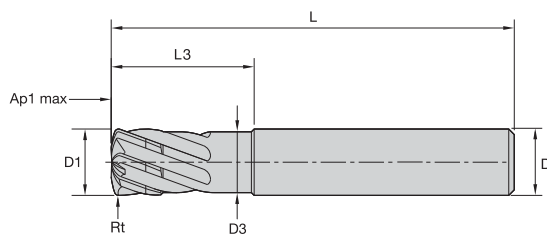
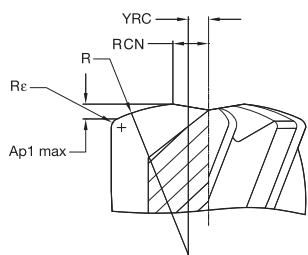


High-Performance Solid Carbide End Mills • Hard Materials

Series 70N6 71N6 • 37–52 HRC • Vision Plus™ X-Feed™



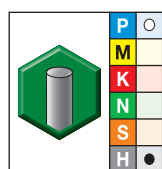
- Non-centre cutting.
- Standard items listed. Additional styles and coatings made-to-order.



End Mill Tolerances

D1	tolerance e8	D	tolerance h6 + / -
≤ 3	-0,014/-0,028	≤ 3	0/0,006
> 3–6	-0,020/-0,038	> 3–6	0/0,008
> 6–10	-0,025/-0,047	> 6–10	0/0,009
> 10–18	-0,032/-0,059	> 10–18	0/0,011
> 18–30	-0,040/-0,073	> 18–30	0/0,013

Series 70N6 71N6 • 37–52 HRC • Vision Plus X-Feed



grade AlTiN-MT1
AlTiN

- first choice
- alternate choice

order #	catalogue #	D1	D	D3	length of cut Ap1 max	L3	length L	Rc	Rt
3745400	71N606002MT	6,0	6	5,50	0,32	9,00	57	0,38	0,62
3341346	70N606002MT	6,0	6	5,50	0,32	18,00	63	0,38	0,62
3745401	71N608003MT	8,0	8	7,50	0,42	12,00	63	0,50	0,83
3341348	70N608003MT	8,0	8	7,50	0,42	24,00	76	0,50	0,83
3745402	71N610004MT	10,0	10	9,00	0,53	15,00	72	0,63	1,04
3101466	70N610004MT	10,0	10	9,00	0,53	30,00	89	0,63	1,04
3745413	71N612005MT	12,0	12	11,00	0,63	18,00	83	0,75	1,24
3101467	70N612005MT	12,0	12	11,00	0,63	36,00	100	0,75	1,24
3484748	70N616006MT	16,0	16	15,00	0,84	48,00	110	1,00	1,66
3484749	70N620007MT	20,0	20	19,00	1,05	60,00	125	1,25	2,07

NOTE: YRC = distance from centre line to the crown of the R radius.
 RCN = distance from centre line to the start of the cutting edge. This dimension can also help determine the minimum circle size when helical ramping.
 R = the head radius size.
 Rc = the shoulder radius or radius at the corner of the cutter.

Programming Data

Tool List 70N6															
Geometrical Parameters									Ramping Guide for Circular and Linear Interpolation						
									Circular Interpolation		Linear Interpolation				
									Allowed Range of Hole Diameter		Calculated Length (mm) per Ramp Angle				
diameter	Ap1 max	Rfm	Rt	Rc	Xfm	Yfm	YD	Number			Ramp Angle (degree)				
[mm]	[mm]	[mm]	[mm]	[mm]	[mm]	[mm]	[mm]	flutes	Smallest	Largest	1	2	3	4	5
6	0,32	6	0,62	0,375	0,32	0,75	1,32	6	8,64	12	18,12	9,06	6,03	4,52	3,61
8	0,42	8	0,83	0,500	0,42	1,00	1,76	6	11,52	16	24,16	12,08	8,05	6,03	4,82
10	0,53	10	1,04	0,625	0,53	1,25	2,20	6	14,4	20	30,20	15,09	10,06	7,54	6,02
12	0,63	12	1,24	0,750	0,63	1,50	2,64	6	17,28	24	36,24	18,11	12,07	9,05	7,23
16	0,84	16	1,66	1,000	0,84	2,00	3,52	6	23,04	32	48,31	24,15	16,09	12,06	9,64
20	1,05	20	2,07	1,250	1,05	2,50	4,40	6	28,8	40	60,39	30,19	20,11	15,08	12,05
Recommended Feed											100%	70%	50%	30%	10%