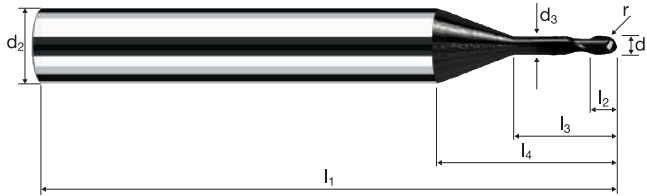
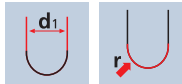


Ball nose end mills MicroX (MicrospheroXG)

Shank \varnothing 6mm, cylindrical neck, 5xd



| | |
|----|---------------|
| HM | λ 30° |
| XA | γ 15° |



| | | | | | | | | | | | |
|--|--|--|--|---------------|--|--|--|--|--|--|---------------------------------------|
| | | | | C Graphite | | | | | | | CF/GF Fiber Reinforced Plastics |
|--|--|--|--|---------------|--|--|--|--|--|--|---------------------------------------|

IV

| Example: Order-N°. | | | | | | | | | | | DIAPLUS | |
|-----------------------|-------|-------------|-------|-------|-------|-------|-------|--------------------|----------|-----|---------|--|
| | | | | | | | | | | | B6064 | |
| \varnothing Code | d_1 | d_2 h4 | d_3 | l_1 | l_2 | l_3 | l_4 | r ± 0.005 | α | z | | |
| 010 | 0.10 | 6.00 | 0.09 | 57 | 0.10 | 0.50 | 17.70 | 0.050 | 14.5° | 2 | ● | |
| 015 | 0.15 | 6.00 | 0.13 | 57 | 0.15 | 0.75 | 17.83 | 0.075 | 14.2° | 2 | ● | |
| 020 | 0.20 | 6.00 | 0.18 | 57 | 0.20 | 1.00 | 17.94 | 0.100 | 13.9° | 2 | ● | |
| 030 | 0.30 | 6.00 | 0.25 | 57 | 0.30 | 1.50 | 18.24 | 0.150 | 13.8° | 2 | ● | |
| 040 | 0.40 | 6.00 | 0.35 | 57 | 0.40 | 2.00 | 18.46 | 0.200 | 12.8° | 2 | ● | |
| 050 | 0.50 | 6.00 | 0.45 | 57 | 0.50 | 2.50 | 18.51 | 0.250 | 12.3° | 2 | ● | |
| 060 | 0.60 | 6.00 | 0.55 | 57 | 0.60 | 3.00 | 18.83 | 0.300 | 11.9° | 2 | ● | |
| 080 | 0.80 | 6.00 | 0.75 | 57 | 0.80 | 4.00 | 19.45 | 0.400 | 11.0° | 2 | ● | |
| 100 | 1.00 | 6.00 | 0.95 | 57 | 1.00 | 5.00 | 20.08 | 0.500 | 10.2° | 2 | ● | |
| 120 | 1.50 | 6.00 | 1.40 | 57 | 1.50 | 7.50 | 21.74 | 0.750 | 8.4° | 2 | ● | |
| 140 | 2.00 | 6.00 | 1.90 | 57 | 2.00 | 10.00 | 23.31 | 1.000 | 6.9° | 2 | ● | |
| 180 | 3.00 | 6.00 | 2.80 | 57 | 3.00 | 15.00 | 26.63 | 1.500 | 4.4° | 2 | ● | |
| 182 | 3.00 | 6.00 | 2.80 | 61 | 3.00 | 18.00 | 24.63 | 1.500 | 3.9° | 2 | ● | |
| 220 | 4.00 | 6.00 | 3.70 | 61 | 4.00 | 20.00 | 24.95 | 2.000 | 2.6° | 2 | ● | |
| 222 | 4.00 | 6.00 | 3.70 | 66 | 4.00 | 25.00 | 29.95 | 2.000 | 2.2° | 2 | ● | |
| 260 | 5.00 | 6.00 | 4.60 | 66 | 5.00 | 25.00 | 28.27 | 2.500 | 1.2° | 2 | ● | |
| 300 | 6.00 | 6.00 | 5.50 | 69 | 6.00 | 29.34 | 30.00 | 3.000 | 0.0° | 2 | ● | |
| | | | | | | | | | | | | |
| | | | | | | | | | | | | |
| | | | | | | | | | | | | |
| | | | | | | | | | | | | |

