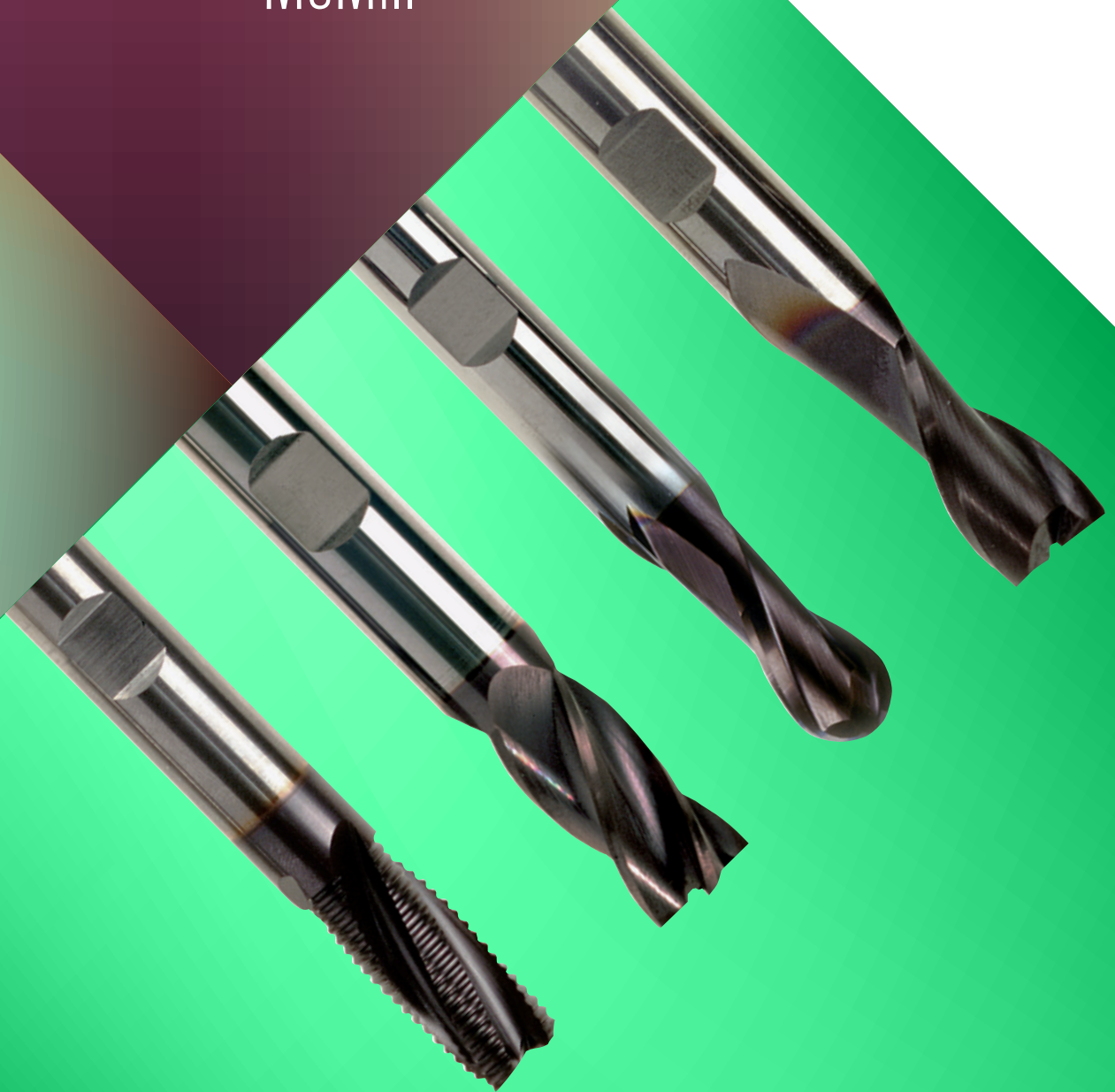


**SOLID CARBIDE  
END MILLS**  
McMill

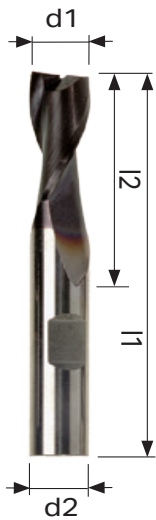


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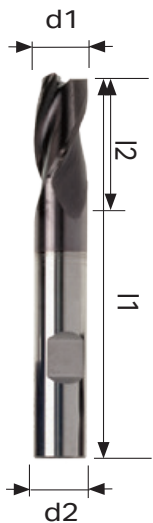
## McMill 10209



