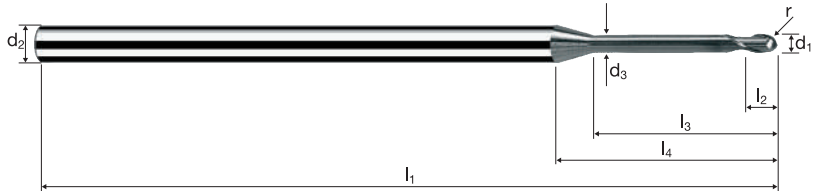


# Ball nose end mills Microcut

Shank  $\varnothing$  3mm, cylindrical neck, 10xd



HM	$\lambda$ 30°
MG10	$\gamma$ 5°

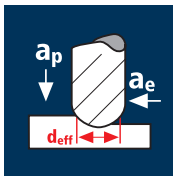


**ToolSchool** X6846  
X6568  
X6768

Rm < 850	Rm 850-1100	Rm 1100-1300	Rm 1300-1500				Inox Stainless	Ti Titanium	Gold / Platinum Copper
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											MICRO
Example: Order-N°: <b>M</b> <b>5787</b> <b>050</b> <small>Coating Article-N° ø-Code</small>											
											<b>M5787</b>
$\varnothing$ Code	$d_1$ ±0.01	$d_2$ h6	$d_3$	$l_1$	$l_2$	$l_3$	$l_4$	$r$ ±0.01	$\alpha$	$z$	
050	0.50	3.00	0.45	40	0.60	5.00	10.15	0.250	7.5°	2	●
060	0.60	3.00	0.55	40	0.72	6.00	10.97	0.300	6.7°	2	●
080	0.80	3.00	0.75	40	0.96	8.00	12.59	0.400	5.4°	2	●
100	1.00	3.00	0.95	50	1.20	10.00	14.22	0.500	4.3°	2	●
108	1.20	3.00	1.10	50	1.44	12.00	15.94	0.600	3.5°	2	●
120	1.50	3.00	1.40	60	1.80	15.00	18.38	0.750	2.6°	2	●
140	2.00	3.00	1.90	60	2.40	20.00	22.45	1.000	1.4°	2	●
160	2.50	3.00	2.30	60	3.00	25.00	26.70	1.250	0.6°	2	●
180	3.00	3.00	2.80	60	3.60	29.56	30.00	1.500	0.0°	2	●
											●
											●
											●
											●
											●
											●
											●
											●
											●
											●
											●

## Application



## Material

Steel  
850 - 1100 N/mm<sup>2</sup>

Steel  
1100 - 1300 N/mm<sup>2</sup>

Inox normal  
[Cr-Ni/1.4301]  
[Cr-Ni-Mo/1.4571]

Titanium alloys  
up to 300 HB  
[Ti5Al2.5Sn]

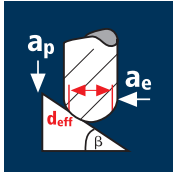
d1 [mm]	z	v <sub>c</sub> [m/min]	f <sub>t</sub> [mm]	a <sub>s</sub> [mm]	a <sub>e</sub> [mm]	d <sub>eff</sub> [mm]	n [min <sup>-1</sup> ]	v <sub>f</sub> [mm/min]	Q [mm <sup>3</sup> /min]
0.50	2	26	0.018	0.020	0.080	0.20	41380	1490	2.4
0.60	2	29	0.022	0.020	0.090	0.22	41960	1845	3.3
0.80	2	40	0.028	0.030	0.120	0.30	42440	2375	8.6
1.00	2	51	0.036	0.040	0.150	0.39	41625	2995	18.0
1.20	2	63	0.042	0.050	0.180	0.48	41780	3510	31.6
1.50	2	78	0.054	0.060	0.230	0.59	42080	4545	62.7
2.00	2	103	0.072	0.080	0.300	0.78	42035	6055	145.3
2.50	2	129	0.090	0.100	0.380	0.98	41900	7540	286.6
3.00	2	156	0.108	0.120	0.450	1.18	42080	9090	490.8

0.50	2	26	0.016	0.020	0.080	0.20	41380	1325	2.1
0.60	2	29	0.020	0.020	0.090	0.22	41960	1680	3.0
0.80	2	40	0.026	0.030	0.120	0.30	42440	2205	7.9
1.00	2	51	0.032	0.040	0.150	0.39	41625	2665	16.0
1.20	2	63	0.038	0.050	0.180	0.48	41780	3175	28.6
1.50	2	78	0.048	0.060	0.230	0.59	42080	4040	55.7
2.00	2	103	0.064	0.080	0.300	0.78	42035	5380	129.1
2.50	2	129	0.082	0.100	0.380	0.98	41900	6870	261.1
3.00	2	156	0.098	0.120	0.450	1.18	42080	8250	445.4

