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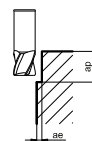
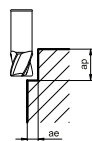
Corner Radius
Endmill

Short Series

S	Order No	Code	d1h9	d2h6	d3	l1	l2	l3	Corner
	20100	114.4.0200.0500.R0050.0020.0190.0120.00.S04G1A01.01	2	4	1,9	50	2	12	R 0.50
	20102	114.4.0300.0500.R0020.0030.0280.0160.00.S04G1A01.01	3	4	2,8	50	3	16	R 0.20
*	20104	114.4.0200.0570.R0050.0020.0190.0120.00.S06G1A01.01	2	6	1,9	57	2	12	R 0.50
*	20106	114.4.0300.0570.R0050.0030.0280.0160.00.S06G1A01.01	3	6	2,8	57	3	16	R 0.50
*	20108	114.4.0300.0510.R0050.0030.0280.0160.00.S03G1A01.01	3	3	2,8	51	3	16	R 0.50
*	20110	114.4.0400.0570.R0050.0040.0380.0200.00.S06G1A01.01	4	6	3,8	57	4	20	R 0.50
*	20112	114.4.0400.0570.R0100.0040.0380.0200.00.S06G1A01.01	4	6	3,8	57	4	20	R 1.00
*	20114	114.4.0400.0500.R0050.0040.0380.0200.00.S04G1A01.01	4	4	3,8	50	4	20	R 0.50
*	20116	114.4.0400.0500.R0100.0040.0380.0200.00.S04G1A01.01	4	4	3,8	50	4	20	R 1.00
*	20118	114.4.0500.0570.R0050.0050.0480.0170.00.S06G1A01.01	5	6	4,8	57	5	17	R 0.50
*	20120	114.4.0500.0570.R0100.0050.0480.0170.00.S06G1A01.01	5	6	4,8	57	5	17	R 1.00
	20122	114.4.0500.0570.R0150.0050.0480.0170.00.S06G1A01.01	5	6	4,8	57	5	17	R 1.50
*	20124	114.4.0600.0570.R0050.0060.0580.0220.00.S06G1A01.01	6	6	5,8	57	6	22	R 0.50
*	20126	114.4.0600.0570.R0100.0060.0580.0220.00.S06G1A01.01	6	6	5,8	57	6	22	R 1.00
*	20128	114.4.0600.0570.R0150.0060.0580.0220.00.S06G1A01.01	6	6	5,8	57	6	22	R 1.50
*	20130	114.4.0800.0630.R0050.0080.0770.0240.00.S08G1A01.01	8	8	7,7	63	8	24	R 0.50
*	20132	114.4.0800.0630.R0100.0080.0770.0240.00.S08G1A01.01	8	8	7,7	63	8	24	R 1.00
	20134	114.4.0800.0630.R0150.0080.0770.0240.00.S08G1A01.01	8	8	7,7	63	8	24	R 1.50
*	20136	114.4.1000.0720.R0050.0100.0970.0310.00.S10G1A01.01	10	10	9,7	72	10	31	R 0.50
*	20138	114.4.1000.0720.R0100.0100.0970.0310.00.S10G1A01.01	10	10	9,7	72	10	31	R 1.00
	20140	114.4.1000.0720.R0150.0100.0970.0310.00.S10G1A01.01	10	10	9,7	72	10	31	R 1.50
*	20142	114.4.1200.0830.R0050.0120.1170.0350.00.S12G1A01.01	12	12	11,7	83	12	35	R 0.50
*	20144	114.4.1200.0830.R0100.0120.1170.0350.00.S12G1A01.01	12	12	11,7	83	12	35	R 1.00
	20146	114.4.1200.0830.R0150.0120.1170.0350.00.S12G1A01.01	12	12	11,7	83	12	35	R 1.50
	20148	114.4.1200.0830.R0200.0120.1170.0350.00.S12G1A01.01	12	12	11,7	83	12	35	R 2.00
	20150	114.4.1400.0820.R0100.0140.1370.0350.00.S14G1A01.01	14	14	13,7	82	14	35	R 1.00
	20152	114.4.1600.0920.R0050.0160.1550.0420.00.S16G1A01.01	16	16	15,5	92	16	42	R 0.50
	20154	114.4.1600.0920.R0100.0160.1550.0420.00.S16G1A01.01	16	16	15,5	92	16	42	R 1.00
	20156	114.4.1600.0920.R0150.0160.1550.0420.00.S16G1A01.01	16	16	15,5	92	16	42	R 1.50
	20158	114.4.1600.0920.R0200.0160.1550.0420.00.S16G1A01.01	16	16	15,5	92	16	42	R 2.00
	20160	114.4.1600.0920.R0300.0160.1550.0420.00.S16G1A01.01	16	16	15,5	92	16	42	R 3.00

Cutting Parameters

Material	Shoulder Milling ap=0.100 / ae=0.025 - 0.010	Finish Milling ap=0.100 / ae=0.010
	Vc (m/min)	Vc (m/min)



Steel	Cold Work Tool Steel	110-150	150-180
	Hot Work Tool Steel	100-140	140-170
	Gray Cast Iron	70-100	100-130
	Alloyed Cast Iron	70-100	100-130
	Precision Cast Iron	65-90	90-120
	≤ 54 HRC	65-90	90-120
Cast Iron	>54 HRC	60-80	80-110
Hardened Steel			

Feed Per Tooth (mm/tooth)

Ø	ae=0.0250	ae=0.020	ae=0.0150	ae=0.010
4	0.031	0.034	0.037	0.040
6	0.031	0.034	0.037	0.041
8	0.038	0.042	0.047	0.053
10	0.049	0.052	0.056	0.061
12	0.052	0.056	0.062	0.068
16	0.063	0.068	0.076	0.082

Z4



≤ 62 HRC

+AlCrN

FORM HA DIN 6535



Steel	●
Stainless Steel	○
Hardened Steel ≤54 HRC	●
Hardened Steel >54 HRC	●
Cast Iron	●
Graphite	○
Non Ferrous Material	○
HRSA	○
Titanium	○

● Recommended ○ Acceptable ○ Not Recommended