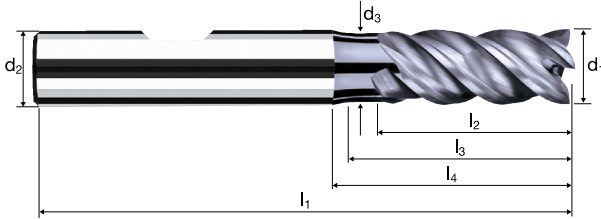
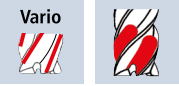
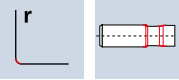


Cylindrical end mills NX-NVDS

Smooth-edged, normal version with short neck
High-performance penetration edge



HM
MG10 λ 45°
 γ -20°



Roughing HPC

Roughing HDC

Finishing



Rm
850-1100

Rm
1100-1300

Rm
1300-1500

HRC
48-56

HRC
56-60

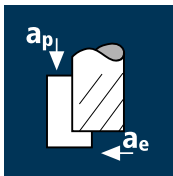
Ti
Titanium

GG(G)
Tool Steel

Ø Code	d ₁ e8	d ₂ h6	d ₃	l ₁	l ₂	l ₃	l ₄	r	α	z	POLYCHROM				
											Coating	Article-N°	ø-Code	POLYCHROM	
Example: Order-N°.											P	8600	220		
220	4.00	6.00	3.70	57	8.00	16.00	20.82	0.100	3.0°	4				●	
260	5.00	6.00	4.60	57	10.00	18.00	21.27	0.100	1.5°	4				●	
300	6.00	6.00	5.50	57	12.00	18.15	20.00	0.100	0.0°	4				●	
391	8.00	8.00	7.40	63	19.00	23.63	26.00	0.150	0.0°	4				●	
450	10.00	10.00	9.20	72	23.00	27.99	31.00	0.200	0.0°	4				●	
501	12.00	12.00	11.00	83	27.00	33.29	37.00	0.200	0.0°	4				●	
610	16.00	16.00	15.00	92	32.00	38.73	43.00	0.200	0.0°	4				●	
682	20.00	20.00	19.00	104	39.00	48.23	53.00	0.200	0.0°	4				●	

Application

Material

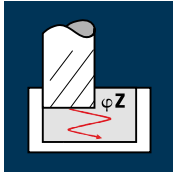


Steel
850 - 1100 N/mm²

P

P

d1 [mm]	z	v _c [m/min]	f _t [mm]	a _p [mm]	a _e [mm]	n [min ⁻¹]	v _r [mm/min]	Q [cm ³ /min]	q _Z [°]
4.00	4	150	0.030	6.000	1.600	11935	1430	13.8	20°
5.00	4	150	0.035	7.500	2.000	9550	1335	20.1	20°
6.00	4	150	0.040	9.000	2.400	7960	1275	27.5	20°
8.00	4	150	0.050	12.000	3.200	5970	1195	45.8	20°
10.00	4	150	0.065	15.000	4.000	4775	1240	74.5	20°
12.00	4	150	0.075	18.000	4.800	3980	1195	103.1	20°
16.00	4	150	0.085	24.000	6.400	2985	1015	155.8	20°
20.00	4	150	0.100	30.000	8.000	2385	955	229.2	20°



Steel
1100 - 1300 N/mm²

P

P

d1 [mm]	z	v _c [m/min]	f _t [mm]	a _p [mm]	a _e [mm]	n [min ⁻¹]	v _r [mm/min]	Q [cm ³ /min]	q _Z [°]
4.00	4	115	0.030	6.000	1.600	9150	1100	10.5	18°
5.00	4	115	0.035	7.500	2.000	7320	1025	15.4	18°
6.00	4	115	0.040	9.000	2.400	6100	975	21.1	18°
8.00	4	115	0.050	12.000	3.200	4575	915	35.1	18°
10.00	4	115	0.065	15.000	4.000	3660	950	57.1	18°
12.00	4	115	0.075	18.000	4.800	3050	915	79.1	18°
16.00	4	115	0.085	24.000	6.400	2290	780	119.5	18°
20.00	4	115	0.100	30.000	8.000	1830	730	175.7	18°

Hardened tool steel
52 - 56 HRC

P

P

d1 [mm]	z	v _c [m/min]	f _t [mm]	a _p [mm]	a _e [mm]	n [min ⁻¹]	v _r [mm/min]	Q [cm ³ /min]	q _Z [°]
4.00	4	50	0.015	6.000	1.600	3980	240	2.3	15°
5.00	4	50	0.020	7.500	2.000	3185	255	3.8	15°
6.00	4	50	0.025	9.000	2.400	2655	265	5.7	15°
8.00	4	50	0.030	12.000	3.200	1990	240	9.2	15°
10.00	4	50	0.035	15.000	4.000	1590	225	13.4	15°
12.00	4	50	0.045	18.000	4.800	1325	240	20.6	15°
16.00	4	50	0.055	24.000	6.400	995	220	33.6	15°
20.00	4	50	0.070	30.000	8.000	795	225	53.5	15°

Titanium alloys
> 300 HB
[Ti6Al4V]

