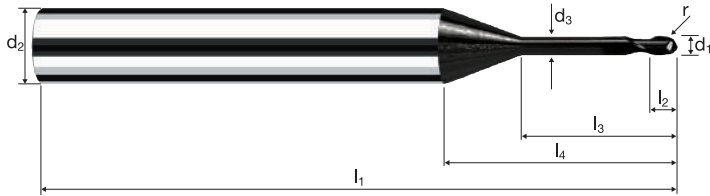
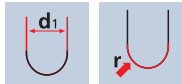


# Ball nose end mills MicroX (MicrospheroXG)

Shank  $\varnothing$  6mm, cylindrical neck, 8xd



HM  $\lambda$  30°  
XA  $\gamma$  15°



C Graphite CF/GF Fiber Reinforced Plastics

IV

Example: Order-N°.											DIAPLUS
Coating Article-N° ø-Code											B6066
Ø Code	d <sub>1</sub>	d <sub>2</sub> h <sub>4</sub>	d <sub>3</sub>	l <sub>1</sub>	l <sub>2</sub>	l <sub>3</sub>	l <sub>4</sub>	r ±0.005	α	z	
010	0.10	6.00	0.09	57	0.10	0.80	18.00	0.050	14.1°	2	●
015	0.15	6.00	0.13	57	0.15	1.20	18.28	0.075	13.7°	2	●
020	0.20	6.00	0.18	57	0.20	1.60	18.54	0.100	13.2°	2	●
030	0.30	6.00	0.25	57	0.30	2.40	19.14	0.150	12.4°	2	●
040	0.40	6.00	0.35	57	0.40	3.20	19.66	0.200	11.7°	2	●
050	0.50	6.00	0.45	57	0.50	4.00	15.01	0.250	11.1°	2	●
060	0.60	6.00	0.55	57	0.60	4.80	15.63	0.300	10.5°	2	●
080	0.80	6.00	0.75	57	0.80	6.40	16.85	0.400	9.4°	2	●
100	1.00	6.00	0.95	57	1.00	8.00	18.08	0.500	8.4°	2	●
120	1.50	6.00	1.40	57	1.50	12.00	21.24	0.750	6.5°	2	●
140	2.00	6.00	1.90	61	2.00	16.00	24.31	1.000	5.1°	2	●
180	3.00	6.00	2.80	66	3.00	24.00	30.63	1.500	3.1°	2	●
220	4.00	6.00	3.70	75	4.00	32.00	36.95	2.000	1.7°	2	●
260	5.00	6.00	4.60	80	5.00	40.00	43.27	2.500	0.8°	2	●
300	6.00	6.00	5.50	87	6.00	47.34	48.00	3.000	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 vf [mm/min]	n=25000 min vf [mm/min]	n=30000 min vf [mm/min]	n=45000 min vf [mm/min]
	Graphite <b>B</b> <b>B</b>	0.20	2	0.002	0.100	0.100	60	100	120	180
		0.50	2	0.006	0.200	0.300	180	300	360	540
		0.80	2	0.009	0.300	0.500	270	450	540	810
		1.00	2	0.012	0.400	0.600	360	600	720	1080
		2.00	2	0.024	0.800	1.200	720	1200	1440	2160
		3.00	2	0.035	1.200	1.800	1050	1750	2100	3150
		4.00	2	0.047	1.600	2.400	1410	2350	2820	4230
		5.00	2	0.059	2.000	3.000	1770	2950	3540	5310
6.00	2	0.071	2.400	3.600	2130	3550	4260	6390		
	Graphite <b>B</b> <b>B</b>	0.20	2	0.002	0.100	0.200	60	100	120	180
		0.50	2	0.005	0.200	0.500	150	250	300	450
		0.80	2	0.007	0.300	0.800	210	350	420	630
		1.00	2	0.009	0.400	1.000	270	450	540	810
		2.00	2	0.018	0.800	2.000	540	900	1080	1620
		3.00	2	0.027	1.200	3.000	810	1350	1620	2430
		4.00	2	0.036	1.600	4.000	1080	1800	2160	3240
		5.00	2	0.045	2.000	5.000	1350	2250	2700	4050
6.00	2	0.055	2.400	6.000	1650	2750	3300	4950		
	Graphite <b>B</b> <b>B</b>	0.20	2	0.003	0.020	0.040	90	150	180	270
		0.50	2	0.007	0.060	0.090	210	350	420	630
		0.80	2	0.011	0.100	0.140	330	550	660	990
		1.00	2	0.013	0.120	0.180	390	650	780	1170
		2.00	2	0.027	0.240	0.360	810	1350	1620	2430
		3.00	2	0.040	0.360	0.540	1200	2000	2400	3600
		4.00	2	0.053	0.480	0.720	1590	2650	3180	4770
		5.00	2	0.067	0.600	0.900	2010	3350	4020	6030
6.00	2	0.080	0.720	1.080	2400	4000	4800	7200		
	Graphite <b>B</b> <b>B</b>	0.20	2	0.003	0.030	0.030	90	150	180	270
		0.50	2	0.007	0.080	0.080	210	350	420	630
		0.80	2	0.011	0.130	0.130	330	550	660	990
		1.00	2	0.013	0.160	0.160	390	650	780	1170
		2.00	2	0.027	0.320	0.320	810	1350	1620	2430
		3.00	2	0.040	0.480	0.480	1200	2000	2400	3600
		4.00	2	0.053	0.640	0.640	1590	2650	3180	4770
		5.00	2	0.067	0.800	0.800	2010	3350	4020	6030
6.00	2	0.080	0.960	0.960	2400	4000	4800	7200		