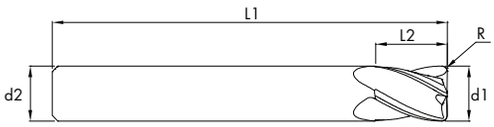
# SOLID CARBIDE END MILLS WITH CORNER RADIUS

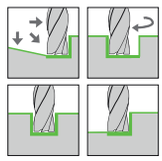
heikenei.com

VOLLHARTMETALL SCHAFTFRASER MIT ECKENRADIUS

KARBÜR KÖŞE RADYÜSLÜ FREZE EDGER RADIUS





## EDGER RADIUS

<52 HRC

END MILL FRÄSER — TYPE

MG-10 — QUALITY

d1 — DIAMETER

HEIKENEI SPECIAL — NORM

4 FLUTES

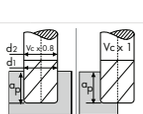
DIN 6535 HA — SHAFT TYPE

30° — HELICAL

R — CORNER RADIUS

nACo MULTILAYER — COATED

| d1(e8) | L2 | L1 | d2(h6) | Z | R | Uncoated Code | Coated Code |
|---|---|---|---|---|---|---|---|
| 3 | 5 | 40 | 3 | 4 | 0,50 | 4026720 | 4026730 |
| 4 | 7 | 50 | 4 | 4 | 0,50 | 4026740 | 4026750 |
| 5 | 8 | 50 | 5 | 4 | 0,50 | 4026760 | 4026770 |
| 6 | 8 | 57 | 6 | 4 | 0,50 | 4026780 | 4026790 |
| 6 | 8 | 57 | 6 | 4 | 1,00 | 4026800 | 4026810 |
| 8 | 11 | 63 | 8 | 4 | 0,50 | 4026820 | 4026830 |
| 8 | 11 | 63 | 8 | 4 | 1,00 | 4026840 | 4026850 |
| 8 | 11 | 63 | 8 | 4 | 1,50 | 4026860 | 4026870 |
| 8 | 11 | 63 | 8 | 4 | 2,00 | 4026880 | 4026890 |
| 10 | 13 | 72 | 10 | 4 | 0,50 | 4026900 | 4026910 |
| 10 | 13 | 72 | 10 | 4 | 1,00 | 4026920 | 4026930 |
| 10 | 13 | 72 | 10 | 4 | 1,50 | 4026940 | 4026950 |
| 10 | 13 | 72 | 10 | 4 | 2,00 | 4026960 | 4026970 |
| 12 | 16 | 83 | 12 | 4 | 0,50 | 4026980 | 4026990 |
| 12 | 16 | 83 | 12 | 4 | 1,00 | 4027000 | 4027010 |
| 12 | 16 | 83 | 12 | 4 | 1,50 | 4027020 | 4027030 |
| 12 | 16 | 83 | 12 | 4 | 2,00 | 4027040 | 4027050 |
| 14 | 16 | 83 | 12 | 4 | 0,50 | 4027060 | 4027070 |
| 14 | 16 | 83 | 12 | 4 | 1,00 | 4027080 | 4027090 |
| 14 | 16 | 83 | 12 | 4 | 1,50 | 4027100 | 4027110 |
| 14 | 16 | 83 | 12 | 4 | 2,00 | 4027120 | 4027130 |
| 16 | 19 | 92 | 16 | 4 | 0,50 | 4027140 | 4027150 |
| 16 | 19 | 92 | 16 | 4 | 1,00 | 4027160 | 4027170 |
| 16 | 19 | 92 | 16 | 4 | 1,50 | 4027180 | 4027190 |
| 16 | 19 | 92 | 16 | 4 | 2,00 | 4027200 | 4027210 |




| | P (20-30 Hrc) | P (30-40 Hrc) | M | GG | AL | CU | Titan | < 52 HRC |
|---|---|---|---|---|---|---|---|---|
| | 1.0050-2<br>1.0060-2<br>1.0070-2 | 1.5864<br>1.6580<br>1.7225 | 1.4405<br>1.4460<br>1.4505 | 0.6035<br>0.7080<br>0.8055 | 3.2151<br>3.2373<br>3.2382 | 2.1247<br>2.0580<br>2.0598 | 3.7035<br>3.7055<br>3.7065 | 1.3255<br>1.3265<br>1.3333 |
| | Vc= 120 m/dk. | Vc = 90 m/dk. | Vc = 65 m/dk. | Vc= 130 m/dk. | Vc = 320 m/dk. | Vc = 200 m/dk. | Vc = 50 m/dk. | Vc = 50 m/dk. |

