



150

Micro Sharpen-Edge
Endmill

S	Order No	Code	d1h9	d2h5	d3	l1	l2	l3	Corner
	24100	150.2.0040.0510.K0000.0010.0000.0000.00.S04H1A04.01	0,4	4	-	51	1	-	Ch 0.00
*	24102	150.2.0050.0510.K0000.0005.0047.0020.00.S04H1A04.01	0,5	4	0,47	51	0,5	2	Ch 0.00
*	24104	150.2.0050.0510.K0000.0005.0047.0030.00.S04H1A04.01	0,5	4	0,47	51	0,5	3	Ch 0.00
*	24106	150.2.0050.0510.K0000.0005.0047.0040.00.S04H1A04.01	0,5	4	0,47	51	0,5	4	Ch 0.00
	24108	150.2.0060.0510.K0000.0006.0055.0020.00.S04H1A04.01	0,6	4	0,55	51	0,6	2	Ch 0.00
	24110	150.2.0060.0510.K0000.0006.0055.0040.00.S04H1A04.01	0,6	4	0,55	51	0,6	4	Ch 0.00
	24112	150.2.0060.0510.K0000.0006.0055.0060.00.S04H1A04.01	0,6	4	0,55	51	0,6	6	Ch 0.00
	24114	150.2.0100.0510.K0000.0010.0094.0028.00.S04H1A04.01	1	4	0,94	51	1	2,8	Ch 0.00
*	24116	150.2.0100.0510.K0000.0010.0094.0040.00.S04H1A04.01	1	4	0,94	51	1	4	Ch 0.00
*	24118	150.2.0100.0510.K0000.0010.0094.0060.00.S04H1A04.01	1	4	0,94	51	1	6	Ch 0.00
*	24120	150.2.0100.0510.K0000.0010.0094.0080.00.S04H1A04.01	1	4	0,94	51	1	8	Ch 0.00
*	24122	150.2.0100.0510.K0000.0010.0094.0100.00.S04H1A04.01	1	4	0,94	51	1	10	Ch 0.00
*	24124	150.2.0100.0510.K0000.0010.0094.0120.00.S04H1A04.01	1	4	0,94	51	1	12	Ch 0.00
	24126	150.2.0100.0510.K0000.0010.0094.0140.00.S04H1A04.01	1	4	0,94	51	1	14	Ch 0.00
*	24128	150.2.0100.0510.K0000.0010.0094.0160.00.S04H1A04.01	1	4	0,94	51	1	16	Ch 0.00
*	24130	150.2.0150.0510.K0000.0015.0140.0040.00.S04H1A04.01	1,5	4	1,4	51	1,5	4	Ch 0.00
*	24132	150.2.0150.0510.K0000.0015.0140.0060.00.S04H1A04.01	1,5	4	1,4	51	1,5	6	Ch 0.00
*	24134	150.2.0150.0510.K0000.0015.0140.0080.00.S04H1A04.01	1,5	4	1,4	51	1,5	8	Ch 0.00
*	24136	150.2.0150.0510.K0000.0015.0140.0100.00.S04H1A04.01	1,5	4	1,4	51	1,5	10	Ch 0.00
*	24138	150.2.0150.0510.K0000.0015.0140.0120.00.S04H1A04.01	1,5	4	1,4	51	1,5	12	Ch 0.00
	24140	150.2.0150.0510.K0000.0015.0140.0140.00.S04H1A04.01	1,5	4	1,4	51	1,5	14	Ch 0.00
*	24142	150.2.0150.0510.K0000.0015.0140.0160.00.S04H1A04.01	1,5	4	1,4	51	1,5	16	Ch 0.00
*	24144	150.2.0200.0510.K0000.0020.0190.0040.00.S04H1A04.01	2	4	1,9	51	2	4	Ch 0.00
*	24146	150.2.0200.0510.K0000.0020.0190.0060.00.S04H1A04.01	2	4	1,9	51	2	6	Ch 0.00
*	24148	150.2.0200.0510.K0000.0020.0190.0080.00.S04H1A04.01	2	4	1,9	51	2	8	Ch 0.00
*	24150	150.2.0200.0510.K0000.0020.0190.0100.00.S04H1A04.01	2	4	1,9	51	2	10	Ch 0.00
*	24152	150.2.0200.0510.K0000.0020.0190.0120.00.S04H1A04.01	2	4	1,9	51	2	12	Ch 0.00
*	24154	150.2.0200.0510.K0000.0020.0190.0160.00.S04H1A04.01	2	4	1,9	51	2	16	Ch 0.00
	24156	150.2.0200.0510.K0000.0020.0190.0200.00.S04H1A04.01	2	4	1,9	51	2	20	Ch 0.00
	24158	150.2.0200.0750.K0000.0060.0190.0400.00.S04H1A04.01	2	4	1,9	75	6	40	Ch 0.00
	24160	150.2.0250.0510.K0000.0025.0240.0060.00.S04H1A04.01	2,5	4	2,4	51	2,5	6	Ch 0.00
	24162	150.2.0250.0510.K0000.0025.0240.0080.00.S04H1A04.01	2,5	4	2,4	51	2,5	8	Ch 0.00
	24164	150.2.0250.0510.K0000.0025.0240.0100.00.S04H1A04.01	2,5	4	2,4	51	2,5	10	Ch 0.00
	24166	150.2.0250.0510.K0000.0025.0240.0120.00.S04H1A04.01	2,5	4	2,4	51	2,5	12	Ch 0.00
	24168	150.2.0250.0510.K0000.0025.0240.0200.00.S04H1A04.01	2,5	4	2,4	51	2,5	20	Ch 0.00
	24170	150.2.0250.0750.K0000.0060.0240.0500.00.S04H1A04.01	2,5	4	2,4	75	6	50	Ch 0.00

