

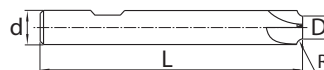
Quarter round profile mill

General machining

5601R90*FM-R



- Type of shank: DIN 6535HB
- Non-centre cutting
- Helix angle 0°



Article	*	Dimensions [mm]				Teeth	Grade
		d(h6)	L	D	R		KMG303
5601R904FM-R02-0600		6	60	5.6	0.2	4	●
5601R904FM-R03-0600		6	60	5.4	0.3	4	●
5601R904FM-R04-0600		6	60	5.2	0.4	4	●
5601R904FM-R05-0800		8	70	7	0.5	4	●
5601R904FM-R06-0800		8	70	6.8	0.6	4	●
5601R904FM-R075-0800		8	70	6.5	0.75	4	●
5601R904FM-R08-0800		8	70	6.4	0.8	4	●
5601R904FM-R10-0800		8	70	6	1	4	●
5601R904FM-R15-1000		10	75	7	1.5	4	●
5601R904FM-R20-1000		10	75	6	2	4	●
5601R904FM-R25-1200		12	75	7	2.5	4	●
5601R904FM-R30-1200		12	75	6	3	4	●
5601R904FM-R40-1600		16	80	8	4	4	●
5601R904FM-R50-2000		20	80	10	5	4	●

● Ex stock ○ On demand

* With internal cooling

Application field

P	M	K	N	S	H
✓	✓	✓	✓		

✓ Very suitable

✓ Suitable

Deburring cutters – FM series

Material group		Composition / structure / heat treatment		Brinell hardness HB	Machining group	Starting values for cutting speed v_c [m/min]				
						5501 / 5601 5501 / 5601 5601				
						KMG303				
						a_e / D				
1/1	1/2	1/10	f-group							
P	Unalloyed steel	approx. 0,15 % C	annealed	125	1	–	–	230	11	
		approx. 0,45 % C	annealed	190	2	–	–	220	11	
		approx. 0,45 % C	tempered	250	3	–	–	165	11	
		approx. 0,75 % C	annealed	270	4	–	–	140	11	
		approx. 0,75 % C	tempered	300	5	–	–	130	11	
	Low-alloyed steel		annealed	180	6	–	–	175	11	
			tempered	275	7	–	–	140	11	
			tempered	300	8	–	–	130	11	
			tempered	350	9	–	–	120	11	
High-alloyed steel and high-alloyed tool steel		annealed	200	10	–	–	165	11		
		hardened and tempered	325	11	–	–	125	11		
M	Stainless steel	ferritic/martensitic	annealed	200	12	–	–	75	11	
		martensitic	tempered	240	13	–	–	65	11	
		austenitic	quench hardened	180	14	–	–	80	11	
		austenitic-ferritic		230	15	–	–	65	11	
K	Grey cast iron	perlitic/ferritic		180	16	–	–	170	11	
		perlitic (martensitic)		260	17	–	–	140	11	
	Cast iron with spheroidal graphite	ferritic		160	18	–	–	210	11	
		perlitic		250	19	–	–	165	11	
	Malleable cast iron	ferritic		130	20	–	–	230	11	
		perlitic		230	21	–	–	185	11	
N	Aluminium wrought alloys	cannot be hardened		60	22	–	–	1200	11	
		hardenable	hardened	100	23	–	–	720	11	
	Cast aluminium alloys	≤ 12 % Si, cannot be hardened		75	24	–	–	480	11	
		≤ 12 % Si, hardenable	hardened	90	25	–	–	600	11	
		> 12 % Si, cannot be hardened		130	26	–	–	180	11	
	Copper and copper alloys (bronze/brass)	machining steel, PB> 1%		110	27	–	–	360	11	
CuZn, CuSnZn		90	28	–	–	420	11			
CuSn, Pb-free copper, electrolytic copper		100	29	–	–	360	11			
S	Heat-resistant alloys	Fe-based alloys	annealed	200	30					
			hardened	280	31					
		Ni or Co bass	annealed	250	32					
			hardened	350	33					
			cast	320	34					
	Titanium alloys	pure titanium		R _m 400	35					
α and β alloys		hardened	R _m 1050	36						
H	Hardened steel		hardened and tempered	55 HRC	37					
			hardened and tempered	60 HRC	38					
	Hard cast iron		cast	400	39					
	Hardened cast iron		hardened and tempered	55 HRC	40					
X	Non-metallic materials	Thermoplasts			41					
		Thermosetting plastics			42					
		Plastic, glass-fibre reinforced GFRP			43					
		Plastic, carbon fibre reinforced CFRP			44					
		Graphite			45					
		Wood			46					

Note: The given cutting values are guide values, which were determined under ideal conditions.

The values have to be adapted in individual cases.

Feed rate recommendations on page B522.

For examples of material for cutting tool groups view page D11.

