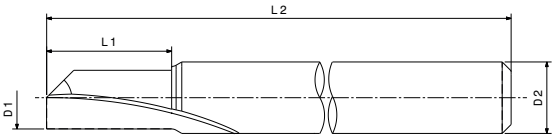
MI0627-NR01101

Gerade genutete Mikrofräser Z1 3/4
Micro end mill with Straight flute Z1 3/4

DWS	P1	P2	P3	P4	P5	M1	M2	M3	K1	N1	N2
	N3	N4	N5	N6	N7	N8	S1	S2	S3	H1	
DWT									K1	N1	N2
	N3	N4	N5	N6	N7	N8					



VHM h5 0° 2xD 90°

D1 +0.005 / -0.01	L1	D2	L2	Z	DWS Art. N°	DWT Art. N°
0.20	0.40	3	39	1	**452673**	**452708**
0.30	0.60	3	39	1	**452674**	**452709**
0.40	0.80	3	39	1	**452675**	**452710**
0.50	1.00	3	39	1	**452676**	**452711**
0.60	1.20	3	39	1	**452677**	**452712**
0.70	1.40	3	39	1	**452678**	**452713**
0.80	1.60	3	39	1	**452679**	**452714**
0.90	1.80	3	39	1	**452680**	**452715**
1.00	2.00	3	39	1	**452681**	**452716**
1.10	2.20	3	39	1	**452682**	**452717**
1.20	2.40	3	39	1	**452683**	**452718**
1.30	2.60	3	39	1	**452684**	**452719**
1.40	2.80	3	39	1	**452685**	**452720**
1.50	3.00	3	39	1	**452686**	**452721**
1.60	3.20	3	39	1	**452687**	**452722**
1.70	3.40	3	39	1	**452688**	**452723**
1.80	3.60	3	39	1	**452689**	**452724**
1.90	3.80	3	39	1	**452690**	**452725**
2.00	4.00	3	39	1	**452691**	**452726**
2.10	4.20	3	39	1	**452692**	**452727**
2.20	4.40	3	39	1	**452693**	**452728**
2.30	4.60	3	39	1	**452694**	**452729**
2.40	4.80	3	39	1	**452695**	**452730**
2.50	5.00	3	39	1	**452696**	**452731**
2.60	5.20	3	39	1	**452697**	**452732**
2.70	5.40	3	39	1	**452698**	**452733**
2.80	5.60	3	39	1	**452699**	**452734**
2.90	5.80	3	39	1	**452700**	**452735**
3.00	6.00	4	40	1	**452701**	**452736**
3.50	7.00	4	40	1	**452702**	**452737**
4.00	8.00	6	51	1	**452703**	**452738**
4.50	9.00	6	51	1	**452704**	**452739**
5.00	10.00	6	51	1	**452705**	**452740**
5.50	11.00	6	51	1	**452706**	**452741**
6.00	12.00	8	59	1	**452707**	**452742**

Weitere Beschichtungen oder kundenspezifische Lösungen auf Anfrage
Other coatings or customized solutions are available on request

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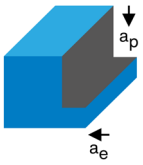
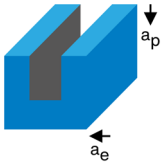
MI0627-NR01101

Schnittparameter
Cutting parameters

Anwendung *Application*	Eckfräsen *Side Milling*		Nutenfräsen *Slotting*	
Funktion *Function*				
a_p	≤1xD_1		a_p	≤0.5xD_1
a_e	≤0.4xD_1		a_e	1xD_1
V_c	x1		V_c	x0.7
f_z	x1		f_z	x0.6

