

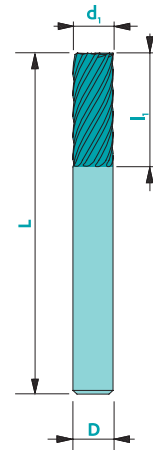
# Finishing end mill multiflutes - helix angle 30°

113

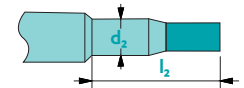
Material	Vc uncoated	Vc coated	Uncoated	Coated	Rec. Coating*
Steel < 700 N/mm <sup>2</sup>	100	130	□	■	Tisi (BQ)
Steel > 700 N/mm <sup>2</sup>	80	100	-	■	Tisi (BQ)
Stainless steel	50	70	□	■	Tisi (BQ)
Cast iron	60	100	□	■	Tisi (BQ)
Copper	130	160	□	■	Solo (DA)
Brass - Bronze	140	190	■	□	Solo (DA)
Aluminium	200	350	□	■	Solo (DA)
Gold - Silver	140	180	■	■	Solo (DA)
Platinum - Palladium	-	35	-	□	Solo (DA)
Superalloys	-	40	-	■	Trio (PO)
Titanium	40	60	■	■	RICO (ZB)

not adapted - adapted □ highly adapted ■

Tolerances  $d_1 < D_1$ , mm ▶ 0/-0.02  
 $d_1 = D_1$  ▶  $d_1$ : e8 D: h5



Upon request



Art. n°	$d_1$	$l_1$	D	L	Z		
						Uncoat.	Trio*
113d2.00	2.0	8	6	51	6	▲	▲
113d2.50	2.5	8	6	51	6	▲	▲
113d3.00	3.0	12	6	51	6	▲	▲
113d3.50	3.5	12	6	51	6	▲	▲
113d4.00	4.0	12	6	51	6	▲	▲
113d4.50	4.5	14	6	51	6	▲	▲
113d5.00	5.0	14	6	51	6	▲	▲
113d5.50	5.5	16	6	51	6	▲	▲
113d6.00	6.0	16	6	51	8	▲	▲
113d7.00	7.0	20	7	61	8	▲	▲
113d8.00	8.0	20	8	61	8	▲	▲
113d10.00	10.0	22	10	72	8	▲	▲
113d12.00	12.0	22	12	83	10	▲	▲
113d14.00	14.0	25	14	83	10	▲	▲
113d16.00	16.0	25	16	92	12	▲	▲

\* Prices for other coatings: contact us!  
 To order a coated tool, add the 2-letter coating code to the article number

Available uncoated or coated (see page 308)

Z6-12



$\lambda$  30°  $\gamma$  8°

CARB



$ae = 0.05 \times d_1$   
 $ap = 1 \times d_1$