Recommended feed rate

Solid carbide milling group 9 – Square shoulder mills UM/UMC series, VPM series HSC/HPC

	a_e / D	Feed rate per cutting edge (f_z) [mm]																			
		Ø 4	Ø 5	Ø 6	Ø 8	Ø 10	Ø 12	Ø 14	Ø 16	Ø 18	Ø 20										
P	1/1	0,06	0,06	0,06	0,07	0,07	0,07	0,07	0,08	0,08	0,08										
	1/2	0,08	0,08	0,08	0,09	0,09	0,09	0,09	0,10	0,10	0,10										
	1/10	0,14	0,14	0,16	0,18	0,22	0,25	0,27	0,3	0,32	0,36										
M	1/1	0,05	0,05	0,05	0,05	0,05	0,05	0,05	0,06	0,06	0,06										
	1/2	0,06	0,06	0,06	0,07	0,07	0,07	0,07	0,08	0,08	0,08										
	1/10	0,10	0,10	0,10	0,12	0,12	0,14	0,16	0,16	0,18	0,18										
K	1/1	0,06	0,06	0,06	0,07	0,07	0,07	0,07	0,08	0,08	0,08										
	1/2	0,08	0,08	0,08	0,09	0,09	0,09	0,09	0,10	0,10	0,10										
	1/10	0,14	0,14	0,16	0,18	0,22	0,25	0,27	0,3	0,32	0,36										
H	1/1	0,045	0,045	0,045	0,053	0,053	0,053	0,053	0,06	0,06	0,06										
	1/2	0,06	0,06	0,06	0,07	0,07	0,07	0,07	0,08	0,08	0,08										
	1/10	0,10	0,10	0,10	0,12	0,12	0,14	0,16	0,16	0,18	0,18										

Note: The given cutting values are guide values, which were determined under ideal conditions.
The values have to be adapted in individual cases.

Solid carbide milling group 10 – Square shoulder mills VSM series, TM series

	a_e / D	Feed rate per cutting edge (f_z) [mm]																			
		Ø 4	Ø 5	Ø 6	Ø 8	Ø 10	Ø 12	Ø 14	Ø 16	Ø 18	Ø 20										
P	1/1	0,03	0,04	0,05	0,05	0,05	0,05	0,06	0,06	0,07	0,08										
	1/2	0,04	0,06	0,07	0,07	0,07	0,07	0,08	0,09	0,10	0,11										
	1/10	0,05	0,08	0,09	0,09	0,09	0,09	0,11	0,12	0,14	0,15										
M	1/1	0,02	0,03	0,04	0,04	0,04	0,04	0,04	0,05	0,05	0,06										
	1/2	0,03	0,05	0,05	0,05	0,05	0,05	0,06	0,07	0,08	0,08										
	1/10	0,04	0,06	0,07	0,07	0,07	0,07	0,08	0,09	0,10	0,11										
S	1/1	0,02	0,03	0,04	0,04	0,04	0,04	0,04	0,05	0,05	0,06										
	1/2	0,03	0,05	0,05	0,05	0,05	0,05	0,06	0,07	0,08	0,08										
	1/10	0,04	0,06	0,07	0,07	0,07	0,07	0,08	0,09	0,10	0,11										

Note: The given cutting values are guide values, which were determined under ideal conditions.
The values have to be adapted in individual cases.

Solid carbide milling group 11 – Deburring cutters FM series

	a_e / D	Feed rate per cutting edge (f_z) [mm]																			
		Ø 3	Ø 4	Ø 5	Ø 6	Ø 8	Ø 10	Ø 12	Ø 14	Ø 16	Ø 18	Ø 20									
P	1/1																				
	1/2																				
	1/10	0,02	0,02	0,03	0,03	0,04	0,06	0,07	0,07	0,08	0,08	0,09									
M	1/1																				
	1/2																				
	1/10	0,02	0,02	0,02	0,02	0,03	0,05	0,06	0,06	0,06	0,06	0,07									
K	1/1																				
	1/2																				
	1/10	0,02	0,02	0,03	0,03	0,04	0,06	0,07	0,07	0,08	0,08	0,09									
N	1/1																				
	1/2																				
	1/10	0,03	0,03	0,05	0,05	0,06	0,09	0,11	0,11	0,12	0,12	0,14									

Note: The given cutting values are guide values, which were determined under ideal conditions.
The values have to be adapted in individual cases.

5 5 0 1 R 30 2 GM R05 0800

1 2 3 4 5 6 7 8 9 10

A

Turning

Type	
Code	Description
5	Milling cutter

Shank type	
Code	Description
1	Shank
5	DIN 6535 HA
6	Weldon shank DIN 6535 HB
7	Whistle Notch DIN 6535 HE
9	Morse taper shank

B

Milling

1

2

Cutting edge type	
Code	Description
0	Square shoulder mill
6	Ball nose cutter
8	Torus mill

Tool length	
Code	Description
1	DIN 6527 K
2	DIN 6527 L
5	Factory standard ZCC-A
6	Factory standard ZCC-B
8	DIN 6528
9	Factory standard ZCC-D

C

Drilling

3

4

Rotation direction	
Code	Description
R	Right
L	Left

Helix angle	
Code	Description
20	20°
30	30°
3841	38°/41°
45	45°
55	55°
60	60°

Number of teeth	
Code	Description
2	2
...	
M	Indicated when different diameters have a different number of teeth

D

5

6

7

Application	
Code	Description
GM	Semi-finishing
GF	Finishing
HM	Hard machining
MHH	High-speed hard machining
NH	High-performance machining of heat-resistant alloys

Radius [mm]	
Code	Description
R03	0,3
R15	1,5
R30	3,0
...	

Diameter [mm]	
Code	Description
0100	1,0
0800	8,0
2000	20,0
...	

E

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a Groove milling
g Plunge milling



b Square shoulder milling
h Circular milling/Ramping



c Profile milling



d Slot milling



e Face milling

f Chamfer milling