

Two Flute Ball Nose Standard
二齿球头标准型



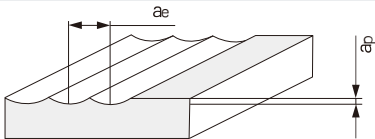
Type & Specifications/类型与规格

D1	D2 h6	L2 js14	L1 js14	Flute No.	Order No.
R1.0	4	4	50	2	D1980103020
R1.25	4	6	50	2	D1980104020
R1.5	4	6	50	2	D1980105020
R1.75	4	8	50	2	D1980106020
R2.0	4	8	50	2	D1980107020
R0.5	6	4	50	2	D1980108020
R1.0	6	6	50	2	D1980109020
R1.5	6	8	50	2	D1980110020
R2.0	6	10	50	2	D1980111020
R2.25	6	12	50	2	D1980112020
R2.5	6	12	50	2	D1980113020
R2.75	6	12	50	2	D1980114020
R3.0	6	12	50	2	D1980115020
R3.5	8	15	60	2	D1980116020
R4.0	8	15	60	2	D1980117020
R4.5	10	20	75	2	D1980118020
R5.0	10	20	75	2	D1980119020
R5.5	12	20	75	2	D1980120020
R6.0	12	20	75	2	D1980121020
R6.5	14	30	90	2	D1980122020
R7.0	14	30	90	2	D1980123020
R7.5	16	30	100	2	D1980124020
R8.0	16	30	100	2	D1980125020
R9.0	18	35	100	2	D1980126020
R10.0	20	35	100	2	D1980127020
R12.5	25	40	100	2	D1980128020

Recommendation/推荐切削条件

Carbon Steel			Alloy Steel		Hardened Steel HRC30~45	
Diameter D1	Speed n	Feed Vf	Speed n	Feed Vf	Speed n	Feed Vf
R2.0	36000	7770	36000	6480	28000	3920
R3.0	25190	6650	25190	5541	19590	3135
R4.0	18890	5670	18890	4725	14695	2645
R5.0	15115	5260	15115	4385	11755	2350
R6.0	12595	4530	12595	3780	9800	2350
R8.0	9450	3685	9450	3020	7350	1990
R10.0	7560	3170	7560	2650	5880	1760
ap (Depth)	ap=0.1D		ap=0.1D		ap=1.0D	
ae (Width)	ae=0.3D		ae=0.1D		ae=0.05D	

Illustration



- 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								

Two Flute Ball Nose
Long Length
二齿球头加长型



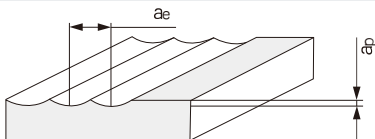
Type & Specifications/类型与规格

D1	D2 h6	L2 js14	L1 js14	Flute No.	Order No.
R0.5	4	4	60	2	D1982201020
R0.75	4	6	60	2	D1982202020
R1.0	4	8	60	2	D1982203020
R1.25	4	10	60	2	D1982204020
R1.5	4	12	60	2	D1982205020
R1.75	4	12	60	2	D1982206020
R2.0	4	15	60	2	D1982207020
R2.25	6	20	75	2	D1982208020
R2.5	6	25	75	2	D1982209020
R2.75	6	25	75	2	D1982210020
R3.0	6	25	75	2	D1982211020
R3.5	8	30	75	2	D1982212020
R4.0	8	30	75	2	D1982213020
R4.5	10	40	100	2	D1982214020
R5.0	10	40	100	2	D1982215020
R6.0	12	45	100	2	D1982216020
R7.0	14	45	100	2	D1982217020
R8.0	16	60	150	2	D1982218020
R9.0	18	60	150	2	D1982219020
R10.0	20	60	150	2	D1982220020

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
R1.0	57600	6900	57600	5760	44800	4480
R1.5	38400	6450	38400	5380	29865	3380
R2.0	28800	6220	28800	5185	22400	3135
R3.0	20150	5320	20150	4435	15675	2510
R4.0	15115	4530	15115	3780	11755	2115
R5.0	12090	4200	12090	3500	9400	1880
R6.0	10080	3620	10080	3020	7840	1880
R8.0	7560	2950	7560	2500	5880	1590
R10.0	6050	2550	6050	2180	4700	1400
ap (Depth)	ap=0.1D		ap=0.1D		ap=1.0D	
ae (Width)	ae=0.3D		ae=0.1D		ae=0.05D	

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								

Type & Specifications/类型与规格

[illegible]

Two Flute Ball Nose

二齿球头型

MG



TYPE
N

HRC
45



AlCrN

Type & Specifications/类型与规格

D1	D2 h6	L2 js14	L1 js14	Flute No.	Order No.
1/16	1/8	1/4	1-1/2	2	1880101120
3/32	1/8	3/8	1-1/2	2	1880101620
1/8	1/8	3/8	1-1/2	2	1880102120
5/32	3/16	9/16	2	2	1880102620
3/16	3/16	5/8	2	2	1880103120
7/32	1/4	5/8	2-1/2	2	1880103620
1/4	1/4	3/4	2-1/2	2	1880104120
9/32	5/16	3/4	2-1/2	2	1880104620
5/16	5/16	13/16	2-1/2	2	1880105120
3/8	3/8	7/8	2-1/2	2	1880105620
7/16	7/16	1	2-3/4	2	1880106120
1/2	1/2	1	3	2	1880106620
5/8	5/8	1-1/4	3-1/2	2	1880107120
3/4	3/4	1-1/2	4	2	1880107620
7/8	7/8	1-1/2	4	2	1880108120
1	1	1-1/2	4	2	1880108620

