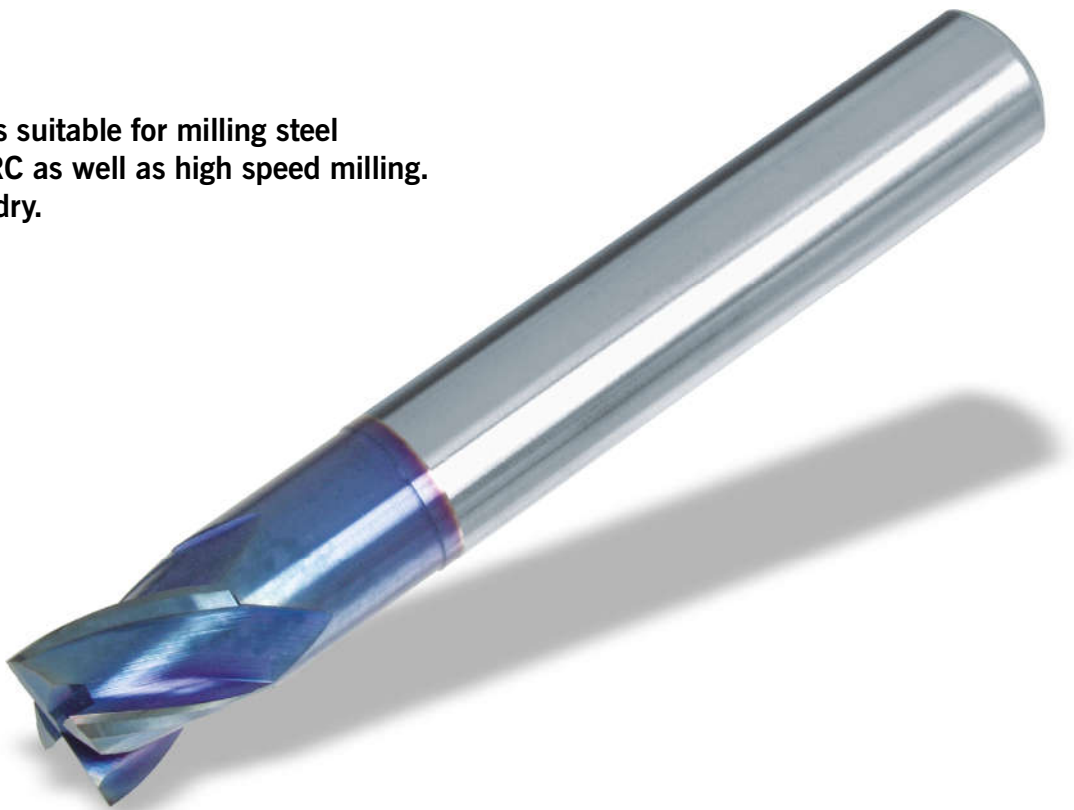


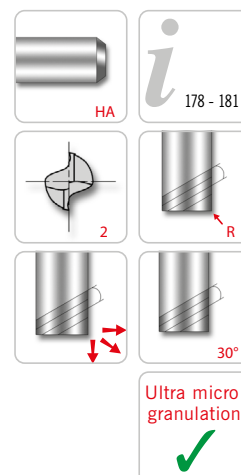
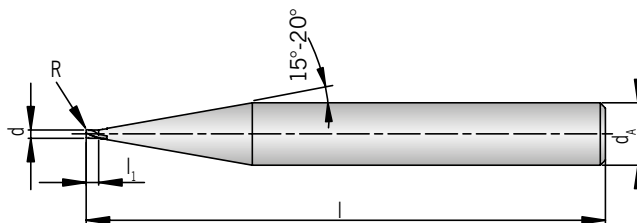
FOR THE REALLY HARD JOBS.

This series is suitable for milling steel
up to 70 HRC as well as high speed milling.
Can be run dry.



AFH50120-...R...

2 flutes, mini design, with corner radius



Shank DIN 6535HA	d -0,012	d _A h6	l ₁	l	R ±0,010	HC
						TiAl70
AFH50120-003	0.3	6	0.45	50	-	◆
AFH50120-004	0.4	6	0.60	50	-	◆
AFH50120-005R0,05	0.5	6	0.70	50	0.05	◆
AFH50120-006R0,05	0.6	6	0.90	50	0.05	◆
AFH50120-008R0,05	0.8	6	1.20	50	0.05	◆
AFH50120-010R0,1	1.0	6	1.50	50	0.10	◆
AFH50120-012R0,1	1.2	6	1.80	50	0.10	◆
AFH50120-015R0,15	1.5	6	2.20	50	0.15	◆
AFH50120-020R0,15	2.0	6	2.20	50	0.15	◆

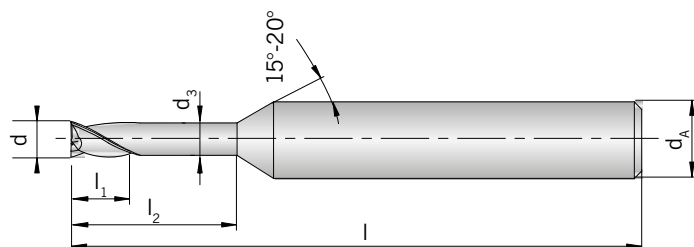
HC = Carbide coated

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● Main application
○ Secondary application

AFH50526-...

2 flutes, mini design



Shank DIN 6535HA	d -0,012	d _A h6	d ₃	l ₁	l ₂	l	HC
							TiA70
AFH50526-001A	0.1	4	0.085	0.15	0.3	45	◆
AFH50526-001B	0.1	4	0.085	0.15	0.5	45	◆
AFH50526-002A	0.2	4	0.180	0.30	0.5	45	◆
AFH50526-002B	0.2	4	0.180	0.30	1.0	45	◆
AFH50526-002C	0.2	4	0.180	0.30	1.5	45	◆
AFH50526-003A	0.3	4	0.270	0.45	1.0	45	◆
AFH50526-003B	0.3	4	0.270	0.45	1.5	45	◆
AFH50526-003C	0.3	4	0.270	0.45	2.0	45	◆
AFH50526-003D	0.3	4	0.270	0.45	3.0	45	◆
AFH50526-003E	0.3	4	0.270	0.45	4.0	45	◆
AFH50526-004A	0.4	4	0.370	0.60	1.0	45	◆
AFH50526-004B	0.4	4	0.370	0.60	2.0	45	◆
AFH50526-004C	0.4	4	0.370	0.60	3.0	45	◆
AFH50526-004D	0.4	4	0.370	0.60	4.0	45	◆
AFH50526-004E	0.4	4	0.370	0.60	5.0	45	◆
AFH50526-005A	0.5	4	0.450	0.70	2.0	45	◆
AFH50526-005B	0.5	4	0.450	0.70	2.5	45	◆
AFH50526-005C	0.5	4	0.450	0.70	4.0	45	◆
AFH50526-005D	0.5	4	0.450	0.70	6.0	45	◆
AFH50526-005E	0.5	4	0.450	0.70	8.0	45	◆
AFH50526-006A	0.6	4	0.550	0.90	2.0	45	◆
AFH50526-006B	0.6	4	0.550	0.90	3.0	45	◆
AFH50526-006C	0.6	4	0.550	0.90	4.0	45	◆
AFH50526-006D	0.6	4	0.550	0.90	6.0	45	◆
AFH50526-006E	0.6	4	0.550	0.90	8.0	45	◆
AFH50526-006F	0.6	4	0.550	0.90	10.0	45	◆
AFH50526-008A	0.8	4	0.750	1.20	2.0	45	◆
AFH50526-008B	0.8	4	0.750	1.20	4.0	45	◆
AFH50526-008C	0.8	4	0.750	1.20	6.0	45	◆
AFH50526-008D	0.8	4	0.750	1.20	8.0	45	◆
AFH50526-008E	0.8	4	0.750	1.20	10.0	45	◆
AFH50526-008F	0.8	4	0.750	1.20	12.0	45	◆
AFH50526-010A	1.0	4	0.950	1.50	4.0	45	◆
AFH50526-010B	1.0	4	0.950	1.50	6.0	45	◆
AFH50526-010C	1.0	4	0.950	1.50	8.0	45	◆
AFH50526-010D	1.0	4	0.950	1.50	10.0	45	◆
AFH50526-010E	1.0	4	0.950	1.50	12.0	45	◆

Shank DIN 6535HA	d -0,012	d _A h6	d ₃	l ₁	l ₂	l	HC
							TIA70
AFH50526-010F	1.0	4	0.950	1.50	16.0	50	◆
AFH50526-010G	1.0	4	0.950	1.50	20.0	55	◆
AFH50526-012A	1.2	4	1.150	1.80	6.0	45	◆
AFH50526-012B	1.2	4	1.150	1.80	8.0	45	◆
AFH50526-012C	1.2	4	1.150	1.80	10.0	45	◆
AFH50526-012D	1.2	4	1.150	1.80	12.0	45	◆
AFH50526-012E	1.2	4	1.150	1.80	16.0	50	◆
AFH50526-015A	1.5	4	1.450	2.30	6.0	45	◆
AFH50526-015B	1.5	4	1.450	2.30	8.0	45	◆
AFH50526-015C	1.5	4	1.450	2.30	10.0	45	◆
AFH50526-015D	1.5	4	1.450	2.30	12.0	45	◆
AFH50526-015E	1.5	4	1.450	2.30	14.0	50	◆
AFH50526-015F	1.5	4	1.450	2.30	16.0	50	◆
AFH50526-015G	1.5	4	1.450	2.30	18.0	55	◆
AFH50526-015H	1.5	4	1.450	2.30	20.0	55	◆
AFH50526-020A	2.0	4	1.950	3.00	6.0	45	◆
AFH50526-020B	2.0	4	1.950	3.00	8.0	45	◆
AFH50526-020C	2.0	4	1.950	3.00	10.0	45	◆
AFH50526-020D	2.0	4	1.950	3.00	12.0	45	◆
AFH50526-020E	2.0	4	1.950	3.00	14.0	50	◆
AFH50526-020F	2.0	4	1.950	3.00	16.0	50	◆
AFH50526-020G	2.0	4	1.950	3.00	18.0	55	◆
AFH50526-020H	2.0	4	1.950	3.00	20.0	55	◆
AFH50526-020J	2.0	4	1.950	3.00	25.0	60	◆
AFH50526-020K	2.0	4	1.950	3.00	30.0	70	◆
AFH50526-030A	3.0	6	2.850	4.50	10.0	45	◆
AFH50526-030B	3.0	6	2.850	4.50	12.0	45	◆
AFH50526-030C	3.0	6	2.850	4.50	14.0	50	◆
AFH50526-030D	3.0	6	2.850	4.50	16.0	55	◆
AFH50526-030E	3.0	6	2.850	4.50	18.0	55	◆
AFH50526-030F	3.0	6	2.850	4.50	20.0	60	◆
AFH50526-030G	3.0	6	2.850	4.50	25.0	65	◆
AFH50526-030H	3.0	6	2.850	4.50	30.0	70	◆
AFH50526-030J	3.0	6	2.850	4.50	35.0	80	◆
AFH50526-030K	3.0	6	2.850	4.50	40.0	90	◆
AFH50526-040A	4.0	6	3.850	6.00	12.0	50	◆
AFH50526-040B	4.0	6	3.850	6.00	16.0	60	◆
AFH50526-040C	4.0	6	3.850	6.00	20.0	60	◆
AFH50526-040D	4.0	6	3.850	6.00	25.0	70	◆
AFH50526-040E	4.0	6	3.850	6.00	30.0	70	◆
AFH50526-040F	4.0	6	3.850	6.00	35.0	80	◆
AFH50526-040G	4.0	6	3.850	6.00	40.0	90	◆
AFH50526-040H	4.0	6	3.850	6.00	45.0	90	◆
AFH50526-040J	4.0	6	3.850	6.00	50.0	100	◆

HC = Carbide coated

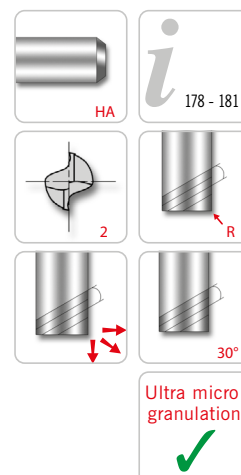
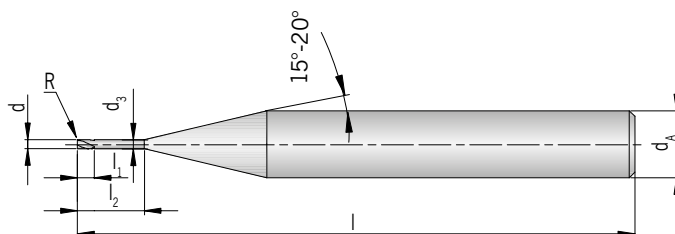
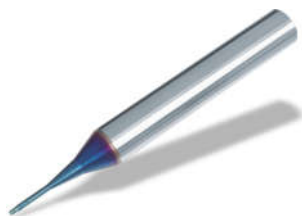
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● Main application

○ Secondary application

AFH50920-...R...

