

RADIUS END MILLS

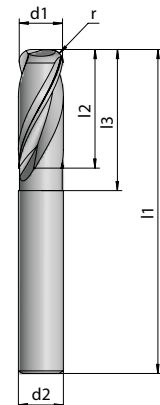
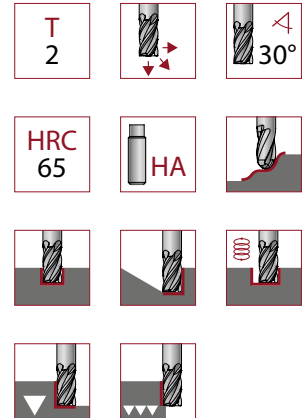
HPC | T 1120 | T 1121

Short version Corner radius 0,5 mm					
Article no.	d1	d2	l1	l2	l3
11200301	3	4	50	6	12
11200401	4	4	50	8	14
11200501	5	5	60	10	16
11200601	6	6	60	12	20
11200801	8	8	70	16	30
11201001	10	10	70	20	30
11201201	12	12	90	24	40

Long version Corner radius 0,5 mm					
Article no.	d1	d2	l1	l2	l3
11210301	3	4	80	6	12
11210401	4	4	80	8	14
11210501	5	5	80	10	16
11210601	6	6	100	12	20
11210801	8	8	100	16	30
11211001	10	10	100	20	30
11211201	12	12	120	24	40

Short version Corner radius 1 mm					
Article no.	d1	d2	l1	l2	l3
11200300	3	4	50	6	12
11200400	4	4	50	8	14
11200500	5	5	60	10	16
11200600	6	6	60	12	20
11200800	8	8	70	16	30
11201000	10	10	70	20	30
11201200	12	12	90	24	40

Long version Corner radius 1 mm					
Article no.	d1	d2	l1	l2	l3
11210300	3	4	80	6	12
11210400	4	4	80	8	14
11210500	5	5	80	10	16
11210600	6	6	100	12	20
11210800	8	8	100	16	30
11211000	10	10	100	20	30
11211200	12	12	120	24	40



Shoulder milling $a_p \times a_e = 1d \times 0,4d$
 Slot milling $a_p \times a_e = 1d \times 1d$



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 Tool/ tempering steels 1.2367 1.2379 1.7225 Alloyed/ cold work steels 1.2312 1.2767 1.3505 1.7707	< 800	300	150
	< 1100	230	100
	< 1400	180	-
M Stainless steels 1.4301 1.4305 1.4034 Stainless steels 1.4435 1.4571	< 750	120	-
	< 850	90	-
K Cast iron GG25 GG40 GGG40 Spherical cast iron GGG50 GGG60 GGG70	< 450	220	130
	< 650	160	100
H Hardened steel HRC 45-50 Hardened steel HRC 51-58 Hardened steel HRC 59-65	-	250	-
	-	210	-
	-	170	-

d1	Shoulder	Slot
	fz mm	
3	0,022	0,010
4	0,030	0,012
5	0,040	0,020
6	0,060	0,025
8	0,070	0,040
10	0,090	0,055
12	0,110	0,070