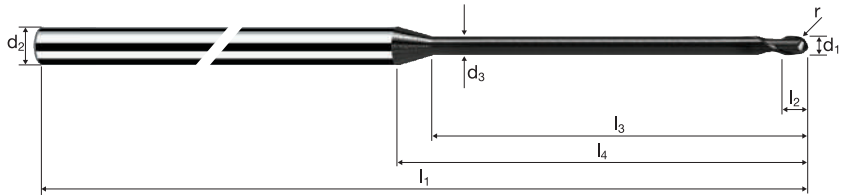


# Ball nose end mills Microcut

Shank  $\varnothing$  3mm, cylindrical neck, 20xd



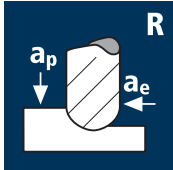


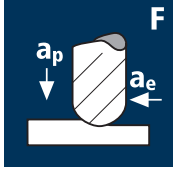





HM	$\lambda$ 30°
MG10	$\gamma$ 5°



C	CF / GF
Graphite	Fiber Reinforced Plastics

IV

Example: Order-N°.		Coating B	Article-N°. 15795	ø-Code 100								DIAMANT
Ø Code	d <sub>1</sub> ±0.01	d <sub>2</sub> h6	d <sub>3</sub>	l <sub>1</sub>	l <sub>2</sub>	l <sub>3</sub>	l <sub>4</sub>	r ±0.01	α	z		B15795
100	1.00	3.00	0.95	60	1.20	20.00	24.22	0.500	2.5°	2	●	
108	1.20	3.00	1.10	60	1.44	24.00	27.94	0.600	2.0°	2	●	
120	1.50	3.00	1.40	70	1.80	30.00	33.38	0.750	1.4°	2	●	
140	2.00	3.00	1.90	80	2.40	40.00	42.45	1.000	0.8°	2	●	
160	2.50	3.00	2.30	80	3.00	50.00	51.70	1.250	0.3°	2	●	
180	3.00	3.00	2.80	90	3.60	59.56	60.00	1.500	0.0°	2	●	

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]
 <p><b>R</b></p>	Graphite  <b>B</b>  <b>B</b>	1.00	2	0.007	0.150	0.200	210	350	420	630
		1.20	2	0.008	0.200	0.250	240	400	480	720
		1.50	2	0.011	0.250	0.300	330	550	660	990
		2.00	2	0.014	0.300	0.400	420	700	840	1260
		2.50	2	0.018	0.400	0.500	540	900	1080	1620
		3.00	2	0.021	0.450	0.600	630	1050	1260	1890
 <p><b>F</b></p>	Graphite  <b>B</b>  <b>B</b>	1.00	2	0.008	0.060	0.080	240	400	480	720
		1.20	2	0.010	0.070	0.100	300	500	600	900
		1.50	2	0.012	0.090	0.120	360	600	720	1080
		2.00	2	0.016	0.120	0.160	480	800	960	1440
		2.50	2	0.020	0.150	0.200	600	1000	1200	1800
		3.00	2	0.024	0.180	0.240	720	1200	1440	2160
 <p><b>F</b></p>	Graphite  <b>B</b>  <b>B</b>	1.00	2	0.008	0.060	0.060	240	400	480	720
		1.20	2	0.010	0.070	0.070	300	500	600	900
		1.50	2	0.012	0.090	0.090	360	600	720	1080
		2.00	2	0.016	0.120	0.120	480	800	960	1440
		2.50	2	0.020	0.150	0.150	600	1000	1200	1800
		3.00	2	0.024	0.180	0.180	720	1200	1440	2160