New EMUGE Cut & Form solid carbide finishing end mills feature a patented tool geometry that performs two functions – cutting and polishing in one operation, generating significant manufacturing time and cost savings!

**Advantages:**
- Enables the production of polished surfaces in a single milling operation with surface grades of N1-N3
- No rework of workpiece required
- Significant reduction of manufacturing costs

**Applications:**
- High performance tool for finishing operations only
- Trimming visible 2D contoured surfaces in non-ferrous materials; wrought aluminum alloys, copper and copper alloys
- Production of design surfaces in medical technology, jewelry industry, food and electronics sector

**Types of tools:**
- Cutting diameter 6-12 mm
- Stub and standard lengths

**DIN 6527 – Stub length**

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**DIN 6527 – Standard length**

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For the purpose of calculating the feed rate, multiply by 3 flutes.

**Unique, patented tool geometry:**

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**Application Example**

Material: 6061

Tool: 2507.010

Surface roughness: $R_a = 0.08 \, \mu m / R_z = 0.46 \, \mu m$

Surface roughness grade: N2

Coolant: Emulsion

Cutting speed $v_c$: 1000 sfm

Speed $n$: 10000 rpm

Feed per tooth $f_z$: .001"

Feed speed $v_f$: 28 ipm

Axial depth of cut $a_x$: .750"

Radial depth of cut $a_r$: .004"

The cutting data must be adapted to the material to be machined, taking into consideration the clamping of tool and workpiece as well as the natural vibration frequency of the component and spindle. For the purpose of calculating the feed rate, multiply by 3 flutes. Contact Emuge for more information.