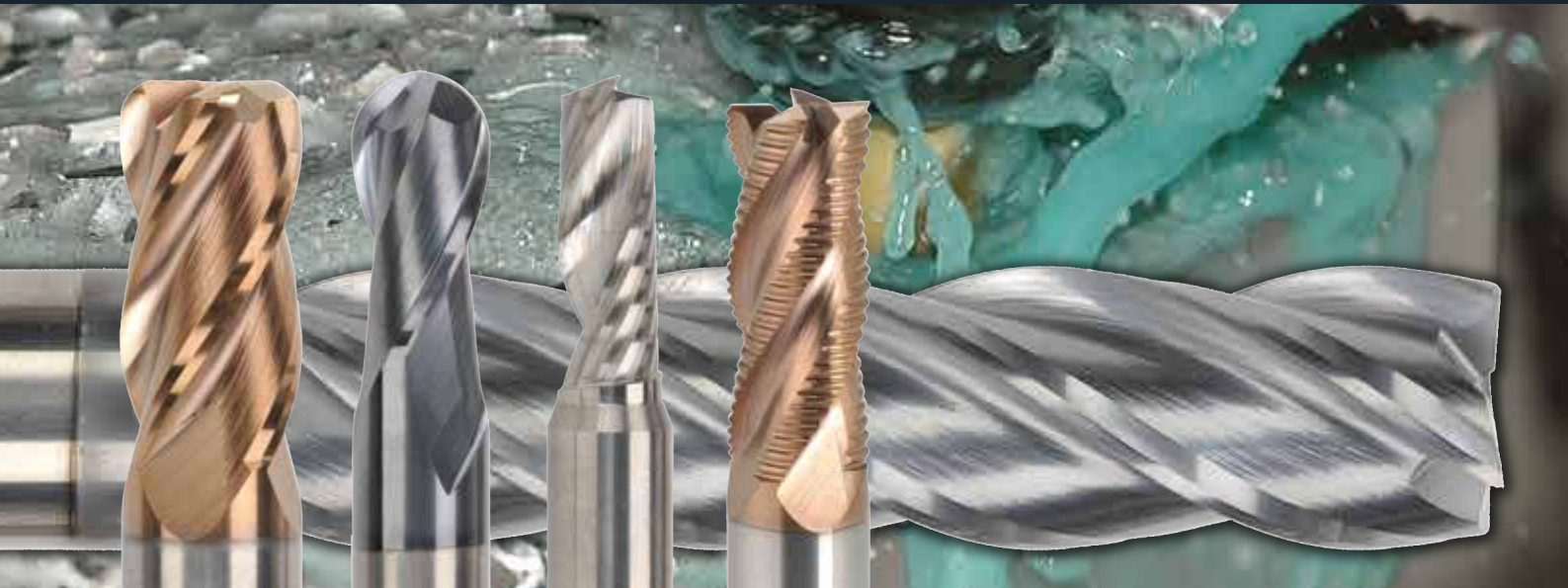




HIGH
PERFORMANCE



CARBIDE END MILLS
BUYER'S GUIDE 09/2025

SLOT DRILLS AND ENDMILLS

2 Flute General Purpose Slot Drills	1
4 Flute Variable Helix (Varimill) Endmills	2
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2 FLUTE, GENERAL PURPOSE

Universal applications, suitable for materials up to 1600N/mm².
For milling of slots and cavities.
Black Nano Coating.

GROUP

CDEM



Tungsten Carbide



2 Flutes



Coating



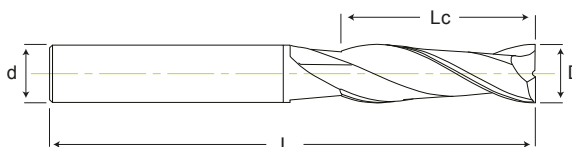
35° Helix



Square



< 1600N/mm²



SHORT SERIES					PART NUMBER
DIAMETER (D) MM	FLUTE (Lc) MM	OAL (L) MM	SHANK (d) MM	fz MM/TOOTH	
1.0	3	50	4	0.005	6561-1.00X50
1.5	4	50	4	0.005	6561-1.50X50
2.0	6	50	4	0.010	6561-2.00X50
2.5	8	50	4	0.010	6561-2.50X50
3.0	8	50	4	0.020	6561-3.00X50
3.5	10	50	4	0.020	6561-3.50X50
4.0	11	50	4	0.020	6561-4.00X50
5.0	13	50	6	0.030	6561-5.00X50
6.0	15	50	6	0.035	6561-6.00X50
8.0	20	60	8	0.040	6561-8.00X60
10.0	25	75	10	0.045	6561-10.00X75
12.0	30	75	12	0.055	6561-12.00X75
14.0	35	100	14	0.060	6561-14.00X100
16.0	40	100	16	0.065	6561-16.00X100
18.0	45	100	18	0.070	6561-18.00X100
20.0	45	100	20	0.070	6561-20.00X100



LONG SERIES					PART NUMBER
DIAMETER (D) MM	FLUTE (Lc) MM	OAL (L) MM	SHANK (d) MM	fz MM/TOOTH	
3.0	10	75	3	0.020	6561-3.00X75
4.0	15	75	4	0.020	6561-4.00X75
5.0	20	75	5	0.030	6561-5.00X75
6.0	20	75	6	0.035	6561-6.00X75
8.0	35	100	8	0.040	6561-8.00X100
10.0	40	100	10	0.045	6561-10.00X100
12.0	55	150	12	0.055	6561-12.00X150
14.0	60	150	14	0.060	6561-14.00X150
16.0	65	150	16	0.065	6561-16.00X150
20.0	75	150	20	0.070	6561-20.00X150

APPLICATION TABLE OF PROCESSED MATERIALS												
ISO	P	P	P	P	M	K	N	N	N	S	S	H
WORKPIECE MATERIAL	MILD STEEL	STRUCT. STEEL	ALLOY STEEL	TOOL STEEL	STAINLESS STEEL	CAST IRON	ALUMINIUM ALLOY	CAST ALUMINIUM	COPPER ALLOYS	SUPER ALLOYS	TITANIUM ALLOYS	HARDENED STEEL
	<500N	<750N	<1400N	<1100N	<900N	<750N	SI<12%	SI>12%	<750N	<1100N	<1100N	<1400N
Vc (m/min)	140 ●	110 ●	80 ●	60 ●	70 ○	110 ○	150 ○	150 ○	150 ○	-	-	-

● OPTIMAL ○ EFFECTIVE

4 FLUTE, VARIABLE HELIX



High performance machining, suitable for most materials up to 1600N/mm².
Unequal helix angle and unequal spacing of teeth greatly reduces vibration.
AlCrSiN coating with high oxidation resistance and high adhesion.

