

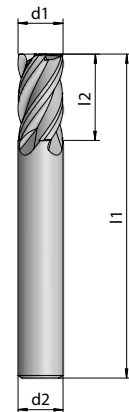
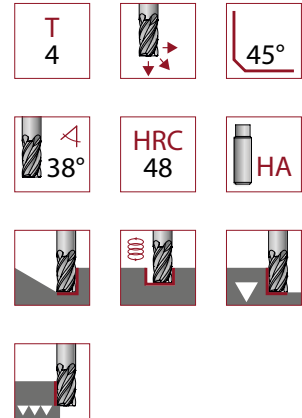
SHANK END MILLS

POWERLINE | S 1020

Short version				
Article no.	d1	d2	l1	l2
10200300	3	6	57	8
10200400	4	6	57	11
10200500	5	6	57	13
10200600	6	6	57	13
10200800	8	8	63	19
10201000	10	10	72	22
10201200	12	12	83	26
10201400	14	14	83	26
10201600	16	16	92	32
10201800	18	18	104	34
10202000	20	20	104	38
10202500	25	25	125	48

Medium version				
Article no.	d1	d2	l1	l2
10201001	10	10	98	40
10201201	12	12	104	48
10201601	16	16	104	48
10201801	18	18	140	72
10202001	20	20	145	80
10202501	25	25	152	75

Long version				
Article no.	d1	d2	l1	l2
10201802	18	18	175	108
10202002	20	20	188	120
10202502	25	25	178	100
10202503	25	25	202	125
10202504	25	25	228	150



Shoulder milling	$a_p \times a_e = 1d \times 0,3d$
Slot milling	$a_p \times a_e = 0,65d \times 1d$



Cutting data for short version		Shoulder	Slot	
Material	N/mm ²	v _c m/min		
P	Gen. structural/ case hard. steels 1.0037 1.0570 1.0503 1.7131	< 800	170	120
	Tool/ tempering steels 1.2367 1.2379 1.7225	< 1100	130	90
	Alloyed/ cold work steels 1.2312 1.2767 1.3505 1.7707	< 1400	90	–
M	Stainless steels 1.4301 1.4305 1.4034	< 750	100	–
N	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	0,007
4	0,035	0,010
5	0,040	0,015
6	0,050	0,025
8	0,060	0,030
10	0,070	0,040
12	0,100	0,060
14	0,110	0,070
16	0,120	0,090
18	0,130	0,100
20	0,150	0,110
25	0,160	0,110