












METRIC

METRIC CARBIDE MICRO MOLD END MILLS

Material	Property	Vc : m/min AITiN	Feed : (mm/t)							
			Ø0.2	Ø0.5	Ø0.8	Ø1.0	Ø1.5	Ø2.0	Ø3.0	
	<500 MPa	200	High Speed ap = 0.1 x Ø ae = 1.0 x Ø	0.002	0.002	0.004	0.005	0.005	0.006	0.007
			Copy Milling	0.001	0.002	0.003	0.004	0.004	0.005	0.006
	<800 MPa	200	High Speed ap = 0.1 x Ø ae = 1.0 x Ø	0.002	0.002	0.004	0.005	0.005	0.006	0.007
			Copy Milling	0.001	0.002	0.003	0.004	0.004	0.005	0.006
	<500 MPa	200	High Speed ap = 0.1 x Ø ae = 1.0 x Ø	0.002	0.002	0.004	0.005	0.005	0.006	0.007
			Copy Milling	0.001	0.002	0.003	0.004	0.004	0.005	0.006
	<800 MPa	120	High Speed ap = 0.1 x Ø ae = 1.0 x Ø	0.002	0.002	0.004	0.005	0.005	0.006	0.007
			Copy Milling	0.001	0.002	0.003	0.004	0.004	0.005	0.006
	<500 MPa	80	High Speed ap = 0.1 x Ø ae = 1.0 x Ø	0.002	0.002	0.004	0.005	0.005	0.006	0.007
	<500 MPa	60	High Speed ap = 0.1 x Ø ae = 1.0 x Ø	0.002	0.002	0.004	0.005	0.005	0.006	0.007
	<800 MPa	100	High Speed ap = 0.1 x Ø ae = 1.0 x Ø	0.002	0.002	0.004	0.005	0.005	0.006	0.007
			Copy Milling	0.001	0.002	0.003	0.004	0.004	0.005	0.006
	<500 MPa	80	High Speed ap = 0.1 x Ø ae = 1.0 x Ø	0.002	0.002	0.004	0.005	0.005	0.006	0.007
			Copy Milling	0.001	0.002	0.003	0.004	0.004	0.005	0.006
	<800 MPa	80	High Speed ap = 0.1 x Ø ae = 1.0 x Ø	0.002	0.002	0.004	0.005	0.005	0.006	0.007
			Copy Milling	0.001	0.002	0.003	0.004	0.004	0.005	0.006
	<500 MPa	200	High Speed ap = 0.1 x Ø ae = 1.0 x Ø	0.002	0.002	0.004	0.005	0.005	0.006	0.007
			Copy Milling	0.001	0.002	0.003	0.004	0.004	0.005	0.006
	<800 MPa	300	High Speed ap = 0.1 x Ø ae = 1.0 x Ø	0.001	0.003	0.004	0.005	0.006	0.008	0.009
			Copy Milling	0.001	0.002	0.003	0.004	0.005	0.006	0.007
	<500 MPa	200	High Speed ap = 0.1 x Ø ae = 1.0 x Ø	0.001	0.003	0.004	0.005	0.006	0.008	0.009
			Copy Milling	0.001	0.002	0.003	0.004	0.005	0.006	0.007
	<800 MPa	120	High Speed ap = 0.1 x Ø ae = 1.0 x Ø	0.001	0.003	0.004	0.005	0.006	0.008	0.009
			Copy Milling	0.001	0.002	0.003	0.004	0.005	0.006	0.007

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