



MS14100090

Type: Endmill with 4 teeth

d1	d2	l1	l2
9,00	9,00	67	16,00

Coolant holes	Cut	Head shape	Spiral angle	Cutting edges Z
No	Right	Flat Center cutting	30°	4

Coated	Coating type	Material	Material type	Norm
No	-	MD	SMG 10	DIN 6528

Machinable Materials				
Cod.	Material type	Machinability	Cutting speed Vc	Advancement per revolution fn
		Recommended Part. recommended Not recommended	(m/min)	(mm/dente)
P01	Unalloyed steels up to 800 N/mm2		80 : 140	0,03 - 0,04
P02	Low alloy steels from 800 N/mm2 to 1100 N/mm2		60 : 100	0,02 - 0,035
P03	Highly alloyed steels from 1100 N/mm2 to 1400 N/mm2		30 : 60	0,015 - 0,03
M01	Ferritic stainless steels		40 : 80	0,015 - 0,03
M02	Martensitic stainless steels		40 : 80	0,015 - 0,03
M03	Martensitic stainless steels - PH		40 : 80	0,015 - 0,03
M04	Austenitic stainless steels		40 : 80	0,015 - 0,03
K01	Gray/lamellar cast iron		60 : 100	0,04 - 0,06
K02	Nodular/nodular cast iron		60 : 100	0,04 - 0,06
N01	Drawn aluminum alloys		150 : 350	0,04 - 0,08
N02	Die-cast aluminum alloys		100 : 250	0,04 - 0,06
N03	Copper		60 : 100	0,04 - 0,06
N04	Brass - Bronze		60 : 100	0,04 - 0,06
N05	Lead-free brass		50 : 80	0,02 - 0,04
S01	Super alloys (Inconel - Hastelloy - Nimonic)		20 : 50	0,01 - 0,02
S02	Pure titanium (Grade 2 - Grade 4)		20 : 40	0,015 - 0,03
S03	Titanium alloys (Grade 5)		20 : 40	0,015 - 0,03
S04	Cobalt Chrome Alloys		20 : 40	0,01 - 0,017
H01	Hardened steels up to 55 HRC		15 : 30	0,008 - 0,010
H02	Hardened steels from 55 HRC		-	-



SWISS HIGH PRECISION TOOLS