		f_z [mm]			
ISO	V_c [m/min]	Ø 0.20 - 0.80	Ø 0.90 - 1.20	Ø 1.30 - 2.90	Ø 3.00 - 6.00
P1	60 - 90	0.004 - 0.009	0.008 - 0.020	0.015 - 0.030	0.020 - 0.040
P2	60 - 90	0.004 - 0.009	0.008 - 0.020	0.015 - 0.030	0.020 - 0.040
P3	40 - 60	0.004 - 0.009	0.008 - 0.020	0.015 - 0.030	0.020 - 0.040
P4	30 - 50	0.004 - 0.009	0.008 - 0.020	0.015 - 0.030	0.020 - 0.040
P5	30 - 50	0.004 - 0.009	0.008 - 0.020	0.015 - 0.030	0.020 - 0.040
M1	50 - 70	0.003 - 0.008	0.007 - 0.015	0.010 - 0.030	0.015 - 0.035
M2	50 - 70	0.003 - 0.008	0.007 - 0.015	0.010 - 0.030	0.015 - 0.035
M3	50 - 70	0.003 - 0.008	0.007 - 0.015	0.010 - 0.030	0.015 - 0.035
K1	90 - 120	0.004 - 0.009	0.008 - 0.025	0.020 - 0.040	0.030 - 0.060
N1	200 - 250	0.004 - 0.009	0.008 - 0.025	0.020 - 0.040	0.030 - 0.060
N2	200 - 250	0.004 - 0.009	0.008 - 0.025	0.020 - 0.040	0.030 - 0.060
N3	140 - 180	0.004 - 0.009	0.008 - 0.025	0.020 - 0.040	0.030 - 0.060
N4	140 - 180	0.004 - 0.009	0.008 - 0.025	0.020 - 0.040	0.030 - 0.060
N5	110 - 160	0.004 - 0.009	0.008 - 0.025	0.020 - 0.040	0.030 - 0.060
N6	100 - 200	0.004 - 0.009	0.008 - 0.025	0.020 - 0.040	0.030 - 0.060
N7	100 - 200	0.004 - 0.009	0.008 - 0.025	0.020 - 0.040	0.030 - 0.060
N8	200 - 250	0.004 - 0.009	0.008 - 0.025	0.020 - 0.040	0.030 - 0.060
S1	30 - 50	0.003 - 0.008	0.008 - 0.015	0.015 - 0.030	0.025 - 0.045
S2	25 - 35	0.003 - 0.008	0.008 - 0.015	0.015 - 0.030	0.025 - 0.045
S3	30 - 50	0.003 - 0.008	0.008 - 0.015	0.015 - 0.030	0.025 - 0.045
H1	25 - 35	0.002 - 0.004	0.003 - 0.005	0.004 - 0.006	0.005 - 0.008
H2					

Richtwerte
Indicative values

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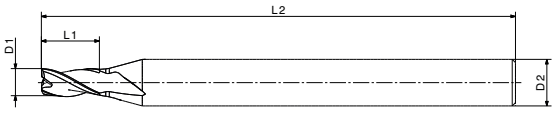
MI0110-NR01101

Mikrofräser
Micro end mill

DWS	P1	P2	P3	P4	P5	M1	M2	M3	K1	N1	N2
	N3	N4	N5	N6	N7	N8	S1	S2	S3	H1	
DWT									K1	N1	N2
	N3	N4	N5	N6	N7	N8					



VHM h5 30° 2xD 90°

D1 +0.005 / -0.01	L1	D2 h5	L2	Z	DWS Art. N°	DWT Art. N°
0.30	0.60	3	39	3	**443445**	**443479**
0.40	0.80	3	39	3	**443446**	**443480**
0.50	1.00	3	39	3	**443447**	**443481**
0.60	1.20	3	39	3	**443448**	**443482**
0.70	1.40	3	39	3	**443449**	**443484**
0.75	1.50	3	39	3	**443450**	**443485**
0.80	1.60	3	39	3	**443451**	**443486**
0.90	1.80	3	39	3	**443452**	**443487**
1.00	2.00	3	39	3	**443453**	**443488**
1.10	2.20	3	39	3	**443454**	**443489**
1.20	2.40	3	39	3	**443455**	**443490**
1.30	2.60	3	39	3	**443456**	**443491**
1.40	2.80	3	39	3	**443457**	**443492**
1.50	3.00	3	39	3	**443458**	**443493**
1.60	3.20	3	39	3	**443459**	**443494**
1.70	3.40	3	39	3	**443460**	**443495**
1.80	3.60	3	39	3	**443461**	**443496**
1.90	3.80	3	39	3	**443462**	**443497**
2.00	4.00	3	39	3	**443463**	**443499**
2.10	4.20	3	39	3	**443464**	**443500**
2.20	4.40	3	39	3	**443465**	**443501**
2.30	4.60	3	39	3	**443466**	**443502**
2.40	4.80	3	39	3	**443467**	**443503**
2.50	5.00	3	39	3	**443468**	**443504**
2.60	5.20	3	39	3	**443469**	**443505**
2.70	5.40	3	39	3	**443470**	**443506**
2.80	5.60	3	39	3	**443471**	**443507**
2.90	5.80	3	39	3	**443472**	**443508**
3.00	6.00	5	51	3	**443475**	**443509**
4.00	8.00	5	51	3	**443476**	**443510**
5.00	10.00	6	58	3	**443477**	**443511**
6.00	12.00	6	58	3	**443478**	**443512**

