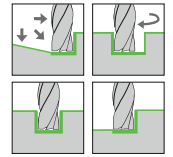


# SOLID CARBIDE END MILLS WITH CORNER RADIUS

VOLLHARTMETALL SCHAFTFRÄSER MIT ECKENRADIUS  
KARBÜR KÖŞE RADYÜSLÜ FREZE PICO CORNER LONG



## PICO CORNER LONG

<52 HRC

|      |         |          |               |          |            |         |               |        |
|------|---------|----------|---------------|----------|------------|---------|---------------|--------|
|      |         |          |               |          |            |         |               |        |
| TYPE | QUALITY | DIAMETER | CORNER RADIUS | 2 FLUTES | SHAFT TYPE | HELICAL | CORNER RADIUS | COATED |

| d1  | L2  | L3   | L4   | d3   | L1 | d2(h6) | Z | γ°    | α°    | Cr   | Coated Code |
|-----|-----|------|------|------|----|--------|---|-------|-------|------|-------------|
| 0,5 | 0,8 | 1,0  | 11,4 | 0,48 | 65 | 3      | 2 | 7,0°  | 6,17° | 0,10 | 4010690     |
| 0,5 | 0,8 | 2,0  | 9,3  | 0,48 | 65 | 3      | 2 | 10,0° | 7,63° | 0,10 | 4010700     |
| 0,5 | 0,8 | 4,0  | 11,3 | 0,48 | 65 | 3      | 2 | 10,0° | 6,30° | 0,10 | 4010710     |
| 0,5 | 0,8 | 6,0  | 13,3 | 0,48 | 65 | 3      | 2 | 10,0° | 5,36° | 0,10 | 4010720     |
| 0,6 | 0,9 | 1,2  | 11,3 | 0,57 | 65 | 3      | 2 | 7,0°  | 6,10° | 0,10 | 4010730     |
| 0,6 | 0,9 | 2,0  | 9,1  | 0,57 | 65 | 3      | 2 | 10,0° | 7,52° | 0,10 | 4010740     |
| 0,6 | 0,9 | 4,0  | 11,1 | 0,57 | 65 | 3      | 2 | 10,0° | 6,18° | 0,10 | 4010750     |
| 0,6 | 0,9 | 8,0  | 15,1 | 0,57 | 65 | 3      | 2 | 10,0° | 4,55° | 0,10 | 4010760     |
| 0,7 | 1,1 | 1,4  | 11,1 | 0,67 | 65 | 3      | 2 | 7,0°  | 5,90° | 0,10 | 4010770     |
| 0,7 | 1,1 | 2,5  | 9,4  | 0,67 | 65 | 3      | 2 | 10,0° | 6,99° | 0,10 | 4010780     |
| 0,7 | 1,1 | 5,0  | 11,9 | 0,67 | 65 | 3      | 2 | 10,0° | 5,54° | 0,10 | 4010790     |
| 0,7 | 1,1 | 8,0  | 14,9 | 0,67 | 65 | 3      | 2 | 10,0° | 4,43° | 0,10 | 4010800     |
| 0,8 | 1,2 | 2,0  | 8,6  | 0,76 | 65 | 3      | 2 | 10,0° | 7,61° | 0,15 | 4010810     |
| 0,8 | 1,2 | 3,0  | 9,6  | 0,76 | 65 | 3      | 2 | 10,0° | 6,51° | 0,15 | 4010820     |
| 0,8 | 1,2 | 6,0  | 12,6 | 0,76 | 65 | 3      | 2 | 10,0° | 4,98° | 0,15 | 4010830     |
| 0,8 | 1,2 | 10,0 | 16,6 | 0,76 | 65 | 3      | 2 | 10,0° | 3,44° | 0,15 | 4010840     |
| 1,0 | 1,5 | 2,0  | 8,2  | 0,95 | 65 | 3      | 2 | 10,0° | 6,98° | 0,20 | 4010850     |
| 1,0 | 1,5 | 4,0  | 10,2 | 0,95 | 65 | 3      | 2 | 10,0° | 5,62° | 0,20 | 4010860     |
| 1,0 | 1,5 | 8,0  | 14,2 | 0,95 | 65 | 3      | 2 | 10,0° | 4,40° | 0,20 | 4010870     |
| 1,0 | 1,5 | 12,0 | 18,2 | 0,95 | 65 | 3      | 2 | 10,0° | 3,16° | 0,20 | 4010880     |
| 1,0 | 1,5 | 16,0 | 22,2 | 0,95 | 65 | 3      | 2 | 10,0° | 2,59° | 0,20 | 4010890     |
| 1,0 | 1,5 | 20,0 | 26,2 | 0,95 | 65 | 3      | 2 | 10,0° | 2,19° | 0,20 | 4010900     |
| 1,2 | 1,8 | 2,0  | 7,7  | 1,14 | 65 | 3      | 2 | 10,0° | 6,67° | 0,25 | 4010910     |
| 1,2 | 1,8 | 4,0  | 9,7  | 1,14 | 65 | 3      | 2 | 10,0° | 5,31° | 0,25 | 4010920     |
| 1,5 | 2,3 | 4,0  | 9,0  | 1,43 | 65 | 3      | 2 | 10,0° | 4,76° | 0,30 | 4010930     |
| 1,5 | 2,3 | 8,0  | 13,0 | 1,43 | 65 | 3      | 2 | 10,0° | 3,30° | 0,30 | 4010940     |
| 1,5 | 2,3 | 12,0 | 17,0 | 1,43 | 65 | 3      | 2 | 10,0° | 2,52° | 0,30 | 4010950     |
| 1,5 | 2,3 | 20,0 | 25,0 | 1,43 | 65 | 3      | 2 | 10,0° | 1,72° | 0,30 | 4010960     |
| 2,0 | 3,0 | 4,0  | 7,8  | 1,90 | 65 | 3      | 4 | 10,0° | 3,65° | 0,50 | 4010970     |
| 2,0 | 3,0 | 8,0  | 11,8 | 1,90 | 65 | 3      | 4 | 10,0° | 2,42° | 0,50 | 4010980     |
| 2,0 | 3,0 | 12,0 | 15,8 | 1,90 | 65 | 3      | 4 | 10,0° | 1,81° | 0,50 | 4010990     |
| 2,0 | 4,0 | 16,0 | 19,8 | 1,90 | 65 | 3      | 4 | 10,0° | 1,45° | 0,50 | 4011000     |
| 2,0 | 4,0 | 20,0 | 23,8 | 1,90 | 65 | 3      | 4 | 10,0° | 1,21° | 0,50 | 4011010     |