GROUP

CDEM

Tungsten
Carbide

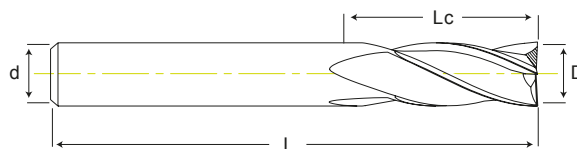
4 Flutes



Coating

Variable
Helix

Square

< 1600N/mm²

SHORT SERIES					PART NUMBER
DIAMETER (D) MM	FLUTE (Lc) MM	OAL (L) MM	SHANK (d) MM	fz MM/TOOTH	
1.0	3	50	4	0.008	6562-1.00X50
1.5	4	50	4	0.012	6562-1.50X50
2.0	6	50	4	0.017	6562-2.00X50
2.5	7	50	4	0.020	6562-2.50X50
3.0	8	50	4	0.025	6562-3.00X50
4.0	11	50	4	0.033	6562-4.00X50
5.0	13	50	6	0.040	6562-5.00X50
6.0	15	50	6	0.045	6562-6.00X50
8.0	20	60	8	0.065	6562-8.00X60
10.0	25	75	10	0.070	6562-10.00X75
12.0	30	75	12	0.075	6562-12.00X75
14.0	45	100	14	0.080	6562-14.00X100
16.0	45	100	16	0.085	6562-16.00X100
20.0	45	100	20	0.095	6562-20.00X100



SHORT SERIES 4 PIECE SET					PART NUMBER
DIAMETER (D) MM	FLUTE (Lc) MM	OAL (L) MM	SHANK (d) MM	fz MM/TOOTH	6562-S1
6.0	15	50	6	0.045	CONTAINS 6562-6.00X50 6562-8.00X60 6562-10.00X75 6562-12.00X75
8.0	20	60	8	0.065	
10.0	25	75	10	0.070	
12.0	30	75	12	0.075	

APPLICATION TABLE OF PROCESSED MATERIALS												
ISO	P	P	P	P	M	K	N	N	N	S	S	H
WORKPIECE MATERIAL	MILD STEEL	STRUCT. STEEL	ALLOY STEEL	TOOL STEEL	STAINLESS STEEL	CAST IRON	ALUMINIUM ALLOY	CAST ALUMINIUM	COPPER ALLOYS	SUPER ALLOYS	TITANIUM ALLOYS	HARDENED STEEL
Vc (m/min)	<500N	<750N	<1400N	<1100N	<900N	<750N	Si<12%	Si>12%	<750N	<1100N	<1100N	<1400N
	210 ●	175 ●	110 ●	90 ●	120 ●	150 ●	200 ○	200 ○	200 ○	50 ○	70 ●	120 ●

● OPTIMAL ○ EFFECTIVE

4 FLUTE, VARIABLE HELIX



High performance machining, suitable for most materials up to 1600N/mm².
Unequal helix angle and unequal spacing of teeth greatly reduces vibration.
AlCrSiN coating with high oxidation resistance and high adhesion.

GROUP
CDEM


Tungsten Carbide



4 Flutes



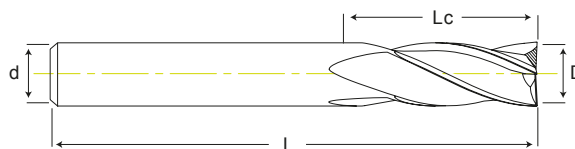
Coating



Variable Helix



Square < 1600N/mm²



LONG SERIES					PART NUMBER
DIAMETER (D) MM	FLUTE (Lc) MM	OAL (L) MM	SHANK (d) MM	fz MM/TOOTH	
3.0	12	75	4	0.025	6562-3.00X75
4.0	15	75	4	0.033	6562-4.00X75
6.0	24	75	6	0.045	6562-6.00X75
8.0	25	75	8	0.065	6562-8.00X75
8.0	32	100	8	0.065	6562-8.00X100
10.0	35	100	10	0.070	6562-10.00X100
12.0	37	100	12	0.075	6562-12.00X100

APPLICATION TABLE OF PROCESSED MATERIALS												
ISO	P	P	P	P	M	K	N	N	N	S	S	H
WORKPIECE MATERIAL	MILD STEEL	STRUCT. STEEL	ALLOY STEEL	TOOL STEEL	STAINLESS STEEL	CAST IRON	ALUMINIUM ALLOY	CAST ALUMINIUM	COPPER ALLOYS	SUPER ALLOYS	TITANIUM ALLOYS	HARDENED STEEL
	<500N	<750N	<1400N	<1100N	<900N	<750N	Si<12%	Si>12%	<750N	<1100N	<1100N	<1400N
Vc (m/min)	210 ●	175 ●	110 ●	90 ●	120 ●	150 ●	200 ○	200 ○	200 ○	50 ○	70 ●	120 ●

● OPTIMAL ○ EFFECTIVE

4 FLUTE, GENERAL PURPOSE – EXTRA LONG

Universal applications, suitable for materials up to 1400N/mm².
AlCrSiN coating with high oxidation resistance and high adhesion.

GROUP

CDEM



Tungsten Carbide



4 Flutes



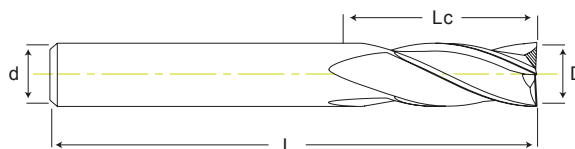
Coating



35° Helix



Square

< 1400N/mm²

EXTRA LONG					PART NUMBER
DIAMETER (D) MM	FLUTE (Lc) MM	OAL (L) MM	SHANK (d) MM	fz MM/TOOTH	
10.0	50	150	10	0.045	6564-10.00X150
12.0	50	150	12	0.055	6564-12.00X150
14.0	60	150	14	0.060	6564-14.00X150
16.0	60	150	16	0.065	6564-16.00X150
20.0	60	150	20	0.070	6564-20.00X150

APPLICATION TABLE OF PROCESSED MATERIALS												
ISO	P	P	P	P	M	K	N	N	N	S	S	H
WORKPIECE MATERIAL	MILD STEEL	STRUCT. STEEL	ALLOY STEEL	TOOL STEEL	STAINLESS STEEL	CAST IRON	ALUMINIUM ALLOY	CAST ALUMINIUM	COPPER ALLOYS	SUPER ALLOYS	TITANIUM ALLOYS	HARDENED STEEL
	<500N	<750N	<1400N	<1100N	<900N	<750N	SI<12%	SI>12%	<750N	<1100N	<1100N	<1400N
Vc (m/min)	140 ●	110 ●	80 ●	60 ●	70 ○	110 ○	100 ○	100 ○	100 ○	–	–	–

● OPTIMAL ○ EFFECTIVE

4 FLUTE, VARIABLE HELIX, CORNER RADIUS



High performance machining, suitable for most materials up to 1600N/mm². Unequal helix angle and unequal spacing of teeth greatly reduces vibration. AlCrSiN coating with high oxidation resistance and high adhesion.