Solid Carbide Slot end mill,  
short version, 2 flutes,  
30 °, TiAlN coating

d1 h10	d2 h6	l2	l1	Teeth	Part No
1,0	6	5	50	2	10209-010
2,0	6	6	50	2	10209-020
3,0	6	6	50	2	10209-030
4,0	6	8	50	2	10209-040
5,0	6	8	50	2	10209-050
6,0	6	16	50	2	10209-060
8,0	8	20	60	2	10209-080
10,0	10	22	70	2	10209-100
12,0	12	22	70	2	10209-120
16,0	16	25	75	2	10209-160
20,0	20	32	100	2	10209-200

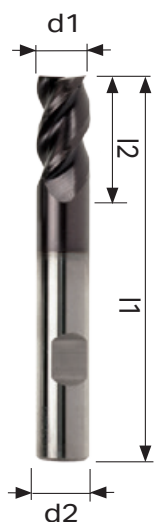
## McMill 10309



Solid Carbide Slot end mill,  
short version, 3 flutes,  
30 °, TiAlN coating

d1 h10	d2 h6	l2	l1	Teeth	Part No
1,0	6	5	50	3	10309-010
2,0	6	6	50	3	10309-020
3,0	6	6	50	3	10309-030
4,0	6	8	50	3	10309-040
5,0	6	8	50	3	10309-050
6,0	6	16	50	3	10309-060
8,0	8	20	60	3	10309-080
10,0	10	22	70	3	10309-100
12,0	12	22	70	3	10309-120
16,0	16	25	75	3	10309-160
20,0	20	32	100	3	10309-200

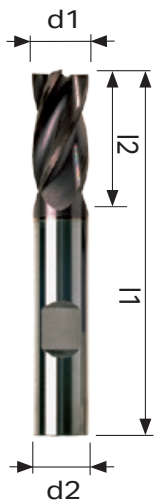
## McMill 10319



Solid Carbide Slot end mill,  
extra long, 3 flutes,  
45 °, TiAlN coating

d1 h10	d2 h6	l2	l1	Teeth	Part No
1,0	6	5	57	3	10319-010
2,0	6	6	57	3	10319-020
3,0	6	7	57	3	10319-030
4,0	6	8	57	3	10319-040
5,0	6	10	57	3	10319-050
6,0	6	10	57	3	10319-060
8,0	8	16	63	3	10319-080
10,0	10	19	72	3	10319-100
12,0	12	22	83	3	10319-120
16,0	16	26	92	3	10319-160
20,0	20	32	104	3	10319-200

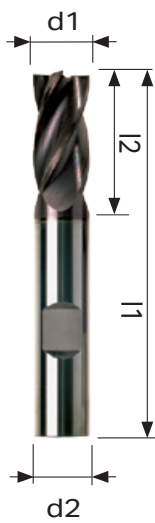
McMill 10409



Solid Carbide Slot end mill,  
Short version, 4 flutes,  
30 °, TiAlN coating

d1 h10	d2 h6	l2	l1	Teeth	Part No
1,0	6	5	50	4	10409-010
2,0	6	7	50	4	10409-020
3,0	6	8	50	4	10409-030
4,0	6	11	50	4	10409-040
5,0	6	13	50	4	10409-050
6,0	6	16	50	4	10409-060
8,0	8	20	60	4	10409-080
10,0	10	22	70	4	10409-100
12,0	12	22	70	4	10409-120
16,0	16	25	75	4	10409-160
20,0	20	32	100	4	10409-200

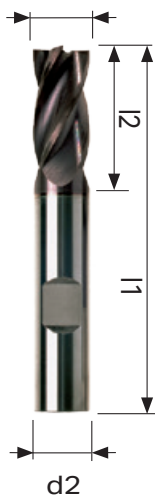
McMill 10419



Solid Carbide Slot end mill,  
long version, 4 Cutting,  
30 °, TiAlN coating

d1 h10	d2 h6	l2	l1	Teeth	Part No
1,0	6	3	50	4	10419-010
2,0	6	4	50	4	10419-020
3,0	6	6	50	4	10419-030
4,0	6	8	50	4	10419-040
5,0	6	8	50	4	10419-050
6,0	6	13	57	4	10419-060
8,0	8	19	63	4	10419-080
10,0	10	22	72	4	10419-100
12,0	12	26	83	4	10419-120
16,0	16	32	92	4	10419-160
20,0	20	38	104	4	10419-200