Weitere Beschichtungen oder kundenspezifische Lösungen auf Anfrage
Other coatings or customized solutions are available on request

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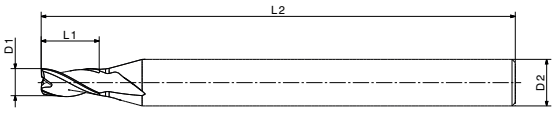
MIO110-NRO1101

Mikrofräser
Micro end mill

DWS	P1	P2	P3	P4	P5	M1	M2	M3	K1	N1	N2
	N3	N4	N5	N6	N7	N8	S1	S2	S3	H1	
DWT									K1	N1	N2
	N3	N4	N5	N6	N7	N8					

VHM h5 30° 3xD 90°



D1 +0.005 / -0.01	L1	D2	L2	Z	DWS Art. N°	DWT Art. N°
0.30	0.90	3	39	3	**443516**	**443573**
0.40	1.20	3	39	3	**443517**	**443574**
0.50	1.50	3	39	3	**443518**	**443575**
0.60	1.80	3	39	3	**443519**	**443576**
0.70	2.10	3	39	3	**443520**	**443577**
0.75	2.30	3	39	3	**443521**	**443578**
0.80	2.40	3	39	3	**443522**	**443579**
0.90	2.70	3	39	3	**443523**	**443580**
1.00	3.00	3	39	3	**443524**	**443581**
1.10	3.30	3	39	3	**443525**	**443582**
1.20	3.60	3	39	3	**443526**	**443583**
1.30	3.90	3	39	3	**443539**	**443584**
1.40	4.20	3	39	3	**443540**	**443585**
1.50	4.50	3	39	3	**443541**	**443586**
1.60	4.80	3	39	3	**443542**	**443587**
1.70	5.10	3	39	3	**443543**	**443588**
1.80	5.40	3	39	3	**443544**	**443589**
1.90	5.70	3	39	3	**443545**	**443590**
2.00	6.00	3	39	3	**443546**	**443591**
2.10	6.30	3	39	3	**443547**	**443592**
2.20	6.60	3	39	3	**443548**	**443593**
2.30	6.90	3	39	3	**443549**	**443594**
2.40	7.20	3	39	3	**443550**	**443595**
2.50	7.50	3	39	3	**443551**	**443596**
2.60	7.80	3	39	3	**443552**	**443597**
2.70	8.10	3	39	3	**443553**	**443598**
2.80	8.40	3	39	3	**443554**	**443599**
2.90	8.70	3	39	3	**443555**	**443600**
3.00	9.00	5	51	3	**443556**	**443601**
4.00	12.00	5	51	3	**443557**	**443602**
5.00	15.00	6	58	3	**443558**	**443603**
6.00	18.00	6	58	3	**443559**	**443604**

Weitere Beschichtungen oder kundenspezifische Lösungen auf Anfrage
Other coatings or customized solutions are available on request

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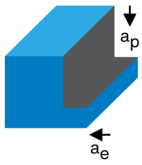
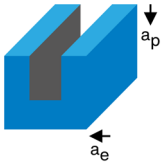
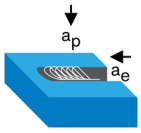
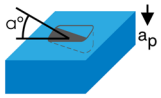
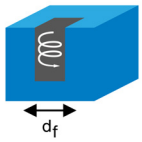
MIO110-NRO1101

Schnittparameter
Cutting parameters

Anwendung *Application*	Eckfräsen *Side Milling*		Nutenfräsen *Slotting*		Trochoidalfräsen *Trochoidal milling*		Rampenfräsen *Diagonal plunging*		Helixinterpolation *Helical interpolation*	
Funktion *Function*										
	a_p	≤1xD_1	a_p	≤0.5xD_1	a_p	≤1.5xD_1	Angle	8°	Angle	8°
	a_e	≤0.4xD_1	a_e	1xD_1	a_e	≤0.2xD_1	a_p	≤1xD_1	D_f	1.7xD_1
	V_c	x1	V_c	x0.7	V_c	x1.2	f_z	x0.7		
	f_z	x1	f_z	x0.6	f_z	x1.2				

