

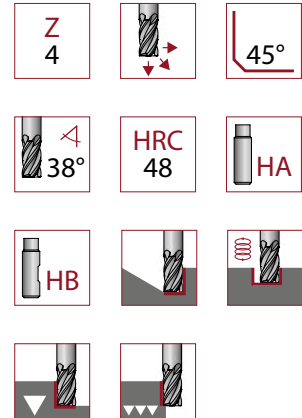
SHANK END MILLS

S 1020

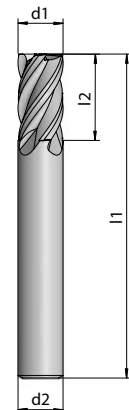
Short version					
Article no.	d1	d2	l1	l2	Euro
10200300	3	6	57	8	21,00
10200400	4	6	57	11	20,00
10200500	5	6	57	13	20,00
10200600	6	6	57	13	20,00
10200800	8	8	63	19	28,00
10201000	10	10	72	22	36,00
10201200	12	12	83	26	56,00
10201400	14	14	83	26	83,00
10201600	16	16	92	32	102,00
10201800	18	18	104	34	129,00
10202000	20	20	104	38	136,00
10202500	25	25	125	48	269,00

Medium version					
Article no.	d1	d2	l1	l2	Euro
10201001	10	10	98	40	52,00
10201201	12	12	104	48	74,00
10201601	16	16	104	48	115,00
10201801	18	18	140	72	164,00
10202001	20	20	145	80	182,00
10202501	25	25	152	75	322,00

Long version					
Article no.	d1	d2	l1	l2	Euro
10201802	18	18	175	108	204,00
10202002	20	20	188	120	224,00
10202502	25	25	178	100	382,00
10202503	25	25	202	125	449,00
10202504	25	25	228	150	507,00



For Weldon add abbreviation HB.
 Example 10200300 becomes 10200300HB



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 Tool/ tempering steels 1.2367 1.2379 1.7225	< 800	130	100
	< 1100	110	80
M Stainless steels 1.4301 1.4305 1.4034	< 750	80	-
K Cast iron GG25 GG40 GGG40 Spherical cast iron GGG50 GGG60 GGG70	< 450	160	130
	< 650	120	100
N Copper/ brass/ bronze 2.0321 2.1030 Medium hard/ soft plastics	-	230	150
	-	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	0.055	0.030
10	0.055	0.040
12	0.060	0.050
14	0.060	0.050
16	0.070	0.060
18	0.080	0.070
20	0.080	0.070
25	0.100	0.080