2 flutes, mini design, with corner radius

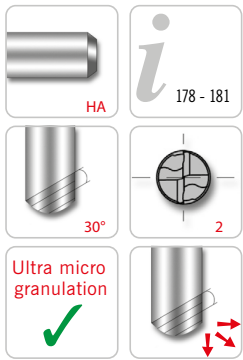
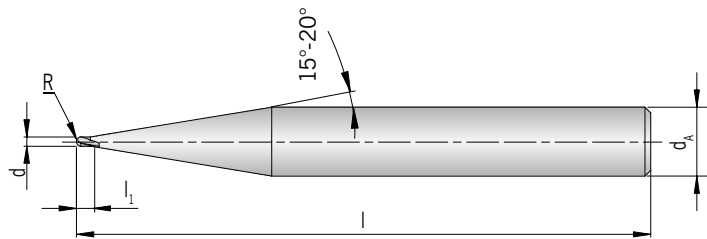


Shank DIN 6535HA	d -0,012	d _A h6	d ₃	l ₁	l ₂	l	R ±0,010	HC
								TiAl70
AFH50920-005AR0,05	0.5	6	0.45	0.7	1.5	50	0.05	◆
AFH50920-005BR0,05	0.5	6	0.45	0.7	3.3	50	0.05	◆
AFH50920-006AR0,05	0.6	6	0.55	0.9	2.0	50	0.05	◆
AFH50920-006BR0,05	0.6	6	0.55	0.9	4.0	50	0.05	◆
AFH50920-008AR0,05	0.8	6	0.75	1.2	2.5	50	0.05	◆
AFH50920-008BR0,05	0.8	6	0.75	1.2	5.5	50	0.05	◆
AFH50920-010AR0,1	1.0	6	0.95	1.5	3.3	50	0.10	◆
AFH50920-010BR0,1	1.0	6	0.95	1.5	6.7	50	0.10	◆
AFH50920-012AR0,1	1.2	6	1.15	1.8	4.4	50	0.10	◆
AFH50920-012BR0,1	1.2	6	1.15	1.8	8.0	50	0.10	◆
AFH50920-015AR0,15	1.5	6	1.45	2.2	5.0	50	0.15	◆
AFH50920-015BR0,15	1.5	6	1.45	2.2	9.7	50	0.15	◆
AFH50920-020AR0,15	2.0	6	1.95	2.2	6.0	50	0.15	◆
AFH50920-020BR0,15	2.0	6	1.95	2.2	13.0	50	0.15	◆

HC = Carbide coated

P	○
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N	
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H	●

AFH50320-...
2 flutes, mini design



Shank DIN 6535HA	d -0,012	d _A h6	l ₁	l	R ±0,005	HC
						TiAl70
AFH50320-004	0.4	6	0.4	50	0.20	◆
AFH50320-005	0.5	6	0.5	50	0.25	◆
AFH50320-006	0.6	6	0.6	50	0.30	◆
AFH50320-008	0.8	6	0.8	50	0.40	◆
AFH50320-010	1.0	6	1.0	50	0.50	◆
AFH50320-012	1.2	6	1.2	50	0.60	◆
AFH50320-015	1.5	6	1.5	50	0.75	◆
AFH50320-020	2.0	6	2.0	50	1.00	◆

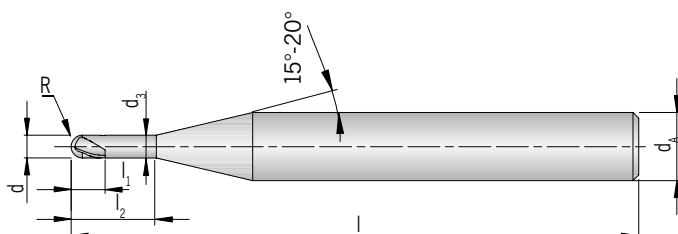
HC = Carbide coated

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● Main application
○ Secondary application

AFH52020-...

2 flutes, mini design



Shank DIN 6535HA	d -0,012	d _A h6	d ₃	l ₁	l ₂	l	R ±0,005	HC
								TiA70
AFH52020-005A	0.5	6	0.45	0.5	1.5	50	0.25	◆
AFH52020-005B	0.5	6	0.45	0.5	3.3	50	0.25	◆
AFH52020-006A	0.6	6	0.55	0.6	2.0	50	0.30	◆
AFH52020-006B	0.6	6	0.55	0.6	4.0	50	0.30	◆
AFH52020-008A	0.8	6	0.75	0.8	2.5	50	0.40	◆
AFH52020-008B	0.8	6	0.75	0.8	5.5	50	0.40	◆
AFH52020-010A	1.0	6	0.95	1.0	3.3	50	0.50	◆
AFH52020-010B	1.0	6	0.95	1.0	6.7	50	0.50	◆
AFH52020-010C	1.0	6	0.95	1.0	12.0	50	0.50	◆
AFH52020-012A	1.2	6	1.15	1.2	4.4	50	0.60	◆
AFH52020-012B	1.2	6	1.15	1.2	8.0	50	0.60	◆
AFH52020-015A	1.5	6	1.45	1.5	5.0	50	0.75	◆
AFH52020-015B	1.5	6	1.45	1.5	9.7	50	0.75	◆
AFH52020-015C	1.5	6	1.45	1.5	15.0	50	0.75	◆
AFH52020-020A	2.0	6	1.95	2.0	6.0	50	1.00	◆
AFH52020-020B	2.0	6	1.95	2.0	13.0	50	1.00	◆
AFH52020-020C	2.0	6	1.95	2.0	20.0	60	1.00	◆

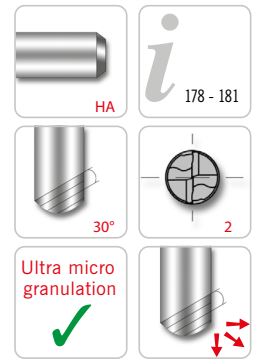
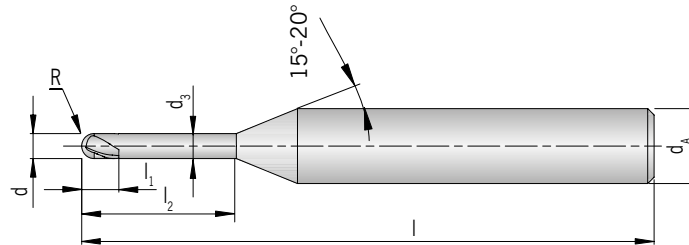
HC = Carbide coated

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● Main application
○ Secondary application

AFH52021-...

2 flutes, mini design



Shank DIN 6535HA	d -0,012	d _A h6	d ₃	l ₁	l ₂	l	R ± 0,005	HC
								TIA70
AFH52021-001A	0.1	4	0.085	0.1	0.3	45	0.05	◆
AFH52021-001B	0.1	4	0.085	0.1	0.5	45	0.05	◆
AFH52021-002A	0.2	4	0.180	0.2	0.5	45	0.10	◆
AFH52021-002B	0.2	4	0.180	0.2	1.0	45	0.10	◆
AFH52021-002C	0.2	4	0.180	0.2	1.5	45	0.10	◆
AFH52021-003A	0.3	4	0.270	0.3	1.0	45	0.15	◆
AFH52021-003B	0.3	4	0.270	0.3	2.0	45	0.15	◆
AFH52021-003C	0.3	4	0.270	0.3	3.0	45	0.15	◆
AFH52021-004A	0.4	4	0.370	0.4	1.0	45	0.20	◆
AFH52021-004B	0.4	4	0.370	0.4	2.0	45	0.20	◆
AFH52021-004C	0.4	4	0.370	0.4	3.0	45	0.20	◆
AFH52021-004D	0.4	4	0.370	0.4	4.0	45	0.20	◆
AFH52021-004E	0.4	4	0.370	0.4	5.0	45	0.20	◆
AFH52021-005A	0.5	4	0.450	0.4	2.0	45	0.25	◆
AFH52021-005B	0.5	4	0.450	0.4	2.5	45	0.25	◆
AFH52021-005C	0.5	4	0.450	0.4	4.0	45	0.25	◆
AFH52021-005D	0.5	4	0.450	0.4	6.0	45	0.25	◆
AFH52021-005E	0.5	4	0.450	0.4	8.0	45	0.25	◆
AFH52021-006A	0.6	4	0.550	0.5	2.0	45	0.30	◆
AFH52021-006B	0.6	4	0.550	0.5	3.0	45	0.30	◆
AFH52021-006C	0.6	4	0.550	0.5	4.0	45	0.30	◆
AFH52021-006D	0.6	4	0.550	0.5	5.0	45	0.30	◆
AFH52021-006E	0.6	4	0.550	0.5	6.0	45	0.30	◆
AFH52021-006F	0.6	4	0.550	0.5	8.0	45	0.30	◆
AFH52021-006G	0.6	4	0.550	0.5	10.0	45	0.30	◆
AFH52021-008A	0.8	4	0.750	0.6	2.0	45	0.40	◆
AFH52021-008B	0.8	4	0.750	0.6	4.0	45	0.40	◆
AFH52021-008C	0.8	4	0.750	0.6	6.0	45	0.40	◆
AFH52021-008D	0.8	4	0.750	0.6	8.0	45	0.40	◆
AFH52021-008E	0.8	4	0.750	0.6	10.0	45	0.40	◆
AFH52021-010A	1.0	4	0.950	0.8	3.0	45	0.50	◆
AFH52021-010B	1.0	4	0.950	0.8	4.0	45	0.50	◆
AFH52021-010C	1.0	4	0.950	0.8	5.0	45	0.50	◆
AFH52021-010D	1.0	4	0.950	0.8	6.0	45	0.50	◆
AFH52021-010E	1.0	4	0.950	0.8	7.0	45	0.50	◆
AFH52021-010F	1.0	4	0.950	0.8	8.0	45	0.50	◆
AFH52021-010G	1.0	4	0.950	0.8	9.0	45	0.50	◆

Shank DIN 6535HA	d -0,012	d _A h6	d ₃	l ₁	l ₂	l	R ± 0,005	HC
								TiAlN
AFH52021-010H	1.0	4	0.950	0.8	10.0	45	0.50	◆
AFH52021-010J	1.0	4	0.950	0.8	12.0	45	0.50	◆
AFH52021-010K	1.0	4	0.950	0.8	14.0	50	0.50	◆
AFH52021-010L	1.0	4	0.950	0.8	16.0	50	0.50	◆
AFH52021-010M	1.0	4	0.950	0.8	20.0	55	0.50	◆
AFH52021-012A	1.2	4	1.150	1.0	6.0	45	0.60	◆
AFH52021-012B	1.2	4	1.150	1.0	8.0	45	0.60	◆
AFH52021-012C	1.2	4	1.150	1.0	10.0	45	0.60	◆
AFH52021-012D	1.2	4	1.150	1.0	12.0	45	0.60	◆
AFH52021-015A	1.5	4	1.450	1.2	6.0	45	0.75	◆
AFH52021-015B	1.5	4	1.450	1.2	8.0	45	0.75	◆
AFH52021-015C	1.5	4	1.450	1.2	10.0	45	0.75	◆
AFH52021-015D	1.5	4	1.450	1.2	12.0	45	0.75	◆
AFH52021-015E	1.5	4	1.450	1.2	14.0	50	0.75	◆
AFH52021-015F	1.5	4	1.450	1.2	16.0	50	0.75	◆
AFH52021-015G	1.5	4	1.450	1.2	20.0	55	0.75	◆
AFH52021-020A	2.0	4	1.950	1.6	4.0	45	1.00	◆
AFH52021-020B	2.0	4	1.950	1.6	6.0	45	1.00	◆
AFH52021-020C	2.0	4	1.950	1.6	8.0	45	1.00	◆
AFH52021-020D	2.0	4	1.950	1.6	10.0	45	1.00	◆
AFH52021-020E	2.0	4	1.950	1.6	12.0	50	1.00	◆
AFH52021-020F	2.0	4	1.950	1.6	14.0	50	1.00	◆
AFH52021-020G	2.0	4	1.950	1.6	16.0	50	1.00	◆
AFH52021-020H	2.0	4	1.950	1.6	18.0	55	1.00	◆
AFH52021-020J	2.0	4	1.950	1.6	20.0	55	1.00	◆
AFH52021-020K	2.0	4	1.950	1.6	22.0	60	1.00	◆
AFH52021-020L	2.0	4	1.950	1.6	25.0	60	1.00	◆
AFH52021-020M	2.0	4	1.950	1.6	30.0	70	1.00	◆
AFH52021-030A	3.0	6	2.850	2.4	12.0	50	1.50	◆
AFH52021-030B	3.0	6	2.850	2.4	14.0	55	1.50	◆
AFH52021-030C	3.0	6	2.850	2.4	16.0	55	1.50	◆
AFH52021-030D	3.0	6	2.850	2.4	18.0	60	1.50	◆
AFH52021-030E	3.0	6	2.850	2.4	20.0	60	1.50	◆
AFH52021-030F	3.0	6	2.850	2.4	25.0	65	1.50	◆
AFH52021-030G	3.0	6	2.850	2.4	30.0	70	1.50	◆
AFH52021-030H	3.0	6	2.850	2.4	35.0	80	1.50	◆
AFH52021-040A	4.0	6	3.850	3.2	12.0	60	2.00	◆
AFH52021-040B	4.0	6	3.850	3.2	16.0	60	2.00	◆
AFH52021-040C	4.0	6	3.850	3.2	20.0	65	2.00	◆
AFH52021-040D	4.0	6	3.850	3.2	25.0	70	2.00	◆
AFH52021-040E	4.0	6	3.850	3.2	30.0	70	2.00	◆
AFH52021-040F	4.0	6	3.850	3.2	35.0	80	2.00	◆
AFH52021-040G	4.0	6	3.850	3.2	40.0	90	2.00	◆
AFH52021-040H	4.0	6	3.850	3.2	45.0	90	2.00	◆
AFH52021-040J	4.0	6	3.850	3.2	50.0	100	2.00	◆

HC = Carbide coated

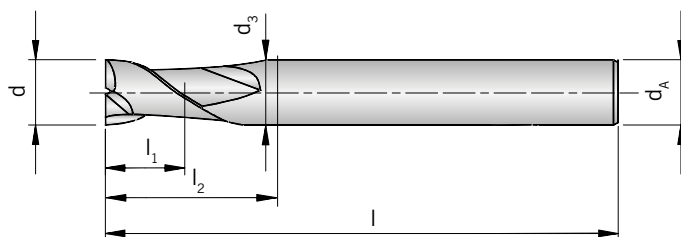
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● Main application

○ Secondary application

AFH50125-...

