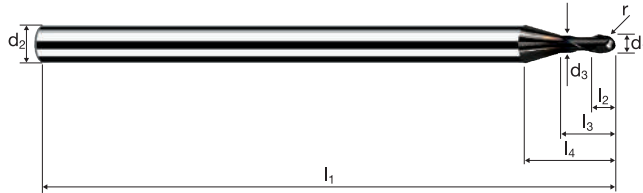


# Ball nose end mills Microcut

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



HM MG10	$\lambda$ 30° $\gamma$ 5°



				C Graphite					CF / GF Fiber Reinforced Plastics
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## IV

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	DIAMANT	
											B5782	
Example: Order-N°.	Coating <b>B</b>		Article-N° <b>5782</b>		ø-Code <b>020</b>							
<b>020</b>	0.20	3.00	0.18	40	0.24	0.60	8.86	0.100	9.4°	2	●	
<b>030</b>	0.30	3.00	0.25	40	0.36	0.90	8.96	0.150	9.0°	2	●	
<b>040</b>	0.40	3.00	0.35	40	0.48	1.20	8.98	0.200	8.7°	2	●	
<b>050</b>	0.50	3.00	0.45	40	0.60	1.50	6.65	0.250	11.8°	2	●	
<b>060</b>	0.60	3.00	0.55	40	0.72	1.80	6.77	0.300	11.2°	2	●	
<b>080</b>	0.80	3.00	0.75	40	0.96	2.40	6.99	0.400	10.1°	2	●	
<b>100</b>	1.00	3.00	0.95	50	1.20	3.00	7.22	0.500	9.0°	2	●	
<b>108</b>	1.20	3.00	1.10	50	1.44	3.60	7.54	0.600	7.9°	2	●	
<b>120</b>	1.50	3.00	1.40	50	1.80	4.50	7.88	0.750	6.5°	2	●	
<b>140</b>	2.00	3.00	1.90	50	2.40	6.00	8.45	1.000	4.1°	2	●	
<b>160</b>	2.50	3.00	2.30	50	3.00	7.50	9.20	1.250	2.0°	2	●	
<b>180</b>	3.00	3.00	2.80	50	3.60	8.56	9.00	1.500	0.0°	2	●	
											●	
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											●	

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 <b>B</b> <b>B</b>	0.30	2	0.003	0.150	0.200	90	150	180	270
		0.50	2	0.005	0.250	0.300	150	250	300	450
		0.80	2	0.008	0.400	0.500	240	400	480	720
		1.00	2	0.009	0.500	0.600	270	450	540	810
		1.20	2	0.011	0.600	0.700	330	550	660	990
		1.50	2	0.014	0.750	0.900	420	700	840	1260
		2.00	2	0.019	1.000	1.200	570	950	1140	1710
		2.50	2	0.024	1.250	1.500	720	1200	1440	2160
3.00	2	0.028	1.500	1.800	840	1400	1680	2520		
	Graphite <b>B</b> <b>B</b>	0.30	2	0.002	0.150	0.300	60	100	120	180
		0.50	2	0.004	0.250	0.500	120	200	240	360
		0.80	2	0.006	0.400	0.800	180	300	360	540
		1.00	2	0.007	0.500	1.000	210	350	420	630
		1.20	2	0.009	0.600	1.200	270	450	540	810
		1.50	2	0.011	0.750	1.500	330	550	660	990
		2.00	2	0.015	1.000	2.000	450	750	900	1350
		2.50	2	0.018	1.250	2.500	540	900	1080	1620
3.00	2	0.022	1.500	3.000	660	1100	1320	1980		
	Graphite <b>B</b> <b>B</b>	0.30	2	0.003	0.050	0.060	90	150	180	270
		0.50	2	0.005	0.080	0.100	150	250	300	450
		0.80	2	0.009	0.120	0.160	270	450	540	810
		1.00	2	0.011	0.150	0.200	330	550	660	990
		1.20	2	0.013	0.180	0.240	390	650	780	1170
		1.50	2	0.016	0.230	0.300	480	800	960	1440
		2.00	2	0.021	0.300	0.400	630	1050	1260	1890
		2.50	2	0.027	0.380	0.500	810	1350	1620	2430
3.00	2	0.032	0.450	0.600	960	1600	1920	2880		
	Graphite <b>B</b> <b>B</b>	0.30	2	0.003	0.060	0.060	90	150	180	270
		0.50	2	0.005	0.100	0.100	150	250	300	450
		0.80	2	0.009	0.160	0.160	270	450	540	810
		1.00	2	0.011	0.200	0.200	330	550	660	990
		1.20	2	0.013	0.240	0.240	390	650	780	1170
		1.50	2	0.016	0.300	0.300	480	800	960	1440
		2.00	2	0.021	0.400	0.400	630	1050	1260	1890
		2.50	2	0.027	0.500	0.500	810	1350	1620	2430
3.00	2	0.032	0.600	0.600	960	1600	1920	2880		