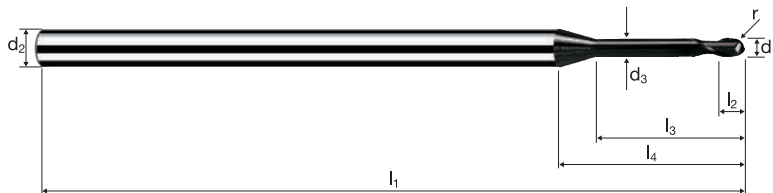
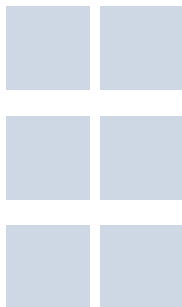


Ball nose end mills Microcut

Shank \varnothing 3mm, cylindrical neck, 8xd



HM λ 30°
MG10 γ 5°



C Graphite CF / GF Fiber Reinforced Plastics

IV

Example: Order-N°.											DIAMANT
Coating Article-N° ø-Code											
B 5786 050											B5786
\varnothing Code	d_1 ± 0.01	d_2 h6	d_3	l_1	l_2	l_3	l_4	r ± 0.01	α	z	
050	0.50	3.00	0.45	40	0.60	4.00	9.15	0.250	8.4°	2	●
060	0.60	3.00	0.55	40	0.72	4.80	9.77	0.300	7.6°	2	●
080	0.80	3.00	0.75	40	0.96	6.40	10.99	0.400	6.2°	2	●
100	1.00	3.00	0.95	50	1.20	8.00	12.22	0.500	5.1°	2	●
108	1.20	3.00	1.10	50	1.44	9.60	13.54	0.600	4.2°	2	●
120	1.50	3.00	1.40	60	1.80	12.00	15.38	0.750	3.1°	2	●
140	2.00	3.00	1.90	60	2.40	16.00	18.45	1.000	1.7°	2	●
160	2.50	3.00	2.30	60	3.00	20.00	21.70	1.250	0.8°	2	●
180	3.00	3.00	2.80	60	3.60	23.56	24.00	1.500	0.0°	2	●

Application	Material	d1 [mm]	z	f _z [mm]	a _p [mm]	a _e [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	0.50	2	0.005	0.200	0.300	150	250	300	450
		0.60	2	0.006	0.250	0.350	180	300	360	540
		0.80	2	0.008	0.300	0.500	240	400	480	720
		1.00	2	0.009	0.400	0.600	270	450	540	810
		1.20	2	0.011	0.500	0.700	330	550	660	990
		1.50	2	0.014	0.600	0.900	420	700	840	1260
		2.00	2	0.019	0.800	1.200	570	950	1140	1710
		2.50	2	0.024	1.000	1.500	720	1200	1440	2160
		3.00	2	0.028	1.200	1.800	840	1400	1680	2520
			Graphite B B	0.50	2	0.004	0.200	0.500	120	200
0.60	2			0.004	0.250	0.600	120	200	240	360
0.80	2			0.006	0.300	0.800	180	300	360	540
1.00	2			0.007	0.400	1.000	210	350	420	630
1.20	2			0.009	0.500	1.200	270	450	540	810
1.50	2			0.011	0.600	1.500	330	550	660	990
2.00	2			0.015	0.800	2.000	450	750	900	1350
2.50	2			0.018	1.000	2.500	540	900	1080	1620
3.00	2			0.022	1.200	3.000	660	1100	1320	1980
	Graphite B B			0.50	2	0.005	0.060	0.090	150	250
		0.60	2	0.006	0.070	0.110	180	300	360	540
		0.80	2	0.009	0.100	0.140	270	450	540	810
		1.00	2	0.011	0.120	0.180	330	550	660	990
		1.20	2	0.013	0.140	0.220	390	650	780	1170
		1.50	2	0.016	0.180	0.270	480	800	960	1440
		2.00	2	0.021	0.240	0.360	630	1050	1260	1890
		2.50	2	0.027	0.300	0.450	810	1350	1620	2430
		3.00	2	0.032	0.360	0.540	960	1600	1920	2880
			Graphite B B	0.50	2	0.005	0.080	0.080	150	250
0.60	2			0.006	0.100	0.100	180	300	360	540
0.80	2			0.009	0.130	0.130	270	450	540	810
1.00	2			0.011	0.160	0.160	330	550	660	990
1.20	2			0.013	0.190	0.190	390	650	780	1170
1.50	2			0.016	0.240	0.240	480	800	960	1440
2.00	2			0.021	0.320	0.320	630	1050	1260	1890
2.50	2			0.027	0.400	0.400	810	1350	1620	2430
3.00	2			0.032	0.480	0.480	960	1600	1920	2880