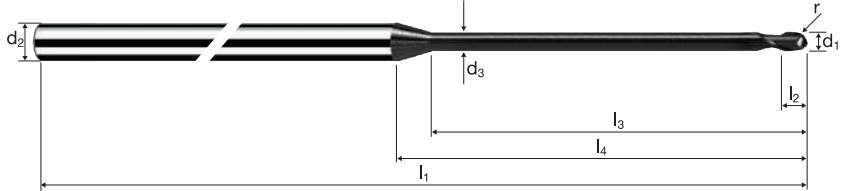


Ball nose end mills Microcut

Shank \varnothing 3mm, cylindrical neck, 20xd



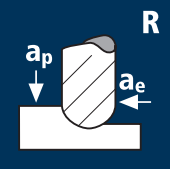


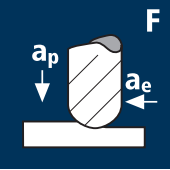


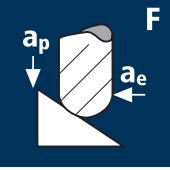


HM λ 30°
MG10 γ 5°



C Graphite CF / GF Fiber Reinforced Plastics

IV

Example: Order-N°.											DIAMANT
Coating Article-N° ø-Code											B 15795 100
\varnothing Code	d_1 ± 0.01	d_2 h6	d_3	l_1	l_2	l_3	l_4	r ± 0.01	α	z	B15795
100	1.00	3.00	0.95	60	1.20	20.00	24.22	0.500	2.5°	2	●
108	1.20	3.00	1.10	60	1.44	24.00	27.94	0.600	2.0°	2	●
120	1.50	3.00	1.40	70	1.80	30.00	33.38	0.750	1.4°	2	●
140	2.00	3.00	1.90	80	2.40	40.00	42.45	1.000	0.8°	2	●
160	2.50	3.00	2.30	80	3.00	50.00	51.70	1.250	0.3°	2	●
180	3.00	3.00	2.80	90	3.60	59.56	60.00	1.500	0.0°	2	●

Application	Material	d1 [mm]	z	f _z [mm]	a _p [mm]	a _e [mm]	n=15000 min ⁻¹ vf [mm/min]	n=25000 min ⁻¹ vf [mm/min]	n=30000 min ⁻¹ vf [mm/min]	n=45000 min ⁻¹ vf [mm/min]
 <p>R</p>	Graphite  B  B	1.00	2	0.007	0.150	0.200	210	350	420	630
		1.20	2	0.008	0.200	0.250	240	400	480	720
		1.50	2	0.011	0.250	0.300	330	550	660	990
		2.00	2	0.014	0.300	0.400	420	700	840	1260
		2.50	2	0.018	0.400	0.500	540	900	1080	1620
		3.00	2	0.021	0.450	0.600	630	1050	1260	1890
 <p>F</p>	Graphite  B  B	1.00	2	0.008	0.060	0.080	240	400	480	720
		1.20	2	0.010	0.070	0.100	300	500	600	900
		1.50	2	0.012	0.090	0.120	360	600	720	1080
		2.00	2	0.016	0.120	0.160	480	800	960	1440
		2.50	2	0.020	0.150	0.200	600	1000	1200	1800
		3.00	2	0.024	0.180	0.240	720	1200	1440	2160
 <p>F</p>	Graphite  B  B	1.00	2	0.008	0.060	0.060	240	400	480	720
		1.20	2	0.010	0.070	0.070	300	500	600	900
		1.50	2	0.012	0.090	0.090	360	600	720	1080
		2.00	2	0.016	0.120	0.120	480	800	960	1440
		2.50	2	0.020	0.150	0.150	600	1000	1200	1800
		3.00	2	0.024	0.180	0.180	720	1200	1440	2160