0.50	2	26	0.016	0.020	0.080	0.20	41380	1325	2.1
0.60	2	29	0.020	0.020	0.090	0.22	41960	1680	3.0
0.80	2	40	0.026	0.030	0.120	0.30	42440	2205	7.9
1.00	2	51	0.032	0.040	0.150	0.39	41625	2665	16.0
1.20	2	63	0.038	0.050	0.180	0.48	41780	3175	28.6
1.50	2	78	0.048	0.060	0.230	0.59	42080	4040	55.7
2.00	2	80	0.064	0.080	0.300	0.78	32645	4180	100.3
2.50	2	80	0.082	0.100	0.380	0.98	25985	4260	161.9
3.00	2	80	0.098	0.120	0.450	1.18	21580	4230	228.4

0.50	2	26	0.012	0.020	0.080	0.20	41380	995	1.6
0.60	2	29	0.016	0.020	0.090	0.22	41960	1345	2.4
0.80	2	40	0.020	0.030	0.120	0.30	42440	1700	6.1
1.00	2	51	0.026	0.040	0.150	0.39	41625	2165	13.0
1.20	2	60	0.030	0.050	0.180	0.48	39790	2385	21.5
1.50	2	60	0.038	0.060	0.230	0.59	32370	2460	34.0
2.00	2	60	0.050	0.080	0.300	0.78	24485	2450	58.8
2.50	2	60	0.064	0.100	0.380	0.98	19490	2495	94.8
3.00	2	60	0.076	0.120	0.450	1.18	16185	2460	132.8

## Application



## Material

Steel  
850 - 1100 N/mm<sup>2</sup>

Steel  
1100 - 1300 N/mm<sup>2</sup>

Inox normal  
[Cr-Ni/1.4301]  
[Cr-Ni-Mo/1.4571]

Titanium alloys  
up to 300 HB  
[Ti5Al2.5Sn]

d1 [mm]	z	v <sub>c</sub> [m/min]	f <sub>t</sub> [mm]	a <sub>s</sub> [mm]	a <sub>e</sub> [mm]	d <sub>eff</sub> [mm]	n [min <sup>-1</sup> ]	v <sub>f</sub> [mm/min]	β [°]
0.50	2	61	0.012	0.018	0.018	0.46	42210	1015	45°
0.60	2	73	0.014	0.022	0.022	0.55	42250	1185	45°
0.80	2	96	0.016	0.028	0.028	0.73	41860	1340	45°
1.00	2	121	0.020	0.036	0.036	0.92	41865	1675	45°
1.20	2	145	0.022	0.042	0.042	1.10	41960	1845	45°
1.50	2	182	0.024	0.052	0.052	1.38	41980	2015	45°
2.00	2	243	0.026	0.070	0.070	1.84	42040	2185	45°
2.50	2	300	0.028	0.088	0.088	2.29	41700	2335	45°
3.00	2	300	0.032	0.106	0.106	2.75	34725	2220	45°

0.50	2	57	0.010	0.008	0.008	0.43	42195	845	45°
0.60	2	71	0.012	0.018	0.018	0.54	41850	1005	45°
0.80	2	96	0.014	0.028	0.028	0.73	41860	1170	45°
1.00	2	121	0.018	0.036	0.036	0.92	41865	1505	45°
1.20	2	145	0.020	0.042	0.042	1.10	41960	1680	45°
1.50	2	182	0.022	0.052	0.052	1.38	41980	1845	45°
2.00	2	243	0.024	0.070	0.070	1.84	42040	2020	45°
2.50	2	250	0.026	0.088	0.088	2.29	34750	1805	45°
3.00	2	250	0.028	0.106	0.106	2.75	28935	1620	45°

0.50	2	57	0.010	0.008	0.008	0.43	42195	845	45°
0.60	2	71	0.012	0.018	0.018	0.54	41850	1005	45°
0.80	2	96	0.012	0.028	0.028	0.73	41860	1005	45°
1.00	2	120	0.016	0.036	0.036	0.92	41520	1330	45°
1.20	2	120	0.018	0.042	0.042	1.10	34725	1250	45°
1.50	2	120	0.020	0.052	0.052	1.38	27680	1105	45°
2.00	2	120	0.020	0.070	0.070	1.84	20760	830	45°
2.50	2	120	0.022	0.088	0.088	2.29	16680	735	45°
3.00	2	120	0.026	0.106	0.106	2.75	13890	720	45°

0.50	2	57	0.008	0.008	0.008	0.43	42195	675	45°
0.60	2	71	0.010	0.018	0.018	0.54	41850	835	45°
0.80	2	96	0.012	0.028	0.028	0.73	41860	1005	45°
1.00	2	100	0.014	0.036	0.036	0.92	34600	970	45°
1.20	2	100	0.016	0.042	0.042	1.10	28935	925	45°
1.50	2	100	0.016	0.052	0.052	1.38	23065	740	45°
2.00	2	100	0.018	0.070	0.070	1.84	17300	625	45°
2.50	2	100	0.020	0.088	0.088	2.29	13900	555	45°
3.00	2	100	0.022	0.106	0.106	2.75	11575	510	45°