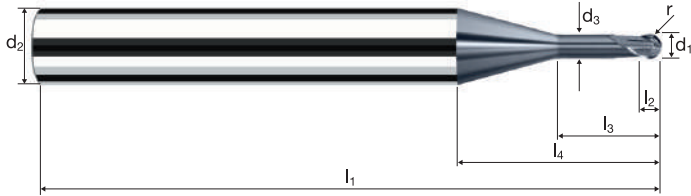
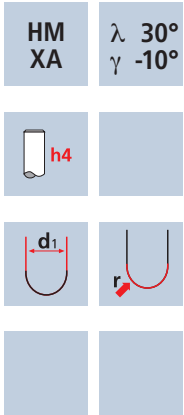


# Ball nose end mills MicroHX

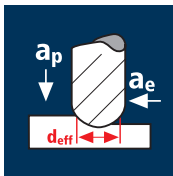
Shank  $\varnothing$  6mm, cylindrical neck, 3.5xd



		Rm	Rm	HRC	HRC	HRC	Inox	Ti	HSS
		1100-1300	1300-1500	48-56	56-60	> 60	Stainless	Titanium	

Example: Order-N°.											DURO-AI	
											Y6482	
$\varnothing$ Code	$d_1$	$d_2$ h4	$d_3$	$l_1$	$l_2$	$l_3$	$l_4$	$r$ $\pm 0.005$	$\alpha$	$z$		
040	0.40	6.00	0.35	57	0.24	1.40	17.36	0.200	13.4°	2	●	
050	0.50	6.00	0.45	57	0.30	1.75	12.26	0.250	13.1°	2	●	
060	0.60	6.00	0.55	57	0.36	2.10	12.43	0.300	12.7°	2	●	
080	0.80	6.00	0.75	57	0.48	2.80	12.75	0.400	12.0°	2	●	
100	1.00	6.00	0.95	57	0.60	3.50	13.08	0.500	11.4°	2	●	

## Application



## Material

Hardened tool steel  
52 - 56 HRC

**Y**

Hardened tool steel  
56 - 60 HRC

**Y**

Hardened tool steel  
> 60 HRC

**Y**

High speed steel,  
hardened  
64 - 70 HRC

**Y**

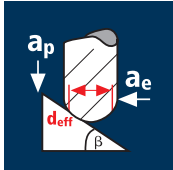
d1 [mm]	z	$v_c$ [m/min]	$f_z$ [mm]	$a_p$ [mm]	$a_e$ [mm]	$d_{eff}$ [mm]	n [min <sup>-1</sup> ]	$v_t$ [mm/min]	Q [mm <sup>3</sup> /min]
0.40	2	22	0.010	0.018	0.080	0.17	41195	825	1.2
0.50	2	28	0.013	0.023	0.100	0.21	42440	1105	2.5
0.60	2	33	0.015	0.028	0.120	0.25	42015	1260	4.2
0.80	2	45	0.020	0.037	0.160	0.34	42130	1685	10.0
1.00	2	55	0.025	0.046	0.200	0.42	41685	2085	19.2

0.40	2	22	0.009	0.018	0.080	0.17	41195	740	1.1
0.50	2	28	0.012	0.023	0.100	0.21	42440	995	2.3
0.60	2	33	0.014	0.028	0.120	0.25	42015	1135	3.8
0.80	2	45	0.018	0.037	0.160	0.34	42130	1515	9.0
1.00	2	55	0.023	0.046	0.200	0.42	41685	1875	17.3

0.40	2	20	0.007	0.014	0.080	0.15	42440	610	0.7
0.50	2	25	0.009	0.018	0.100	0.19	41885	785	1.4
0.60	2	30	0.011	0.022	0.120	0.23	41520	895	2.4
0.80	2	40	0.014	0.030	0.160	0.30	42440	1220	5.8
1.00	2	50	0.018	0.037	0.200	0.38	41885	1510	11.1

0.40	2	17	0.006	0.012	0.080	0.13	41625	480	0.4
0.50	2	22	0.007	0.015	0.100	0.17	41195	615	0.9
0.60	2	26	0.009	0.018	0.120	0.20	41380	715	1.5
0.80	2	36	0.012	0.024	0.160	0.27	42440	980	3.7
1.00	2	40	0.014	0.029	0.200	0.34	37450	1080	6.4

## Application



## Material

Hardened tool steel  
52 - 56 HRC

**Y**

Hardened tool steel  
56 - 60 HRC

**Y**

Hardened tool steel  
> 60 HRC

**Y**

High speed steel,  
hardened  
64 - 70 HRC

**Y**

d1 [mm]	z	$v_c$ [m/min]	$f_z$ [mm]	$a_p$ [mm]	$a_e$ [mm]	$d_{eff}$ [mm]	n [min <sup>-1</sup> ]	$v_t$ [mm/min]	$\beta$ [°]
0.40	2	49	0.012	0.016	0.016	0.37	42155	1010	45°
0.50	2	62	0.018	0.022	0.022	0.47	41990	1510	45°
0.60	2	74	0.018	0.026	0.026	0.56	42060	1515	45°
0.80	2	99	0.020	0.034	0.034	0.75	42015	1680	45°
1.00	2	123	0.026	0.042	0.042	0.93	42100	2190	45°

0.40	2	49	0.012	0.016	0.016	0.37	42155	1010	45°
0.50	2	62	0.016	0.022	0.022	0.47	41990	1345	45°
0.60	2	74	0.016	0.026	0.026	0.56	42060	1345	45°
0.80	2	99	0.018	0.034	0.034	0.75	42015	1515	45°
1.00	2	123	0.022	0.042	0.042	0.93	42100	1850	45°

0.40	2	48	0.010	0.010	0.010	0.36	42440	850	45°
0.50	2	61	0.015	0.020	0.020	0.46	42210	1265	45°
0.60	2	73	0.015	0.020	0.020	0.55	42250	1265	45°
0.80	2	98	0.015	0.030	0.030	0.74	42155	1265	45°
1.00	2	120	0.020	0.040	0.040	0.93	41070	1645	45°

0.40	2	48	0.010	0.010	0.010	0.36	42440	850	45°
0.50	2	61	0.010	0.020	0.020	0.46	42210	845	45°
0.60	2	73	0.010	0.020	0.020	0.55	42250	845	45°
0.80	2	85	0.010	0.020	0.030	0.71	38110	760	45°
1.00	2	85	0.015	0.030	0.040	0.91	29730	890	45°