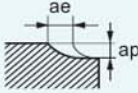


Nanomite® & Dinomite®

High Speed Machining EndMills

Technical Specifications

Work material		Carbon steel, Alloy steel, Cast iron (-30HRC) Ck55, 41CrMo				Alloy steel, Tool steel, Pre-hardened steel (30-45HRC) W.Nr. 1.2344(H13), X210Cr12			
Dia. (mm)	R (mm)	Revolution (min ⁻¹)	Feed rate (mm/min)	Depth of cut ae (mm)	Depth of cut ap (mm)	Revolution (min ⁻¹)	Feed rate (mm/min)	Depth of cut ae (mm)	Depth of cut ap (mm)
2	R 0.5	33,000	10,000	0.8	0.08	27,000	8,400	0.8	0.05
3	R 0.75	22,000	11,000	1.2	0.12	18,000	9,000	1.2	0.08
4	R 1	17,000	12,000	1.5	0.15	14,000	9,500	1.5	0.12
5	R 1.2	13,000	13,000	2.0	0.20	11,000	11,000	2.0	0.15
6	R 1.5	11,000	13,000	2.5	0.25	9,000	11,000	2.5	0.15
7	R 1.5	9,400	13,000	3.0	0.25	7,800	11,000	3.0	0.15
8	R 2	8,200	13,000	3.0	0.30	7,000	11,000	3.0	0.20
9	R 2	7,300	13,000	4.0	0.30	6,000	11,000	4.0	0.20
10	R 2	6,500	13,000	4.5	0.30	5,500	11,000	4.5	0.20
11	R 2	6,000	12,000	5.5	0.30	5,000	10,000	5.5	0.20
12	R 3	5,500	12,000	4.5	0.45	4,600	10,000	4.5	0.30
13	R 3	5,000	12,000	5.5	0.45	4,200	10,000	5.5	0.30
16	R 3	4,100	10,000	7.5	0.45	3,400	8,800	7.5	0.30
Depth of cut									

Work material		Hardened steel (45-55HRC) W.Nr. 1.2344(H13)				Hardened steel (55-60HRC) X210Cr12, S6-5-2 etc.			
Dia. (mm)	R (mm)	Revolution (min ⁻¹)	Feed rate (mm/min)	Depth of cut ae (mm)	Depth of cut ap (mm)	Revolution (min ⁻¹)	Feed rate (mm/min)	Depth of cut ae (mm)	Depth of cut ap (mm)
2	R 0.5	24,000	7,500	0.8	0.04	16,000	3,000	0.8	0.03
3	R 0.75	16,000	8,500	1.2	0.06	11,000	3,300	1.2	0.05
4	R 1	12,000	8,800	1.5	0.08	8,000	3,500	1.5	0.07
5	R 1.2	9,600	9,500	2.0	0.10	6,400	3,800	2.0	0.08
6	R 1.5	8,000	9,600	2.5	0.10	5,300	3,800	2.5	0.10
7	R 1.5	6,900	9,600	3.0	0.10	4,600	3,800	3.0	0.10
8	R 2	6,000	9,600	3.0	0.15	4,000	3,800	3.0	0.13
9	R 2	5,300	9,500	4.0	0.15	3,800	3,800	4.0	0.13
10	R 2	4,800	9,500	4.5	0.15	3,200	3,800	4.5	0.13
11	R 2	4,500	9,000	5.5	0.15	2,900	3,500	5.5	0.13
12	R 3	4,100	9,000	4.5	0.25	2,700	3,500	4.5	0.20
13	R 3	3,700	8,900	5.5	0.25	2,500	3,500	5.5	0.20
16	R 3	3,000	7,800	7.5	0.25	2,000	3,200	7.5	0.20
Depth of cut		