		f_z [mm]			
ISO	V_c [m/min]	Ø 0.30 - 0.80	Ø 0.90 - 1.20	Ø 1.30 - 2.90	Ø 3.00 - 6.00
P1	60 - 90	0.004 - 0.009	0.008 - 0.020	0.015 - 0.030	0.020 - 0.040
P2	60 - 90	0.004 - 0.009	0.008 - 0.020	0.015 - 0.030	0.020 - 0.040
P3	40 - 60	0.004 - 0.009	0.008 - 0.020	0.015 - 0.030	0.020 - 0.040
P4	30 - 50	0.004 - 0.009	0.008 - 0.020	0.015 - 0.030	0.020 - 0.040
P5	30 - 50	0.004 - 0.009	0.008 - 0.020	0.015 - 0.030	0.020 - 0.040
M1	50 - 70	0.003 - 0.008	0.007 - 0.015	0.010 - 0.030	0.015 - 0.035
M2	50 - 70	0.003 - 0.008	0.007 - 0.015	0.010 - 0.030	0.015 - 0.035
M3	50 - 70	0.003 - 0.008	0.007 - 0.015	0.010 - 0.030	0.015 - 0.035
K1	90 - 120	0.004 - 0.009	0.008 - 0.025	0.020 - 0.040	0.030 - 0.060
N1	200 - 250	0.004 - 0.009	0.008 - 0.025	0.020 - 0.040	0.030 - 0.060
N2	200 - 250	0.004 - 0.009	0.008 - 0.025	0.020 - 0.040	0.030 - 0.060
N3	140 - 180	0.004 - 0.009	0.008 - 0.025	0.020 - 0.040	0.030 - 0.060
N4	140 - 180	0.004 - 0.009	0.008 - 0.025	0.020 - 0.040	0.030 - 0.060
N5	110 - 160	0.004 - 0.009	0.008 - 0.025	0.020 - 0.040	0.030 - 0.060
N6	100 - 200	0.004 - 0.009	0.008 - 0.025	0.020 - 0.040	0.030 - 0.060
N7	100 - 200	0.004 - 0.009	0.008 - 0.025	0.020 - 0.040	0.030 - 0.060
N8	200 - 250	0.004 - 0.009	0.008 - 0.025	0.020 - 0.040	0.030 - 0.060
S1	30 - 50	0.003 - 0.008	0.008 - 0.015	0.015 - 0.030	0.025 - 0.045
S2	25 - 35	0.003 - 0.008	0.008 - 0.015	0.015 - 0.030	0.025 - 0.045
S3	30 - 50	0.003 - 0.008	0.008 - 0.015	0.015 - 0.030	0.025 - 0.045
H1	25 - 35	0.002 - 0.004	0.003 - 0.005	0.004 - 0.006	0.005 - 0.008
H2					

Richtwerte
Indicative values

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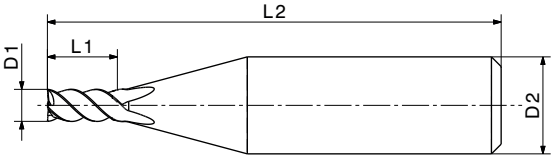
MI0110-NR01102

Schlicht Mikrofräser
Finishing Micro end mill

DWS	P1	P2	P3	P4	P5	M1	M2	M3	K1	N1	N2
	N3	N4	N5	N6	N7	N8	S1	S2	S3	H1	
DWT									K1	N1	N2
	N3	N4	N5	N6	N7	N8					

VHM h5 45° 2xD 90°



D1 h10	L1	D2	L2	Z	DWS Art. N°	DWT Art. N°
0.50	1.00	6	40	4	**452743**	**452774**
0.60	1.20	6	40	4	**452744**	**452775**
0.70	1.40	6	40	4	**452745**	**452776**
0.80	1.60	6	40	4	**452746**	**452777**
0.90	1.80	6	40	4	**452747**	**452778**
1.00	2.00	6	40	4	**452748**	**452779**
1.10	2.20	6	40	4	**452749**	**452780**
1.20	2.40	6	40	4	**452750**	**452781**
1.30	2.60	6	40	4	**452751**	**452782**
1.40	2.80	6	40	4	**452752**	**452783**
1.50	3.00	6	40	4	**452753**	**452784**
1.60	3.20	6	40	4	**452754**	**452785**
1.70	3.40	6	40	4	**452755**	**452786**
1.80	3.60	6	40	4	**452756**	**452787**
1.90	3.80	6	40	4	**452757**	**452788**
2.00	4.00	6	40	4	**452758**	**452789**
2.10	4.20	6	40	4	**452759**	**452790**
2.20	4.40	6	40	4	**452760**	**452791**
2.30	4.60	6	40	4	**452761**	**452792**
2.40	4.80	6	40	4	**452762**	**452793**
2.50	5.00	6	40	4	**452763**	**452794**
2.60	5.20	6	40	4	**452764**	**452795**
2.70	5.40	6	40	4	**452765**	**452796**
2.80	5.60	6	40	4	**452766**	**452797**
2.90	5.80	6	40	4	**452767**	**452798**
3.00	6.00	6	40	4	**452768**	**452799**
3.50	7.00	6	40	4	**452769**	**452800**
4.00	8.00	6	40	4	**452770**	**452801**
4.50	9.00	6	40	4	**452771**	**452802**
5.00	10.00	6	40	4	**452772**	**452803**
6.00	12.00	6	40	4	**452773**	**452804**