GROUP
CDEM


Tungsten Carbide



4 Flutes



Coating



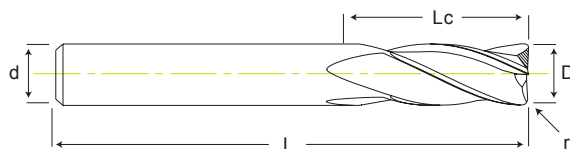
Variable Helix



Corner Radius



< 1600N/mm²



DIAMETER (D) MM	CNR RAD (r) MM	FLUTE (Lc) MM	OAL (L) MM	SHANK (d) MM	fz MM/TOOTH	PART NUMBER
3.0	0.2	9	50	4	0.025	6563-3.00R0.2
3.0	0.5	9	50	4	0.025	6563-3.00R0.5
4.0	0.2	10	50	4	0.033	6563-4.00R0.2
4.0	0.5	10	50	4	0.033	6563-4.00R0.5
4.0	1.0	10	50	4	0.033	6563-4.00R1.0
5.0	0.5	15	50	6	0.040	6563-5.00R0.5
5.0	1.0	15	50	6	0.040	6563-5.00R1.0
6.0	0.2	15	50	6	0.045	6563-6.00R0.2
6.0	0.5	15	50	6	0.045	6563-6.00R0.5
6.0	1.0	15	50	6	0.045	6563-6.00R1.0
8.0	0.5	20	60	8	0.065	6563-8.00R0.5
8.0	1.0	20	60	8	0.065	6563-8.00R1.0
10.0	0.5	25	75	10	0.070	6563-10.00R0.5
10.0	1.0	25	75	10	0.070	6563-10.00R1.0
10.0	2.0	25	75	10	0.070	6563-10.00R2.0
12.0	0.5	30	75	12	0.075	6563-12.00R0.5
12.0	1.0	30	75	12	0.075	6563-12.00R1.0
12.0	1.5	30	75	12	0.075	6563-12.00R1.5
12.0	2.0	30	75	12	0.075	6563-12.00R2.0
16.0	1.0	40	100	16	0.085	6563-16.00R1.0
20.0	1.0	45	100	20	0.095	6563-20.00R1.0

APPLICATION TABLE OF PROCESSED MATERIALS												
ISO	P	P	P	P	M	K	N	N	N	S	S	H
WORKPIECE MATERIAL	MILD STEEL	STRUCT. STEEL	ALLOY STEEL	TOOL STEEL	STAINLESS STEEL	CAST IRON	ALUMINIUM ALLOY	CAST ALUMINIUM	COPPER ALLOYS	SUPER ALLOYS	TITANIUM ALLOYS	HARDENED STEEL
	<500N	<750N	<1400N	<1100N	<900N	<750N	SI<12%	SI>12%	<750N	<1100N	<1100N	<1400N
Vc (m/min)	210 ●	175 ●	110 ●	90 ●	120 ●	150 ●	200 ○	200 ○	200 ○	50 ○	70 ●	120 ●

● OPTIMAL ○ EFFECTIVE

2 FLUTE, BALL NOSE

For profile and contour milling, suitable for materials up to 1600N/mm².
AlCrSiN coating with high oxidation resistance and high adhesion.

GROUP

CDEM

Tungsten
Carbide

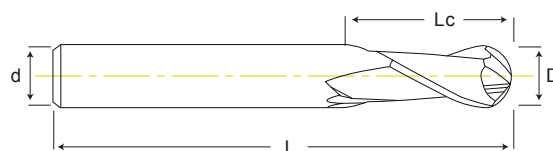
2 Flutes



Coating



30° Helix

Ball
Nose< 1600N/mm²

SHORT SERIES

DIAMETER (D) MM	FLUTE (Lc) MM	OAL (L) MM	SHANK (d) MM	fz MM/TOOTH	PART NUMBER
1.0	2	50	4	0.015	6565-1.00X50
1.5	3	50	4	0.020	6565-1.50X50
2.0	4	50	4	0.025	6565-2.00X50
2.5	5	50	4	0.030	6565-2.50X50
3.0	6	50	4	0.035	6565-3.00X50
4.0	8	50	4	0.040	6565-4.00X50
5.0	10	50	6	0.050	6565-5.00X50
6.0	12	50	6	0.060	6565-6.00X50
8.0	16	60	8	0.080	6565-8.00X60
10.0	20	75	10	0.100	6565-10.00X75
12.0	24	75	12	0.120	6565-12.00X75



LONG SERIES

DIAMETER (D) MM	FLUTE (Lc) MM	OAL (L) MM	SHANK (d) MM	fz MM/TOOTH	PART NUMBER
4.0	8	75	4	0.040	6565-4.00X75
6.0	12	75	6	0.060	6565-6.00X75
6.0	12	100	6	0.060	6565-6.00X100
8.0	16	75	8	0.080	6565-8.00X75
8.0	16	100	8	0.080	6565-8.00X100
10.0	20	100	10	0.100	6565-10.00X100
12.0	24	100	12	0.120	6565-12.00X100

APPLICATION TABLE OF PROCESSED MATERIALS

ISO	P	P	P	P	M	K	N	N	N	S	S	H
WORKPIECE MATERIAL	MILD STEEL	STRUCT. STEEL	ALLOY STEEL	TOOL STEEL	STAINLESS STEEL	CAST IRON	ALUMINIUM ALLOY	CAST ALUMINIUM	COPPER ALLOYS	SUPER ALLOYS	TITANIUM ALLOYS	HARDENED STEEL
Vc (m/min)	<500N	<750N	<1400N	<1100N	<900N	<750N	SI<12%	SI>12%	<750N	<1100N	<1100N	<1400N
	140 ●	110 ●	80 ●	60 ●	70 ○	110 ○	150 ○	150 ○	150 ○	-	-	-

● OPTIMAL ○ EFFECTIVE

4 FLUTE, BALL NOSE

For profile and contour milling, suitable for materials up to 1600N/mm².
AlCrSiN coating with high oxidation resistance and high adhesion.

GROUP

CDEM



Tungsten Carbide



4 Flutes



Coating



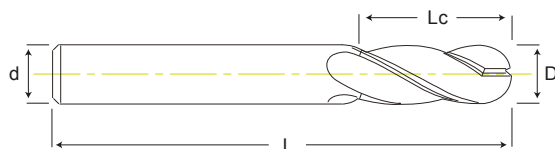
30° Helix



Ball Nose



< 1600N/mm²



DIAMETER (D) MM	FLUTE (Lc) MM	OAL (L) MM	SHANK (d) MM	fz MM/TOOTH	PART NUMBER
4.0	8	50	4	0.040	6566-4.00X50
6.0	12	50	6	0.060	6566-6.00X50
8.0	16	60	8	0.080	6566-8.00X60
10.0	20	75	10	0.100	6566-10.00X75
12.0	24	75	12	0.120	6566-12.00X75

APPLICATION TABLE OF PROCESSED MATERIALS												
ISO	P	P	P	P	M	K	N	N	N	S	S	H
WORKPIECE MATERIAL	MILD STEEL	STRUCT. STEEL	ALLOY STEEL	TOOL STEEL	STAINLESS STEEL	CAST IRON	ALUMINIUM ALLOY	CAST ALUMINIUM	COPPER ALLOYS	SUPER ALLOYS	TITANIUM ALLOYS	HARDENED STEEL
Vc (m/min)	<500N	<750N	<1400N	<1100N	<900N	<750N	SI<12%	SI>12%	<750N	<1100N	<1100N	<1400N
	140 ●	110 ●	80 ●	65 ●	70 ○	110 ○	150 ○	150 ○	150	-	-	-

● OPTIMAL ○ EFFECTIVE

4 FLUTE, HARDENED STEEL



Suitable for materials of hardened steel (<HRC65) semi-finishing and finishing.
TiAlCrSiN coating with high hardness and high oxidation resistance.

