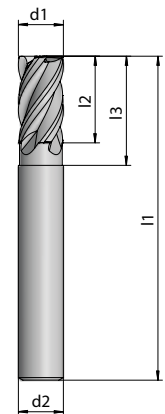
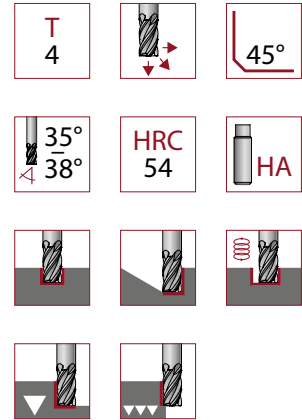


SHANK END MILLS

UNIVERSAL | S 1025

Short version					
Article no.	d1	d2	l1	l2	l3
10250400	4	6	57	11	19
10250500	5	6	57	13	21
10250600	6	6	57	13	21
10250800	8	8	63	19	27
10251000	10	10	72	24	32
10251200	12	12	83	28	36
10251400	14	14	83	29	37
10251600	16	16	92	35	43
10252000	20	20	104	44	54
10252500	25	25	125	52	65



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	210	150
	Tool/ tempering steels 1.2367 1.2379 1.7225	< 1100	160	100
	Alloyed/ cold work steels 1.2312 1.2767 1.3505 1.7707	< 1400	100	–
M	Stainless steels 1.4301 1.4305 1.4034	< 750	120	–
	Stainless steels 1.4435 1.4571	< 850	90	–
K	Cast iron GG25 GG40 GGG40	< 450	200	130
	Spherical cast iron GGG50 GGG60 GGG70	< 650	150	100
N	Copper/ brass/ bronze 2.0321 2.1030	–	230	150
	Medium hard/ soft plastics	–	200–300	180–250

d1	Shoulder	Slot
	fz mm	
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
20	0,150	0,100
25	0,160	0,110