

SHANK END MILLS

POWERLINE FINISHING END MILLS | S 1040

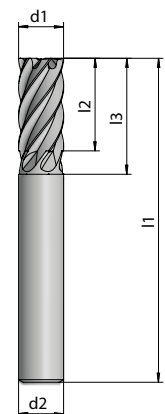
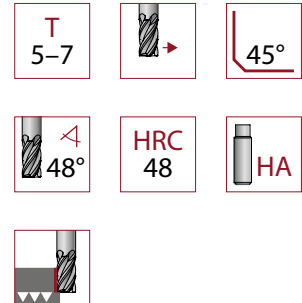


Short version Number of teeth 5					
Article no.	d1	d2	l1	l2	l3
10400601	6	6	56	12	20
10400801	8	8	62	16	26
10401001	10	10	85	20	40
10401201	12	12	86	24	40

Long version Number of teeth 5					
Article no.	d1	d2	l1	l2	l3
10400600	6	6	62	18	26
10400800	8	8	70	24	34
10401000	10	10	98	30	50
10401200	12	12	98	36	52

Short version Number of teeth 7					
Article no.	d1	d2	l1	l2	l3
10401601	16	16	86	32	38
10401801	18	18	90	36	42
10402001	20	20	98	40	48
10402501	25	25	117	50	61

Long version Number of teeth 7					
Article no.	d1	d2	l1	l2	l3
10401600	16	16	102	48	54
10401800	18	18	108	54	60
10402000	20	20	118	60	68
10402500	25	25	142	75	86



Shoulder milling $a_p \times a_e = 2,5d \times 0,04d$



Cutting data for short version		Shoulder	
Material	N/mm ²	v _c m/min	
P Gen. structural/ case hard. steels 1.0037 1.0570 1.0503 1.7131 Tool/ tempering steels 1.2367 1.2379 1.7225 Alloyed/ cold work steels 1.2312 1.2767 1.3505 1.7707	< 800	150	
	< 1100	110	
	< 1400	70	
M Stainless steels 1.4301 1.4305 1.4034	< 750	70	
N Copper/ brass/ bronze 2.0321 2.1030 Medium hard/ soft plastics	-	230	
	-	200-300	

Shoulder	
d1	fz mm
6	0,020
8	0,025
10	0,030
12	0,040
16	0,055
18	0,065
20	0,075
25	0,080