

Four Flute Ball Nose Standard 四齿球头标准型

MG

TYPE
N

HRC
45

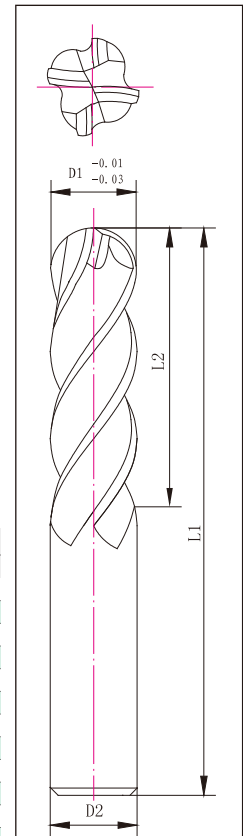
RUN
OUT
<0.02

R
±0.01

AlCrN

Type & Specifications/类型与规格

D1	D2 h6	L2 js14	L1 js14	Flute No.	Order No.
R0.5	4	3	50	4	D1980501020
R1.0	4	4	50	4	D1980502020
R1.5	4	6	50	4	D1980503020
R2.0	4	8	50	4	D1980504020
R1.0	6	6	50	4	D1980505020
R1.5	6	8	50	4	D1980506020
R2.0	6	10	50	4	D1980507020
R2.5	6	12	50	4	D1980508020
R3.0	6	12	50	4	D1980509020
R4.0	8	20	60	4	D1980510020
R5.0	10	25	75	4	D1980511020
R6.0	12	25	75	4	D1980512020
R7.0	14	35	90	4	D1980513020
R8.0	16	35	100	4	D1980514020
R9.0	18	40	100	4	D1980515020
R10.0	20	40	100	4	D1980516020

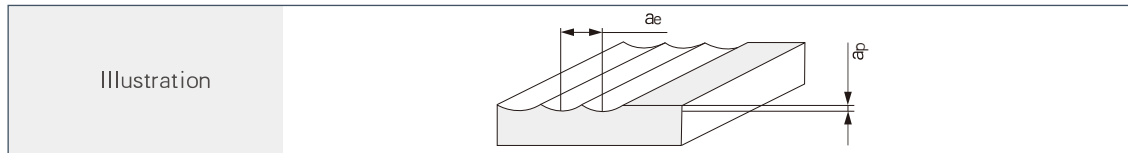


Carbide End Mills



Recommendation/推荐切削条件

Diameter D1	Carbon Steel		Alloy Steel		Hardened Steel HRC30~45	
	Speed n	Feed Vf	Speed n	Feed Vf	Speed n	Feed Vf
R3.0	4020	510	3360	370	2340	245
R4.0	3000	505	2520	360	1740	240
R5.0	2400	455	2040	340	1380	210
R6.0	1980	420	1680	310	1140	185
R8.0	1500	420	1260	350	840	260
R10.0	1200	400	1000	300	670	220
ap (Depth)	ap=0.3D		ap=0.3D		ap=0.3D	
ae (Width)	ae=0.1D		ae=0.1D		ae=0.1D	



- ⊙ Please use rigid and precision equipments and chucks
- ⊙ Be in climb milling. Please lower the recommendations simultaneously in case cutting tools shake badly
- ⊙ Please use suitable coolants

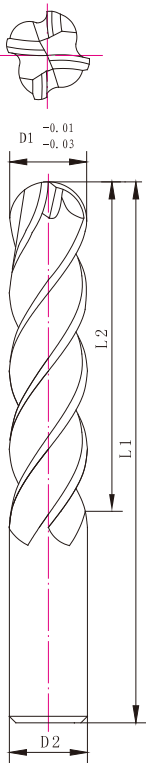
Work Materials/被加工材质

Steels			Cast Iron	Aluminium Alloys	Copper Alloys	Stainless Steel	Titanium Alloys	Graphite
<HRC45	<HRC60	<HRC65						
⊙			⊙	○	○	○		
⊙ Preferential			○ Suitable					

