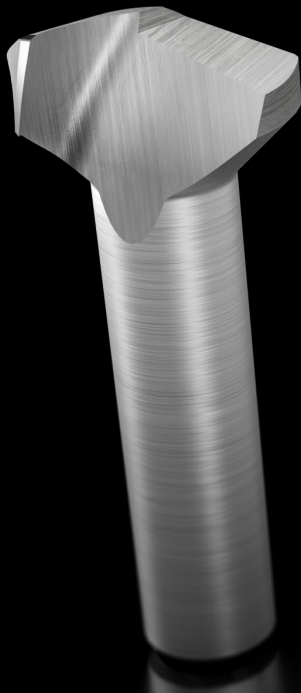
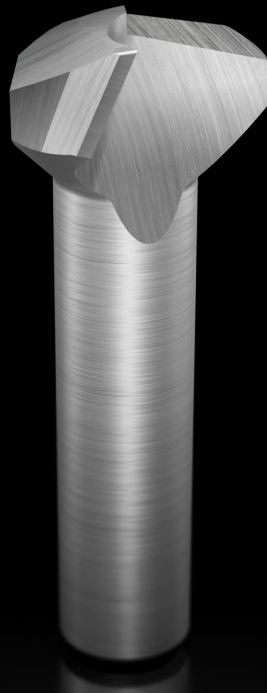


STEPPED SINGLE FLUTE END MILL

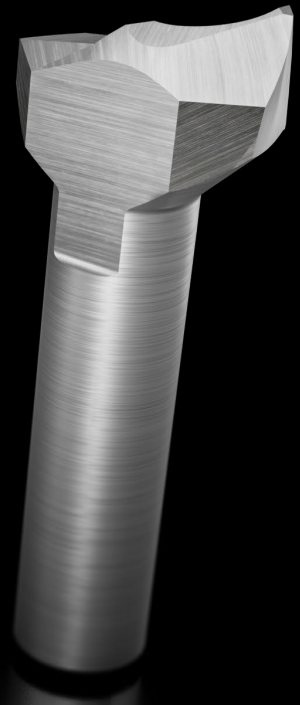
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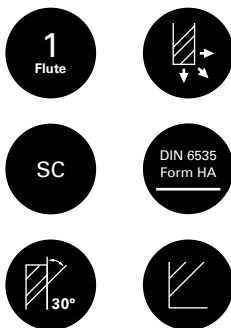
Optimized chip flute for fast and efficient chip removal



Sharp cutting edge and wiper flat for excellent surface quality



Patented balanced tool tip for maximum smoothness and low-vibration operation



Aluminium



Brass



Copper



Plastic



Wood



Art. No.	D1 (mm)	D2 (mm)	L1 (mm)	L2 (mm)
0068814E	14.0	8.0	45.0	5.0
0068820E	20.0	10.0	50.0	7.0
0068824E	24.0	12.0	60.0	8.5

Regrinding service max. three times per tool due to balancing surface

D1 (mm) Cutter Diameter	Z Number of Flutes	Vc (m/min) Cutting Speed	n (1/min) RPM	fz (mm) Feed per Flute	Vf (mm/min) Feed XY	ap (mm) Cutting Depth	ae (mm) Cutting Width	Q (cm ³ /min) Chip Volume
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Art. No.	D1 (mm)	Z	Vc (m/min)	n (1/min)	fz (mm)	Vf (mm/min)	ap (mm)	ae (mm)	Q (cm ³ /min)
0068814E	14	1	1495	34000	0.2	6800	0.5	14	47.6
0068820E	20	1	2011	32000	0.25	8000	1	20	160
0068824E	24	1	2262	30000	0.3	9000	1.5	24	324

Art. No.	D1 (mm)	Z	Vc (m/min)	n (1/min)	fz (mm)	Vf (mm/min)	ap (mm)	ae (mm)	Q (cm ³ /min)
0068814E	14	1	1495	34000	0.2	6800	5	1	34
0068820E	20	1	2011	32000	0.25	8000	7	2	112
0068824E	24	1	2262	30000	0.3	9000	8.5	3	229.5

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