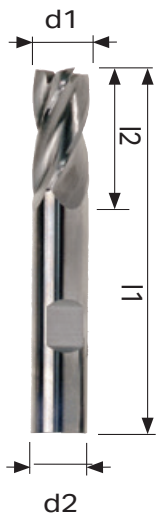
McMill 10429



Solid Carbide Slot end mill,  
Extra long version  
4 Cutting flutes  
30 °, TiAlN coating

d1 h10	d2 h6	l2	l1	Teeth	Part No
3,0	6	12	50	4	10429-030
4,0	6	15	50	4	10429-040
5,0	6	20	60	4	10429-050
6,0	6	20	60	4	10429-060
8,0	8	25	70	4	10429-080
10,0	10	30	90	4	10429-100
12,0	12	30	90	4	10429-120
16,0	16	50	110	4	10429-160
20,0	20	55	110	4	10429-200

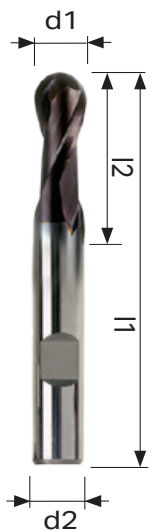
## McMill 10509



Solid Carbide Slot end mill,  
Extra long version,  
4 Cutting flutes, 39 °, for non-ferrous  
metals.

d1 h10	d2 h6	l2	l1	Teeth	Part No
4,0	6	8	62	4	10509-040
5,0	6	15	62	4	10509-050
6,0	6	18	62	4	10509-060
8,0	8	24	68	4	10509-080
10,0	10	30	80	4	10509-100
12,0	12	36	93	4	10509-120
16,0	16	48	108	4	10509-160
20,0	20	60	126	4	10509-200

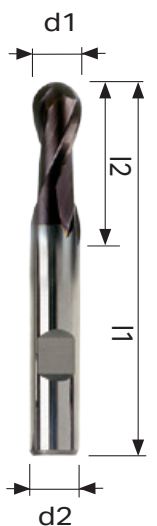
## McMill 10229



Solid Carbide ball nose end mills,  
short version, 2 flutes,  
30 °, TiAlN coating

d1 h10	d2 h6	l2	l1	Teeth	Part No
1,0	6	3	50	2	10229-010
2,0	6	4	50	2	10229-020
3,0	6	5	50	2	10229-030
4,0	6	6	50	2	10229-040
5,0	6	7	50	2	10229-050
6,0	6	7	51	2	10229-060
8,0	8	9	59	2	10229-080
10,0	10	10	60	2	10229-100
12,0	12	14	71	2	10229-120
16,0	16	16	76	2	10229-160
20,0	20	20	82	2	10229-200

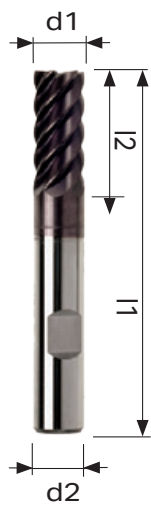
## McMill 10239



Solid Carbide ball nose end mills,  
long version, 2 cutting flutes,  
30 °, TiAlN coating

d1 h10	d2 h6	l2	l1	Teeth	Part No
6,0	6	10	57	2	10239-060
8,0	8	16	63	2	10239-080
10,0	10	19	72	2	10239-100
12,0	12	22	83	2	10239-120
16,0	16	26	92	2	10239-160
20,0	20	32	104	2	10239-200

McMill 10609



Solid Carbide end mills,  
long version, 6-8 cutting flutes  
45° TiAlN coating

d1 h10	d2 h6	l2	l1	Teeth	Part No
6,0	6	13	57	6	10609-060
8,0	8	19	63	6	10609-080
10,0	10	22	72	6	10609-100
12,0	12	26	83	6	10609-120
16,0	16	32	92	6	10609-160
20,0	20	38	104	8	10609-200

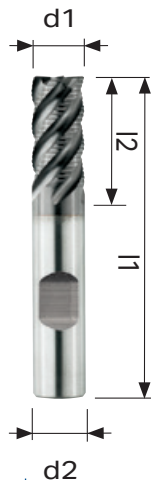
McMill 10709



Solid Carbide end mill ( roughing,)  
long version, 3-4 cutting flutes  
30 °, TiAlN coating

d1 h10	d2 h6	l2	l1	Teeth	Part No
3,0	6	6	57	3	10709-030
4,0	6	8	57	3	10709-040
5,0	6	10	57	3	10709-050
6,0	6	16	57	3	10709-060
8,0	8	16	63	3	10709-080
10,0	10	22	72	4	10709-100
12,0	12	26	83	4	10709-120
16,0	16	32	92	4	10709-160
20,0	20	38	104	4	10709-200