2 flutes



Shank DIN 6535HA	d -0,012	d _A h6	d ₃	l ₁	l ₂	l	HC
							TiAl70
AFH50125-001	0.1	4	-	0.2	-	40	◆
AFH50125-002	0.2	4	-	0.4	-	40	◆
AFH50125-003	0.3	4	-	0.6	-	40	◆
AFH50125-004	0.4	4	-	0.8	-	40	◆
AFH50125-005	0.5	4	-	1.0	-	40	◆
AFH50125-006	0.6	4	-	1.2	-	40	◆
AFH50125-007	0.7	4	-	1.4	-	40	◆
AFH50125-008	0.8	4	-	1.6	-	40	◆
AFH50125-009	0.9	4	-	2.0	-	40	◆
AFH50125-010	1.0	6	0.95	1.5	3	50	◆
AFH50125-015	1.5	6	1.45	1.7	4	50	◆
AFH50125-020	2.0	6	1.95	2.0	5	50	◆
AFH50125-025	2.5	6	2.40	2.5	6	55	◆
AFH50125-030	3.0	6	2.85	3.0	8	55	◆
AFH50125-035	3.5	6	3.35	3.5	9	55	◆
AFH50125-040	4.0	6	3.85	4.0	10	55	◆
AFH50125-050	5.0	6	4.85	5.0	13	55	◆

HC = Carbide coated

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● Main application
○ Secondary application

Shank DIN 6535HA	d -0,012	d _A h6	d ₃	l ₁	l ₂	l	HC
							TIA70
AFH50125-060	6	6	5.85	6	15	55	◆
AFH50125-080	8	8	7.70	8	20	65	◆
AFH50125-100	10	10	9.70	10	25	75	◆
AFH50125-120	12	12	11.70	12	28	85	◆
AFH50125-160	16	16	15.70	16	32	90	◆
AFH50125-200	20	20	19.70	20	40	105	◆

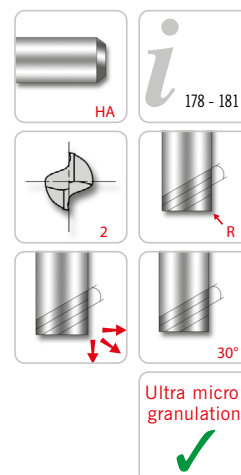
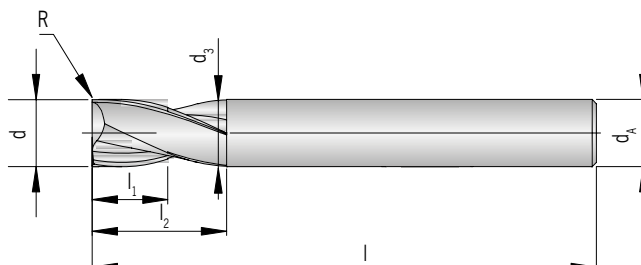
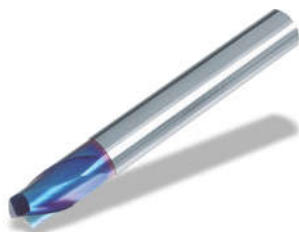
HC = Carbide coated

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● Main application
○ Secondary application

AFH50725-...R...

2 flutes, with corner radius



Shank DIN 6535HA	d -0,012	d _A h6	d ₃	l ₁	l ₂	l	R ±0,010	HC
								TiAl70
AFH50725-005R0,05	0.5	4	-	1.0	-	40	0.05	◆
AFH50725-006R0,05	0.6	4	-	1.2	-	40	0.05	◆
AFH50725-007R0,05	0.7	4	-	1.4	-	40	0.05	◆
AFH50725-008R0,05	0.8	4	-	1.6	-	40	0.05	◆
AFH50725-009R0,05	0.9	4	-	2.0	-	40	0.05	◆
AFH50725-010AR0,1	1.0	4	-	1.5	-	40	0.10	◆
AFH50725-010BR0,1	1.0	6	-	1.5	-	40	0.10	◆
AFH50725-015R0,1	1.5	6	-	2.2	-	40	0.10	◆
AFH50725-020AR0,1	2.0	4	1.95	3.0	6	40	0.10	◆
AFH50725-020BR0,1	2.0	6	1.95	3.0	6	40	0.10	◆
AFH50725-025R0,1	2.5	6	2.40	4.0	6	40	0.10	◆
AFH50725-030R0,1	3.0	6	2.85	4.0	7	45	0.10	◆
AFH50725-035R0,1	3.5	6	3.35	5.0	9	45	0.10	◆
AFH50725-040R0,1	4.0	6	3.85	5.0	9	45	0.10	◆
AFH50725-045R0,1	4.5	6	4.35	6.0	10	45	0.10	◆
AFH50725-050R0,2	5.0	6	4.85	6.0	11	50	0.20	◆

HC = Carbide coated

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● Main application
○ Secondary application

Shank DIN 6535HA	d -0,012	d _A h6	d ₃	l ₁	l ₂	l	R ±0,010	HC
								TIA70
AFH50725-060R0,2	6	6	5.85	7	14	50	0.2	◆
AFH50725-080R0,2	8	8	7.70	9	18	60	0.2	◆
AFH50725-100R0,2	10	10	9.70	12	25	75	0.2	◆
AFH50725-120R0,3	12	12	11.70	15	30	75	0.3	◆
AFH50725-160R0,3	16	16	15.70	18	38	90	0.3	◆
AFH50725-200R0,3	20	20	19.70	24	45	100	0.3	◆

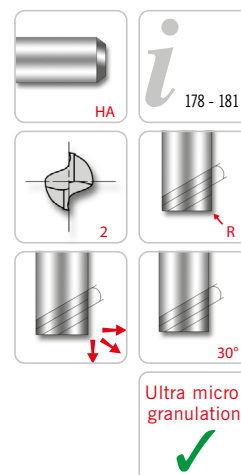
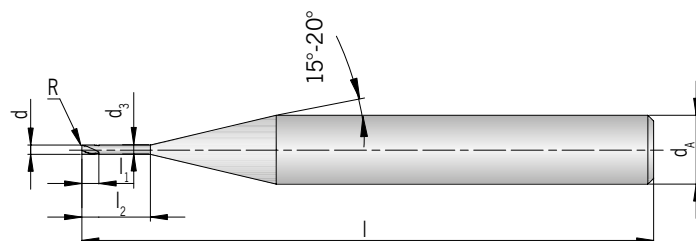
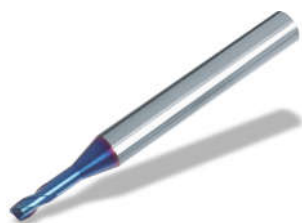
HC = Carbide coated

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● Main application
○ Secondary application

AFH50926-...R...

2 flutes, with corner radius



Shank DIN 6535HA	d -0,012	d _A h6	d ₃	l ₁	l ₂	l	R ±0,010	HC
								TiAl70
AFH50926-005AR0,05	0.5	4	0.45	0.7	1.5	45	0.05	◆
AFH50926-005BR0,05	0.5	4	0.45	0.7	2.5	45	0.05	◆
AFH50926-005CR0,05	0.5	4	0.45	0.7	4.0	45	0.05	◆
AFH50926-006AR0,05	0.6	4	0.55	0.9	2.0	45	0.05	◆
AFH50926-006BR0,05	0.6	4	0.55	0.9	3.0	45	0.05	◆
AFH50926-006CR0,05	0.6	4	0.55	0.9	4.0	45	0.05	◆
AFH50926-006DR0,1	0.6	4	0.55	0.9	2.0	45	0.10	◆
AFH50926-007R0,1	0.7	4	0.65	1.0	4.0	45	0.10	◆
AFH50926-008AR0,1	0.8	4	0.75	1.2	2.0	45	0.10	◆
AFH50926-008BR0,1	0.8	4	0.75	1.2	4.0	45	0.10	◆
AFH50926-008CR0,1	0.8	4	0.75	1.2	6.0	45	0.10	◆
AFH50926-010AR0,1	1.0	6	0.95	1.5	4.0	50	0.10	◆
AFH50926-010BR0,1	1.0	6	0.95	1.5	6.0	50	0.10	◆
AFH50926-010CR0,2	1.0	6	0.95	1.5	4.0	50	0.20	◆
AFH50926-010DR0,2	1.0	6	0.95	1.5	6.0	50	0.20	◆
AFH50926-010ER0,2	1.0	6	0.95	1.5	8.0	50	0.20	◆
AFH50926-010FR0,3	1.0	6	0.95	1.5	4.0	50	0.30	◆
AFH50926-010GR0,3	1.0	6	0.95	1.5	6.0	50	0.30	◆
AFH50926-010HR0,3	1.0	6	0.95	1.5	8.0	50	0.30	◆
AFH50926-015AR0,2	1.5	6	1.45	2.5	4.0	50	0.20	◆
AFH50926-015BR0,2	1.5	6	1.45	2.5	6.0	50	0.20	◆
AFH50926-015CR0,2	1.5	6	1.45	2.5	8.0	50	0.20	◆
AFH50926-015DR0,2	1.5	6	1.45	2.5	10.0	50	0.20	◆
AFH50926-015ER0,2	1.5	6	1.45	2.5	12.0	50	0.20	◆
AFH50926-015FR0,3	1.5	6	1.45	2.5	4.0	50	0.30	◆
AFH50926-015GR0,3	1.5	6	1.45	2.5	6.0	50	0.30	◆
AFH50926-015HR0,3	1.5	6	1.45	2.5	8.0	50	0.30	◆
AFH50926-020AR0,2	2.0	6	1.95	3.0	6.0	50	0.20	◆
AFH50926-020BR0,2	2.0	6	1.95	3.0	8.0	50	0.20	◆
AFH50926-020CR0,2	2.0	6	1.95	3.0	10.0	55	0.20	◆
AFH50926-020DR0,2	2.0	6	1.95	3.0	12.0	55	0.20	◆
AFH50926-020ER0,3	2.0	6	1.95	3.0	6.0	50	0.30	◆
AFH50926-020FR0,3	2.0	6	1.95	3.0	8.0	50	0.30	◆
AFH50926-020GR0,3	2.0	6	1.95	3.0	10.0	55	0.30	◆
AFH50926-020HR0,3	2.0	6	1.95	3.0	12.0	55	0.30	◆
AFH50926-020JR0,3	2.0	6	1.95	3.0	16.0	55	0.30	◆
AFH50926-020KR0,5	2.0	6	1.95	3.0	6.0	50	0.50	◆

Shank DIN 6535HA	d -0,012	d _A h6	d ₃	l ₁	l ₂	l	R ±0,010	HC
								TIA70
AFH50926-020LR0,5	2.0	6	1.95	3.0	10.0	55	0.50	◆
AFH50926-020MR0,5	2.0	6	1.95	3.0	12.0	55	0.50	◆
AFH50926-030AR0,2	3.0	6	2.85	4.0	8.0	55	0.20	◆
AFH50926-030BR0,2	3.0	6	2.85	4.0	10.0	55	0.20	◆
AFH50926-030CR0,2	3.0	6	2.85	4.0	12.0	55	0.20	◆
AFH50926-030DR0,2	3.0	6	2.85	4.0	16.0	55	0.20	◆
AFH50926-030ER0,3	3.0	6	2.85	4.0	8.0	55	0.30	◆
AFH50926-030FR0,3	3.0	6	2.85	4.0	10.0	55	0.30	◆
AFH50926-030GR0,3	3.0	6	2.85	4.0	12.0	55	0.30	◆
AFH50926-030HR0,3	3.0	6	2.85	4.0	16.0	55	0.30	◆
AFH50926-030JR0,5	3.0	6	2.85	4.0	10.0	55	0.50	◆
AFH50926-030KR0,5	3.0	6	2.85	4.0	12.0	55	0.50	◆
AFH50926-030LR0,5	3.0	6	2.85	4.0	16.0	55	0.50	◆
AFH50926-030MR0,5	3.0	6	2.85	4.0	20.0	55	0.50	◆
AFH50926-040AR0,2	4.0	6	3.85	5.0	12.0	55	0.20	◆
AFH50926-040BR0,2	4.0	6	3.85	5.0	16.0	55	0.20	◆
AFH50926-040CR0,2	4.0	6	3.85	5.0	20.0	55	0.20	◆
AFH50926-040DR0,3	4.0	6	3.85	5.0	10.0	55	0.30	◆
AFH50926-040ER0,3	4.0	6	3.85	5.0	12.0	55	0.30	◆
AFH50926-040FR0,3	4.0	6	3.85	5.0	16.0	55	0.30	◆
AFH50926-040GR0,3	4.0	6	3.85	5.0	20.0	55	0.30	◆
AFH50926-040HR0,5	4.0	6	3.85	5.0	12.0	55	0.50	◆
AFH50926-040JR0,5	4.0	6	3.85	5.0	16.0	55	0.50	◆
AFH50926-040KR0,5	4.0	6	3.85	5.0	20.0	55	0.50	◆
AFH50926-040LR1,0	4.0	6	3.85	5.0	12.0	55	1.00	◆
AFH50926-040MR1,0	4.0	6	3.85	5.0	16.0	55	1.00	◆

HC = Carbide coated

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● Main application

○ Secondary application

Shank DIN 6535HA	d -0,012	d _A h6	d ₃	l ₁	l ₂	l	R ±0,010	HC
								TIA70
AFH50926-060AR0,3	6	6	5.85	7	20	60	0.3	◆
AFH50926-060BR0,5	6	6	5.85	7	20	60	0.5	◆
AFH50926-060CR1,0	6	6	5.85	7	20	60	1.0	◆
AFH50926-060DR1,5	6	6	5.85	7	20	60	1.5	◆
AFH50926-060ER2,0	6	6	5.85	7	20	60	2.0	◆
AFH50926-080AR0,3	8	8	7.70	9	25	60	0.3	◆
AFH50926-080BR0,5	8	8	7.70	9	25	60	0.5	◆
AFH50926-080CR1,0	8	8	7.70	9	25	60	1.0	◆
AFH50926-080DR1,5	8	8	7.70	9	25	60	1.5	◆
AFH50926-080ER2,0	8	8	7.70	9	25	60	2.0	◆
AFH50926-100AR0,3	10	10	9.70	11	32	70	0.3	◆
AFH50926-100BR0,5	10	10	9.70	11	32	70	0.5	◆
AFH50926-100CR1,0	10	10	9.70	11	32	70	1.0	◆
AFH50926-100DR1,5	10	10	9.70	11	32	70	1.5	◆
AFH50926-100ER2,0	10	10	9.70	11	32	70	2.0	◆
AFH50926-120AR0,5	12	12	11.70	12	38	80	0.5	◆
AFH50926-120BR1,0	12	12	11.70	12	38	80	1.0	◆
AFH50926-120CR1,5	12	12	11.70	12	38	80	1.5	◆
AFH50926-120DR2,0	12	12	11.70	12	38	80	2.0	◆

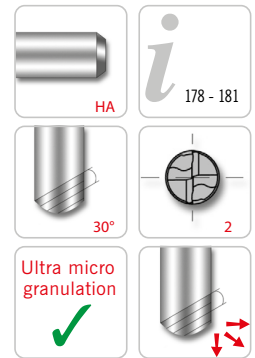
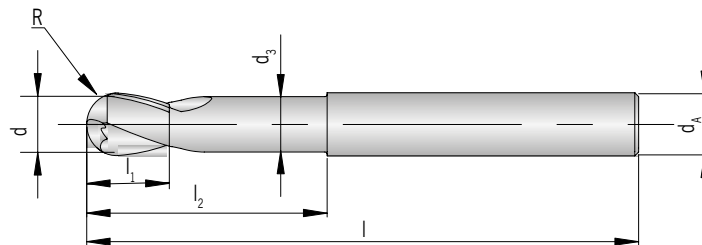
HC = Carbide coated

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● Main application
○ Secondary application

AFH51625-...

