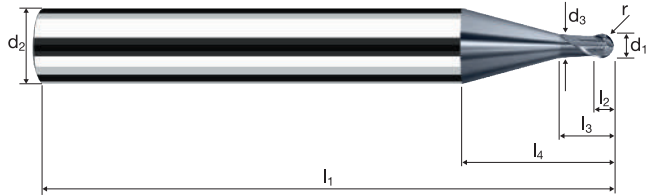
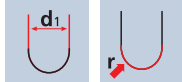


Ball nose end mills MicroHX

Shank \varnothing 6mm, cylindrical neck, 1xd



HM
XA λ 30°
 γ -10°

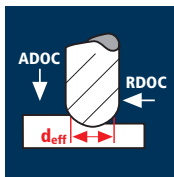


		HRC 34-42	HRC 42-48	HRC 48-56	HRC 56-60	HRC > 60	Inox Stainless	Ti Titanium	HSS
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Order-N°	d ₁	d ₂ h5	d ₃	l ₁	l ₂	l ₃	l ₄	r ±0.005	α	fl	DURO-AI
Y6460040	0.4	6	0.35	57	0.40	0.4	16.78	0.20	14.6°	2	●
Y6460050	0.5	6	0.45	57	0.50	0.5	11.50	0.25	14.5°	2	●
Y6460060	0.6	6	0.55	57	0.60	0.6	11.43	0.30	14.5°	2	●
Y6460080	0.8	6	0.75	57	0.80	0.8	11.30	0.40	14.3°	2	●
Y6460100	1.0	6	0.95	57	1.00	1.0	11.19	0.50	14.1°	2	●
Y6460120	1.5	6	1.40	57	1.50	1.5	10.86	0.75	13.5°	2	●
Y6460140	2.0	6	1.90	57	2.00	2.0	10.52	1.00	12.9°	2	●

VII

Application



Material

Hardened tool steel
52 - 56 HRC



d1 [mm]	fl	Speed [m/min]	FPT [mm]	ADOC [mm]	RDOC [mm]	d _{eff} [mm]	RPM [min ⁻¹]	Feed [mm/min]	MRR [mm ³ /min]
0.4	2	100	0.012	0.03	0.08	0.21	60000	1440	3.5
0.5	2	100	0.014	0.04	0.10	0.27	60000	1680	6.7
0.6	2	100	0.018	0.04	0.12	0.30	60000	2160	10.4
0.8	2	100	0.024	0.06	0.16	0.42	60000	2880	27.6
1.0	2	100	0.030	0.07	0.20	0.51	60000	3600	50.4
1.5	2	100	0.044	0.11	0.30	0.78	40810	3590	118.5
2.0	2	100	0.058	0.14	0.40	1.02	31210	3620	202.5

Hardened tool steel
56 - 60 HRC



0.4	2	60	0.010	0.03	0.08	0.21	60000	1200	2.9
0.5	2	60	0.014	0.04	0.10	0.27	60000	1680	6.7
0.6	2	60	0.016	0.04	0.12	0.30	60000	1920	9.2
0.8	2	60	0.022	0.06	0.16	0.42	45475	2000	19.2
1.0	2	60	0.026	0.07	0.20	0.51	37450	1945	27.2
1.5	2	60	0.040	0.11	0.30	0.78	24485	1960	64.7
2.0	2	60	0.054	0.14	0.40	1.02	18725	2020	113.0

Hardened tool steel
60 - 64 HRC



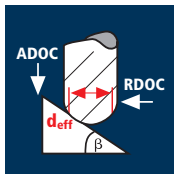
0.4	2	55	0.008	0.02	0.08	0.17	60000	960	1.5
0.5	2	55	0.010	0.03	0.10	0.24	60000	1200	3.6
0.6	2	55	0.012	0.03	0.12	0.26	60000	1440	5.2
0.8	2	55	0.016	0.05	0.16	0.39	44890	1435	11.5
1.0	2	55	0.018	0.06	0.20	0.47	37250	1340	16.1
1.5	2	55	0.028	0.09	0.30	0.71	24660	1380	37.3
2.0	2	55	0.038	0.11	0.40	0.91	19240	1460	64.0

Hardened tool steel
64 - 70 HRC



0.4	2	45	0.006	0.02	0.08	0.17	60000	720	1.2
0.5	2	45	0.008	0.02	0.10	0.20	60000	960	1.9
0.6	2	45	0.010	0.02	0.12	0.22	60000	1200	2.9
0.8	2	45	0.012	0.04	0.16	0.35	40925	980	6.3
1.0	2	45	0.014	0.05	0.20	0.44	32555	910	9.1
1.5	2	45	0.022	0.07	0.30	0.63	22735	1000	21.0
2.0	2	45	0.030	0.09	0.40	0.83	17260	1035	37.5

Application



Material

Hardened tool steel
52 - 56 HRC



d1 [mm]	fl	Speed [m/min]	FPT [mm]	ADOC [mm]	RDOC [mm]	d _{eff} [mm]	RPM [min ⁻¹]	Feed [mm/min]	β [°]
0.4	2	200	0.012	0.018	0.018	0.37	60000	1440	45°
0.5	2	200	0.016	0.022	0.022	0.47	60000	1920	45°
0.6	2	200	0.018	0.026	0.026	0.56	60000	2160	45°
0.8	2	200	0.020	0.036	0.036	0.75	60000	2400	45°
1.0	2	200	0.026	0.044	0.044	0.93	60000	3120	45°
1.5	2	200	0.030	0.066	0.066	1.40	45475	2730	45°
2.0	2	200	0.034	0.088	0.088	1.87	34045	2315	45°

Hardened tool steel
56 - 60 HRC



0.4	2	150	0.010	0.018	0.018	0.37	60000	1200	45°
0.5	2	150	0.014	0.022	0.022	0.47	60000	1680	45°
0.6	2	150	0.016	0.026	0.026	0.56	60000	1920	45°
0.8	2	150	0.018	0.036	0.036	0.75	60000	2160	45°
1.0	2	150	0.024	0.044	0.044	0.93	51340	2465	45°
1.5	2	150	0.028	0.066	0.066	1.40	34105	1910	45°
2.0	2	150	0.030	0.088	0.088	1.87	25535	1530	45°

Hardened tool steel
60 - 64 HRC



0.4	2	120	0.008	0.016	0.016	0.37	60000	960	45°
0.5	2	120	0.012	0.020	0.020	0.46	60000	1440	45°
0.6	2	120	0.012	0.024	0.024	0.56	60000	1440	45°
0.8	2	120	0.014	0.032	0.032	0.74	51620	1445	45°
1.0	2	120	0.020	0.040	0.040	0.93	41075	1645	45°
1.5	2	120	0.022	0.060	0.060	1.39	27480	1210	45°
2.0	2	120	0.024	0.080	0.080	1.86	20535	985	45°

Hardened tool steel
64 - 70 HRC



0.4	2	85	0.006	0.012	0.012	0.36	60000	720	45°
0.5	2	85	0.010	0.016	0.016	0.46	58820	1175	45°
0.6	2	85	0.010	0.020	0.020	0.55	49195	985	45°
0.8	2	85	0.012	0.026	0.026	0.73	37065	890	45°
1.0	2	85	0.016	0.032	0.032	0.91	29735	950	45°
1.5	2	85	0.018	0.048	0.048	1.37	19750	710	45°
2.0	2	85	0.020	0.064	0.064	1.82	14865	595	45°