

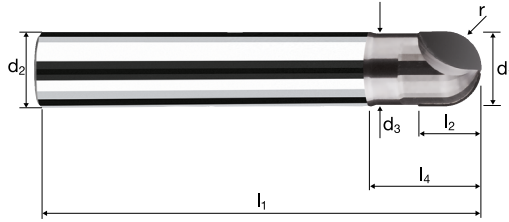
Ball nose end mills CVD

Short version, straight cutting edge



CVD λ 0°
 γ 0°

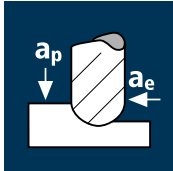
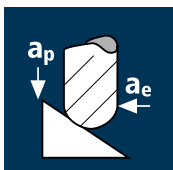
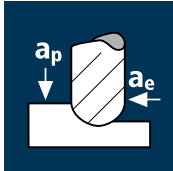
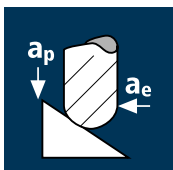
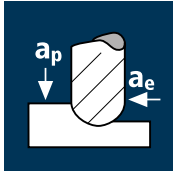
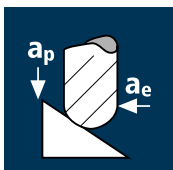
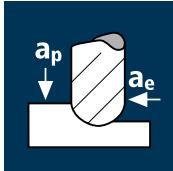
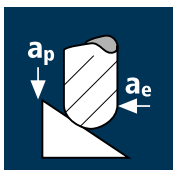
Wear resistance



Al Aluminium Cast	Cu Copper	CuZn Brass	C Graphite	CFK GFK I	CFK GFK II	CFK GFK II	CFK/AL
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Ø Code	d ₁ h7	d ₂ h6	d ₃	l ₁	l ₂	l ₃	l ₄	r ±0.005	α	z	Example: Order-N°.	
											Coating	Article-N°
											25700	140
140	2.00	6.00	1.90	50	2.50	4.00	11.80	1.000	10.6°	2	●	
180	3.00	6.00	2.80	50	2.50	4.00	10.10	1.500	9.9°	2	●	
220	4.00	6.00	3.80	50	2.50	6.00	10.20	2.000	6.9°	2	●	
300	6.00	6.00	5.60	50	6.00	9.00	9.90	3.000	0.0°	2	●	
391	8.00	8.00	7.60	60	7.00	12.00	12.90	4.000	0.0°	2	●	
450	10.00	10.00	9.60	60	8.00	14.00	14.90	5.000	0.0°	2	●	
501	12.00	12.00	11.60	65	9.00	14.00	14.90	6.000	0.0°	2	●	



Application	Material	d1 [mm]	z	f _z [mm]	a _p [mm]	a _e [mm]	n=10000 min ⁻¹ vf [mm/min]	n=15000 min ⁻¹ vf [mm/min]	n=20000 min ⁻¹ vf [mm/min]	n=30000 min ⁻¹ vf [mm/min]	
	CFC	2.00	2	0.025	1.200	0.900	500	750	1000	1500	
		3.00	2	0.035	1.800	1.350	700	1050	1400	2100	
		4.00	2	0.045	2.400	1.800	900	1350	1800	2700	
		6.00	2	0.070	3.600	2.700	1400	2100	2800	4200	
		8.00	2	0.095	4.800	3.600	1900	2850	3800	5700	
		10.00	2	0.120	6.000	4.500	2400	3600	4800	7200	
		12.00	2	0.135	7.200	5.400	2700	4050	5400	8100	
	GRP	2.00	2	0.020	1.200	0.900	400	600	800	1200	
		3.00	2	0.030	1.800	1.350	600	900	1200	1800	
		4.00	2	0.040	2.400	1.800	800	1200	1600	2400	
		6.00	2	0.060	3.600	2.700	1200	1800	2400	3600	
		8.00	2	0.080	4.800	3.600	1600	2400	3200	4800	
		10.00	2	0.100	6.000	4.500	2000	3000	4000	6000	
		12.00	2	0.115	7.200	5.400	2300	3450	4600	6900	
	Aluminium Si > 6%	2.00	2	0.020	1.200	0.900	400	600	800	1200	
		3.00	2	0.025	1.800	1.350	500	750	1000	1500	
		4.00	2	0.035	2.400	1.800	700	1050	1400	2100	
		6.00	2	0.055	3.600	2.700	1100	1650	2200	3300	
		8.00	2	0.070	4.800	3.600	1400	2100	2800	4200	
		10.00	2	0.090	6.000	4.500	1800	2700	3600	5400	
		12.00	2	0.105	7.200	5.400	2100	3150	4200	6300	
	Graphite	2.00	2	0.020	1.200	0.900	400	600	800	1200	
		3.00	2	0.030	1.800	1.350	600	900	1200	1800	
		4.00	2	0.040	2.400	1.800	800	1200	1600	2400	
		6.00	2	0.060	3.600	2.700	1200	1800	2400	3600	
		8.00	2	0.080	4.800	3.600	1600	2400	3200	4800	
		10.00	2	0.100	6.000	4.500	2000	3000	4000	6000	
		12.00	2	0.115	7.200	5.400	2300	3450	4600	6900	
	CFC	2.00	2	0.025	0.200	0.200	500	750	1000	1500	
		3.00	2	0.035	0.300	0.300	700	1050	1400	2100	
		4.00	2	0.045	0.400	0.400	900	1350	1800	2700	
		6.00	2	0.070	0.600	0.600	1400	2100	2800	4200	
		8.00	2	0.095	0.800	0.800	1900	2850	3800	5700	
		10.00	2	0.120	1.000	1.000	2400	3600	4800	7200	
		12.00	2	0.135	1.200	1.200	2700	4050	5400	8100	
	GRP	2.00	2	0.020	0.200	0.200	400	600	800	1200	
		3.00	2	0.030	0.300	0.300	600	900	1200	1800	
		4.00	2	0.040	0.400	0.400	800	1200	1600	2400	
		6.00	2	0.060	0.600	0.600	1200	1800	2400	3600	
		8.00	2	0.080	0.800	0.800	1600	2400	3200	4800	
		10.00	2	0.100	1.000	1.000	2000	3000	4000	6000	
		12.00	2	0.115	1.200	1.200	2300	3450	4600	6900	
	Aluminium Si > 6%	2.00	2	0.020	0.200	0.200	400	600	800	1200	
		3.00	2	0.025	0.300	0.300	500	750	1000	1500	
		4.00	2	0.035	0.400	0.400	700	1050	1400	2100	
		6.00	2	0.055	0.600	0.600	1100	1650	2200	3300	
		8.00	2	0.070	0.800	0.800	1400	2100	2800	4200	
		10.00	2	0.090	1.000	1.000	1800	2700	3600	5400	
		12.00	2	0.105	1.200	1.200	2100	3150	4200	6300	
	Graphite	2.00	2	0.020	0.200	0.200	400	600	800	1200	
		3.00	2	0.030	0.300	0.300	600	900	1200	1800	
		4.00	2	0.040	0.400	0.400	800	1200	1600	2400	
		6.00	2	0.060	0.600	0.600	1200	1800	2400	3600	
		8.00	2	0.080	0.800	0.800	1600	2400	3200	4800	
		10.00	2	0.100	1.000	1.000	2000	3000	4000	6000	
		12.00	2	0.115	1.200	1.200	2300	3450	4600	6900	