GROUP

CDEM



Tungsten
Carbide



4 Flutes



Coating



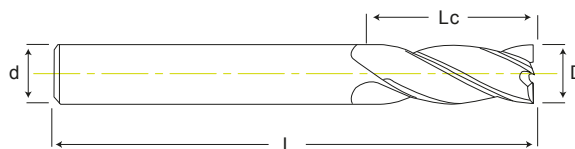
45° Helix



Square



< HRC65



DIAMETER (D) MM	FLUTE (Lc) MM	OAL (L) MM	SHANK (d) MM	fz MM/TOOTH	PART NUMBER
1.0	3	50	4	0.007	6567-1.00X50
1.5	4	50	4	0.010	6567-1.50X50
2.0	6	50	4	0.013	6567-2.00X50
2.5	7	50	4	0.015	6567-2.50X50
3.0	9	50	4	0.018	6567-3.00X50
4.0	11	50	4	0.025	6567-4.00X50
5.0	13	50	6	0.030	6567-5.00X50
6.0	15	50	6	0.035	6567-6.00X50
8.0	20	60	8	0.045	6567-8.00X60
10.0	25	75	10	0.055	6567-10.00X75
12.0	30	75	12	0.065	6567-12.00X75
14.0	35	100	14	0.075	6567-14.00X100
16.0	45	100	16	0.085	6567-16.00X100

APPLICATION TABLE OF PROCESSED MATERIALS

ISO	P	P	P	P	M	K	N	N	N	S	S	H
WORKPIECE MATERIAL	MILD STEEL	STRUCT. STEEL	ALLOY STEEL	TOOL STEEL	STAINLESS STEEL	CAST IRON	ALUMINIUM ALLOY	CAST ALUMINIUM	COPPER ALLOYS	SUPER ALLOYS	TITANIUM ALLOYS	HARDENED STEEL
Vc (m/min)	<500N	<750N	<1400N	<1100N	<900N	<750N	SI<12%	SI>12%	<750N	<1100N	<1100N	<HRC65
	—	—	75 ●	85 ●	—	—	—	—	—	95 ○	85 ○	70 ●

● OPTIMAL ○ EFFECTIVE

4 FLUTE, HARDENED STEEL, CORNER RADIUS



Suitable for materials of hardened steel (<HRC65) semi-finishing and finishing. TiAlCrSiN coating with high hardness and high oxidation resistance.

GROUP

CDEM



Tungsten Carbide



4 Flutes



Coating



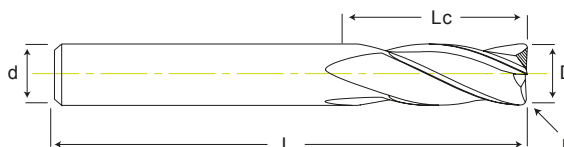
35° Helix



Corner Radius



< HRC65



DIAMETER (D) MM	CNR RAD (r) MM	FLUTE (Lc) MM	OAL (L) MM	SHANK (d) MM	fz MM/TOOTH	PART NUMBER
3.0	0.2	6	50	4	0.018	6568-3.00R0.2
4.0	0.3	8	50	4	0.025	6568-4.00R0.3
4.0	0.5	8	50	4	0.025	6568-4.00R0.5
5.0	0.5	10	50	6	0.030	6568-5.00R0.5
6.0	0.5	12	50	6	0.035	6568-6.00R0.5
6.0	1.0	12	50	6	0.035	6568-6.00R1.0
8.0	0.5	16	60	8	0.045	6568-8.00R0.5
8.0	1.0	16	60	8	0.045	6568-8.00R1.0
10.0	0.5	20	75	10	0.055	6568-10.00R0.5
10.0	1.0	20	75	10	0.055	6568-10.00R1.0
12.0	0.5	24	75	12	0.065	6568-12.00R0.5
12.0	1.0	24	75	12	0.065	6568-12.00R1.0
12.0	2.0	24	75	12	0.065	6568-12.00R2.0

APPLICATION TABLE OF PROCESSED MATERIALS												
ISO	P	P	P	P	M	K	N	N	N	S	S	H
WORKPIECE MATERIAL	MILD STEEL	STRUCT. STEEL	ALLOY STEEL	TOOL STEEL	STAINLESS STEEL	CAST IRON	ALUMINIUM ALLOY	CAST ALUMINIUM	COPPER ALLOYS	SUPER ALLOYS	TITANIUM ALLOYS	HARDENED STEEL
Vc (m/min)	<500N	<750N	<1400N	<1100N	<900N	<750N	SI<12%	SI>12%	<750N	<1100N	<1100N	<HRC65
	—	—	75 ●	85 ●	—	—	—	—	—	95 ○	85 ○	70 ●

● OPTIMAL ○ EFFECTIVE

2 FLUTE, HARDENED STEEL, BALL NOSE



Suitable for milling hardened steels (<HRC65).
TiAlCrSiN coating with high hardness and high oxidation resistance.

GROUP

CDEM



Tungsten
Carbide



2 Flutes



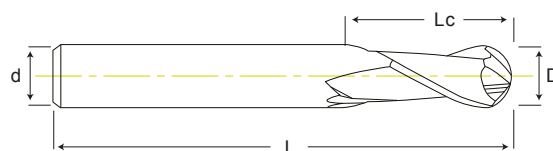
Coating



30° Helix

Ball
Nose

< HRC65



DIAMETER (D) MM	FLUTE (Lc) MM	OAL (L) MM	SHANK (d) MM	fz MM/TOOTH	PART NUMBER
1.0	1.5	50	4	0.010	6569-1.00X50
1.5	2.5	50	4	0.016	6569-1.50X50
2.0	3	50	4	0.024	6569-2.00X50
2.5	4	50	4	0.028	6569-2.50X50
3.0	5	50	4	0.034	6569-3.00X50
4.0	6	50	4	0.044	6569-4.00X50
5.0	7.5	50	6	0.055	6569-5.00X50
6.0	9	50	6	0.060	6569-6.00X50
8.0	12	60	8	0.080	6569-8.00X60
10.0	15	75	10	0.100	6569-10.00X75
12.0	18	75	12	0.120	6569-12.00X75
16.0	24	100	16	0.160	6569-16.00X100

APPLICATION TABLE OF PROCESSED MATERIALS												
ISO	P	P	P	P	M	K	N	N	N	S	S	H
WORKPIECE MATERIAL	MILD STEEL	STRUCT. STEEL	ALLOY STEEL	TOOL STEEL	STAINLESS STEEL	CAST IRON	ALUMINIUM ALLOY	CAST ALUMINIUM	COPPER ALLOYS	SUPER ALLOYS	TITANIUM ALLOYS	HARDENED STEEL
	<500N	<750N	<1400N	<1100N	<900N	<750N	Si<12%	Si>12%	<750N	<1100N	<1100N	<HRC65
Vc (m/min)	—	—	90 ●	100 ●	—	—	—	—	—	135 ○	100 ○	80 ●

● OPTIMAL ○ EFFECTIVE

SINGLE FLUTE



Suitable for application of non ferrous alloys such as aluminium, brass, bronze.
Also suitable for plastics, MDF, etc.
Large single flute, mirror-polished.