Makro Series

S	Order No	Code	d1h9	d2h5	d3	l1	l2	l3	Corner
	24172	150.2.0300.0580.K0000.0025.0290.0100.00.S06H1A04.01	3	6	2,9	58	2,5	10	Ch 0.00
	24174	150.2.0300.0580.K0000.0025.0290.0120.00.S06H1A04.01	3	6	2,9	58	2,5	12	Ch 0.00
	24176	150.2.0300.0580.K0000.0025.0290.0160.00.S06H1A04.01	3	6	2,9	58	2,5	16	Ch 0.00
	24178	150.2.0300.0750.K0000.0025.0290.0200.00.S06H1A04.01	3	6	2,9	75	2,5	20	Ch 0.00
	24180	150.2.0300.0750.K0000.0025.0290.0250.00.S06H1A04.01	3	6	2,9	75	2,5	25	Ch 0.00
	24182	150.2.0300.0750.K0000.0025.0290.0300.00.S06H1A04.01	3	6	2,9	75	2,5	30	Ch 0.00
	24184	150.2.0300.0750.K0000.0060.0290.0500.00.S04H1A04.01	3	4	2,9	75	6	50	Ch 0.00
	24186	150.2.0350.0510.K0000.0100.0340.0150.00.S04H1A04.01	3,5	4	3,4	51	10	15	Ch 0.00
	24188	150.2.0400.0580.K0000.0040.0390.0120.00.S06H1A04.01	4	6	3,9	58	4	12	Ch 0.00
	24190	150.2.0400.0580.K0000.0040.0390.0160.00.S06H1A04.01	4	6	3,9	58	4	16	Ch 0.00
	24192	150.2.0400.0750.K0000.0040.0390.0200.00.S06H1A04.01	4	6	3,9	75	4	20	Ch 0.00
	24194	150.2.0400.0750.K0000.0040.0390.0250.00.S06H1A04.01	4	6	3,9	75	4	25	Ch 0.00
	24196	150.2.0400.0750.K0000.0040.0390.0300.00.S06H1A04.01	4	6	3,9	75	4	30	Ch 0.00
	24198	150.2.0400.0750.K0000.0100.0390.0500.00.S04H1A04.01	4	4	3,9	75	10	50	Ch 0.00

Cutting Parameters

Material	Shoulder Milling ap=0.20 / ae=0.20 - 0.100	Slotting ap=0.10
	Vc (m/min)	Vc (m/min)
Unalloyed Steel	170-220	170-220
Steel	170-220	170-220
Tempered Steel	140-180	140-180
Cold Work Tool Steel	140-180	140-180
Hot Work Tool Steel	110-150	110-150
AISI 304 - 416 - 420	80-130	80-130
AISI 316 - 440	70-120	70-120
17-4 PH 15-5 PH	70-100	70-100
Cobalt-Chrome Alloys	60-100	60-10
Duplex F51	50-80	50-80
Super Duplex F55	50-80	50-80
Gray Cast Iron	110-150	110-150
Titanium	30-60	30-60
Titanium Alloys	30-60	30-60
≤ 54 HRC	100-140	100-140
>54 HRC	70-90	70-90

Feed Per Tooth (mm/tooth)

Ø	ae=0.200	ae=0.100	ae=0.200	ae=0.100
0,5	0,007	0,009	0,1	0,12
1	0,015	0,02	0,015	0,02
1,5	0,018	0,025	0,018	0,025
2	0,022	0,031	0,022	0,031
2,5	0,027	0,038	0,027	0,038
3	0,03	0,042	0,035	0,045
4	0,035	0,048	0,044	0,049



+0/-0,01

Z2



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

● Recommended ○ Acceptable ○ Not Recommended

*Marked products can be delivered
quickly from stock.