2 flutes



Shank DIN 6535HA	d -0,012	d _A h6	d ₃	l ₁	l ₂	l	R ±0,005	HC
								TiAl70
AFH51625-010	1.0	4	0.95	1.0	2.2	50	0.50	◆
AFH51625-012	1.2	4	1.15	1.2	2.6	50	0.60	◆
AFH51625-015	1.5	4	1.45	1.5	3.0	50	0.75	◆
AFH51625-020	2.0	6	1.95	2.0	4.0	50	1.00	◆
AFH51625-030	3.0	6	2.85	3.0	6.0	60	1.50	◆
AFH51625-040	4.0	6	3.85	4.0	8.0	70	2.00	◆
AFH51625-050	5.0	6	4.85	5.0	10.0	80	2.50	◆

HC = Carbide coated

P	○
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● Main application
○ Secondary application

Shank DIN 6535HA	d -0,012	d _A h6	d ₃	l ₁	l ₂	l	R ±0,005	HC
								TIA70
AFH51625-060	6	6	5.85	6	12	90	3.0	◆
AFH51625-070	7	8	6.70	7	14	90	3.5	◆
AFH51625-080	8	8	7.70	8	16	100	4.0	◆
AFH51625-090	9	10	8.70	9	18	100	4.5	◆
AFH51625-100	10	10	9.70	10	20	100	5.0	◆
AFH51625-120	12	12	11.70	12	24	110	6.0	◆
AFH51625-140	14	14	13.70	14	28	110	7.0	◆
AFH51625-160	16	16	15.70	16	32	140	8.0	◆
AFH51625-180	18	18	17.70	18	36	140	9.0	◆
AFH51625-200	20	20	19.70	20	40	160	10.0	◆
AFH51625-250	25	25	24.70	25	50	180	12.5	◆

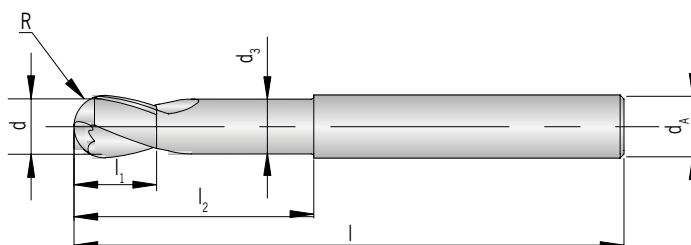
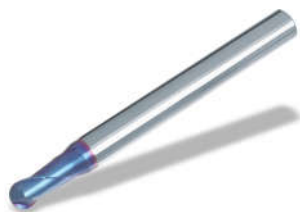
HC = Carbide coated

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● Main application
○ Secondary application

AFH51626-...

2 flutes



Shank DIN 6535HA	d -0,012	d _A h6	d ₃	l ₁	l ₂	l	R ±0,005	HC
								TiA70
AFH51626-001	0.1	4	-	0.2	-	40	0.05	◆
AFH51626-002	0.2	4	-	0.3	-	40	0.10	◆
AFH51626-003	0.3	4	-	0.5	-	40	0.15	◆
AFH51626-004	0.4	4	-	0.6	-	40	0.20	◆
AFH51626-005	0.5	4	-	0.7	-	40	0.25	◆
AFH51626-006	0.6	4	-	0.9	-	40	0.30	◆
AFH51626-007	0.7	4	-	1.1	-	40	0.35	◆
AFH51626-008	0.8	4	-	1.2	-	40	0.40	◆
AFH51626-009	0.9	4	-	1.4	-	40	0.45	◆
AFH51626-010	1.0	6	0.95	1.5	3	50	0.50	◆
AFH51626-015	1.5	6	1.45	2.0	4	50	0.75	◆
AFH51626-020	2.0	6	1.95	2.5	5	50	1.00	◆
AFH51626-025	2.5	6	2.40	3.0	7	50	1.25	◆
AFH51626-030	3.0	6	2.85	4.0	10	60	1.50	◆
AFH51626-035	3.5	6	3.35	4.5	10	60	1.75	◆
AFH51626-040	4.0	6	3.85	5.0	10	60	2.00	◆
AFH51626-045	4.5	6	4.35	5.5	10	60	2.25	◆
AFH51626-050	5.0	6	4.85	6.0	12	60	2.50	◆
AFH51626-055	5.5	6	5.35	6.5	12	60	2.75	◆

HC = Carbide coated

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● Main application
○ Secondary application

Shank DIN 6535HA	d -0,012	d _A h6	d ₃	l ₁	l ₂	l	R ±0,005	HC
								TiA70
AFH51626-060A	6	6	5.85	7	15	60	3	◆

Shank DIN 6535HA	d -0,012	d _A h6	d ₃	l ₁	l ₂	l	R ±0,005	HC
								TIA70
AFH51626-060B	6	6	5.85	9	30	90	3	◆
AFH51626-080A	8	8	7.70	9	15	60	4	◆
AFH51626-080B	8	8	7.70	9	15	80	4	◆
AFH51626-080C	8	8	7.70	12	30	100	4	◆
AFH51626-100A	10	10	9.70	11	25	60	5	◆
AFH51626-100B	10	10	9.70	11	25	80	5	◆
AFH51626-100C	10	10	9.70	15	30	100	5	◆
AFH51626-120	12	12	11.70	14	25	80	6	◆

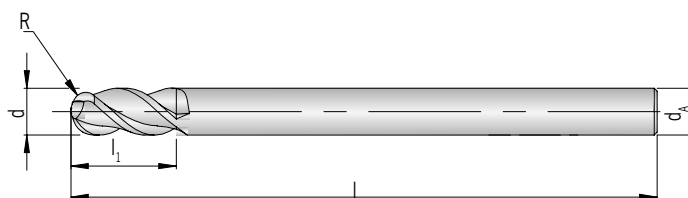
HC = Carbide coated

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● Main application
○ Secondary application

AFH51635-...

3 flutes



Shank DIN 6535HA	d -0,012	d _A h6	l ₁	l	R ±0,005	HC
						TIA70
AFH51635-030	3	6	8	60	1.5	◆
AFH51635-040	4	6	8	70	2.0	◆
AFH51635-050	5	6	10	80	2.5	◆

HC = Carbide coated

P	○
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H	●

● Main application
○ Secondary application

Shank DIN 6535HA	d -0,012	d _A h6	l ₁	l	R ±0,005	HC
						TIA70
AFH51635-060	6	6	12	90	3	◆
AFH51635-080	8	8	14	100	4	◆
AFH51635-100	10	10	18	100	5	◆
AFH51635-120	12	12	22	110	6	◆
AFH51635-160	16	16	30	140	8	◆
AFH51635-200	20	20	38	160	10	◆

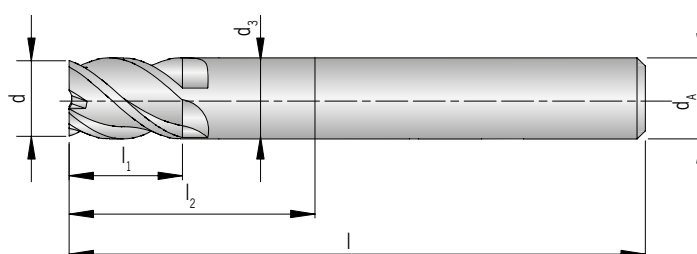
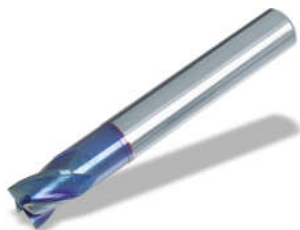
HC = Carbide coated

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● Main application
○ Secondary application

AFH50140-...

4 flutes



Shank DIN 6535HA	d -0,012	d _A h6	d ₃	l ₁	l ₂	l	HC
							TiAl70
AFH50140-010	1	6	0.95	1.5	3	50	◆
AFH50140-020	2	6	1.95	2.0	5	50	◆
AFH50140-030	3	6	2.85	3.0	8	55	◆
AFH50140-040	4	6	3.85	4.0	10	55	◆
AFH50140-050	5	6	4.85	5.0	13	55	◆

HC = Carbide coated

P	○
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H	●

● Main application
○ Secondary application

Shank DIN 6535HA	d -0,012	d _A h6	d ₃	l ₁	l ₂	l	HC
							TiAl70
AFH50140-060	6	6	5.85	6	15	55	◆
AFH50140-080	8	8	7.70	8	20	65	◆
AFH50140-100	10	10	9.70	10	25	75	◆
AFH50140-120	12	12	11.70	12	28	85	◆
AFH50140-160	16	16	15.70	16	32	90	◆
AFH50140-200	20	20	19.70	20	40	105	◆

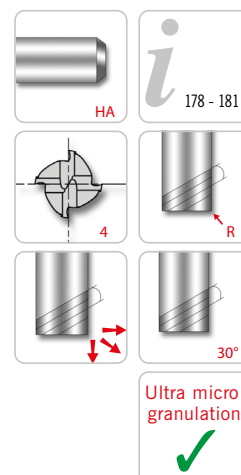
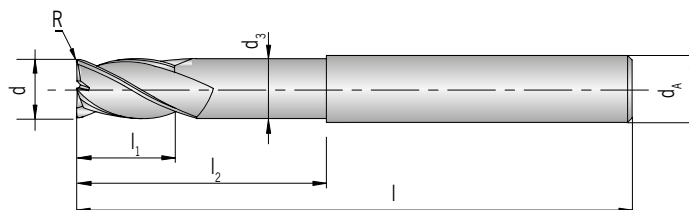
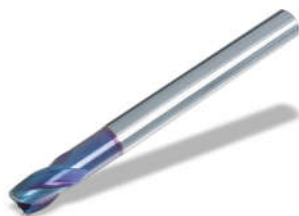
HC = Carbide coated

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● Main application
○ Secondary application

AFH50142-...R...

4 flutes, with corner radius



Shank DIN 6535HA	d -0,015	d _A h6	d ₃	l ₁	l ₂	l	R ±0,015	HC
								TiAl70
AFH50142-060R0,5	6	6	5.85	9	20	90	0.5	◆
AFH50142-060R1,0	6	6	5.85	9	20	90	1.0	◆
AFH50142-080R0,5	8	8	7.70	12	25	100	0.5	◆
AFH50142-080R1,0	8	8	7.70	12	25	100	1.0	◆
AFH50142-100R0,5	10	10	9.70	15	32	100	0.5	◆
AFH50142-100R1,0	10	10	9.70	15	32	100	1.0	◆
AFH50142-100R2,0	10	10	9.70	15	32	100	2.0	◆
AFH50142-120R0,5	12	12	11.70	18	38	110	0.5	◆
AFH50142-120R1,0	12	12	11.70	18	38	110	1.0	◆
AFH50142-120R2,0	12	12	11.70	18	38	110	2.0	◆

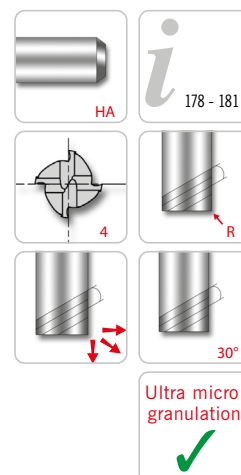
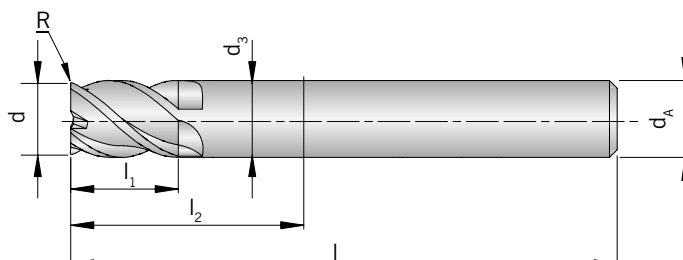
HC = Carbide coated

P	○
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● Main application
○ Secondary application

AFH50146-...R...

4 flutes, with corner radius



Shank DIN 6535HA	d -0,012	d _A h6	d ₃	l ₁	l ₂	l	R ±0,010	HC
								TiAl70
AFH50146-030AR0,3	3	6	2.85	4	12	55	0.3	◆
AFH50146-030BR0,3	3	6	2.85	4	16	55	0.3	◆
AFH50146-030CR0,3	3	6	2.85	4	20	55	0.3	◆
AFH50146-030DR0,5	3	6	2.85	4	10	55	0.5	◆
AFH50146-030ER0,5	3	6	2.85	4	16	55	0.5	◆
AFH50146-030FR0,5	3	6	2.85	4	20	55	0.5	◆
AFH50146-040AR0,3	4	6	3.85	5	12	55	0.3	◆
AFH50146-040BR0,3	4	6	3.85	5	16	55	0.3	◆
AFH50146-040CR0,3	4	6	3.85	5	20	55	0.3	◆
AFH50146-040DR0,5	4	6	3.85	5	12	55	0.5	◆
AFH50146-040ER0,5	4	6	3.85	5	16	55	0.5	◆
AFH50146-040FR0,5	4	6	3.85	5	20	55	0.5	◆
AFH50146-040GR1,0	4	6	3.85	5	12	55	1.0	◆

HC = Carbide coated

P	○
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● Main application
○ Secondary application

Shank DIN 6535HA	d -0,012	d _A h6	d ₃	l ₁	l ₂	l	R ±0,010	HC
								TIA70
AFH50146-060AR0,5	6	6	5.85	7	20	60	0.5	◆
AFH50146-060BR1,0	6	6	5.85	7	20	60	1.0	◆
AFH50146-060CR1,5	6	6	5.85	7	20	60	1.5	◆
AFH50146-080AR0,5	8	8	7.70	9	25	60	0.5	◆
AFH50146-080BR1,0	8	8	7.70	9	25	60	1.0	◆
AFH50146-080CR1,5	8	8	7.70	9	25	60	1.5	◆
AFH50146-080DR2,0	8	8	7.70	9	25	60	2.0	◆
AFH50146-100AR0,5	10	10	9.70	11	32	70	0.5	◆
AFH50146-100BR1,0	10	10	9.70	11	32	70	1.0	◆
AFH50146-100CR1,5	10	10	9.70	11	32	70	1.5	◆
AFH50146-100DR2,0	10	10	9.70	11	32	70	2.0	◆
AFH50146-120AR0,5	12	12	11.70	12	38	80	0.5	◆
AFH50146-120BR1,0	12	12	11.70	12	38	80	1.0	◆
AFH50146-120CR1,5	12	12	11.70	12	38	80	1.5	◆
AFH50146-120DR2,0	12	12	11.70	12	38	80	2.0	◆

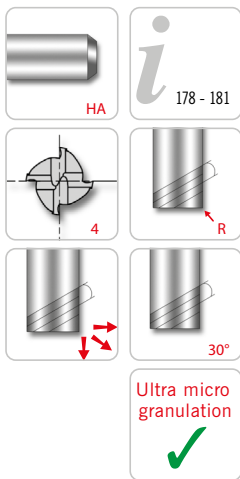
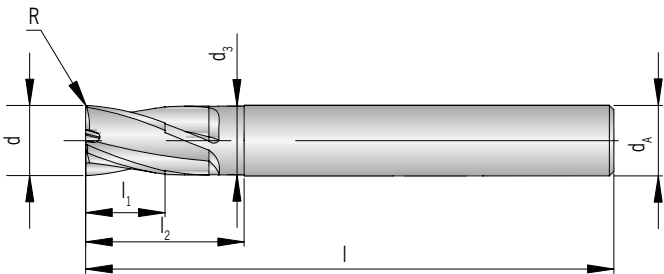
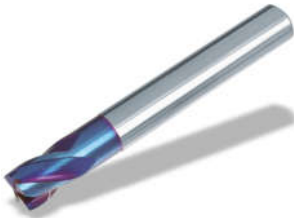
HC = Carbide coated

P	○
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● Main application
○ Secondary application

AFH50745-...R...