GROUP
CDEM


Tungsten
Carbide



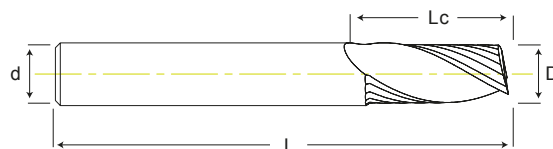
1 Flute



30° Helix



Square



SHORT SERIES					PART NUMBER
DIAMETER (D) MM	FLUTE (Lc) MM	OAL (L) MM	SHANK (d) MM	fz MM/TOOTH	
3.0	8	50	6	0.016	6560-3.00
4.0	11	54	6	0.021	6560-4.00
5.0	13	54	6	0.025	6560-5.00
6.0	13	54	6	0.030	6560-6.00
8.0	19	58	8	0.040	6560-8.00
10.0	22	66	10	0.050	6560-10.00
12.0	26	73	12	0.060	6560-12.00



LONG SERIES					PART NUMBER
DIAMETER (D) MM	FLUTE (Lc) MM	OAL (L) MM	SHANK (d) MM	fz MM/TOOTH	
3.0	20	60	6	0.016	6560-3.00X60
4.0	20	60	6	0.021	6560-4.00X60
5.0	30	75	6	0.025	6560-5.00X75
6.0	20	75	6	0.030	6560-6.00X75
6.0	30	100	6	0.030	6560-6.00X100
8.0	30	75	8	0.040	6560-8.00X75
8.0	40	100	8	0.040	6560-8.00X100
10.0	40	100	10	0.050	6560-10.00X100
12.0	40	100	12	0.060	6560-12.00X100

APPLICATION TABLE OF PROCESSED MATERIALS												
ISO	P	P	P	P	M	K	N	N	N	S	S	H
WORKPIECE MATERIAL	MILD STEEL	STRUCT. STEEL	ALLOY STEEL	TOOL STEEL	STAINLESS STEEL	CAST IRON	ALUMINIUM ALLOY	CAST ALUMINIUM	COPPER ALLOYS	SUPER ALLOYS	TITANIUM ALLOYS	HARDENED STEEL
	<500N	<750N	<1400N	<1100N	<900N	<750N	SI<12%	SI>12%	<750N	<1100N	<1100N	<1400N
Vc (m/min)	-	-	-	-	-	-	220 ●	220 ●	160 ●	-	-	-

● OPTIMAL ○ EFFECTIVE

2 FLUTE, ALUMINIUM



Suitable for slots and cavities in aluminium & non ferrous materials.
Excellent chip removal.

GROUP

CDEM



Tungsten
Carbide



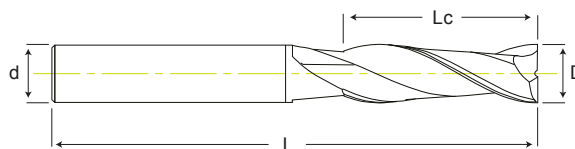
2 Flutes



35° Helix



Square



DIAMETER (D) MM	FLUTE (Lc) MM	OAL (L) MM	SHANK (d) MM	fz MM/TOOTH	PART NUMBER
1.0	3	50	4	0.005	6559-1.00X50
1.5	4.5	50	4	0.006	6559-1.50X50
2.0	6	50	4	0.007	6559-2.00X50
2.5	7	50	4	0.008	6559-2.50X50
3.0	8	50	4	0.010	6559-3.00X50
4.0	11	50	4	0.014	6559-4.00X50
5.0	13	50	6	0.017	6559-5.00X50
6.0	15	50	6	0.021	6559-6.00X50
8.0	20	60	8	0.028	6559-8.00X60
10.0	25	75	10	0.036	6559-10.00X75
12.0	30	75	12	0.044	6559-12.00X75
16.0	40	100	16	0.055	6559-16.00X100
20.0	40	100	20	0.065	6559-20.00X100

APPLICATION TABLE OF PROCESSED MATERIALS

ISO	P	P	P	P	M	K	N	N	N	S	S	H
WORKPIECE MATERIAL	MILD STEEL	STRUCT. STEEL	ALLOY STEEL	TOOL STEEL	STAINLESS STEEL	CAST IRON	ALUMINIUM ALLOY	CAST ALUMINIUM	COPPER ALLOYS	SUPER ALLOYS	TITANIUM ALLOYS	HARDENED STEEL
Vc (m/min)	<500N	<750N	<1400N	<1100N	<900N	<750N	SI<12%	SI>12%	<750N	<1100N	<1100N	<1400N
	—	—	—	—	—	—	350 ●	350 ●	500 ●	—	—	—

● OPTIMAL ○ EFFECTIVE

3 FLUTE, ALUMINIUM



Suitable for roughing and finishing of aluminium alloys and copper alloys.
Variable helix and special edge design reduces vibration, excellent surface finish.

GROUP
CDEM


Tungsten Carbide



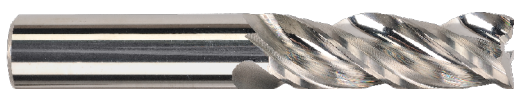
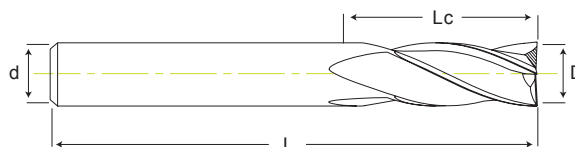
3 Flutes