McMill 10719



Solid Carbide end mill (roughing)  
long version, 3-6 cutting flutes  
45 °, TiAlN coating

d1 h10	d2 h6	l2	l1	Teeth	Part No
4,0	6	11	57	3	10719-040
5,0	6	13	57	4	10719-050
6,0	6	16	57	4	10719-060
8,0	8	16	69	4	10719-080
10,0	10	22	72	4	10719-100
12,0	12	28	83	4	10719-120
16,0	16	32	92	5	10719-160
20,0	20	38	104	6	10719-200

## TOOL DATA RECOMMENDATION FOR SOLID CARBIDE END MILLS

Material	Tensile Strength N/mm2	DIN No	Material Code	vc m/min.	2-3	4-5	6-10	12-16	20
Aluminum Alloy <10% Si	<550	AlMg 3	3 3535 3 4365	400 - 500	0,02	0,03	0,05	0,08	0,12
Aluminum Alloy <10% Si	<600	AlZnMgCu 1 5	3 4365	200 - 250	0,01	0,02	0,04	0,06	0,10
Copper Alloy	<550	MS 63 CuAl 10 Ni	2 0320 2 0975	90 - 110	0,01	0,02	0,04	0,07	0,10
Copper Alloy	<700	MS 68	2 0402	80 - 100	0,01	0,02	0,04	0,07	0,10
Free Cutting Steel	<700	9SMn 28	1. 0715	80 - 100	0,02	0,04	0,05	0,08	0,12
Construction Steel	<520	St 52	1.0052	85 - 110	0,02	0,03	0,04	0,07	0,08
Construction Steel	<750	CK 45 26 CrMo 4	1. 1191 1. 2241	80 - 100	0,02	0,03	0,04	0,07	0,08
Heat Tretable Steel Medium Strength	<950	42 CrMo 4 50 CrV 4	1. 7225 1. 2241	65 - 75	0,02	0,03	0,04	0,07	0,08
Nitriding Steel	<950	16 MnCr 5	1 7131	75 - 95	0,02	0,03	0,04	0,07	0,08
Heat Tretable Steel High Strength	<1200	30 CrNiMo 8	1 7225 1 6580	65 - 75	0,01	0,01	0,02	0,03	0,05
Nitriding Steel	<1400	34 CrAl 6	1 8504	65 - 80	0,01	0,01	0,02	0,04	0,06
Tool Steel	<1400	X 38CrMoV 5 1 X 155 CrVMo 12	1 2343 1 2379	65 - 75	0,01	0,01	0,02	0,03	0,05
Steel - 55 Hrc	- 1800 N/mm <sup>2</sup>	Hardened Steel	-	45 - 55	0,02	0,04	0,05	0,07	0,15
Steel - 65 Hrc	- 2000 N/mm <sup>2</sup>	Hardened Steel	-	25 - 30	0,02	0,04	0,05	0,07	0,15
Stainless Steel	<900	X 10 Cr 13 X 12 CrMoS17X 35CrMo 17	1 4006 1 4104 1 4122	45 - 55	0,01	0,01	0,02	0,04	0,05
Stainless Steel	>900	X 5 CrNi 18 10 X 10 CrNiMo 18 10	1 4301 1 4571	35 - 45	0,01	0,01	0,02	0,04	0,05
Gray Cast Iron	100-400	GG 25	0 6025	100 - 130	0,02	0,03	0,05	0,08	0,12
Alloy Cast Iron	150-250	GGL-NiCr 35 2	0 6678	80 - 100	0,01	0,02	0,04	0,07	0,08
Ductile Iron	400-800	GGG 60	0 7060	80 - 100	0,01	0,02	0,04	0,07	0,10
Malleable	350-700	GTS 55	0 8155	80 - 100	0,02	0,03	0,05	0,08	0,12
Nickel Alloy Medium Strength	<950	NiCr 12 Al 6 MoNo	2 4670	20 - 25	0,01	0,01	0,02	0,04	0,05
Nickel Alloy High Strength	<1400	NiCr 19Fe 19NbMo	Inconel	15 - 20	0,01	0,01	0,02	0,03	0,04
Hard Cast	<600	Ni-Hard, Ampco	-	25 - 35	0,01	0,01	0,02	0,04	0,05

## FEED-CORRECTION FACTORS FOR SOLID CARBIDE END MILLS

