

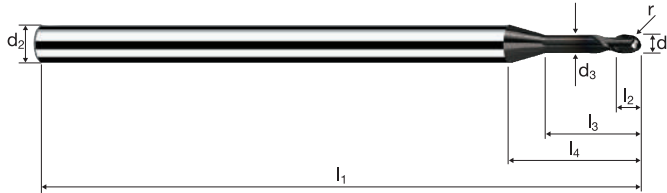
Ball nose end mills Microcut

Shank \varnothing 3mm, cylindrical neck, 5xd



HM
MG10

λ 30°
 γ 5°



C Graphite

CF / GF
Fiber Reinforced
Plastics

IV

Example: Order-N°.											DIAMANT	
											B5784	
											B5784	
\varnothing Code	d_1 ± 0.01	d_2 h6	d_3	l_1	l_2	l_3	l_4	r ± 0.01	α	z		
050	0.50	3.00	0.45	40	0.60	2.50	7.65	0.250	10.1°	2	●	
060	0.60	3.00	0.55	40	0.72	3.00	7.97	0.300	9.4°	2	●	
070	0.70	3.00	0.65	40	0.84	3.50	8.28	0.350	8.7°	2	●	
080	0.80	3.00	0.75	40	0.96	4.00	8.59	0.400	8.1°	2	●	
090	0.90	3.00	0.85	40	1.08	4.50	8.91	0.450	7.4°	2	●	
100	1.00	3.00	0.95	50	1.20	5.00	9.22	0.500	6.9°	2	●	
108	1.20	3.00	1.10	50	1.44	6.00	9.94	0.600	5.8°	2	●	
120	1.50	3.00	1.40	50	1.80	7.50	10.88	0.750	4.5°	2	●	
132	1.80	3.00	1.70	50	2.16	9.00	11.82	0.900	3.3°	2	●	
140	2.00	3.00	1.90	50	2.40	10.00	12.45	1.000	2.7°	2	●	
152	2.30	3.00	2.10	50	2.76	11.50	13.57	1.150	1.8°	2	●	
160	2.50	3.00	2.30	50	3.00	12.50	14.20	1.250	1.2°	2	●	
172	2.80	3.00	2.60	50	3.36	14.00	15.14	1.400	0.5°	2	●	
180	3.00	3.00	2.80	50	3.60	14.56	15.00	1.500	0.0°	2	●	

Application	Material	d1 [mm]	z	f _z [mm]	a _p [mm]	a _e [mm]	n=15000 min ⁻¹ vf [mm/min]	n=25000 min ⁻¹ vf [mm/min]	n=30000 min ⁻¹ vf [mm/min]	n=45000 min ⁻¹ vf [mm/min]
	Graphite B B	0.50	2	0.005	0.250	0.300	150	250	300	450
		0.60	2	0.006	0.250	0.350	180	300	360	540
		0.80	2	0.008	0.350	0.500	240	400	480	720
		1.00	2	0.009	0.450	0.600	270	450	540	810
		1.20	2	0.011	0.550	0.700	330	550	660	990
		1.50	2	0.014	0.700	0.900	420	700	840	1260
		2.00	2	0.019	0.900	1.200	570	950	1140	1710
		2.50	2	0.024	1.150	1.500	720	1200	1440	2160
		3.00	2	0.028	1.350	1.800	840	1400	1680	2520
			Graphite B B	0.50	2	0.004	0.250	0.500	120	200
0.60	2			0.004	0.250	0.600	120	200	240	360
0.80	2			0.006	0.350	0.800	180	300	360	540
1.00	2			0.007	0.450	1.000	210	350	420	630
1.20	2			0.009	0.550	1.200	270	450	540	810
1.50	2			0.011	0.700	1.500	330	550	660	990
2.00	2			0.015	0.900	2.000	450	750	900	1350
2.50	2			0.018	1.150	2.500	540	900	1080	1620
3.00	2			0.022	1.350	3.000	660	1100	1320	1980
	Graphite B B			0.50	2	0.005	0.070	0.100	150	250
		0.60	2	0.006	0.080	0.120	180	300	360	540
		0.80	2	0.009	0.110	0.160	270	450	540	810
		1.00	2	0.011	0.140	0.200	330	550	660	990
		1.20	2	0.013	0.170	0.240	390	650	780	1170
		1.50	2	0.016	0.210	0.300	480	800	960	1440
		2.00	2	0.021	0.280	0.400	630	1050	1260	1890
		2.50	2	0.027	0.350	0.500	810	1350	1620	2430
		3.00	2	0.032	0.420	0.600	960	1600	1920	2880
			Graphite B B	0.50	2	0.005	0.090	0.090	150	250
0.60	2			0.006	0.110	0.110	180	300	360	540
0.80	2			0.009	0.140	0.140	270	450	540	810
1.00	2			0.011	0.180	0.180	330	550	660	990
1.20	2			0.013	0.220	0.220	390	650	780	1170
1.50	2			0.016	0.270	0.270	480	800	960	1440
2.00	2			0.021	0.360	0.360	630	1050	1260	1890
2.50	2			0.027	0.450	0.450	810	1350	1620	2430
3.00	2			0.032	0.540	0.540	960	1600	1920	2880