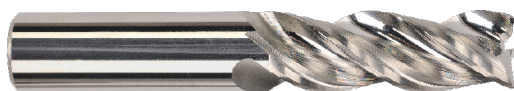
35° Helix



Square



SHORT SERIES					PART NUMBER
DIAMETER (D) MM	FLUTE (Lc) MM	OAL (L) MM	SHANK (d) MM	fz MM/TOOTH	
1.0	3	50	4	0.011	6570-1.00X50
1.5	5	50	4	0.016	6570-1.50X50
2.0	6	50	4	0.023	6570-2.00X50
2.5	8	50	4	0.025	6570-2.50X50
3.0	9	50	4	0.030	6570-3.00X50
3.5	11	50	4	0.035	6570-3.50X50
4.0	12	50	4	0.040	6570-4.00X50
5.0	15	50	6	0.050	6570-5.00X50
6.0	18	50	6	0.055	6570-6.00X50
8.0	24	60	8	0.070	6570-8.00X60
10.0	30	75	10	0.080	6570-10.00X75
12.0	35	75	12	0.100	6570-12.00X75
14.0	45	100	14	0.120	6570-14.00X100
16.0	45	100	16	0.140	6570-16.00X100
18.0	45	100	18	0.160	6570-18.00X100
20.0	45	100	20	0.180	6570-20.00X100



SHORT SERIES 4 PIECE SET					PART NUMBER
DIAMETER (D) MM	FLUTE (Lc) MM	OAL (L) MM	SHANK (d) MM	fz MM/TOOTH	CONTAINS
6.0	18	50	6	0.055	6570-6.00X50
8.0	24	60	8	0.070	6570-8.00X60
10.0	30	75	10	0.080	6570-10.00X75
12.0	35	75	12	0.100	6570-12.00X75

APPLICATION TABLE OF PROCESSED MATERIALS												
ISO	P	P	P	P	M	K	N	N	N	S	S	H
WORKPIECE MATERIAL	MILD STEEL	STRUCT. STEEL	ALLOY STEEL	TOOL STEEL	STAINLESS STEEL	CAST IRON	ALUMINIUM ALLOY	CAST ALUMINIUM	COPPER ALLOYS	SUPER ALLOYS	TITANIUM ALLOYS	HARDENED STEEL
Vc (m/min)	<500N	<750N	<1400N	<1100N	<900N	<750N	SI<12%	SI>12%	<750N	<1100N	<1100N	<1400N
	-	-	-	-	-	-	350 ●	350 ●	500 ●	-	-	-

● OPTIMAL ○ EFFECTIVE

3 FLUTE, ALUMINIUM



Suitable for roughing and finishing of aluminium alloys and copper alloys.
Variable helix and special edge design reduces vibration, excellent surface finish.

GROUP

CDEM



Tungsten
Carbide



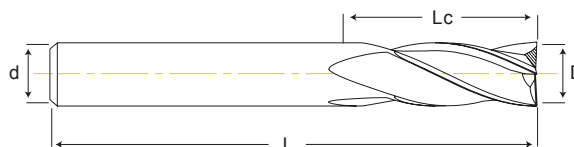
3 Flutes



35° Helix



Square



LONG SERIES

DIAMETER (D) MM	FLUTE (Lc) MM	OAL (L) MM	SHANK (d) MM	PART NUMBER
3.0	12	75	3	6570-3.00X75
3.0	12	100	3	6570-3.00X100
4.0	16	75	4	6570-4.00X75
4.0	20	100	4	6570-4.00X100
5.0	20	75	5	6570-5.00X75
5.0	30	100	5	6570-5.00X100
6.0	25	75	6	6570-6.00X75
6.0	30	100	6	6570-6.00X100
6.0	45	150	6	6570-6.00X150
8.0	30	75	8	6570-8.00X75
8.0	35	100	8	6570-8.00X100
8.0	50	150	8	6570-8.00X150
10.0	40	100	10	6570-10.00X100
10.0	55	150	10	6570-10.00X150
12.0	45	100	12	6570-12.00X100
12.0	55	150	12	6570-12.00X150
14.0	70	150	14	6570-14.00X150
16.0	80	150	16	6570-16.00X150
18.0	80	150	18	6570-18.00X150
20.0	80	150	20	6570-20.00X150

APPLICATION TABLE OF PROCESSED MATERIALS

ISO	P	P	P	P	M	K	N	N	N	S	S	H
WORKPIECE MATERIAL	MILD STEEL	STRUCT. STEEL	ALLOY STEEL	TOOL STEEL	STAINLESS STEEL	CAST IRON	ALUMINIUM ALLOY	CAST ALUMINIUM	COPPER ALLOYS	SUPER ALLOYS	TITANIUM ALLOYS	HARDENED STEEL
	<500N	<750N	<1400N	<1100N	<900N	<750N	Si<12%	Si>12%	<750N	<1100N	<1100N	<1400N
Vc (m/min)	-	-	-	-	-	-	350 ●	350 ●	500 ●	-	-	-

● OPTIMAL ○ EFFECTIVE

2 FLUTE, ALUMINIUM, BALL NOSE



Suitable for roughing and finishing of aluminium alloys and copper alloys.
Special edge design reduces vibration, excellent surface finish.

GROUP
CDEM


Tungsten
Carbide



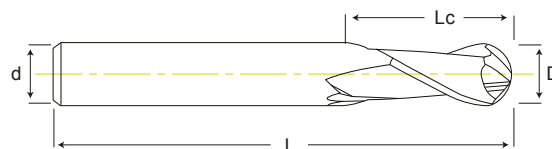
2 Flutes



30° Helix



Ball
Nose



DIAMETER (D) MM	FLUTE (Lc) MM	OAL (L) MM	SHANK (d) MM	fz MM/TOOTH	PART NUMBER
2.0	4	50	4	0.024	6571-2.00X50
3.0	6	50	4	0.034	6571-3.00X50
4.0	8	50	4	0.044	6571-4.00X50
6.0	12	50	6	0.060	6571-6.00X50
8.0	16	60	8	0.080	6571-8.00X60
10.0	20	75	10	0.100	6571-10.00X75
12.0	24	75	12	0.120	6571-12.00X75
14.0	28	100	14	0.140	6571-14.00X100
16.0	32	100	16	0.160	6571-16.00X100
18.0	36	100	18	0.180	6571-18.00X100
20.0	40	100	20	0.200	6571-20.00X100

APPLICATION TABLE OF PROCESSED MATERIALS												
ISO	P	P	P	P	M	K	N	N	N	S	S	H
WORKPIECE MATERIAL	MILD STEEL	STRUCT. STEEL	ALLOY STEEL	TOOL STEEL	STAINLESS STEEL	CAST IRON	ALUMINIUM ALLOY	CAST ALUMINIUM	COPPER ALLOYS	SUPER ALLOYS	TITANIUM ALLOYS	HARDENED STEEL
Vc (m/min)	<500N	<750N	<1400N	<1100N	<900N	<750N	SI<12%	SI>12%	<750N	<1100N	<1100N	<1400N
	-	-	-	-	-	-	350 ●	350 ●	500 ●	-	-	-

● OPTIMAL ○ EFFECTIVE

4 FLUTE, ROUGHING

For roughing applications of steels up to 1600N/mm².
TiSiN coated.

