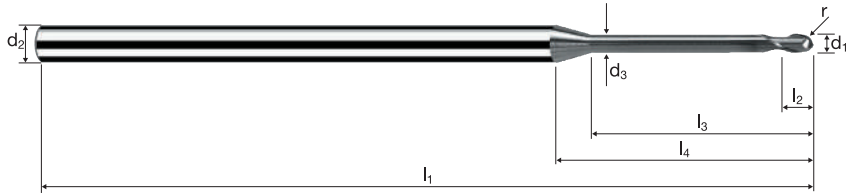


Ball nose end mills Microcut

Shank \varnothing 3mm, cylindrical neck, 12xd



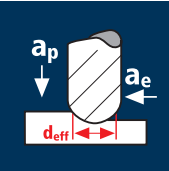
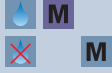



HM	λ 30°
MG10	γ 5°

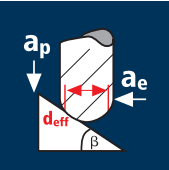
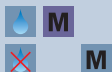




ToolSchool X6847 X6770

Rm < 850	Rm 850-1100	Rm 1100-1300	Rm 1300-1500				Inox Stainless	Ti Titanium	Gold / Platinum Copper
----------	-------------	--------------	--------------	--	--	--	----------------	-------------	------------------------

Example: Order-N°.											MICRO
											M5791
\varnothing Code	d ₁ ±0.01	d ₂ h6	d ₃	l ₁	l ₂	l ₃	l ₄	r ±0.01	α	z	
100	1.00	3.00	0.95	50	1.20	12.00	16.22	0.500	3.8°	2	●
108	1.20	3.00	1.10	60	1.44	14.40	18.34	0.600	3.0°	2	●
120	1.50	3.00	1.40	60	1.80	18.00	21.38	0.750	2.2°	2	●
140	2.00	3.00	1.90	60	2.40	24.00	26.45	1.000	1.2°	2	●
160	2.50	3.00	2.30	70	3.00	30.00	31.70	1.250	0.5°	2	●
180	3.00	3.00	2.80	70	3.60	35.56	36.00	1.500	0.0°	2	●

Application	Material	d1 [mm]	z	v _c [m/min]	f _s [mm]	a _s [mm]	a _e [mm]	d _{eff} [mm]	n [min ⁻¹]	v _r [mm/min]	Q [mm ³ /min]
	Steel 850 - 1100 N/mm ²	1.00	2	45	0.028	0.030	0.120	0.34	42130	2360	8.5
		1.20	2	57	0.034	0.040	0.140	0.43	42195	2870	16.1
		1.50	2	71	0.042	0.050	0.180	0.54	41850	3515	31.6
		2.00	2	90	0.058	0.060	0.240	0.68	42130	4885	70.4
		2.50	2	116	0.072	0.080	0.300	0.88	41960	6040	145.0
		3.00	2	135	0.086	0.090	0.360	1.02	42130	7245	234.8
											
	Steel 1100 - 1300 N/mm ²	1.00	2	45	0.026	0.030	0.120	0.34	42130	2190	7.9
		1.20	2	57	0.030	0.040	0.140	0.43	42195	2530	14.2
		1.50	2	71	0.038	0.050	0.180	0.54	41850	3180	28.6
		2.00	2	90	0.052	0.060	0.240	0.68	42130	4380	63.1
		2.50	2	116	0.064	0.080	0.300	0.88	41960	5370	128.9
		3.00	2	135	0.078	0.090	0.360	1.02	42130	6570	212.9
											
	Inox normal [Cr-Ni/1.4301] [Cr-Ni-Mo/1.4571]	1.00	2	45	0.022	0.030	0.120	0.34	42130	1855	6.7
		1.20	2	57	0.028	0.040	0.140	0.43	42195	2365	13.2
		1.50	2	71	0.034	0.050	0.180	0.54	41850	2845	25.6
		2.00	2	80	0.046	0.060	0.240	0.68	37450	3445	49.6
		2.50	2	80	0.058	0.080	0.300	0.88	28935	3355	80.6
		3.00	2	80	0.068	0.090	0.360	1.02	24965	3395	110.0
											
	Titanium alloys up to 300 HB [Ti5Al2.5Sn]	1.00	2	45	0.020	0.030	0.120	0.34	42130	1685	6.1
		1.20	2	57	0.024	0.040	0.140	0.43	42195	2025	11.3
		1.50	2	60	0.030	0.050	0.180	0.54	35370	2120	19.1
		2.00	2	60	0.040	0.060	0.240	0.68	28085	2245	32.4
		2.50	2	60	0.050	0.080	0.300	0.88	21705	2170	52.1
		3.00	2	60	0.060	0.090	0.360	1.02	18725	2245	72.8
											

Application	Material	d1 [mm]	z	v _c [m/min]	f _s [mm]	a _s [mm]	a _e [mm]	d _{eff} [mm]	n [min ⁻¹]	v _r [mm/min]	β [°]
	Steel 850 - 1100 N/mm ²	1.00	2	119	0.020	0.028	0.028	0.90	42090	1685	45°
		1.20	2	143	0.022	0.034	0.034	1.08	42145	1855	45°
		1.50	2	178	0.024	0.042	0.042	1.35	41970	2015	45°
		2.00	2	238	0.026	0.056	0.056	1.80	42090	2190	45°
		2.50	2	297	0.028	0.070	0.070	2.25	42015	2355	45°
		3.00	2	300	0.032	0.084	0.084	2.70	35370	2265	45°
											
	Steel 1100 - 1300 N/mm ²	1.00	2	119	0.018	0.028	0.028	0.90	42090	1515	45°
		1.20	2	143	0.020	0.034	0.034	1.08	42145	1685	45°
		1.50	2	178	0.022	0.042	0.042	1.35	41970	1845	45°
		2.00	2	238	0.024	0.056	0.056	1.80	42090	2020	45°
		2.50	2	250	0.026	0.070	0.070	2.25	35370	1840	45°
		3.00	2	250	0.028	0.084	0.084	2.70	29475	1650	45°
											
	Inox normal [Cr-Ni/1.4301] [Cr-Ni-Mo/1.4571]	1.00	2	119	0.016	0.028	0.028	0.90	42090	1345	45°
		1.20	2	120	0.018	0.034	0.034	1.08	35370	1275	45°
		1.50	2	120	0.020	0.042	0.042	1.35	28295	1130	45°
		2.00	2	120	0.020	0.056	0.056	1.80	21220	850	45°
		2.50	2	120	0.022	0.070	0.070	2.25	16975	745	45°
		3.00	2	120	0.026	0.084	0.084	2.70	14145	735	45°
											
	Titanium alloys up to 300 HB [Ti5Al2.5Sn]	1.00	2	100	0.014	0.028	0.028	0.90	35370	990	45°
		1.20	2	100	0.016	0.034	0.034	1.08	29475	945	45°
		1.50	2	100	0.016	0.042	0.042	1.35	23580	755	45°
		2.00	2	100	0.018	0.056	0.056	1.80	17685	635	45°
		2.50	2	100	0.020	0.070	0.070	2.25	14145	565	45°
		3.00	2	100	0.022	0.084	0.084	2.70	11790	520	45°
	