|     |      |      | P (20-30 Hrc)  |       |        | P (30-40 Hrc) |       |        | M             |       |       | GG             |       |       | AL             |       |        | CU             |       |        | Titan         |       |       | < 52 HRC      |       |       |
|-----|------|------|----------------|-------|--------|---------------|-------|--------|---------------|-------|-------|----------------|-------|-------|----------------|-------|--------|----------------|-------|--------|---------------|-------|-------|---------------|-------|-------|
|     |      |      | 1.0050-2       |       |        | 1.5864        |       |        | 1.4405        |       |       | 0.6035         |       |       | 3.2151         |       |        | 2.1247         |       |        | 3.7035        |       |       | 1.3255        |       |       |
|     |      |      | 1.0060-2       |       |        | 1.6580        |       |        | 1.4460        |       |       | 0.7080         |       |       | 3.2373         |       |        | 2.0580         |       |        | 3.7055        |       |       | 1.3265        |       |       |
|     |      |      | 1.0070-2       |       |        | 1.7225        |       |        | 1.4505        |       |       | 0.8055         |       |       | 3.2382         |       |        | 2.0598         |       |        | 3.7065        |       |       | 1.3333        |       |       |
|     |      |      | Vc = 120 m/dk. |       |        | Vc = 80 m/dk. |       |        | Vc = 60 m/dk. |       |       | Vc = 200 m/dk. |       |       | Vc = 460 m/dk. |       |        | Vc = 230 m/dk. |       |        | Vc = 60 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    |
| 0,5 | 0,05 | 0,05 | 0,009          | 60000 | 1000x2 | 0,011         | 51200 | 1000x2 | 0,011         | 38400 | 800x2 | 0,007          | 60000 | 600x2 | 0,016          | 60000 | 1250x2 | 0,010          | 60000 | 1250x2 | 0,007         | 38400 | 400x2 | 0,008         | 32000 | 300x2 |
| 1,0 | 0,10 | 0,10 | 0,016          | 38400 | 1000x2 | 0,023         | 25600 | 1000x2 | 0,021         | 19200 | 800x2 | 0,013          | 60000 | 600x2 | 0,016          | 60000 | 1250x2 | 0,013          | 60000 | 1250x2 | 0,015         | 19200 | 400x2 | 0,016         | 16000 | 300x2 |
| 1,5 | 0,15 | 0,15 | 0,023          | 25600 | 1000x2 | 0,035         | 17000 | 1000x2 | 0,031         | 12800 | 800x2 | 0,019          | 42600 | 600x2 | 0,016          | 60000 | 1250x2 | 0,016          | 49000 | 1250x2 | 0,023         | 12800 | 400x2 | 0,024         | 10600 | 300x2 |
| 2,0 | 0,20 | 0,20 | 0,031          | 19200 | 1000x2 | 0,047         | 12800 | 1000x2 | 0,042         | 9600  | 800x2 | 0,025          | 32000 | 600x2 | 0,016          | 60000 | 1250x2 | 0,022          | 36800 | 1250x2 | 0,031         | 9600  | 400x2 | 0,033         | 8000  | 300x2 |