| Application | Material | d1 [mm] | z | f _z [mm] | a _p [mm] | a _e [mm] | n=15000 min vf [mm/min] | n=25000 min vf [mm/min] | n=30000 min vf [mm/min] | n=45000 min vf [mm/min] |
|-------------|----------------------------------|------------|-------|------------------------|------------------------|------------------------|----------------------------|----------------------------|----------------------------|----------------------------|
| | Graphite B B | 0.20 | 2 | 0.002 | 0.100 | 0.100 | 60 | 100 | 120 | 180 |
| | | 0.50 | 2 | 0.006 | 0.250 | 0.300 | 180 | 300 | 360 | 540 |
| | | 0.80 | 2 | 0.009 | 0.350 | 0.500 | 270 | 450 | 540 | 810 |
| | | 1.00 | 2 | 0.012 | 0.450 | 0.600 | 360 | 600 | 720 | 1080 |
| | | 2.00 | 2 | 0.024 | 0.900 | 1.200 | 720 | 1200 | 1440 | 2160 |
| | | 3.00 | 2 | 0.035 | 1.350 | 1.800 | 1050 | 1750 | 2100 | 3150 |
| | | 4.00 | 2 | 0.047 | 1.800 | 2.400 | 1410 | 2350 | 2820 | 4230 |
| | | 5.00 | 2 | 0.059 | 2.250 | 3.000 | 1770 | 2950 | 3540 | 5310 |
| 6.00 | 2 | 0.071 | 2.700 | 3.600 | 2130 | 3550 | 4260 | 6390 | | |
| | Graphite B B | 0.20 | 2 | 0.002 | 0.100 | 0.200 | 60 | 100 | 120 | 180 |
| | | 0.50 | 2 | 0.005 | 0.250 | 0.500 | 150 | 250 | 300 | 450 |
| | | 0.80 | 2 | 0.007 | 0.350 | 0.800 | 210 | 350 | 420 | 630 |
| | | 1.00 | 2 | 0.009 | 0.450 | 1.000 | 270 | 450 | 540 | 810 |
| | | 2.00 | 2 | 0.018 | 0.900 | 2.000 | 540 | 900 | 1080 | 1620 |
| | | 3.00 | 2 | 0.027 | 1.350 | 3.000 | 810 | 1350 | 1620 | 2430 |
| | | 4.00 | 2 | 0.036 | 1.800 | 4.000 | 1080 | 1800 | 2160 | 3240 |
| | | 5.00 | 2 | 0.045 | 2.250 | 5.000 | 1350 | 2250 | 2700 | 4050 |
| 6.00 | 2 | 0.055 | 2.700 | 6.000 | 1650 | 2750 | 3300 | 4950 | | |
| | Graphite B B | 0.20 | 2 | 0.003 | 0.030 | 0.040 | 90 | 150 | 180 | 270 |
| | | 0.50 | 2 | 0.007 | 0.070 | 0.100 | 210 | 350 | 420 | 630 |
| | | 0.80 | 2 | 0.011 | 0.110 | 0.160 | 330 | 550 | 660 | 990 |
| | | 1.00 | 2 | 0.013 | 0.140 | 0.200 | 390 | 650 | 780 | 1170 |
| | | 2.00 | 2 | 0.027 | 0.280 | 0.400 | 810 | 1350 | 1620 | 2430 |
| | | 3.00 | 2 | 0.040 | 0.420 | 0.600 | 1200 | 2000 | 2400 | 3600 |
| | | 4.00 | 2 | 0.053 | 0.560 | 0.800 | 1590 | 2650 | 3180 | 4770 |
| | | 5.00 | 2 | 0.067 | 0.700 | 1.000 | 2010 | 3350 | 4020 | 6030 |
| 6.00 | 2 | 0.080 | 0.840 | 1.200 | 2400 | 4000 | 4800 | 7200 | | |
| | Graphite B B | 0.20 | 2 | 0.003 | 0.040 | 0.040 | 90 | 150 | 180 | 270 |
| | | 0.50 | 2 | 0.007 | 0.090 | 0.090 | 210 | 350 | 420 | 630 |
| | | 0.80 | 2 | 0.011 | 0.140 | 0.140 | 330 | 550 | 660 | 990 |
| | | 1.00 | 2 | 0.013 | 0.180 | 0.180 | 390 | 650 | 780 | 1170 |
| | | 2.00 | 2 | 0.027 | 0.360 | 0.360 | 810 | 1350 | 1620 | 2430 |
| | | 3.00 | 2 | 0.040 | 0.540 | 0.540 | 1200 | 2000 | 2400 | 3600 |
| | | 4.00 | 2 | 0.053 | 0.720 | 0.720 | 1590 | 2650 | 3180 | 4770 |
| | | 5.00 | 2 | 0.067 | 0.900 | 0.900 | 2010 | 3350 | 4020 | 6030 |
| 6.00 | 2 | 0.080 | 1.080 | 1.080 | 2400 | 4000 | 4800 | 7200 | | |