

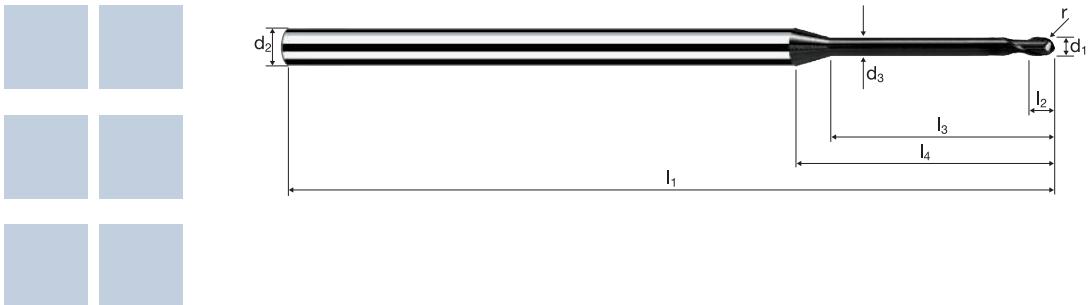
## Ball nose end mills Microcut

Shank ø 3mm, cylindrical neck, 12xd

Base-X

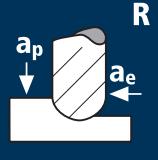
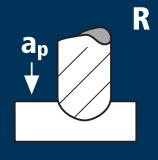
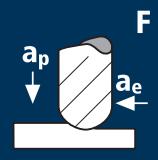
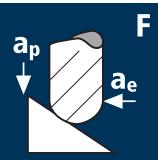
B

HM  
MG10       $\lambda$  30°  
                 $\gamma$  5°



**C**  
Graphite      **CF / GF**  
Fiber Reinforced  
Plastics

IV

Application	Material	d1 [mm]	z	f <sub>z</sub> [mm]	a <sub>p</sub> [mm]	a <sub>e</sub> [mm]	n=15000 min <sup>-1</sup> vf [mm/min]	n=25000 min <sup>-1</sup> vf [mm/min]	n=30000 min <sup>-1</sup> vf [mm/min]	n=45000 min <sup>-1</sup> vf [mm/min]
	Graphite	1.00	2	0.007	0.300	0.400	210	350	420	630
		1.20	2	0.008	0.350	0.500	240	400	480	720
		1.50	2	0.011	0.450	0.600	330	550	660	990
		2.00	2	0.014	0.600	0.800	420	700	840	1260
		2.50	2	0.018	0.750	1.000	540	900	1080	1620
		3.00	2	0.021	0.900	1.200	630	1050	1260	1890
	Graphite	1.00	2	0.005	0.200	1.000	150	250	300	450
		1.20	2	0.007	0.250	1.200	210	350	420	630
		1.50	2	0.008	0.300	1.500	240	400	480	720
		2.00	2	0.011	0.400	2.000	330	550	660	990
		2.50	2	0.014	0.500	2.500	420	700	840	1260
		3.00	2	0.016	0.600	3.000	480	800	960	1440
	Graphite	1.00	2	0.008	0.100	0.140	240	400	480	720
		1.20	2	0.010	0.120	0.170	300	500	600	900
		1.50	2	0.012	0.150	0.210	360	600	720	1080
		2.00	2	0.016	0.200	0.280	480	800	960	1440
		2.50	2	0.020	0.250	0.350	600	1000	1200	1800
		3.00	2	0.024	0.300	0.420	720	1200	1440	2160
	Graphite	1.00	2	0.008	0.100	0.100	240	400	480	720
		1.20	2	0.010	0.120	0.120	300	500	600	900
		1.50	2	0.012	0.150	0.150	360	600	720	1080
		2.00	2	0.016	0.200	0.200	480	800	960	1440
		2.50	2	0.020	0.250	0.250	600	1000	1200	1800
		3.00	2	0.024	0.300	0.300	720	1200	1440	2160