GROUP

CDEM



Tungsten
Carbide



4 Flutes



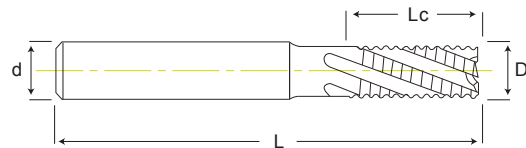
Coating



30° Helix



Square

< 1600N/mm²

DIAMETER (D) MM	FLUTE (Lc) MM	OAL (L) MM	SHANK (d) MM	fz MM/TOOTH	PART NUMBER
4.0	10	50	4	0.023	6557-4.00X50
6.0	15	50	6	0.034	6557-6.00X50
8.0	20	60	8	0.045	6557-8.00X60
10.0	25	75	10	0.055	6557-10.00X75
12.0	30	75	12	0.065	6557-12.00X75
16.0	45	100	16	0.085	6557-16.00X100
20.0	45	100	20	0.110	6557-20.00X100

APPLICATION TABLE OF PROCESSED MATERIALS												
ISO	P	P	P	P	M	K	N	N	N	S	S	H
WORKPIECE MATERIAL	MILD STEEL	STRUCT. STEEL	ALLOY STEEL	TOOL STEEL	STAINLESS STEEL	CAST IRON	ALUMINIUM ALLOY	CAST ALUMINIUM	COPPER ALLOYS	SUPER ALLOYS	TITANIUM ALLOYS	HARDENED STEEL
	<500N	<750N	<1400N	<1100N	<900N	<750N	SI<12%	SI>12%	<750N	<1100N	<1100N	<1400N
Vc (m/min)	180 ●	100 ○	100 ○	80 ○	—	140 ○	300 ○	300 ○	—	—	—	—

● OPTIMAL ○ EFFECTIVE

3 FLUTE, ROUGHING, ALUMINIUM



For roughing applications of aluminium alloys and copper alloys

GROUP

CDEM



Tungsten Carbide



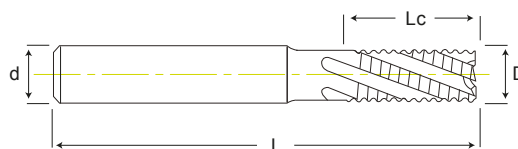
3 Flutes



30° Helix



Square



DIAMETER (D) MM	FLUTE (Lc) MM	OAL (L) MM	SHANK (d) MM	fz MM/TOOTH	PART NUMBER
4.0	12	50	4	0.040	6558-4.00X50
6.0	18	50	6	0.055	6558-6.00X50
8.0	24	60	8	0.075	6558-8.00X60
10.0	30	75	10	0.090	6558-10.00X75
12.0	36	75	12	0.110	6558-12.00X75
16.0	45	100	16	0.140	6558-16.00X100
20.0	45	100	20	0.180	6558-20.00X100

APPLICATION TABLE OF PROCESSED MATERIALS												
ISO	P	P	P	P	M	K	N	N	N	S	S	H
WORKPIECE MATERIAL	MILD STEEL	STRUCT. STEEL	ALLOY STEEL	TOOL STEEL	STAINLESS STEEL	CAST IRON	ALUMINIUM ALLOY	CAST ALUMINIUM	COPPER ALLOYS	SUPER ALLOYS	TITANIUM ALLOYS	HARDENED STEEL
	<500N	<750N	<1400N	<1100N	<900N	<750N	SI<12%	SI>12%	<750N	<1100N	<1100N	<1400N
Vc (m/min)	-	-	-	-	-	-	220 ●	220 ●	160 ●	-	-	-

● OPTIMAL ○ EFFECTIVE

4 FLUTE, CHAMFER

For chamfering and deburring. TiSiN coating.

GROUP

CDEM



Tungsten Carbide



4 Flutes



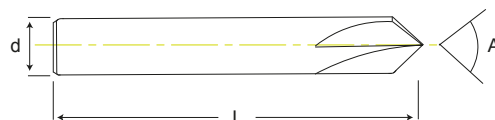
Coating



0° Helix



Chamfer < 1600N/mm²



DIAMETER (D) MM	ANGLE (A) DEGREE	OAL (L) MM	SHANK (d) MM	fz MM/TOOTH	PART NUMBER
6.0	60	50	6	0.050	6556-6.00X60
6.0	90	50	6	0.050	6556-6.00X90
8.0	60	60	8	0.065	6556-8.00X60
8.0	90	60	8	0.065	6556-8.00X90
10.0	60	75	10	0.085	6556-10.00X60
10.0	90	75	10	0.085	6556-10.00X90
12.0	60	75	12	0.100	6556-12.00X60
12.0	90	75	12	0.100	6556-12.00X90

4 FLUTE, CORNER ROUNDING

For corner rounding applications. TiSiN coating.



Tungsten Carbide



4 Flutes



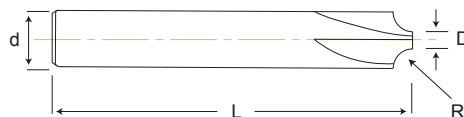
Coating



0° Helix



Corner Rounding < 1600N/mm²



RADIUS (R) MM	FLAT (D) MM	OAL (L) MM	SHANK (d) MM	fz MM/TOOTH	PART NUMBER
0.50	3.0	50	4	0.036	6555-R0.5X50
0.75	2.5	50	4	0.036	6555-R0.75X50
1.00	2.0	50	4	0.036	6555-R1.0X50
1.50	3.0	50	6	0.050	6555-R1.5X50
2.00	2.0	50	6	0.050	6555-R2.0X50
2.50	1.0	50	6	0.050	6555-R2.5X50
3.00	2.0	60	8	0.065	6555-R3.0X60
4.00	2.0	60	10	0.085	6555-R4.0X60
5.00	2.0	60	12	0.100	6555-R5.0X60

APPLICATION TABLE OF PROCESSED MATERIALS

ISO	P	P	P	P	M	K	N	N	N	S	S	H
WORKPIECE MATERIAL	MILD STEEL	STRUCT. STEEL	ALLOY STEEL	TOOL STEEL	STAINLESS STEEL	CAST IRON	ALUMINIUM ALLOY	CAST ALUMINIUM	COPPER ALLOYS	SUPER ALLOYS	TITANIUM ALLOYS	HARDENED STEEL
Vc (m/min)	<500N	<750N	<1400N	<1100N	<900N	<750N	SI<12%	SI>12%	<750N	<1100N	<1100N	<1400N
	180 ●	100 ●	100 ●	80 ●	90 ●	140 ●	-	-	-	50 ●	70 ●	80 ●

● OPTIMAL ○ EFFECTIVE

ENGRAVING TOOL FOR ALUMINIUM

Uncoated for engraving Aluminium.

