

MIC-CUT

150 Series Micro Straight Endmill



General Engineering



Mold&Die



Finish



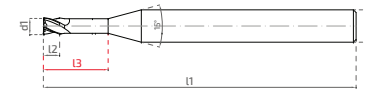
Rough

High Precision, Advanced Technology, Know-how

Swiss and German technologies met Karcan expertise and passion, we intended to achieve Japanese performance, here's our new series; 150, 153 and 250.

High efficiency and precision milling on work pieces up to **63HRC**.

Up to **40%** enhanced tool life with special grades and coating technology developed for micro end mills.



Stock	Code	d1	d2h5	l1	l2	l3
*	150200502	0,5	4	50	0,5	2
*	150200503	0,5	4	50	0,5	3
*	150200504	0,5	4	50	0,5	4
*	150201002	1	4	50	1	2
*	150201004	1	4	50	1	4
*	150201006	1	4	50	1	6
*	150201008	1	4	50	1	8
*	150201010	1	4	50	1	10
*	150201012	1	4	50	1	12
*	150201014	1	4	50	1	14
*	150201016	1	4	50	1	16
*	150215004	1,5	4	50	1,5	4
*	150215006	1,5	4	50	1,5	6
*	150215008	1,5	4	50	1,5	8
*	150215010	1,5	4	50	1,5	10
*	150215012	1,5	4	50	1,5	12
*	150215014	1,5	4	50	1,5	14
*	150215016	1,5	4	50	1,5	16
*	150220004	2	4	50	2	4
*	150220006	2	4	50	2	6
*	150220008	2	4	50	2	8
*	150220010	2	4	50	2	10
*	150220012	2	4	50	2	12
*	150220016	2	4	50	2	16
*	150220020	2	4	50	2	20
*	150225006	2,5	4	50	2,5	6
*	150225008	2,5	4	50	2,5	8
*	150225010	2,5	4	50	2,5	10
*	150225012	2,5	4	50	2,5	12
*	150225020	2,5	4	50	2,5	20

Cutting Parameters		
Material	Shoulder Milling ap=0.20 / ae=0.20 - 0.100	Slotting ap=0.10
	Vc (m/min)	Vc (m/min)



Material	Vc (m/min)	
	Shoulder Milling	Slotting
Unalloyed Steel	170-220	170-220
Steel	170-220	170-220
Tempered Steel	140-180	140-180
Cold Work Tool Steel	140-180	140-180
Hot Work Tool Steel	110-150	110-150
AISI 304 - 416 - 420	80-130	80-130
AISI 316 - 440	70-120	70-120
17-4 PH 15-5 PH	70-100	70-100
Cobalt-Chrome Alloys	60-100	60-100
Duplex F51	50-80	50-80
Super Duplex F55	50-80	50-80
Gray Cast Iron	110-150	110-150
Titanium	30-60	30-60
Titanium Alloys	30-60	30-60
≤ 54 HRC	100-140	100-140
>54 HRC	70-90	70-90

Ø	Feed Per Tooth (mm/tooth)			
	ae=0.200	ae=0.100	ae=0.200	ae=0.100
1	0.015	0.020	0.015	0.020
1,5	0.018	0.025	0.018	0.025
2	0.022	0.031	0.022	0.031
2,5	0.027	0.038	0.027	0.038

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150 Micro Straight Endmill



Steel	●
Stainless Steel	●
Hardened Steel ≤54 HRC	●
Hardened Steel >54 HRC	●
Cast Iron	○
Graphite	○
Non Ferrous Material	○
HRSA	○
Titanium	○

● Recommended ○ Acceptable ○ Not Recommended

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* Marked products can be delivered quickly from stock.

