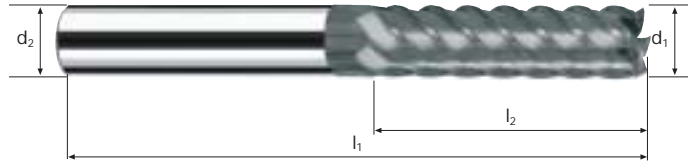


Square end mills Multicut N

Finishing, long length

HM
MG10 λ 45°
 γ 8°



Roughing

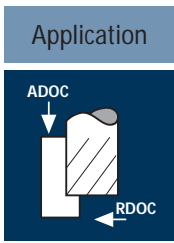


Finishing



HRC < 24	HRC 24-34	HRC 34-42					Inox Stainless	Ti Titanium	GG(G) Copper
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Order-N°	d1 e8	d2 h6	l1	l2	45°	fl	POLYCHROM
P5865530	1/2	1/2	4	2	0.006	6	●
P5865605	5/8	5/8	5	2 1/2	0.006	8	●
P5865652	3/4	3/4	5	2 1/2	0.006	10	●
P5865775	1	1	6	3	0.008	12	●



Material

Steel
up to 24 HRC

d1 [in]	fI	Speed [ft/min]	FPT [in]	ADOC [in]	RDOC [in]	RPM [min ⁻¹]	Feed [in/min]
1/2	6	425	0.0010	1.250	0.024	3245	19
5/8	8	425	0.0012	1.563	0.030	2595	25
3/4	10	425	0.0015	1.876	0.036	2165	32
1	12	425	0.0018	2.500	0.049	1625	35

Steel
24 - 34 HRC

1/2	6	295	0.0010	1.250	0.024	2255	14
5/8	8	295	0.0012	1.563	0.030	1805	17
3/4	10	295	0.0015	1.876	0.036	1500	23
1	12	295	0.0018	2.500	0.049	1125	24

Steel
34 - 42 HRC

1/2	6	195	0.0010	1.250	0.024	1490	9
5/8	8	195	0.0012	1.563	0.030	1190	11
3/4	10	195	0.0015	1.876	0.036	995	15
1	12	195	0.0018	2.500	0.049	745	16

Stainless steel
[Cr-Ni/304]

1/2	6	165	0.0010	1.250	0.024	1260	8
5/8	8	165	0.0012	1.563	0.030	1010	10
3/4	10	165	0.0015	1.876	0.036	840	13
1	12	165	0.0018	2.500	0.049	630	14

Material

Cast iron
(lamellar / spheroidal)

d1 [in]	fI	Speed [ft/min]	FPT [in]	ADOC [in]	RDOC [in]	RPM [min ⁻¹]	Feed [in/min]
1/2	6	330	0.0010	1.194	0.025	2520	15
5/8	8	330	0.0012	1.476	0.031	2015	19
3/4	10	330	0.0015	1.802	0.038	1680	25
1	12	330	0.0018	2.460	0.050	1260	27

Unalloyed copper

1/2	6	590	0.0010	1.194	0.004	4505	27
5/8	8	590	0.0012	1.476	0.004	3605	35
3/4	10	590	0.0015	1.802	0.004	3005	45
1	12	590	0.0018	2.460	0.004	2255	49