GROUP

CDEM



Tungsten Carbide



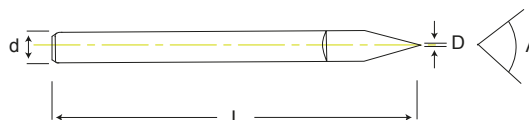
Fluteless



Engraving



< 1600N/mm²



FOR ALUMINIUM				PART NUMBER
POINT (D) MM	ANGLE (A) DEGREE	OAL (L) MM	SHANK (d) MM	
0.1	20	38	3.175	6553-20X38
0.1	30	38	3.175	6553-30X38
0.1	45	38	3.175	6553-45X38
0.1	60	38	3.175	6553-60X38
0.1	90	38	3.175	6553-90X38

ENGRAVING TOOL FOR STEEL

TiAlN coated for engraving ferrous metals.



Tungsten Carbide



Fluteless



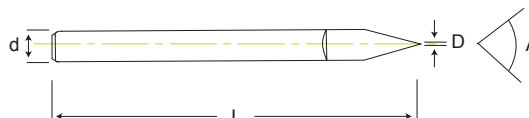
Coating



Engraving



< 1600N/mm²



FOR STEEL				PART NUMBER
POINT (D) MM	ANGLE (A) DEGREE	OAL (L) MM	SHANK (d) MM	
0.1	20	38	3.175	6554-20X38
0.1	30	38	3.175	6554-30X38
0.1	45	38	3.175	6554-45X38
0.1	60	38	3.175	6554-60X38
0.1	90	38	3.175	6554-90X38

APPLICATION TABLE OF PROCESSED MATERIALS												
ISO	P	P	P	P	M	K	N	N	N	S	S	H
WORKPIECE MATERIAL	MILD STEEL	STRUCT. STEEL	ALLOY STEEL	TOOL STEEL	STAINLESS STEEL	CAST IRON	ALUMINIUM ALLOY	CAST ALUMINIUM	COPPER ALLOYS	SUPER ALLOYS	TITANIUM ALLOYS	HARDENED STEEL
Vc (m/min)	<500N	<750N	<1400N	<1100N	<900N	<750N	SI<12%	SI>12%	<750N	<1100N	<1100N	<1400N
	180 ●	100 ●	100 ●	80 ●	90 ●	140 ●	350 ●	350 ●	350 ●	50 ●	70 ●	80 ●

● OPTIMAL ○ EFFECTIVE

TROUBLESHOOTING GUIDE

Problem	Cause	Solution
Chip Packing	• Feed per tooth too high • Not enough chip room • Not enough coolant	• Lower feed rate • Use endmill with fewer flutes • Use more coolant to flush chips
Rough Finish	• Feed too fast • Slow speed • Too much cutter wear • Feed per tooth too high	• Reduce to correct feed • Use higher speed • Resharpen or replace tool • Lower feed rate
Burrs	• Dull cutting edge • Improper cutting angle	• Resharpen or replace tool • Change to correct cutting angle
Wandering	• Machine or holder runout • Insufficient rigidity in machine or holder • Not enough flutes • Tool deflection	• Repair machine or holder • Change machine or holder • Use endmill with more flutes • Choke up on shank or reduce feed
Chipping	• Feed too fast • Feed too fast on the first cut • Lack of machine / tool holder rigidity • Loose holder • Loose vice • Lack of cutting tool rigidity • Teeth too sharp	• Lower feed rate • Lower feed on initial contact • Change to a more rigid machine / holder • Tighten tool holder • Tighten workpiece fixture • Choke up on shank or use shorter tool • Choose a tool with correct primary relief angle
Excessive Tool Wear	• Speed too fast • Hard material • Feed too slow • Improper cutting angle • Primary relief angle too small	• Reduce speed and use more coolant • Use a cutter of better grade material • Use a cutter with a suitable coating • Increase feed speed • Change to correct cutting angle • Increase primary relief angle
Tool Breakage	• Feed too fast • Chip load per tooth too great • Flute length too long • Overall length too long • Too much cutter wear	• Reduce feed speed • Adjust to smaller chip load per tooth • Choke up on the shank • Use a shorter tool • Resharpen or replace tool
Tool Chatter	• Feed and speed too fast • Poor rigidity of machine / holder • Relief angle too large • Loose workpiece holder • Cutting too deep • Flute length too long • Overall tool length too long	• Adjust feed and speed • Change to a more rigid machine / holder • Change to a smaller relief angle • Tighten tool holder • Change to a smaller depth of cut • Choke up on the shank • Use a shorter tool

FORMULAE FOR METRIC ENDMILLS

$\varnothing$	Nominal tool diameter (mm)	$n = \frac{v_c \times 1000}{\varnothing \times \pi} \approx \frac{v_c}{\varnothing} \times 318$	
n	Spindle speed (RPM)		
v_c	Cutting speed (m/min)	$v_c = \frac{n \times \varnothing \times \pi}{1000} \approx \frac{n \times \varnothing}{318}$	
f_z	Feed rate per tooth (mm/tooth)		
v_f	Feed rate (mm/min)	$f_z = \frac{v_f}{z \times n}$	$v_f = f_z \times z \times n$
z	Number of cutting edges		
Q	Metal removal rate (cm ³ /min)		
a_p	Cutting depth (mm)		
a_e	Cutting width (mm)	$Q = \frac{a_p \times a_e \times v_f}{1000}$	

ALSO IN THE HIGH PERFORMANCE RANGE

Carbide Countersinks Single Flute Indexable, Spade Drills and Inserts, Powdered Metal Taps and Drills, Collet Chucks, Face Mill Holders, Side Lock Holders and Collets.





COMMITMENT TO EXCELLENCE

At Bordo International Pty Ltd, we believe that excellence is not just a goal; it is our guiding principle. Since our establishment in 1987, we have dedicated ourselves to providing the highest quality industrial cutting tools and accessories to our customers across Australia. As a proud 100% family-owned Australian company, we are committed to serving our customers and supporting our local community.

COMPREHENSIVE PRODUCT RANGE

Our extensive product range is designed to meet the diverse needs of our customers in various industries. We take pride in offering one of the most comprehensive selections of industrial tools available, ensuring that you can find everything you need in one convenient location. Our unwavering commitment to "quality without compromise" drives us to source our products from the world's leading manufacturers, ensuring reliability and performance in every tool we offer.

CUSTOMER-CENTRIC APPROACH

At Bordo, our customers are at the heart of everything we do. We understand that each customer has unique requirements, and we are dedicated to fostering strong relationships built on trust and collaboration. Our team works closely with both suppliers and customers to continuously improve and expand our product offerings, ensuring that we can meet even the most specialized tooling needs with precision and care.

ENVIRONMENTAL RESPONSIBILITY

We recognize the importance of sustainability and are committed to minimizing our environmental impact. Our state-of-the-art headquarters features a landmark 5-star certified building, one of Australia's first, equipped with an 105kW solar power array to meet our energy needs. We focus on minimising packaging and using recyclable materials whenever possible. We actively prioritise sea and land freight over air freight to minimise our carbon impact, ensuring that we contribute positively to our community and the planet.

JOIN US ON OUR JOURNEY

At Bordo International, our corporate philosophy is built on a foundation of excellence, customer focus, and environmental stewardship. We invite you to explore our product range and experience the Bordo difference for yourself.



INDUSTRIAL TOOLS

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