4 flutes, with corner radius



Shank DIN 6535HA	d -0,012	d _A h6	d ₃	l ₁	l ₂	l	R ±0,010	HC
								TiAl70
AFH50745-010R0,1	1.0	6	-	1.5	-	40	0.1	◆
AFH50745-015R0,1	1.5	6	-	2.2	-	40	0.1	◆
AFH50745-020R0,1	2.0	6	1.95	3.0	6	40	0.1	◆
AFH50745-025R0,1	2.5	6	2.40	4.0	6	40	0.1	◆
AFH50745-030R0,1	3.0	6	2.85	4.0	7	45	0.1	◆
AFH50745-035R0,1	3.5	6	3.35	5.0	9	45	0.1	◆
AFH50745-040R0,1	4.0	6	3.85	5.0	9	45	0.1	◆
AFH50745-045R0,1	4.5	6	4.35	6.0	10	45	0.1	◆
AFH50745-050R0,2	5.0	6	4.85	6.0	11	50	0.2	◆

HC = Carbide coated

P	○
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● Main application
○ Secondary application

Shank DIN 6535HA	d -0,012	d _A h6	d ₃	l ₁	l ₂	l	R ±0,010	HC
								TiAlN
AFH50745-060R0,2	◆	6	5.85	7	14	50	0.2	◆
AFH50745-080R0,2	◆	8	7.70	9	18	60	0.2	◆
AFH50745-100R0,2	◆	10	9.70	12	25	75	0.2	◆
AFH50745-120R0,3	◆	12	11.70	15	30	75	0.3	◆
AFH50745-160R0,3	◆	16	15.70	18	38	90	0.3	◆
AFH50745-200R0,3	◆	20	19.70	24	45	100	0.3	◆

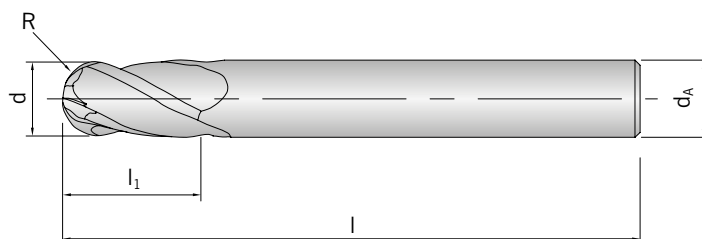
HC = Carbide coated

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● Main application
○ Secondary application

AFH50341-...

4 flutes



Shank DIN 6535HA	d -0,012	d _A h6	l ₁	l	R ±0,005	HC
						TiAl70
AFH50341-030	3	6	8	60	1.5	◆
AFH50341-040	4	6	8	70	2.0	◆
AFH50341-050	5	6	10	80	2.5	◆

HC = Carbide coated

P	○
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● Main application
○ Secondary application

Shank DIN 6535HA	d -0,012	d _A h6	l ₁	l	R ±0,005	HC
						TiAl70
AFH50341-060	6	6	12	90	3	◆
AFH50341-080	8	8	14	100	4	◆
AFH50341-100	10	10	18	100	5	◆
AFH50341-120	12	12	22	110	6	◆
AFH50341-160	16	16	30	140	8	◆
AFH50341-200	20	20	38	160	10	◆

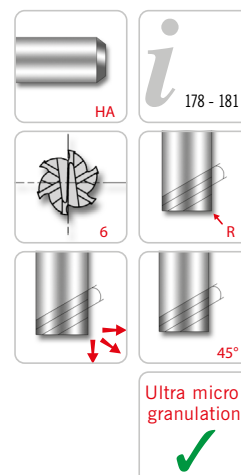
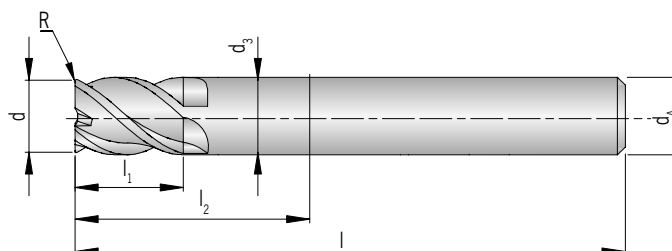
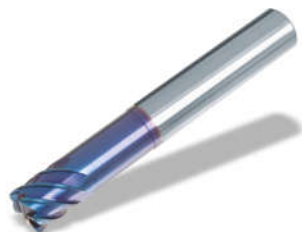
HC = Carbide coated

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● Main application
○ Secondary application

AFH50865-...R...

6 flutes, with corner radius



Shank DIN 6535HA	d -0,015	d _A h6	d ₃	l ₁	l ₂	l	R ±0,015	HC
								TiAl70
AFH50865-060AR0,25	6	6	5.85	6	14	50	0.25	◆
AFH50865-060BR0,5	6	6	5.85	6	14	50	0.50	◆
AFH50865-060CR0,5	6	6	-	13	-	70	0.50	◆
AFH50865-060DR0,5 ¹⁾	6	6	-	26	-	70	0.50	◆
AFH50865-080AR0,5	8	8	7.70	8	24	60	0.50	◆
AFH50865-080BR0,5	8	8	-	19	-	90	0.50	◆
AFH50865-080CR0,5 ¹⁾	8	8	-	36	-	90	0.50	◆
AFH50865-100AR0,5	10	10	-	22	-	100	0.50	◆
AFH50865-100BR1,0	10	10	9.70	10	30	70	1.00	◆
AFH50865-100CR1,0	10	10	-	22	-	100	1.00	◆
AFH50865-100DR1,0 ¹⁾	10	10	-	46	-	100	1.00	◆
AFH50865-120AR0,5	12	12	-	26	-	110	0.50	◆
AFH50865-120BR1,0	12	12	11.70	12	30	75	1.00	◆
AFH50865-120CR1,0	12	12	-	26	-	110	1.00	◆
AFH50865-120DR1,0 ¹⁾	12	12	-	56	-	110	1.00	◆
AFH50865-160AR1,0	16	16	-	32	-	130	1.00	◆
AFH50865-160BR1,5	16	16	-	32	-	130	1.50	◆
AFH50865-160CR1,5 ¹⁾	16	16	-	66	-	130	1.50	◆
AFH50865-200AR1,0	20	20	-	38	-	140	1.00	◆
AFH50865-200BR1,5	20	20	-	38	-	140	1.50	◆
AFH50865-200CR2,0 ¹⁾	20	20	-	38	-	140	2.00	◆
AFH50865-200DR2,0	20	20	-	76	-	140	2.00	◆

HC = Carbide coated

1) Tolerance for d of -0.03

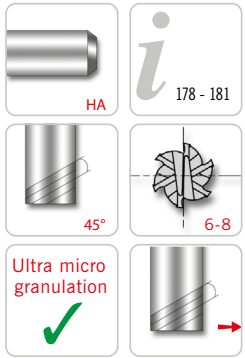
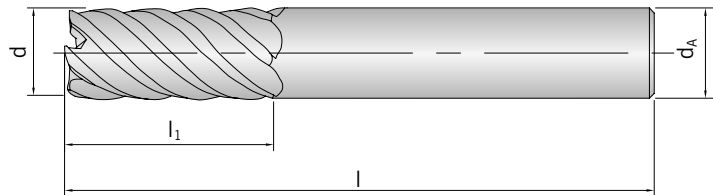
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● Main application

○ Secondary application

AFH508.1-...

6 - 8 flutes, long design



Shank DIN 6535HA	d -0,02	d _A h6	l ₁	l	z	HC
						TiAl70
AFH50861-060	6	6	13	57	6	◆
AFH50861-080	8	8	19	63	6	◆
AFH50861-100	10	10	22	72	6	◆
AFH50861-120	12	12	26	83	6	◆
AFH50861-140	14	14	26	83	6	◆
AFH50861-160	16	16	32	92	6	◆
AFH50881-180	18	18	32	92	8	◆
AFH50881-200	20	20	38	104	8	◆
AFH50881-250	25	25	44	104	8	◆

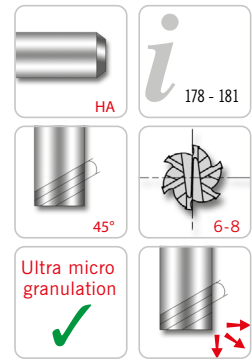
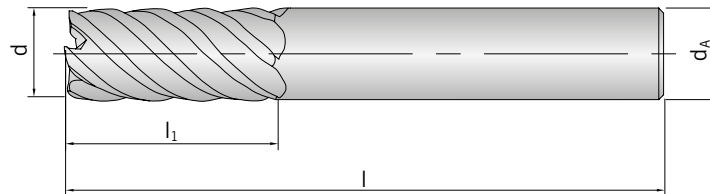
HC = Carbide coated

P	○
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● Main application
○ Secondary application

AFH508.2-...

6 - 8 flutes, extra long design



Shank DIN 6535HA	d -0,03	d _A h6	l ₁	l	z	HC
						TiAl70
AFH50862-060	6	6	26	70	6	◆
AFH50862-080	8	8	36	90	6	◆
AFH50862-100	10	10	46	100	6	◆
AFH50862-120	12	12	56	110	6	◆
AFH50862-160	16	16	66	130	6	◆
AFH50882-200	20	20	76	140	8	◆
AFH50882-250	25	25	92	180	8	◆

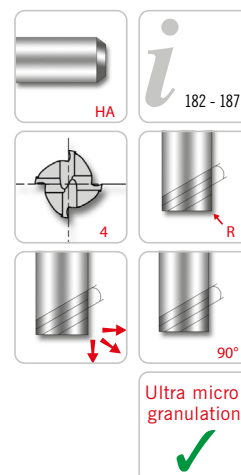
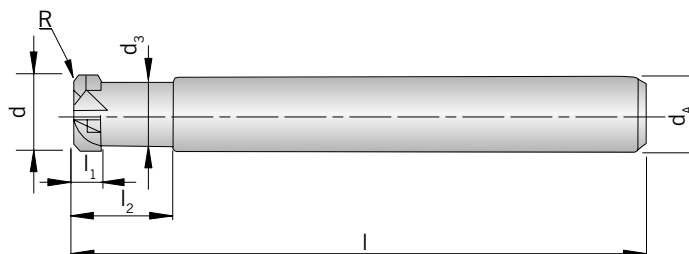
HC = Carbide coated

P	○
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● Main application
○ Secondary application

AFH50746-...R...

4 flutes, short design, with corner radius



AFH

Shank DIN 6535HA	d -0,02	d _A h6	d ₃	l ₁	l ₂	l	R ±0,005	HC
								TiAl70
AFH50746-020 R0.5	2	6	1.8	1.0	6	50	0.5	◆
AFH50746-030 R0.5	3	6	2.8	1.2	8	50	0.5	◆
AFH50746-040 R0.5	4	6	3.8	1.5	10	50	0.5	◆
AFH50746-060 R0.5	6	6	5.4	2.5	12	60	0.5	◆
AFH50746-060 R1.0	6	6	5.4	2.5	12	60	1.0	◆
AFH50746-080 R1.0	8	8	7.2	3.5	16	60	1.0	◆
AFH50746-080 R2.0	8	8	7.2	3.5	16	60	2.0	◆
AFH50746-100 R1.0	10	10	9.0	4.0	20	70	1.0	◆
AFH50746-100 R2.0	10	10	9.0	4.0	20	70	2.0	◆
AFH50746-120 R2.0	12	12	11.0	5.0	25	80	2.0	◆
AFH50746-120 R3.0	12	12	11.0	5.0	25	80	3.0	◆

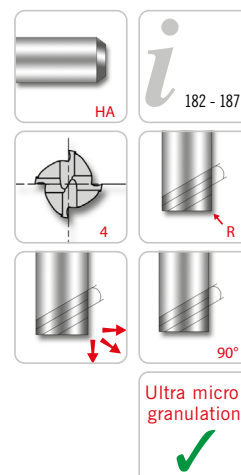
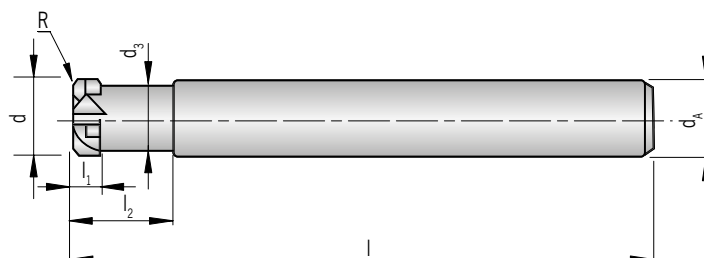
HC = Carbide coated

P	○
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● Main application
○ Secondary application

AFH50741-...R...

