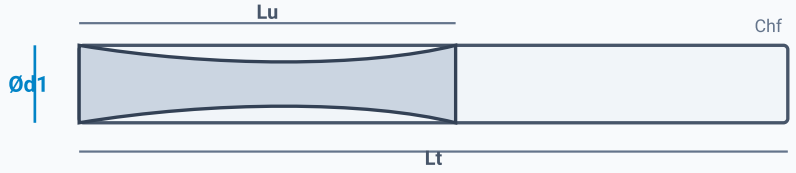
CARBIDEN.COM PRECISION TOOLING

Solid Carbide End Mills with Polished Flutes DLC coating

M49-132



SUITABLE MATERIALS

Aluminium | Copper | Brass

Ø d1	Ø d2	Lu	Lt	Chf	Part Code
2	3	5	40	0.02	**M49-132 0200**
3	3	6	39	0.03	**M49-132 0300**
4	4	8	51	0.03	**M49-132 0400**
	6	10	50	0.03	**M49-132 0400A**
5	5	10	50	0.04	**M49-132 0500**
6	6	12	60	0.04	**M49-132 0600**
		25	70	0.04	**M49-132 0600A**
8	8	19	64	0.04	**M49-132 0800**
		22	80	0.04	**M49-132 0800A**
		38	100	0.04	**M49-132 0800B**
10	10	22	73	0.05	**M49-132 1000**
		38	100	0.05	**M49-132 1000A**
12	12	24	84	0.05	**M49-132 1200**
		50	100	0.05	**M49-132 1200A**
		75	150	0.05	**M49-132 1200B**
14	14	26	84	0.06	**M49-132 1400**
		42	100	0.06	**M49-132 1400A**
		75	150	0.06	**M49-132 1400B**
16	16	32	93	0.06	**M49-132 1600**
		48	100	0.06	**M49-132 1600A**
		75	150	0.06	**M49-132 1600C**
18	18	32	93	0.06	**M49-132 1800**
20	20	38	105	0.06	**M49-132 2000**
		80	150	0.06	**M49-132 2000B**

Machining Advice Example (Brass Cut)

Tool: **Ø6 (M49-132 0600)**
Cutting Speed (Vc): **250 m/min**
Spindle Speed (N): **14,000 rpm**
Feed Rate (A): **1,120 mm/min**
Axial Depth (ap): **3 – 4 mm**
Radial Depth (ae): **6 mm**
Plunge Feed: **350 mm/min**
Milling Mode: **Climb milling (down-cut)**

Coolant Requirements

Operation is possible dry or with minimal cooling. To ensure optimal chip evacuation, achieve the desired surface finish, and maximize tool life, use an appropriate coolant.