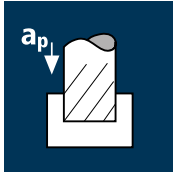
P

P

d1 [mm]	z	v _c [m/min]	f _t [mm]	a _p [mm]	a _e [mm]	n [min ⁻¹]	v _r [mm/min]	Q [cm ³ /min]	q _Z [°]
4.00	4	60	0.020	6.000	1.600	4775	380	3.7	12°
5.00	4	60	0.025	7.500	2.000	3820	380	5.7	12°
6.00	4	60	0.030	9.000	2.400	3185	380	8.3	12°
8.00	4	60	0.040	12.000	3.200	2385	380	14.7	12°
10.00	4	60	0.045	15.000	4.000	1910	345	20.6	12°
12.00	4	60	0.055	18.000	4.800	1590	350	30.3	12°
16.00	4	60	0.065	24.000	6.400	1195	310	47.7	12°
20.00	4	60	0.080	30.000	8.000	955	305	73.3	12°

Application

Material

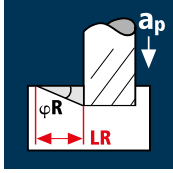


Steel
850 - 1100 N/mm²

P

P

d1 [mm]	z	v _c [m/min]	f _t [mm]	a _p [mm]	a _e [mm]	n [min ⁻¹]	v _r [mm/min]	Q [cm ³ /min]	q _R [°]	LR [mm]
4.00	4	120	0.025	5.000	4.000	9550	955	19.1	32°	8.0
5.00	4	120	0.025	6.250	5.000	7640	765	23.9	32°	10.0
6.00	4	120	0.030	7.500	6.000	6365	765	34.4	32°	12.0
8.00	4	120	0.040	10.000	8.000	4775	765	61.1	32°	16.0
10.00	4	120	0.050	12.500	10.000	3820	765	95.5	32°	20.0
12.00	4	120	0.055	15.000	12.000	3185	700	126.1	32°	24.0
16.00	4	120	0.065	20.000	16.000	2385	620	198.6	32°	32.0
20.00	4	120	0.075	25.000	20.000	1910	575	286.5	32°	40.0



Steel
1100 - 1300 N/mm²

P

P

d1 [mm]	z	v _c [m/min]	f _t [mm]	a _p [mm]	a _e [mm]	n [min ⁻¹]	v _r [mm/min]	Q [cm ³ /min]	q _R [°]	LR [mm]
4.00	4	90	0.025	5.000	4.000	7160	715	14.3	28°	9.4
5.00	4	90	0.025	6.250	5.000	5730	575	17.9	28°	11.8
6.00	4	90	0.030	7.500	6.000	4775	575	25.8	28°	14.1
8.00	4	90	0.040	10.000	8.000	3580	575	45.8	28°	18.8
10.00	4	90	0.050	12.500	10.000	2865	575	71.6	28°	23.5
12.00	4	90	0.055	15.000	12.000	2385	525	94.5	28°	28.2
16.00	4	90	0.065	20.000	16.000	1790	465	149.0	28°	37.6
20.00	4	90	0.075	25.000	20.000	1430	430	214.9	28°	47.0

Hardened tool steel
52 - 56 HRC

P

P

d1 [mm]	z	v _c [m/min]	f _t [mm]	a _p [mm]	a _e [mm]	n [min ⁻¹]	v _r [mm/min]	Q [cm ³ /min]	q _R [°]	LR [mm]
4.00	4	40	0.010	5.000	4.000	3185	125	2.5	24°	11.2
5.00	4	40	0.015	6.250	5.000	2545	155	4.8	24°	14.0
6.00	4	40	0.020	7.500	6.000	2120	170	7.6	24°	16.8
8.00	4	40	0.025	10.000	8.000	1590	160	12.7	24°	22.5
10.00	4	40	0.025	12.500	10.000	1275	125	15.9	24°	28.1
12.00	4	40	0.035	15.000	12.000	1060	150	26.7	24°	33.7
16.00	4	40	0.040	20.000	16.000	795	125	40.7	24°	44.9
20.00	4	40	0.055	25.000	20.000	635	140	70.0	24°	56.2

Titanium alloys
> 300 HB
[Ti6Al4V]

P

P

d1 [mm]	z	v _c [m/min]	f _t [mm]	a _p [mm]	a _e [mm]	n [min ⁻¹]	v _r [mm/min]	Q [cm ³ /min]	q _R [°]	LR [mm]
4.00	4	50	0.015	5.000	4.000	3980	240	4.8	19°	14.5
5.00	4	50	0.020	6.250	5.000	3185	255	8.0	19°	18.2
6.00	4	50	0.025	7.500	6.000	2655	265	11.9	19°	21.8
8.00	4	50	0.030	10.000	8.000	1990	240	19.1	19°	29.0
10.00	4	50	0.035	12.500	10.000	1590	225	27.9	19°	36.3
12.00	4	50	0.040	15.000	12.000	1325	210	38.2	19°	43.6
16.00	4	50	0.050	20.000	16.000	995	200	63.7	19°	58.1
20.00	4	50	0.060	25.000	20.000	795	190	95.5	19°	72.6