4 flutes, long design, with corner radius



Shank DIN 6535HA	d -0,02	d _A h6	d ₃	l ₁	l ₂	l	R ±0,005	HC
								TiAl70
AFH50741-020 R0.5	2	6	1.8	1.0	6	70	0.5	◆
AFH50741-030 R0.5	3	6	2.8	1.2	8	70	0.5	◆
AFH50741-040 R0.5	4	6	3.8	1.5	10	70	0.5	◆
AFH50741-050 R0.5	5	6	4.6	2.0	10	70	0.5	◆
AFH50741-060 R0.5	6	6	5.4	2.5	12	90	0.5	◆
AFH50741-060 R1.0	6	6	5.4	2.5	12	90	1.0	◆
AFH50741-080 R1.0	8	8	7.2	3.5	16	100	1.0	◆
AFH50741-080 R2.0	8	8	7.2	3.5	16	100	2.0	◆
AFH50741-100 R1.0	10	10	9.0	4.0	20	100	1.0	◆
AFH50741-100 R2.0	10	10	9.0	4.0	20	100	2.0	◆
AFH50741-120 R2.0	12	12	11.0	5.0	25	110	2.0	◆
AFH50741-120 R3.0	12	12	11.0	5.0	25	110	3.0	◆
AFH50741-160 R3.0	16	16	15.0	6.5	30	130	3.0	◆

HC = Carbide coated

P	○
M	
K	
N	
S	
H	●

● Main application

○ Secondary application

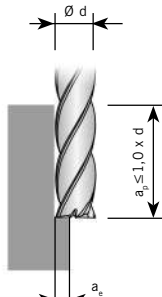
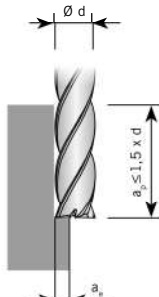
→ Radius 0,1 mm – D 4,0 mm MINI Z2

End-mill		Steel						Steel						Steel						Hardened steel				Hardened steel			
		≤ 800 N/mm² (≥ 22 HRC)						≤ 1100 N/mm² (25-35 HRC)				≤ 1400 N/mm² (35-45 HRC)				≤ 1950 N/mm² (45-55 HRC)				≥ 2000 N/mm² (55-70 HRC)							
D	R	l ₁	a _p	n	f _z	v _f	a _p	n	f _z	v _f	a _p	n	f _z	v _f	a _p	n	f _z	v _f	a _p	n	f _z	v _f	a _p	n	f _z	v _f	
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]	[mm/min]	[mm]	[mm]	[mm]	[mm/min]	[mm]	[mm]	[mm]	[mm/min]	[mm]	[mm]	[mm]	[mm/min]	[mm]	[mm]	[mm]	[mm/min]	[mm]	[mm]	[mm]	[mm/min]	
0,10	-	0,15	0,006	50000	0,011	1050	0,005	50000	0,011	1050	0,004	50000	0,008	780	0,003	45000	0,007	594	0,002	42000	0,006	479					
0,10	-	0,20	0,006	50000	0,011	1050	0,005	50000	0,011	1050	0,004	50000	0,008	780	0,003	45000	0,007	594	0,002	42000	0,006	479					
0,20	-	0,30	0,020	45000	0,016	1418	0,018	40500	0,016	1276	0,014	38250	0,012	895	0,010	33750	0,010	668	0,008	31500	0,009	539					
0,20	-	0,40	0,020	45000	0,016	1418	0,018	40500	0,016	1276	0,014	38250	0,012	895	0,010	33750	0,010	668	0,008	31500	0,009	539					
0,30	-	0,45	0,021	40000	0,016	1260	0,019	36000	0,016	1134	0,015	34000	0,012	796	0,011	30000	0,010	594	0,008	28000	0,009	479					
0,30	-	0,60	0,021	40000	0,016	1260	0,019	36000	0,016	1134	0,015	34000	0,012	796	0,011	30000	0,010	594	0,008	28000	0,009	479					
0,40	-	0,60	0,040	32000	0,021	1344	0,036	28800	0,021	1210	0,028	27200	0,016	849	0,020	24000	0,013	634	0,016	22400	0,011	511					
0,40	-	0,80	0,040	32000	0,021	1344	0,036	28800	0,021	1210	0,028	27200	0,016	849	0,020	24000	0,013	634	0,016	22400	0,011	511					
0,50	-	0,70	0,050	32000	0,021	1344	0,045	28800	0,021	1210	0,035	27200	0,016	849	0,025	24000	0,013	634	0,020	22400	0,011	511					
0,50	0,05	0,70	0,050	32000	0,021	1344	0,045	28800	0,021	1210	0,035	27200	0,016	849	0,025	24000	0,013	634	0,020	22400	0,011	511					
0,50	-	1,00	0,050	32000	0,021	1344	0,045	28800	0,021	1210	0,035	27200	0,016	849	0,025	24000	0,013	634	0,020	22400	0,011	511					
0,50	0,05	1,00	0,050	32000	0,021	1344	0,045	28800	0,021	1210	0,035	27200	0,016	849	0,025	24000	0,013	634	0,020	22400	0,011	511					
0,60	-	0,90	0,042	32000	0,026	1680	0,038	28800	0,026	1512	0,029	27200	0,020	1061	0,021	24000	0,017	792	0,017	22400	0,014	638					
0,60	0,05	0,90	0,042	32000	0,026	1680	0,038	28800	0,026	1512	0,029	27200	0,020	1061	0,021	24000	0,017	792	0,017	22400	0,014	638					
0,60	-	1,20	0,042	32000	0,026	1680	0,038	28800	0,026	1512	0,029	27200	0,020	1061	0,021	24000	0,017	792	0,017	22400	0,014	638					
0,60	0,05	1,20	0,042	32000	0,026	1680	0,038	28800	0,026	1512	0,029	27200	0,020	1061	0,021	24000	0,017	792	0,017	22400	0,014	638					
0,70	-	1,40	0,049	28800	0,024	1382	0,044	25920	0,024	1244	0,034	24480	0,020	955	0,025	21600	0,017	713	0,020	20160	0,014	575					
0,70	0,05	1,40	0,049	28800	0,024	1382	0,044	25920	0,024	1244	0,034	24480	0,020	955	0,025	21600	0,017	713	0,020	20160	0,014	575					
0,70	0,10	1,00	0,049	28800	0,024	1382	0,044	25920	0,024	1244	0,034	24480	0,020	955	0,025	21600	0,017	713	0,020	20160	0,014	575					
0,80	-	1,20	0,056	32000	0,026	1680	0,050	28800	0,026	1512	0,039	27200	0,020	1061	0,028	24000	0,017	792	0,022	22400	0,014	638					
0,80	0,05	1,20	0,056	32000	0,026	1680	0,050	28800	0,026	1512	0,039	27200	0,020	1061	0,028	24000	0,017	792	0,022	22400	0,014	638					
0,80	-	1,60	0,056	32000	0,026	1680	0,050	28800	0,026	1512	0,039	27200	0,020	1061	0,028	24000	0,017	792	0,022	22400	0,014	638					
0,80	0,05	1,60	0,056	32000	0,026	1680	0,050	28800	0,026	1512	0,039	27200	0,020	1061	0,028	24000	0,017	792	0,022	22400	0,014	638					
0,80	0,10	1,20	0,056	32000	0,026	1680	0,050	28800	0,026	1512	0,039	27200	0,020	1061	0,028	24000	0,017	792	0,022	22400	0,014	638					
0,90	-	2,00	0,036	28800	0,024	1382	0,032	25920	0,024	1244	0,025	24480	0,020	955	0,018	21600	0,017	713	0,014	20160	0,014	575					
0,90	0,05	2,00	0,036	28800	0,024	1382	0,032	25920	0,024	1244	0,025	24480	0,020	955	0,018	21600	0,017	713	0,014	20160	0,014	575					
1,00	-	1,50	0,010	28800	0,032	1814	0,090	25920	0,032	1633	0,070	24480	0,023	1146	0,050	21600	0,020	855	0,040	20160	0,017	689					
1,00	0,10	1,50	0,010	28800	0,032	1814	0,090	25920	0,032	1633	0,070	24480	0,023	1146	0,050	21600	0,020	855	0,040	20160	0,017	689					
1,00	0,10	1,80	0,010	28800	0,032	1814	0,090	25920	0,032	1633	0,070	24480	0,023	1146	0,050	21600	0,020	855	0,040	20160	0,017	689					
1,20	0,10	1,80	0,084	25600	0,032	1613	0,076	23040	0,032	1452	0,059	21760	0,023	1018	0,042	19200	0,020	760	0,034	17920	0,017	613					
1,50	-	1,70	0,110	22400	0,032	1411	0,099	20160	0,032	1270	0,077	19040	0,023	891	0,055	16800	0,020	665	0,044	15680	0,017	536					
1,50	-	2,30	0,110	22400	0,032	1411	0,099	20160	0,032	1270	0,077	19040	0,023	891	0,055	16800	0,020	665	0,044	15680	0,017	536					
1,50	0,10	2,20	0,110	22400	0,032	1411	0,099	20160	0,032	1270	0,077	19040	0,023	891	0,055	16800	0,020	665	0,044	15680	0,017	536					
1,50	0,15	2,20	0,110	22400	0,032	1411	0,099	20160	0,032	1270	0,077	19040	0,023	891	0,055	16800	0,020	665	0,044	15680	0,017	536					
1,50	0,20	2,50	0,110	22400	0,032	1411	0,099	20160	0,032	1270	0,077	19040	0,023	891	0,055	16800	0,020	665	0,044	15680	0,017	536					
2,00	-	2,00	0,200	16800	0,042	1411	0,180	15120	0,042	1270	0,140	14280	0,031	891	0,100	12600	0,026	665	0,080	11760	0,023	536					
2,00	-	3,00	0,200	16800	0,042	1411	0,180	15120	0,042	1270	0,140	14280	0,031	891	0,100	12600	0,026	665	0,080	11760	0,023	536					
2,00	0,10	3,00	0,200	16800	0,042	1411	0,180	15120	0,042	1270	0,140	14280	0,031	891	0,100	12600	0,026	665	0,080	11760	0,023	536					
2,00	0,15	2,20	0,200	16800	0,042	1411	0,180	15120	0,042	1270	0,140	14280	0,031	891	0,100	12600	0,026	665	0,080	11760	0,023	536					
2,00	0,20	3,00	0,200	16800	0,042	1411	0,180	15120	0,042	1270	0,140	14280	0,031	891	0,100	12600	0,026	665	0,080	11760	0,023	536					
2,00	0,30	3,00	0,200	16800	0,042	1411	0,180	15120	0,042	1270	0,140	14280	0,031	891	0,100	12600	0,026	665	0,080	11760	0,023	536					
2,00	0,50	3,00	0,200	16800	0,042	1411	0																				

Contour milling

55–70 HRC

Ø	Hardened steel (≤ 55 HRC)			Hardened steel (55–62 HRC)			Hardened steel (62–70 HRC)			
	D [mm]	n [min ⁻¹]	v _f [mm/min]	a _e [mm]	n [min ⁻¹]	v _f [mm/min]	a _e [mm]	n [min ⁻¹]	v _f [mm/min]	a _e [mm]
1,0		40000	1200	0,05	40000	800	0,03	32000	500	0,02
2,0		40000	2000	0,10	24000	1000	0,05	16000	600	0,05
3,0		32000	3800	0,20	16000	1900	0,10	11000	1200	0,05
4,0		24000	4400	0,20	12000	2200	0,10	8000	1300	0,05
6,0		16000	5800	0,30	8000	2900	0,20	5300	1800	0,10
8,0		12000	5800	0,40	6000	2900	0,20	4000	1800	0,10
10,0		9600	5800	0,50	4800	2900	0,30	3200	1800	0,20
12,0		8000	4800	0,60	4000	2400	0,30	2700	1500	0,20
16,0		6000	3600	0,80	3000	1800	0,50	2000	1100	0,30
20,0		4800	2900	1,00	2400	1400	0,50	1600	880	0,30

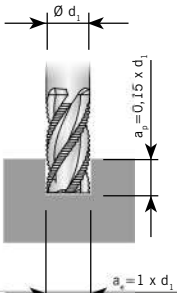


AFH

Slot milling

35–70 HRC

Ø	Steel					Hardened steel					Hardened steel				
	≤ 1400 N/mm² (35-45 HRC)					≤ 1950 N/mm² (45-55 HRC)					> 2000 N/mm² (55-70 HRC)				
D	a _p	a _e	n	f _z	v _f	a _p	a _e	n	f _z	v _f	a _p	a _e	n	f _z	v _f
(mm)	(mm)	(mm)	(min ⁻¹)	(mm)	(mm/min)	(mm)	(mm)	(min ⁻¹)	(mm)	(mm/min)	(mm)	(mm)	(min ⁻¹)	(mm)	(mm/min)
1,0	0,15	1,0	15000	0,008	240	0,15	1,0	12600	0,004	100	0,15	1,0	6300	0,003	38
2,0	0,30	2,0	7600	0,010	152	0,30	2,0	6400	0,006	76	0,30	2,0	3200	0,006	38
3,0	0,45	3,0	5100	0,015	153	0,45	3,0	4200	0,010	84	0,45	3,0	2100	0,009	38
4,0	0,60	4,0	3800	0,025	190	0,60	4,0	3200	0,018	115	0,60	4,0	1600	0,013	41
5,0	0,75	5,0	3100	0,030	186	0,75	5,0	2500	0,025	125	0,75	5,0	1300	0,018	47
6,0	0,90	6,0	2500	0,038	190	0,90	6,0	2100	0,030	126	0,90	6,0	1100	0,021	46
8,0	1,20	8,0	1900	0,050	190	1,20	8,0	1600	0,040	128	1,20	8,0	800	0,028	45
10,0	1,50	10,0	1500	0,063	189	1,50	10,0	1300	0,050	130	1,50	10,0	600	0,035	42
12,0	1,80	12,0	1300	0,070	182	1,80	12,0	1100	0,055	121	1,80	12,0	500	0,039	39
16,0	2,40	16,0	955	0,085	162	2,40	16,0	800	0,060	96	2,40	16,0	400	0,043	35
20,0	3,00	20,0	765	0,112	171	3,00	20,0	640	0,070	90	3,00	20,0	340	0,049	35