Weitere Beschichtungen oder kundenspezifische Lösungen auf Anfrage
Other coatings or customized solutions are available on request

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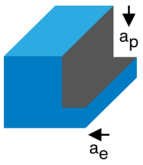
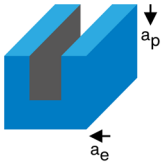
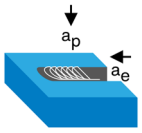
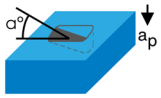
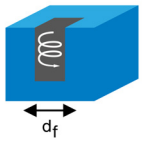
MIO110-NRO1102

Schnittparameter
Cutting parameters

Anwendung *Application*	Eckfräsen *Side Milling*		Nutenfräsen *Slotting*		Trochoidalfräsen *Trochoidal milling*		Rampenfräsen *Diagonal plunging*		Helixinterpolation *Helical interpolation*	
Funktion *Function*										
a_p	≤1xD1	a_p	≤0.5xD1	a_p	≤1.5xD1	Angle	8°	Angle	8°
a_e	≤0.4xD1	a_e	1xD1	a_e	≤0.2xD1	a_p	≤1xD1	D_f	≤1xD1
V_c	x1	V_c	x0.7	V_c	x1.2	f_z	x0.7		
f_z	x1	f_z	x0.6	f_z	x1.2				

ISO	V_c [m/min]	f_z [mm] Ø 0.50 - 0.80	Ø 0.90 - 1.20	Ø 1.30 - 2.90	Ø 3.00 - 6.00
P1	60 - 90	0.004 - 0.009	0.008 - 0.020	0.015 - 0.030	0.020 - 0.040
P2	60 - 90	0.004 - 0.009	0.008 - 0.020	0.015 - 0.030	0.020 - 0.040
P3	40 - 60	0.004 - 0.009	0.008 - 0.020	0.015 - 0.030	0.020 - 0.040
P4	30 - 50	0.004 - 0.009	0.008 - 0.020	0.015 - 0.030	0.020 - 0.040
P5	30 - 50	0.004 - 0.009	0.008 - 0.020	0.015 - 0.030	0.020 - 0.040
M1	50 - 70	0.003 - 0.008	0.007 - 0.015	0.010 - 0.030	0.015 - 0.035
M2	50 - 70	0.003 - 0.008	0.007 - 0.015	0.010 - 0.030	0.015 - 0.035
M3	50 - 70	0.003 - 0.008	0.007 - 0.015	0.010 - 0.030	0.015 - 0.035
K1	90 - 120	0.004 - 0.009	0.008 - 0.025	0.020 - 0.040	0.030 - 0.060
N1	200 - 250	0.004 - 0.009	0.008 - 0.025	0.020 - 0.040	0.030 - 0.060
N2	200 - 250	0.004 - 0.009	0.008 - 0.025	0.020 - 0.040	0.030 - 0.060
N3	140 - 180	0.004 - 0.009	0.008 - 0.025	0.020 - 0.040	0.030 - 0.060
N4	140 - 180	0.004 - 0.009	0.008 - 0.025	0.020 - 0.040	0.030 - 0.060
N5	110 - 160	0.004 - 0.009	0.008 - 0.025	0.020 - 0.040	0.030 - 0.060
N6	100 - 200	0.004 - 0.009	0.008 - 0.025	0.020 - 0.040	0.030 - 0.060
N7	100 - 200	0.004 - 0.009	0.008 - 0.025	0.020 - 0.040	0.030 - 0.060
N8	200 - 250	0.004 - 0.009	0.008 - 0.025	0.020 - 0.040	0.030 - 0.060
S1	30 - 50	0.003 - 0.008	0.008 - 0.015	0.015 - 0.030	0.025 - 0.045
S2	25 - 35	0.003 - 0.008	0.008 - 0.015	0.015 - 0.030	0.025 - 0.045
S3	30 - 50	0.003 - 0.008	0.008 - 0.015	0.015 - 0.030	0.025 - 0.045
H1	25 - 35	0.002 - 0.004	0.003 - 0.005	0.004 - 0.006	0.005 - 0.008
H2					

Richtwerte
Indicative values

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