Four Flute Ball Nose Long Length 四齿球头加长型



Type & Specifications/类型与规格

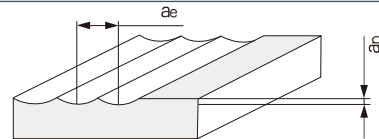


D1	D2 h6	L2 js14	L1 js14	Flute No.	Order No.
R0.5	4	6	60	4	D1982601020
R0.75	4	8	60	4	D1982602020
R1.0	4	8	60	4	D1982603020
R1.25	4	10	60	4	D1982604020
R1.5	4	12	60	4	D1982605020
R1.75	4	12	60	4	D1982606020
R2.0	4	15	60	4	D1982607020
R2.25	6	20	75	4	D1982608020
R2.5	6	25	75	4	D1982609020
R2.75	6	25	75	4	D1982610020
R3.0	6	25	75	4	D1982611020
R3.5	8	30	75	4	D1982612020
R4.0	8	30	75	4	D1982613020
R4.5	10	40	100	4	D1982614020
R5.0	10	40	100	4	D1982615020
R6.0	12	45	100	4	D1982616020
R7.0	14	45	100	4	D1982617020
R8.0	16	60	150	4	D1982618020
R9.0	18	60	150	4	D1982619020
R10.0	20	60	150	4	D1982620020

Recommendation/推荐切削条件

Diameter D1	Carbon Steel		Alloy Steel		Hardened Steel HRC30-45	
	Speed n	Feed Vf	Speed n	Feed Vf	Speed n	Feed Vf
R3.0	3220	410	2690	300	1870	200
R4.0	2400	400	3020	290	1390	190
R5.0	1920	365	1630	270	1100	170
R6.0	1585	340	1345	245	910	150
R8.0	1200	335	1000	280	675	200
R10.0	960	290	800	270	540	180
ap (Depth)	ap=0.3D		ap=0.3D		ap=0.3D	
ae (Width)	ae=0.1D		ae=0.1D		ae=0.1D	

Illustration



- Please optimize the over-hang
- Be in climb milling. Please lower the recommendations simultaneously in case cutting tools shake badly
- Please use suitable coolants

Work Materials/被加工材质

Steels			Cast Iron	Aluminium Alloys	Copper Alloys	Stainless Steel	Titanium Alloys	Graphite
<HRC45	<HRC60	<HRC65						
⊙			⊙	○	○	○		
⊙ Preferential			○ Suitable					

