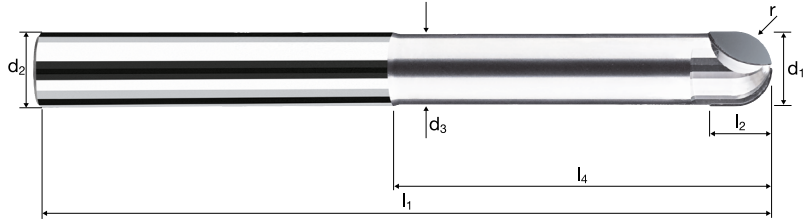


# Ball nose end mills CVD

Long version, straight cutting edge



**CVD**     $\lambda$  0°  
                $\gamma$  0°



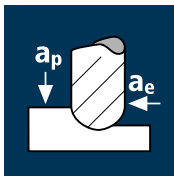
Wear resistance

Al Aluminium Cast	Cu Copper	CuZn Brass	C Graphite	CFK GFK I	CFK GFK II	CFK GFK II	CFK/AL
-------------------------	--------------	---------------	---------------	-----------------	------------------	------------------	--------

Ø Code	d <sub>1</sub> h7	d <sub>2</sub> h6	d <sub>3</sub>	l <sub>1</sub>	l <sub>2</sub>	l <sub>3</sub>	l <sub>4</sub>	r ±0.005	α	z	Example: Order-N°.	
											Coating	Article-N°
												25704
140	2.00	6.00	1.90	55	2.50	10.00	17.80	1.000	6.8°	2	●	
180	3.00	6.00	2.80	75	2.50	20.00	26.10	1.500	3.5°	2	●	
220	4.00	6.00	3.80	75	2.50	30.00	34.30	2.000	1.8°	2	●	
300	6.00	6.00	5.60	100	6.00	40.00	40.90	3.000	0.0°	2	●	
391	8.00	8.00	7.60	100	7.00	40.00	40.90	4.000	0.0°	2	●	
450	10.00	10.00	9.60	100	8.00	50.00	50.90	5.000	0.0°	2	●	
501	12.00	12.00	11.60	107	9.00	60.00	60.90	6.000	0.0°	2	●	



## Application



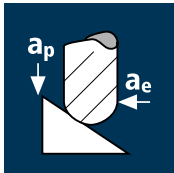
## Material

**CFC**

**GRP**

**Aluminium  
Si > 6%**

**Graphite**



**CFC**

**GRP**

**Aluminium  
Si > 6%**

**Graphite**

d1 [mm]	z	f <sub>z</sub> [mm]	a <sub>p</sub> [mm]	a <sub>e</sub> [mm]	n=10000 min <sup>-1</sup> vf [mm/min]	n=15000 min <sup>-1</sup> vf [mm/min]	n=20000 min <sup>-1</sup> vf [mm/min]	n=30000 min <sup>-1</sup> vf [mm/min]
2.00	2	0.020	1.100	0.900	400	600	800	1200
3.00	2	0.030	1.650	1.350	600	900	1200	1800
4.00	2	0.040	2.200	1.800	800	1200	1600	2400
6.00	2	0.065	3.300	2.700	1300	1950	2600	3900
8.00	2	0.085	4.400	3.600	1700	2550	3400	5100
10.00	2	0.105	5.500	4.500	2100	3150	4200	6300
12.00	2	0.120	6.600	5.400	2400	3600	4800	7200
2.00	2	0.015	1.100	0.900	300	450	600	900
3.00	2	0.025	1.650	1.350	500	750	1000	1500
4.00	2	0.035	2.200	1.800	700	1050	1400	2100
6.00	2	0.055	3.300	2.700	1100	1650	2200	3300
8.00	2	0.070	4.400	3.600	1400	2100	2800	4200
10.00	2	0.090	5.500	4.500	1800	2700	3600	5400
12.00	2	0.100	6.600	5.400	2000	3000	4000	6000
2.00	2	0.015	1.100	0.900	300	450	600	900
3.00	2	0.025	1.650	1.350	500	750	1000	1500
4.00	2	0.030	2.200	1.800	600	900	1200	1800
6.00	2	0.050	3.300	2.700	1000	1500	2000	3000
8.00	2	0.065	4.400	3.600	1300	1950	2600	3900
10.00	2	0.080	5.500	4.500	1600	2400	3200	4800
12.00	2	0.090	6.600	5.400	1800	2700	3600	5400
2.00	2	0.015	1.100	0.900	300	450	600	900
3.00	2	0.025	1.650	1.350	500	750	1000	1500
4.00	2	0.035	2.200	1.800	700	1050	1400	2100
6.00	2	0.055	3.300	2.700	1100	1650	2200	3300
8.00	2	0.070	4.400	3.600	1400	2100	2800	4200
10.00	2	0.090	5.500	4.500	1800	2700	3600	5400
12.00	2	0.100	6.600	5.400	2000	3000	4000	6000
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	0.065	0.600	0.600	1300	1950	2600	3900
8.00	2	0.085	0.800	0.800	1700	2550	3400	5100
10.00	2	0.105	1.000	1.000	2100	3150	4200	6300
12.00	2	0.120	1.200	1.200	2400	3600	4800	7200
2.00	2	0.015	0.200	0.200	300	450	600	900
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	0.100	1.200	1.200	2000	3000	4000	6000
2.00	2	0.015	0.200	0.200	300	450	600	900
3.00	2	0.025	0.300	0.300	500	750	1000	1500
4.00	2	0.030	0.400	0.400	600	900	1200	1800
6.00	2	0.050	0.600	0.600	1000	1500	2000	3000
8.00	2	0.065	0.800	0.800	1300	1950	2600	3900
10.00	2	0.080	1.000	1.000	1600	2400	3200	4800
12.00	2	0.090	1.200	1.200	1800	2700	3600	5400
2.00	2	0.015	0.200	0.200	300	450	600	900
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	0.100	1.200	1.200	2000	3000	4000	6000