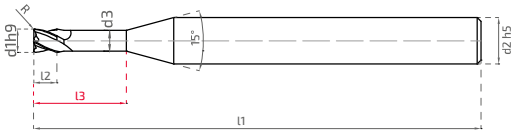
153
Micro Corner Radius Endmill



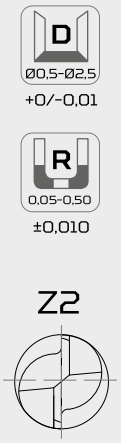
Short Series

S	Order No	Code	d1h9	d2h5	d3	l1	l2	l3	Corner
	25100	153.2.0050.0510.R0005.0005.0047.0020.00.S04H1A04.01	0,5	4	0,47	51	0,5	2	R 0.05
	25102	153.2.0050.0510.R0005.0005.0047.0030.00.S04H1A04.01	0,5	4	0,47	51	0,5	3	R 0.05
	25104	153.2.0050.0510.R0005.0005.0047.0040.00.S04H1A04.01	0,5	4	0,47	51	0,5	4	R 0.05
*	**25106**	153.2.0100.0510.R0010.0010.0094.0060.00.S04H1A04.01	1	4	0,94	51	1	6	R 0.10
	25108	153.2.0100.0510.R0020.0010.0094.0060.00.S04H1A04.01	1	4	0,94	51	1	6	R 0.20
*	**25110**	153.2.0100.0510.R0010.0010.0094.0080.00.S04H1A04.01	1	4	0,94	51	1	8	R 0.10
	25112	153.2.0100.0510.R0020.0010.0094.0080.00.S04H1A04.01	1	4	0,94	51	1	8	R 0.20
*	**25114**	153.2.0100.0510.R0010.0010.0094.0100.00.S04H1A04.01	1	4	0,94	51	1	10	R 0.10
*	**25116**	153.2.0100.0510.R0010.0010.0094.0120.00.S04H1A04.01	1	4	0,94	51	1	12	R 0.10
	25118	153.2.0100.0510.R0020.0010.0094.0120.00.S04H1A04.01	1	4	0,94	51	1	12	R 0.20
	25120	153.2.0100.0510.R0020.0010.0094.0160.00.S04H1A04.01	1	4	0,94	51	1	16	R 0.20
	25122	153.2.0100.0510.R0020.0010.0094.0200.00.S04H1A04.01	1	4	0,94	51	1	20	R 0.20
*	**25124**	153.2.0150.0510.R0020.0015.0140.0060.00.S04H1A04.01	1,5	4	1,4	51	1,5	6	R 0.20
	25126	153.2.0150.0510.R0050.0015.0140.0060.00.S04H1A04.01	1,5	4	1,4	51	1,5	6	R 0.50
	25128	153.2.0150.0510.R0010.0015.0140.0080.00.S04H1A04.01	1,5	4	1,4	51	1,5	8	R 0.10
*	**25130**	153.2.0150.0510.R0020.0015.0140.0080.00.S04H1A04.01	1,5	4	1,4	51	1,5	8	R 0.20
	25132	153.2.0150.0510.R0050.0015.0140.0080.00.S04H1A04.01	1,5	4	1,4	51	1,5	8	R 0.50
*	**25134**	153.2.0150.0510.R0020.0015.0140.0100.00.S04H1A04.01	1,5	4	1,4	51	1,5	10	R 0.20
	25136	153.2.0150.0510.R0050.0015.0140.0100.00.S04H1A04.01	1,5	4	1,4	51	1,5	10	R 0.50
	25138	153.2.0150.0510.R0010.0015.0140.0120.00.S04H1A04.01	1,5	4	1,4	51	1,5	12	R 0.10
*	**25140**	153.2.0150.0510.R0020.0015.0140.0120.00.S04H1A04.01	1,5	4	1,4	51	1,5	12	R 0.20
*	**25142**	153.2.0200.0510.R0020.0020.0195.0060.00.S04H1A04.01	2	4	1,95	51	2	6	R 0.20
*	**25144**	153.2.0200.0510.R0050.0020.0195.0060.00.S04H1A04.01	2	4	1,95	51	2	6	R 0.50
*	**25146**	153.2.0200.0510.R0020.0020.0195.0080.00.S04H1A04.01	2	4	1,95	51	2	8	R 0.20
*	**25148**	153.2.0200.0510.R0050.0020.0195.0080.00.S04H1A04.01	2	4	1,95	51	2	8	R 0.50
*	**25150**	153.2.0200.0510.R0020.0020.0195.0100.00.S04H1A04.01	2	4	1,95	51	2	10	R 0.20
*	**25152**	153.2.0200.0510.R0050.0020.0195.0100.00.S04H1A04.01	2	4	1,95	51	2	10	R 0.50
*	**25154**	153.2.0200.0510.R0020.0020.0195.0120.00.S04H1A04.01	2	4	1,95	51	2	12	R 0.20
*	**25156**	153.2.0200.0510.R0050.0020.0195.0120.00.S04H1A04.01	2	4	1,95	51	2	12	R 0.50

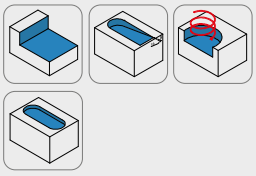
Long Series

S	Order No	Code	d1h9	d2h5	d3	l1	l2	l3	Corner
*	**25158**	153.2.0100.0510.R0010.0010.0094.0160.00.S04H1A04.01	1	4	0,94	51	1	16	R 0.10
	25160	153.2.0100.0510.R0010.0010.0094.0200.00.S04H1A04.01	1	4	0,94	51	1	20	R 0.10
*	**25162**	153.2.0150.0510.R0020.0015.0140.0160.00.S04H1A04.01	1,5	4	1,4	51	1,5	16	R 0.20
	25164	153.2.0150.0510.R0020.0015.0140.0200.00.S04H1A04.01	1,5	4	1,4	51	1,5	20	R 0.20
*	**25166**	153.2.0200.0510.R0020.0020.0194.0160.00.S04H1A04.01	2	4	1,94	51	2	16	R 0.20
*	**25168**	153.2.0200.0510.R0050.0020.0194.0160.00.S04H1A04.01	2	4	1,94	51	2	16	R 0.50
	25170	153.2.0200.0510.R0020.0020.0194.0200.00.S04H1A04.01	2	4	1,94	51	2	20	R 0.20











Cutting Parameters

	Material	Finish Milling ap=0.2Ø / ae=0.2Ø - 0.1Ø Vc (m/min)
Steel	Unalloyed Steel	170-220
	Steel	170-220
	Tempered Steel	140-180
	Cold Work Tool Steel	140-180
	Hot Work Tool Steel	110-150
Stainless Steel	AISI 304 - 416 - 420	80-130
	AISI 316 - 440	70-120
	17-4 PH 15-5 PH	70-100
	Cobalt-Chrome Alloys	60-100
	Duplex F51	50-80
	Super Duplex F55	50-80
Cast Iron	Gray Cast Iron	110-150
Titanium	Titanium	30-60
	Titanium Alloys	30-60
Hardened Steel	≤ 54 HRC	100-140
	>54 HRC	70-90

Feed Per Tooth (mm/tooth)

Ø	ae=0.2Ø	ae=0.1Ø
0,5	0,07	0,01
1	0.015	0,02
1,5	0.018	0,025
2	0.022	0,031

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.