| d1 | ap | ae | fz | n | Vf | fz | n | Vf | fz | n | Vf | fz | n | Vf | fz | n | Vf | fz | n | Vf | fz | n | Vf | fz | n | Vf |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 3 | 1,5 | 1,5 | 0,016 | 12739 | 205xZ | 0,019 | 9554 | 180xZ | 0,017 | 6900 | 120xZ | 0,045 | 13800 | 620xZ | 0,034 | 33970 | 1150xZ | 0,037 | 21233 | 785xZ | 0,012 | 5300 | 65 xZ | 0,010 | 5300 | 53xZ |
| 4 | 2,0 | 2,0 | 0,021 | 9554 | 205xZ | 0,025 | 7166 | 180xZ | 0,023 | 5175 | 120xZ | 0,060 | 10350 | 620xZ | 0,045 | 25477 | 1150xZ | 0,049 | 15925 | 785xZ | 0,016 | 3975 | 65 xZ | 0,013 | 3975 | 53xZ |
| 5 | 2,5 | 2,5 | 0,027 | 7643 | 205xZ | 0,031 | 5732 | 180xZ | 0,029 | 4140 | 120xZ | 0,075 | 8280 | 620xZ | 0,056 | 20382 | 1150xZ | 0,062 | 12740 | 785xZ | 0,020 | 3180 | 65 xZ | 0,017 | 3180 | 53xZ |
| 6 | 3,0 | 3,0 | 0,032 | 6369 | 205xZ | 0,038 | 4777 | 180xZ | 0,035 | 3450 | 120xZ | 0,090 | 6900 | 620xZ | 0,068 | 16985 | 1150xZ | 0,074 | 10617 | 785xZ | 0,025 | 2650 | 65 xZ | 0,020 | 2650 | 53xZ |
| 8 | 4,0 | 4,0 | 0,043 | 4777 | 205xZ | 0,050 | 3583 | 180xZ | 0,046 | 2587 | 120xZ | 0,120 | 5175 | 620xZ | 0,090 | 12739 | 1150xZ | 0,099 | 7962 | 785xZ | 0,033 | 1987 | 65 xZ | 0,027 | 1987 | 53xZ |
| 10 | 5,0 | 5,0 | 0,053 | 3822 | 205xZ | 0,063 | 2866 | 180xZ | 0,058 | 2070 | 120xZ | 0,150 | 4140 | 620xZ | 0,110 | 10191 | 1150xZ | 0,123 | 6370 | 785xZ | 0,041 | 1590 | 65 xZ | 0,033 | 1590 | 53xZ |
| 12 | 6,0 | 6,0 | 0,064 | 3185 | 205xZ | 0,075 | 2389 | 180xZ | 0,070 | 1725 | 120xZ | 0,180 | 3450 | 620xZ | 0,140 | 8492 | 1150xZ | 0,148 | 5308 | 785xZ | 0,049 | 1325 | 65 xZ | 0,040 | 1325 | 53xZ |
| 14 | 7,0 | 7,0 | 0,075 | 2730 | 205xZ | 0,088 | 2047 | 180xZ | 0,081 | 1478 | 120xZ | 0,210 | 2957 | 620xZ | 0,160 | 7279 | 1150xZ | 0,173 | 4550 | 785xZ | 0,057 | 1136 | 65 xZ | 0,047 | 1136 | 53xZ |
| 16 | 8,0 | 8,0 | 0,086 | 2389 | 205xZ | 0,100 | 1791 | 180xZ | 0,093 | 1294 | 120xZ | 0,240 | 2588 | 620xZ | 0,180 | 6369 | 1150xZ | 0,197 | 3981 | 785xZ | 0,065 | 994 | 65 xZ | 0,053 | 994 | 53xZ |