

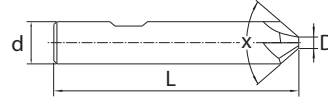
Deburring cutter

General machining

5501/5601R120*FM



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



Article	*	Dimensions [mm]					Teeth	Grade
		d(h6)	L	D	Shank	X		KMG406
5501R1203FM-0300		3	48	0.2	HA	120	3	○
5501R1204FM-0400		4	48	0.2	HA	120	4	○
5501R1204FM-0600		6	55	0.2	HA	120	4	○
5601R1204FM-0600		6	55	0.2	HB	120	4	○
5501R1204FM-0800		8	58	0.5	HA	120	4	○
5601R1204FM-0800		8	58	0.5	HB	120	4	○
5501R1204FM-1000		10	65	0.5	HA	120	4	○
5601R1204FM-1000		10	65	0.5	HB	120	4	○
5601R1206FM-1000		10	65	0.7	HB	120	6	○
5501R1206FM-1000		10	65	0.7	HA	120	6	○
5501R1204FM-1200		12	75	0.5	HA	120	4	○
5601R1204FM-1200		12	75	0.5	HB	120	4	○
5601R1206FM-1200		12	75	0.7	HB	120	6	○
5501R1206FM-1200		12	75	0.7	HA	120	6	○
5501R1206FM-1600		16	85	0.7	HA	120	6	○
5601R1204FM-1600		16	85	0.7	HB	120	4	○
5501R1204FM-1600		16	85	0.7	HA	120	4	○
5601R1206FM-1600		16	85	0.7	HB	120	6	○

● Ex stock ○ On demand

* With internal cooling

Application field					
P	M	K	N	S	H
✓	✓	✓	✓		

✓ Very suitable

✓ Suitable

System code > B278

Cutting data > B492

Nonstandard order > B541



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

1

2

Milling

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

3

4

C

Drilling

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

5

6

7

D

Technical Information

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
...	

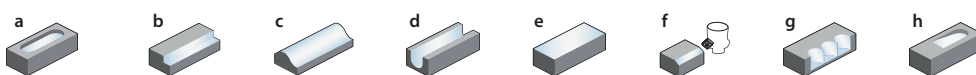
8

9

10

E

Index



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

GM – 2 E L P – D12 R0.5 – M08

1 **2** **3** **4** **5** **6** **7** **8**

Application	
Code	Description
GR	General roughing
GM	Semi-finishing
GF	Finishing
PM	High-performance machining
EPM	«Ecoline» – High-performance machining
VPM	Full-slot applications
HM	Hard machining
NM	General machining of non-ferrous metals
AL	General machining of Al and Al alloys
ALP	High-performance machining of Al and Al alloys
ALG	General machining of Al and Al alloys
UM	HSC/HPC machining
UMC	HSC machining with chip splitter geometry
VSM	General machining of heat-resistant alloys
TM	General machining of heat-resistant alloys

Number of teeth

1

2

Cutting edge type	
Code	Description
E	Square shoulder mill with protective chamfer
F	Square shoulder mill with sharp cutting edges
B	Ball nose cutter
R	Torus mill
W	Ripper
H	High-feed mill

Cutting edge length	
Code	Description
L	Long
X	Extra long
F	Short

Type	
Code	Description
S	Mini diameter
P	Ground neck
C	Conical neck

3

4

5

Diameter [mm]	
Code	Description
D3.0	3,0
D20.0	20,0
...	

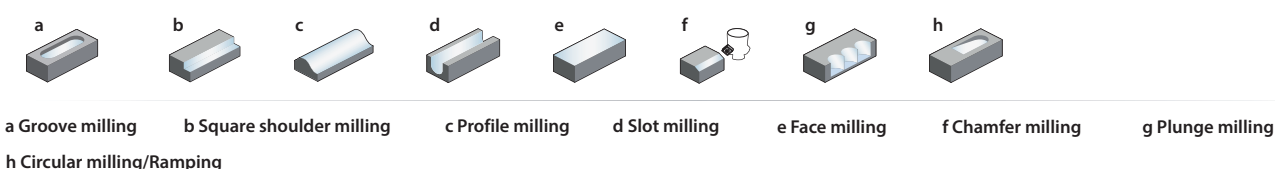
Radius [mm]	
Code	Description
R0.5	0,5
R3.0	3,0
...	

Features	
Code	Description
G	Spiral angle 30°
M	Neck length [mm]
S	Thin shank
AIR	For aerospace industry

6

7

8



A Turning

B Milling

C Drilling

D Technical Information

E Index

A

Recommended feed rate

Turning

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.

B

Milling

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.

C

Drilling

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.

D

Technical Information

E

Index