

# RADIUS END MILLS

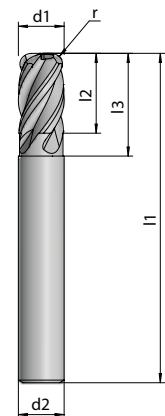
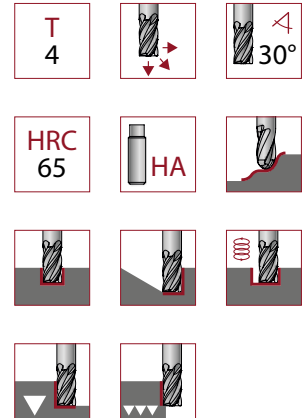
## HPC | T 1160 | T 1161

Short version   Corner radius 0,5 mm					
Article no.	d1	d2	l1	l2	l3
11600300	3	6	58	3	9
11600400	4	6	58	4	12
11600500	5	6	58	5	15
11600600	6	6	58	6	18
11600800	8	8	64	8	24
11601000	10	10	73	10	30
11601200	12	12	84	12	36

Short version   Corner radius 1 mm					
Article no.	d1	d2	l1	l2	l3
11600401	4	6	58	4	12
11600501	5	6	58	5	15
11600601	6	6	58	6	18
11600801	8	8	64	8	24
11601001	10	10	73	10	30
11601201	12	12	84	12	36

Long version   Corner radius 0,5 mm					
Article no.	d1	d2	l1	l2	l3
11610600	6	6	74	6	18
11610800	8	8	78	8	24
11611000	10	10	98	10	30
11611200	12	12	108	12	36

Long version   Corner radius 1 mm					
Article no.	d1	d2	l1	l2	l3
11610601	6	6	74	6	18
11610801	8	8	78	8	24
11611001	10	10	98	10	30
11611201	12	12	108	12	36



Shoulder milling	$a_p \times a_e = 1d \times 0,4d$
Slot milling	$a_p \times a_e = 0,65d \times 1d$



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

d1	Shoulder	Slot
	fz mm	
3	0,022	0,007
4	0,030	0,010
5	0,040	0,015
6	0,060	0,025
8	0,070	0,030
10	0,090	0,040
12	0,110	0,060

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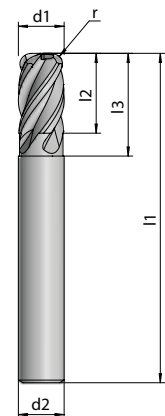
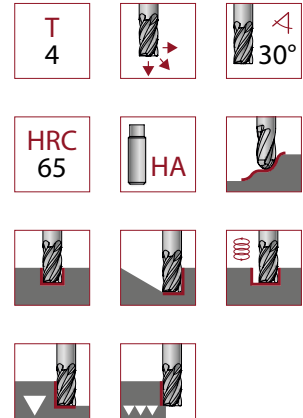
## HPC | T 1160 | T 1161

Short version   Corner radius 1,5 mm					
Article no.	d1	d2	l1	l2	l3
11600402	4	6	58	4	12
11600502	5	6	58	5	15
11600602	6	6	58	6	18
11600802	8	8	64	8	24
11601002	10	10	73	10	30
11601202	12	12	84	12	36

Short version   Corner radius 2 mm					
Article no.	d1	d2	l1	l2	l3
11600503	5	6	58	5	15
11600603	6	6	58	6	18
11600803	8	8	64	8	24
11601003	10	10	73	10	30
11601203	12	12	84	12	36

Long version   Corner radius 1,5 mm					
Article no.	d1	d2	l1	l2	l3
11610602	6	6	74	6	18
11610802	8	8	78	8	24
11611002	10	10	98	10	30
11611202	12	12	108	12	36

Long version   Corner radius 2 mm					
Article no.	d1	d2	l1	l2	l3
11610603	6	6	74	6	18
11610803	8	8	78	8	24
11611003	10	10	98	10	30
11611203	12	12	108	12	36



Shoulder milling	$a_p \times a_e = 1d \times 0,4d$
Slot milling	$a_p \times a_e = 0,65d \times 1d$



Cutting data for short version		Shoulder	Slot
Material	N/mm <sup>2</sup>	v <sub>c</sub> m/min	
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	< 1100	230	100
	< 1400	180	-
<b>M</b> Stainless steels 1.4301   1.4305   1.4034	< 750	120	-
<b>K</b> Cast iron GGG25   GGG40   GGG40 Spherical cast iron GGG50   GGG60   GGG70	< 450	220	130
	< 650	160	100
<b>H</b> Hardened steel HRC 45-50 Hardened steel HRC 51-58 Hardened steel HRC 59-65	-	250	-
	-	210	-
	-	170	-

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	fz mm	
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10	0,090	0,040
12	0,110	0,060