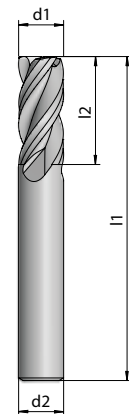
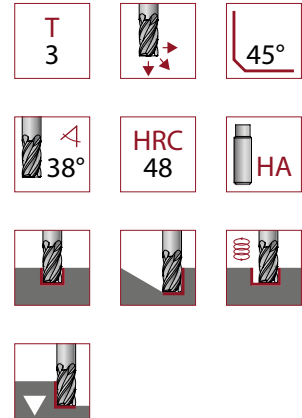


# SHANK END MILLS

## POWERLINE | S 1005

Short version				
Article no.	d1	d2	l1	l2
10050300	3	6	57	7
10050400	4	6	57	8
10050500	5	6	57	10
10050600	6	6	57	10
10050800	8	8	63	16
10051000	10	10	72	19
10051200	12	12	83	22
10051600	16	16	92	30
10051800	18	18	104	34
10052000	20	20	104	38



Shoulder milling	$a_p \times a_e = 1d \times 0,3d$
Slot milling	$a_p \times a_e = 1d \times 1d$



Cutting data for short version		Shoulder	Slot	
Material	N/mm <sup>2</sup>	v <sub>c</sub> m/min		
<b>P</b>	Gen. structural/ case hard. steels 1.0037   1.0570   1.0503   1.7131	< 800	150	100
	Tool/ tempering steels 1.2367   1.2379   1.7225	< 1100	100	70
	Alloyed/ cold work steels 1.2312   1.2767   1.3505   1.7707	< 1400	75	50
<b>M</b>	Stainless steels 1.4301   1.4305   1.4034	< 750	60	–
<b>N</b>	Aluminum Si content 0,5–9% 3.1645   3.2163	–	350	300
	Aluminum Si content 10–15% 3.2523	–	300	260
	Copper/ brass/ bronze 2.0321   2.1030	–	230	150
	Medium hard/ soft plastics	–	200–300	180–250

d1	Shoulder	Slot
	fz mm	
3	0,025	0,010
4	0,035	0,020
5	0,040	0,025
6	0,050	0,030
8	0,060	0,035
10	0,070	0,040
12	0,100	0,045
16	0,120	0,055
18	0,130	0,070
20	0,150	0,090