Four Flute Ball Nose Standard

四齿球头标准型

MG



TYPE
N

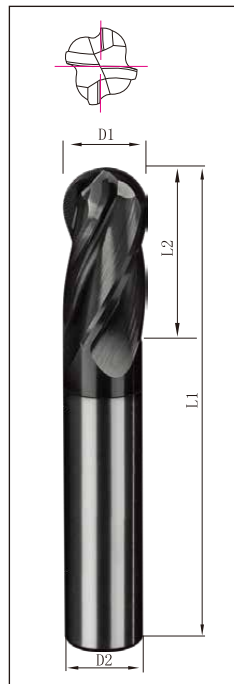
HRC
45



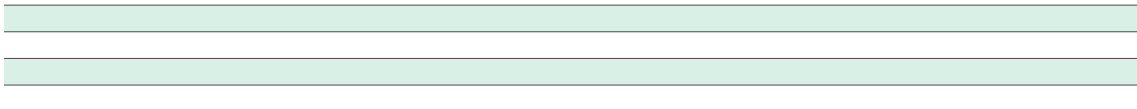
DIN
6527

AlCrN

Type & Specifications/类型与规格



D1	D2 h6	L2 js14	L1 js14	Flute No.	Order No.
1.0	3	3	38	4	1980530020
1.5	3	5	38	4	1980530520
2.0	3	6	38	4	1980531020
2.5	3	7	38	4	1980531520
3.0	3	7	38	4	1980532020
3.5	4	10	50	4	1980532520
4.0	4	10	50	4	1980533020
5.0	5	11	50	4	1980533520
6.0	6	13	57	4	1980534020
7.0	8	13	63	4	1980534520
8.0	8	16	63	4	1980535020
9.0	10	16	72	4	1980535520
10.0	10	19	72	4	1980536020
12.0	12	22	83	4	1980536520
14.0	14	22	83	4	1980537020
16.0	16	26	92	4	1980537520
18.0	18	26	92	4	1980538020
20.0	20	32	104	4	1980538520



Four Flute Ball Nose Long Length 四齿球头加长型

MG TYPE N HRC 45 30° DIN 6527 AlCrN

Type & Specifications / 类型与规格

D1	D2 h6	L2 js14	L1 js14	Flute No.	Order No.
3.0	3	15	57	4	1982641120
4.0	4	19	57	4	1982641620
5.0	5	25	63	4	1982642120
6.0	6	25	75	4	1982642620
8.0	8	30	75	4	1982643120
10.0	10	35	90	4	1982643620
12.0	12	45	100	4	1982644120
14.0	14	45	100	4	1982644620
16.0	16	50	100	4	1982645120
18.0	18	50	100	4	1982645620
20.0	20	60	120	4	1982646120
25.0	25	60	120	4	1982646620



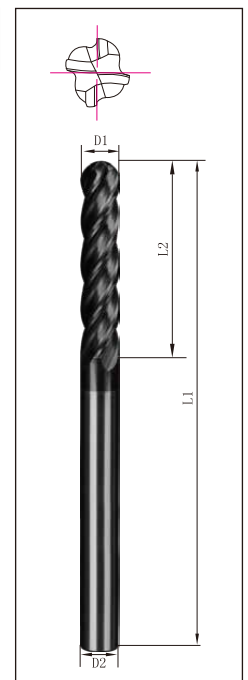
Carbide End Mills

Four Flute Ball Nose Extra Long Length 四齿球头超长型

MG TYPE N HRC 45 30° DIN 6527 AlCrN

Type & Specifications / 类型与规格

D1	D2 h6	L2 js14	L1 js14	Flute No.	Order No.
3.0	3	20	75	4	1984021120
4.0	4	25	75	4	1984021620
5.0	5	30	75	4	1984022120
6.0	6	35	100	4	1984022620
8.0	8	45	100	4	1984023120
10.0	10	45	100	4	1984023620
12.0	12	65	150	4	1984024120
14.0	14	65	150	4	1984024620
16.0	16	75	150	4	1984025120
18.0	18	75	150	4	1984025620
20.0	20	75	150	4	1984026120
25.0	25	75	150	4	1984026620



Four Flute Ball Nose

四齿球头



Type & Specifications/类型与规格

D1	D2	L2	L1	Flute No.	Order No.
1/16	h6	js14	js14	4	1880501120
1/8	1/8	1/4	1-1/2	4	1880501620
3/32	1/8	3/8	1-1/2	4	1880502120
1/8	1/8	3/8	1-1/2	4	1880502220
5/32	3/16	9/16	2	4	1880502620
3/16	3/16	5/8	2	4	1880503120
7/32	1/4	5/8	2-1/2	4	1880503620
1/4	1/4	3/4	2-1/2	4	1880504120
9/32	5/16	3/4	2-1/2	4	1880504620
5/16	5/16	13/16	2-1/2	4	1880505120
3/8	3/8	7/8	2-1/2	4	1880505620
7/16	7/16	1	2-3/4	4	1880506120
1/2	1/2	1	3	4	1880506620
5/8	5/8	1-1/4	3-1/2	4	1880507120
3/4	3/4	1-1/2	4	4	1880507620
7/8	7/8	1-1/2	4	4	1880508120
1	1	1-1/2	4	4	1880508620