Information: Calculation is based on two tooth Z2

→ Radius 0,05 mm – 1,5 mm

End-mill		Steel						Steel						Steel						Hardened steel						Hardened steel					
		≤ 800 N/mm² (≥ 22 HRC)						≤ 1100 N/mm² (25-35 HRC)						≤ 1400 N/mm² (35-45 HRC)						≤ 1950 N/mm² (45-55 HRC)						≥ 2000 N/mm² (55-70 HRC)					
D	R	I ₁	a _p	a _e	n	f _z	v _f	a _p	a _e	n	f _z	v _f	a _p	a _e	n	f _z	v _f	a _p	a _e	n	f _z	v _f	a _p	a _e	n	f _z	v _f				
(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(mm/min)	(mm)	(mm)	(mm)	(mm)	(mm/min)	(mm)	(mm)	(mm)	(mm)	(mm/min)	(mm)	(mm)	(mm)	(mm)	(mm/min)	(mm)	(mm)	(mm)	(mm)	(mm/min)				
0,10	0,05	0,10	0,008	0,024	50000	0,015	1500	0,007	0,022	50000	0,015	1500	0,006	0,019	50000	0,014	1350	0,005	0,016	45000	0,012	1080	0,005	0,014	42000	0,011	882				
0,10	0,05	0,20	0,008	0,024	50000	0,015	1500	0,007	0,022	50000	0,015	1500	0,006	0,019	50000	0,014	1350	0,005	0,016	45000	0,012	1080	0,005	0,014	42000	0,011	882				
0,20	0,10	0,20	0,020	0,060	50000	0,023	2250	0,018	0,054	45000	0,023	2025	0,016	0,048	42500	0,020	1721	0,013	0,039	37500	0,018	1350	0,012	0,036	35000	0,016	1103				
0,20	0,10	0,30	0,020	0,060	50000	0,023	2250	0,018	0,054	45000	0,023	2025	0,016	0,048	42500	0,020	1721	0,013	0,039	37500	0,018	1350	0,012	0,036	35000	0,016	1103				
0,30	0,15	0,30	0,021	0,063	50000	0,023	2250	0,019	0,057	45000	0,023	2025	0,017	0,050	42500	0,020	1721	0,014	0,041	37500	0,018	1350	0,013	0,038	35000	0,016	1103				
0,30	0,15	0,50	0,021	0,063	50000	0,023	2250	0,019	0,057	45000	0,023	2025	0,017	0,050	42500	0,020	1721	0,014	0,041	37500	0,018	1350	0,013	0,038	35000	0,016	1103				
0,40	0,20	0,40	0,040	0,120	40000	0,030	2400	0,036	0,108	36000	0,030	2160	0,032	0,096	34000	0,027	1836	0,026	0,078	30000	0,024	1440	0,024	0,072	28000	0,021	1176				
0,40	0,20	0,60	0,040	0,120	40000	0,030	2400	0,036	0,108	36000	0,030	2160	0,032	0,096	34000	0,027	1836	0,026	0,078	30000	0,024	1440	0,024	0,072	28000	0,021	1176				
0,50	0,25	0,40	0,045	0,135	40000	0,030	2400	0,041	0,122	36000	0,030	2160	0,036	0,108	34000	0,027	1836	0,029	0,088	30000	0,024	1440	0,027	0,081	28000	0,021	1176				
0,50	0,25	0,50	0,045	0,135	40000	0,030	2400	0,041	0,122	36000	0,030	2160	0,036	0,108	34000	0,027	1836	0,029	0,088	30000	0,024	1440	0,027	0,081	28000	0,021	1176				
0,50	0,25	0,70	0,045	0,135	40000	0,030	2400	0,041	0,122	36000	0,030	2160	0,036	0,108	34000	0,027	1836	0,029	0,088	30000	0,024	1440	0,027	0,081	28000	0,021	1176				
0,60	0,30	0,50	0,042	0,126	40000	0,038	3000	0,038	0,113	36000	0,038	2700	0,034	0,101	34000	0,034	2295	0,027	0,082	30000	0,030	1800	0,025	0,076	28000	0,026	1470				
0,60	0,30	0,60	0,042	0,126	40000	0,038	3000	0,038	0,113	36000	0,038	2700	0,034	0,101	34000	0,034	2295	0,027	0,082	30000	0,030	1800	0,025	0,076	28000	0,026	1470				
0,60	0,30	0,90	0,042	0,126	40000	0,038	3000	0,038	0,113	36000	0,038	2700	0,034	0,101	34000	0,034	2295	0,027	0,082	30000	0,030	1800	0,025	0,076	28000	0,026	1470				
0,70	0,35	1,10	0,080	0,240	40000	0,038	3000	0,072	0,216	36000	0,038	2700	0,064	0,192	34000	0,034	2295	0,052	0,156	30000	0,030	1800	0,048	0,144	28000	0,026	1470				
0,80	0,40	0,60	0,080	0,240	40000	0,038	3000	0,072	0,216	36000	0,038	2700	0,064	0,192	34000	0,034	2295	0,052	0,156	30000	0,030	1800	0,048	0,144	28000	0,026	1470				
0,80	0,40	0,80	0,080	0,240	40000	0,038	3000	0,072	0,216	36000	0,038	2700	0,064	0,192	34000	0,034	2295	0,052	0,156	30000	0,030	1800	0,048	0,144	28000	0,026	1470				
0,80	0,40	1,20	0,080	0,240	40000	0,038	3000	0,072	0,216	36000	0,038	2700	0,064	0,192	34000	0,034	2295	0,052	0,156	30000	0,030	1800	0,048	0,144	28000	0,026	1470				
0,90	0,45	1,40	0,100	0,300	36000	0,045	3240	0,090	0,270	32400	0,045	2916	0,080	0,240	30600	0,041	2479	0,065	0,195	27000	0,036	1944	0,060	0,180	25200	0,032	1588				
1,00	0,50	0,80	0,100	0,300	36000	0,045	3240	0,090	0,270	32400	0,045	2916	0,080	0,240	30600	0,041	2479	0,065	0,195	27000	0,036	1944	0,060	0,180	25200	0,032	1588				
1,00	0,50	1,00	0,100	0,300	36000	0,045	3240	0,090	0,270	32400	0,045	2916	0,080	0,240	30600	0,041	2479	0,065	0,195	27000	0,036	1944	0,060	0,180	25200	0,032	1588				
1,00	0,50	1,50	0,100	0,300	36000	0,045	3240	0,090	0,270	32400	0,045	2916	0,080	0,240	30600	0,041	2479	0,065	0,195	27000	0,036	1944	0,060	0,180	25200	0,032	1588				
1,20	0,60	1,00	0,040	0,120	28800	0,041	2333	0,036	0,108	25920	0,041	2100	0,032	0,096	24480	0,041	1983	0,026	0,078	21600	0,036	1555	0,024	0,072	20160	0,032	1270				
1,20	0,60	1,20	0,040	0,120	28800	0,041	2333	0,036	0,108	25920	0,041	2100	0,032	0,096	24480	0,041	1983	0,026	0,078	21600	0,036	1555	0,024	0,072	20160	0,032	1270				
1,50	0,75	1,20	0,100	0,300	28800	0,045	2520	0,090	0,270	25200	0,045	2268	0,080	0,240	23800	0,041	1928	0,065	0,195	21000	0,036	1512	0,060	0,180	19600	0,032	1235				
1,50	0,75	1,50	0,100	0,300	28800	0,045	2520	0,090	0,270	25200	0,045	2268	0,080	0,240	23800	0,041	1928	0,065	0,195	21000	0,036	1512	0,060	0,180	19600	0,032	1235				
1,50	0,75	2,00	0,100	0,300	28800	0,045	2520	0,090	0,270	25200	0,045	2268	0,080	0,240	23800	0,041	1928	0,065	0,195	21000	0,036	1512	0,060	0,180	19600	0,032	1235				
2,00	1,00	1,60	0,140	0,042	21000	0,075	3150	0,126	0,378	18900	0,075	2835	0,112	0,336	17850	0,075	2678	0,091	0,273	15750	0,060	1890	0,084	0,253	14700	0,053	1544				
2,00	1,00	2,00	0,140	0,042	21000	0,075	3150	0,126	0,378	18900	0,075	2835	0,112	0,336	17850	0,075	2678	0,091	0,273	15750	0,060	1890	0,084	0,253	14700	0,053	1544				
2,00	1,00	2,50	0,140	0,042	21000	0,075	3150	0,126	0,378	18900	0,075	2835	0,112	0,336	17850	0,075	2678	0,091	0,273	15750	0,060	1890	0,084	0,253	14700	0,053	1544				
2,50	1,25	3,00	0,140	0,042	21000	0,075	3150	0,126	0,378	18900	0,075	2835	0,112	0,336	17850	0,075	2678	0,091	0,273	15750	0,060	1890	0,084	0,253	14700	0,053	1544				
3,00	1,50	2,40	0,210	0,630	14400	0,068	1944	0,189	0,567	12960	0,068	1750	0,168	0,504	12240	0,069	1652	0,137	0,410	10800	0,060	1296	0,126	0,380	10080	0,053	1058				
3,00	1,50	3,00	0,210	0,630	14400	0,068	1944	0,189	0,567	12960	0,068	1750	0,168	0,504	12240	0,069	1652	0,137	0,410	10800	0,060	1296	0,126	0,380	10080	0,053	1058				
3,00	1,50	4,00	0,210	0,630	14400	0,068	1944	0,189	0,567	12960	0,068	1750	0,168	0,504	12240	0,069	1652	0,137	0,410	10800	0,060	1296	0,126	0,380	10080	0,053	1058				
3,00	1,50	8,00	0,080	0,240	14400	0,068	1944	0,072	0,216	12960	0,068	1750	0,064	0,192	12240	0,068	1652	0,052	0,156	10800	0,060	1296	0,048	0,144	10080	0,053	1058				

D = Shank diameter

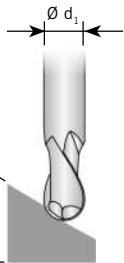
R = Radius

I₁ = Cutting length

Attention: The recommended cutting data are only approximate values. It may be necessary to adjust them to each individual machining application.

→ Radius 0,2 mm – 12,5 mm

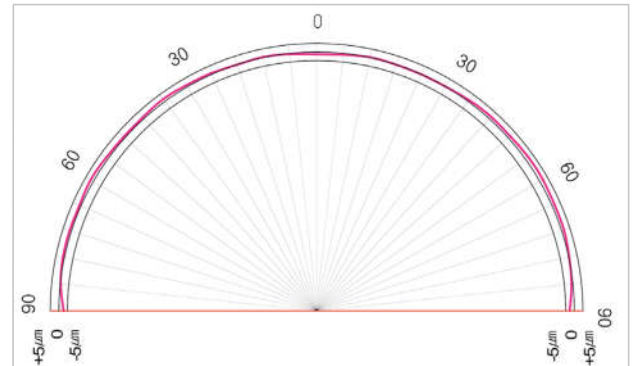
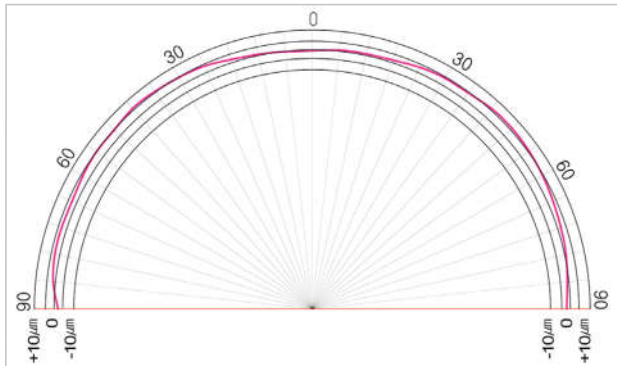
Radius R	Hardened steel (≤ 55 HRC)					Hardened steel (55–62 HRC)					Hardened steel (62–70 HRC)				
	α < 15°		α > 15°		a _p	α < 15°		α > 15°		a _p	α < 15°		α > 15°		a _p
	n	v _f	n	v _f		n	v _f	n	v _f		n	v _f	n	v _f	
[mm]	[min ⁻¹]	[mm/min]	[min ⁻¹]	[mm/min]	[mm]	[min ⁻¹]	[mm/min]	[min ⁻¹]	[mm/min]	[mm]	[min ⁻¹]	[mm/min]	[min ⁻¹]	[mm/min]	[mm]
2,0	32000	10880	20000	3600	0,15	24000	6200	12000	1900	0,13	12000	2400	8000	800	0,10
2,5	25000	9000	16000	2900	0,20	19000	5300	9600	1700	0,15	9600	2100	6000	600	0,10
3,0	21000	8400	13000	2600	0,25	16000	4800	8000	1600	0,20	8000	1700	5000	600	0,11
4,0	16000	6400	10000	2000	0,30	12000	3600	6000	1200	0,20	6000	1400	4000	480	0,11
4,5	14500	5800	9000	1800	0,40	11000	3300	5400	1080	0,20	5400	1200	3500	450	0,11
5,0	13000	5200	8000	1700	0,50	10000	3200	4800	960	0,20	4800	1100	3000	420	0,12
5,5	11000	4400	7000	1450	0,50	8500	2550	4200	840	0,30	3600	860	2200	310	0,12
6,0	9000	3600	6000	1300	0,50	7000	2200	3600	720	0,30	3000	780	1850	290	0,12
8,0	6000	2400	4000	1000	0,50	5000	1600	2500	500	0,30	2500	650	1500	240	0,15
9,0	5500	2200	3500	875	0,50	4500	1400	2100	420	0,30	2200	570	1250	200	0,15
10,0	4500	1800	3000	780	0,50	4000	1300	1800	360	0,30	1800	470	1000	160	0,15
12,5	3500	1400	2000	520	0,50	3500	1100	1500	300	0,30	1500	390	700	105	0,15

**Information:**

1. In case of unstable workpiece or tool clamping or heavy vibration during machining, we recommend proportional reduction of feed rate and revolutions.
2. At low cutting depths, revolutions and feed rate can be increased.
3. "α" is the machine angle.

Tighter **radius tolerance**

0,005 - 0,010 mm

Tighter radius tolerance $\pm 0,005$ mm for a higher accuracy and longer tool life.**Polished surface and specifically engineered coating** for the best results also for high speed machining:

High end-mill

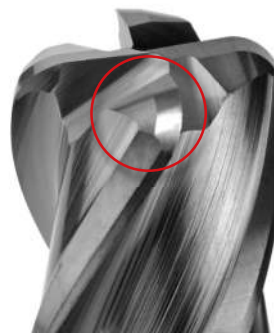


Normal end-mill

Special coating give consistent result in high speed cutting of high hardness materials.

