










# METRIC

## METRIC CARBIDE MICRO END MILLS

Material	Property	Vc : m/min Uncoated	Vc : m/min AlTiN	Feed : (mm/t)							
				Ø0.2	Ø0.5	Ø0.8	Ø1.0	Ø1.5	Ø2.0	Ø3.0	
	<500 MPa	60	80	Slotting ap = 1.0 ae = 1.0	0.001	0.001	0.002	0.002	0.003	0.004	0.006
				Finishing ap = 1.0 ae = 0.3	0.001	0.001	0.001	0.001	0.001	0.001	0.001
	<800 MPa	60	80	Slotting ap = 1.0 ae = 1.0	0.001	0.001	0.002	0.002	0.003	0.004	0.006
				Finishing ap = 1.0 ae = 0.3	0.001	0.001	0.001	0.001	0.001	0.001	0.001
	<1,000 MPa	60	80	Slotting ap = 1.0 ae = 1.0	0.001	0.001	0.002	0.002	0.003	0.004	0.006
				Finishing ap = 1.0 ae = 0.3	0.001	0.001	0.001	0.001	0.001	0.001	0.001
	<1,300 MPa	40	60	Slotting ap = 1.0 ae = 1.0	0.001	0.001	0.002	0.002	0.003	0.004	0.006
				Finishing ap = 1.0 ae = 0.3	0.001	0.001	0.001	0.001	0.001	0.001	0.001
	-	25	45	Slotting ap = 1.0 ae = 1.0	0.001	0.001	0.002	0.002	0.003	0.004	0.006
				Finishing ap = 1.0 ae = 0.3	0.001	0.001	0.001	0.001	0.001	0.001	0.001
	-	-	25	Slotting ap = 1.0 ae = 1.0	0.001	0.001	0.002	0.002	0.003	0.004	0.006
				Finishing ap = 1.0 ae = 0.3	0.001	0.001	0.001	0.001	0.001	0.001	0.001
	-	-	25	Slotting ap = 1.0 ae = 1.0	0.001	0.001	0.002	0.002	0.003	0.004	0.006
				Finishing ap = 1.0 ae = 0.3	0.001	0.001	0.001	0.001	0.001	0.001	0.001
	-	60	80	Slotting ap = 1.0 ae = 1.0	0.001	0.001	0.002	0.002	0.003	0.004	0.006
				Finishing ap = 1.0 ae = 0.3	0.001	0.001	0.001	0.001	0.001	0.001	0.001
	-	150	-	Slotting ap = 1.0 ae = 1.0	0.002	0.005	0.009	0.012	0.018	0.024	0.036
				Finishing ap = 1.0 ae = 0.3	0.001	0.001	0.001	0.001	0.002	0.002	0.004
	-	80	-	Slotting ap = 1.0 ae = 1.0	0.002	0.006	0.008	0.012	0.018	0.024	0.036
				Finishing ap = 1.0 ae = 0.3	0.001	0.001	0.001	0.001	0.002	0.002	0.004
	-	80	-	Slotting ap = 1.0 ae = 1.0	0.002	0.005	0.008	0.010	0.015	0.020	0.030
				Finishing ap = 1.0 ae = 0.3	0.001	0.001	0.001	0.001	0.002	0.002	0.003

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