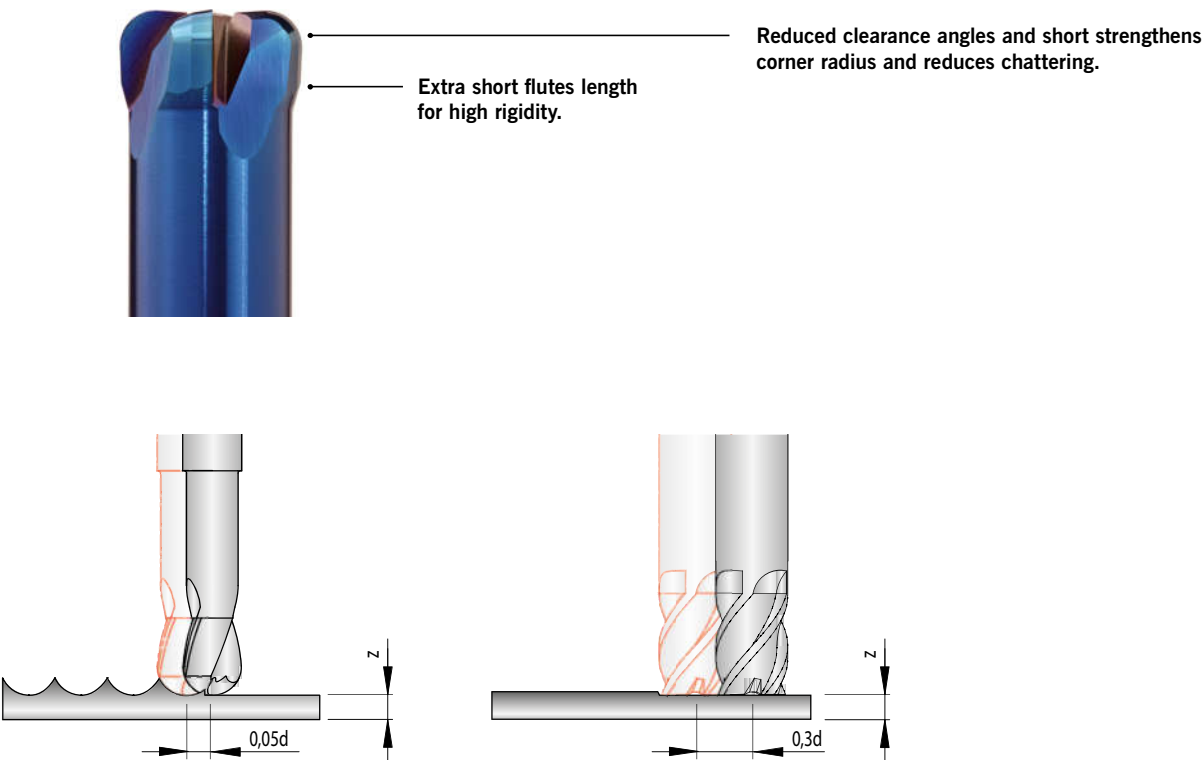
Comparison of the endteeth shape: **High feed end-mill** – **normal end-mill**

High end-mill



Normal end-mill

Comparison of the endteeth shape: High feed end-mill – normal end-mill

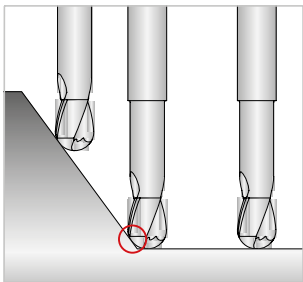


AFH

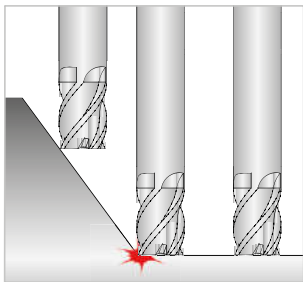
Example of performance

(HRC 50 - 55)

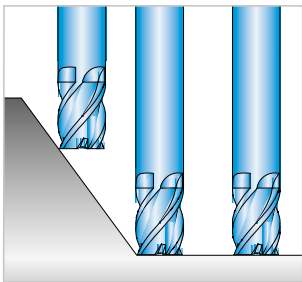
Item	Size	Revolution [U/min] / RPM	Feed rate [mm/U]	Depth of cut	
	[mm]			Z [mm]	X-Y [mm]
High feed end-mill	Ø10 R2	5400	11000	0,2	3,0



Ball-nose milling cutter



End-mill



Torus end-mill

Approximate values Feed per tooth f_z [mm]

ISO	Material	Strength [N/mm ²]	Medium machining V_c [m/min]	Rough machining V_c [m/min]	Medium $d_1 = 2$ mm		Roughing $d_1 = 2$ mm	
					a_p [mm]	f_z [mm]	a_p [mm]	f_z [mm]
P	General construction steel	< 800	250-300	150-250	0,05-0,2	0,1-0,2	0,2-0,3	0,2-0,3
	Free cutting steel	< 800	250-300	150-250	0,05-0,2	0,1-0,2	0,2-0,3	0,2-0,3
	Case hardened steel, non alloyed	< 800	250-300	150-250	0,05-0,2	0,1-0,2	0,2-0,3	0,2-0,3
	Alloyed case hardened steel	< 1000	200-250	180-200	0,05-0,2	0,1-0,2	0,2-0,3	0,2-0,3
	Tempering steel, non alloyed	< 850	220-250	200-220	0,05-0,2	0,1-0,2	0,2-0,3	0,2-0,3
	Tempering steel, non alloyed	< 1000	220-250	200-220	0,05-0,2	0,1-0,2	0,2-0,3	0,2-0,3
	Tempering steel, alloyed	< 800	170-190	170-190	0,05-0,2	0,1-0,2	0,2-0,3	0,2-0,3
	Tempering steel, alloyed	< 1300	160-180	160-180	0,05-0,2	0,1-0,2	0,2-0,3	0,2-0,3
	Steel castings	< 850	220-250	200-220	0,05-0,2	0,1-0,2	0,2-0,3	0,2-0,3
	Nitriding steel	< 1000	170-190	170-190	0,05-0,2	0,1-0,2	0,2-0,3	0,2-0,3
	Nitriding steel	< 1200	160-180	160-180	0,05-0,2	0,1-0,2	0,2-0,3	0,2-0,3
	Roller bearing steel	< 1200	170-190	170-190	0,05-0,2	0,1-0,2	0,2-0,3	0,2-0,3
	Spring steel	< 1200	100-120	100-120	0,05-0,2	0,1-0,2	0,2-0,3	0,2-0,3
	High-speed steel	< 1300	80-100	80-100	0,05-0,2	0,1-0,2	0,2-0,3	0,2-0,3
	Cold working tool steel	< 1300	140-180	140-180	0,05-0,2	0,1-0,2	0,2-0,3	0,2-0,3
	Hot working tool steel	< 1300	140-180	140-180	0,05-0,2	0,1-0,2	0,2-0,3	0,2-0,3
M	Steel and sulphured cast stainless steel	< 850						
	Stainless steel, ferritic	< 750						
	Stainless steel, martensitic	< 900						
	Stainless steel, ferritic / martensitic	< 1100						
	Stainless steel, austenitic / ferritic	< 850						
	Stainless steel, austenitic	< 750						
	Heat resistant steel	< 1100						
K	Grey cast iron with lamellar graphite	100-350						
	Grey cast iron with lamellar graphite	300-1000						
	Spheroidal cast iron	300-500						
	Spheroidal cast iron	550-800						
	White cast iron, tempered	350-450						
	White cast iron, tempered	500-650						
	Black cast iron, tempered	350-450						
	Black cast iron, tempered	500-700						
N	Aluminium (non alloyed, low alloyed)	< 350						
	Aluminium alloys < 0,5% Si	< 500						
	Aluminium alloys 0,5% - 10% Si	< 400						
	Aluminium alloys 10% - 15% Si	< 400						
	Aluminium alloys > 15% Si	< 400						
	Copper (non alloyed, low alloyed)	< 350						
	Copper wrought alloys	< 700						
	Special copper alloys	< 200 HB						
	Special copper alloys	< 300 HB						
	Special copper alloys	> 300 HB						
	Short-chipping brass, bronze, red bronze	< 600						
	Long-chipping brass	< 600						
	Thermoplastics							
	Duroplastics							
	Fibre-reinforced plastics							
	Magnesium and magnesium alloys	< 850						
	Graphite							
	Tungsten and tungsten alloys							
	Molybdenum and molybdenum alloys							
S	Pure nickel							
	Nickel alloys							
	Nickel alloys	< 850						
	Nickel-chromium alloys							
	Nickel and cobalt alloys	< 1300						
	Nickel and cobalt alloys	< 1300						
	Heat resistant alloys	< 1400						
	Nickel-cobalt-chromium alloys	< 1300						
	Pure titanium	< 900						
	Titanium alloys	< 700						
H	Titanium alloys	< 1200						
	Tempered steel	< 45 HRC	160-190	160-190	0,05-0,2	0,1-0,2	0,2-0,3	0,2-0,3
		46-55 HRC	150-180	80-120	0,05-0,2	0,1-0,2	0,2-0,3	0,2-0,3
		56-60 HRC	120-150	80-100	0,05-0,2	0,1-0,2	0,2-0,3	0,2-0,25
		61-65 HRC	80-110	60-90	0,05-0,2	0,1-0,2	0,2-0,3	0,2-0,25
		65-70 HRC						

The recommended cutting data are only approximate values. It may be necessary to adjust them to each individual machining application.

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Approximate values Feed per tooth f_z [mm]

ISO	Material	Strength [N/mm ²]	Medium machining V_c [m/min]	Rough machining V_c [m/min]	Medium $d_1 = 8$ mm		Roughing $d_1 = 8$ mm	
					a_p [mm]	f_z [mm]	a_p [mm]	f_z [mm]
P	General construction steel	< 800	250-300	150-250	0,1-0,2	0,1-0,3	0,2-0,3	0,3-0,5
	Free cutting steel	< 800	250-300	150-250	0,1-0,2	0,1-0,3	0,2-0,3	0,3-0,5
	Case hardened steel, non alloyed	< 800	250-300	150-250	0,1-0,2	0,1-0,3	0,2-0,3	0,3-0,5
	Alloyed case hardened steel	< 1000	200-250	180-200	0,1-0,2	0,1-0,25	0,2-0,3	0,25-0,4
	Tempering steel, non alloyed	< 850	220-250	200-220	0,1-0,2	0,1-0,25	0,2-0,3	0,25-0,4
	Tempering steel, non alloyed	< 1000	220-250	200-220	0,1-0,2	0,1-0,25	0,2-0,3	0,25-0,4
	Tempering steel, alloyed	< 800	170-190	170-190	0,1-0,2	0,1-0,25	0,2-0,3	0,25-0,4
	Tempering steel, alloyed	< 1300	160-180	160-180	0,1-0,2	0,1-0,25	0,2-0,3	0,25-0,4
	Steel castings	< 850	220-250	200-220	0,1-0,2	0,1-0,25	0,2-0,3	0,25-0,4
	Nitriding steel	< 1000	170-190	170-190	0,1-0,2	0,1-0,25	0,2-0,3	0,25-0,4
	Nitriding steel	< 1200	160-180	160-180	0,1-0,2	0,1-0,25	0,2-0,3	0,25-0,4
	Roller bearing steel	< 1200	170-190	170-190	0,1-0,2	0,1-0,25	0,2-0,3	0,25-0,4
	Spring steel	< 1200	100-120	100-120	0,1-0,2	0,1-0,25	0,2-0,3	0,25-0,4
	High-speed steel	< 1300	80-100	80-100	0,1-0,2	0,1-0,25	0,2-0,3	0,25-0,4
	Cold working tool steel	< 1300	140-180	140-180	0,1-0,2	0,1-0,25	0,2-0,3	0,25-0,4
	Hot working tool steel	< 1300	140-180	140-180	0,1-0,2	0,1-0,25	0,2-0,3	0,25-0,4
M	Steel and sulphured cast stainless steel	< 850						
	Stainless steel, ferritic	< 750						
	Stainless steel, martensitic	< 900						
	Stainless steel, ferritic/martensitic	< 1100						
	Stainless steel, austenitic/ferritic	< 850						
	Stainless steel, austenitic	< 750						
K	Heat resistant steel	< 1100						
	Grey cast iron with lamellar graphite	100-350						
	Grey cast iron with lamellar graphite	300-1000						
	Spheroidal cast iron	300-500						
	Spheroidal cast iron	550-800						
	White cast iron, tempered	350-450						
N	White cast iron, tempered	500-650						
	Black cast iron, tempered	350-450						
	Black cast iron, tempered	500-700						
	Aluminium (non alloyed, low alloyed)	< 350						
	Aluminium alloys < 0,5% Si	< 500						
	Aluminium alloys 0,5% - 10% Si	< 400						
	Aluminium alloys 10% - 15% Si	< 400						
	Aluminium alloys > 15% Si	< 400						
	Copper (non alloyed, low alloyed)	< 350						
	Copper wrought alloys	< 700						
	Special copper alloys	< 200 HB						
	Special copper alloys	< 300 HB						
	Special copper alloys	> 300 HB						
	Short-chipping brass, bronze, red bronze	< 600						
	Long-chipping brass	< 600						
	Thermoplastics							
	Duroplastics							
	Fibre-reinforced plastics							
	Magnesium and magnesium alloys	< 850						
S	Graphite							
	Tungsten and tungsten alloys							
	Molybdenum and molybdenum alloys							
	Pure nickel							
	Nickel alloys							
	Nickel alloys	< 850						
	Nickel-chromium alloys							
	Nickel and cobalt alloys	< 1300						
	Nickel and cobalt alloys	< 1300						
	Heat resistant alloys	< 1400						
H	Nickel-cobalt-chromium alloys	< 1300						
	Pure titanium	< 900						
	Titanium alloys	< 700						
	Titanium alloys	< 1200						
	Tempered steel	< 45 HRC	160-190	160-190	0,1-0,2	0,1-0,3	0,2-0,3	0,3-0,5
		46-55 HRC	150-180	80-120	0,1-0,2	0,1-0,25	0,2-0,3	0,25-0,4
		56-60 HRC	120-150	80-100	0,1-0,2	0,1-0,25	0,2-0,3	0,2-0,3
		61-65 HRC	80-110	60-90	0,1-0,2	0,1-0,25	0,2-0,3	0,2-0,3
		65-70 HRC						

The recommended cutting data are only approximate values. It may be necessary to adjust them to each individual machining application.

Attention:
The width of cut (a_e) in steel should be 60 - 90% of the cutter diameter ϕd_1 with high-grade steels and for sticking materials 40% of ϕd_1 maximum.

Coolant:
For machining stainless steel and non-ferrous materials use emulsion. For cast iron and hardened materials use compressed air.
For steel and heat resistant alloys use MMS.

The recommended cutting data are only approximate values. It may be necessary to adjust them to each individual machining application.