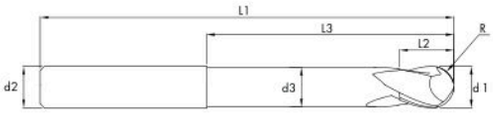
# SOLID CARBIDE BALL NOSE END MILLS

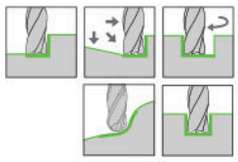
heikenei.com

VOLLHARTMETALL RADIUSFRASER

KARBÜR KÜRE FREZE ALUCAST BALL NOSE LONG





## ALUCAST BALL NOSE LONG



TYPE



QUALITY



DIAMETER



NORM

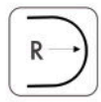

2 FLUTES



SHAFT TYPE



HELICAL

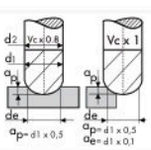


RADIUS



COATED

| $d_1$(e8) | $L_2$ | $d_3$ | $L_3$ | $L_1$ | $d_2$(h6) | Z | R | CNC R | Uncoated Code | Coated Code |
|---|---|---|---|---|---|---|---|---|---|---|
| 4 | 6 | 3,8 | 48 | 65 | 4 | 2 | 2 | 1,986 | 4034930 | 4034940 |
| 5 | 7 | 4,8 | 48 | 80 | 5 | 2 | 2.5 | 2,486 | 4034950 | 4034960 |
| 6 | 8 | 5,7 | 48 | 80 | 6 | 2 | 3 | 2,986 | 4034970 | 4034980 |
| 8 | 10 | 7,6 | 54 | 88 | 8 | 2 | 4 | 3,982 | 4034990 | 4035000 |
| 4 | 6 | 3,8 | 60 | 100 | 4 | 2 | 2 | 1,986 | 4035010 | 4035020 |
| 5 | 7 | 4,8 | 60 | 100 | 5 | 2 | 2.5 | 2,486 | 4035030 | 4035040 |
| 6 | 8 | 5,7 | 60 | 100 | 6 | 2 | 3 | 2,986 | 4035050 | 4035060 |
| 8 | 10 | 7,6 | 60 | 100 | 8 | 2 | 4 | 3,982 | 4035070 | 4035080 |
| 10 | 14 | 9,5 | 60 | 100 | 10 | 2 | 5 | 4,982 | 4035090 | 4035100 |
| 12 | 16 | 11,5 | 60 | 100 | 12 | 2 | 6 | 5,977 | 4035110 | 4035120 |
| 14 | 18 | 13,5 | 60 | 100 | 14 | 2 | 7 | 6,977 | 4035130 | 4035140 |
| 16 | 20 | 15,5 | 60 | 100 | 16 | 2 | 8 | 7,977 | 4035150 | 4035160 |
| 18 | 22 | 17,5 | 60 | 100 | 18 | 2 | 9 | 8,977 | 4035170 | 4035180 |
| | | | | | | | | | | |
| 10 | 14 | 9,5 | 120 | 165 | 10 | 2 | 5 | 4,982 | 4035190 | 4035200 |
| 12 | 16 | 11,5 | 120 | 165 | 12 | 2 | 6 | 5,977 | 4035210 | 4035220 |
| 14 | 18 | 13,5 | 120 | 165 | 14 | 2 | 7 | 6,977 | 4035230 | 4035240 |
| 16 | 20 | 15,5 | 120 | 165 | 16 | 2 | 8 | 7,977 | 4035250 | 4035260 |
| 18 | 22 | 17,5 | 120 | 165 | 18 | 2 | 9 | 8,977 | 4035270 | 4035280 |
| 20 | 24 | 19,5 | 120 | 165 | 20 | 2 | 10 | 9,972 | 4035290 | 4035300 |




| | | | AL | | | CU | | | Graphit | | |
|---|---|---|---|---|---|---|---|---|---|---|---|
| | | | 1.7139 - 1.7262<br>1.7311 - 1.7323 | | | 1.8509 - 1.2713<br>1.2714 - 1.2718 | | | | | |
| | | | Vc = 450 m/dk. | | | Vc = 400 m/dk. | | | Vc = 600 m/dk. | | |
| d1 | ap | ae | fz | n | Vf | fz | n | Vf | fz | n | Vf |
| 4 | 2,0 | 0,40 | 0,040 | 31847 | 2548 | 0,030 | 27866 | 1672 | 0,040 | 43790 | 3503 |
| 5 | 2,5 | 0,50 | 0,050 | 25478 | 2548 | 0,040 | 22293 | 1783 | 0,050 | 35032 | 3503 |
| 6 | 3,0 | 0,60 | 0,060 | 21231 | 2548 | 0,050 | 18577 | 1858 | 0,060 | 29193 | 3503 |
| 8 | 4,0 | 0,80 | 0,080 | 15924 | 2548 | 0,070 | 13933 | 1951 | 0,080 | 21895 | 3503 |
| 10 | 5,0 | 1,00 | 0,100 | 12739 | 2548 | 0,090 | 11146 | 2006 | 0,100 | 17516 | 3503 |
| 12 | 6,0 | 1,20 | 0,120 | 10616 | 2548 | 0,110 | 9289 | 2044 | 0,120 | 14597 | 3503 |
| 14 | 7,0 | 1,40 | 0,140 | 9099 | 2548 | 0,120 | 7962 | 1911 | 0,140 | 12511 | 3503 |
| 16 | 8,0 | 1,60 | 0,160 | 7962 | 2548 | 0,140 | 6967 | 1951 | 0,160 | 10947 | 3503 |
| 18 | 9,0 | 1,80 | 0,180 | 7077 | 2548 | 0,160 | 6192 | 1982 | 0,180 | 9731 | 3503 |
| 20 | 10,0 | 2,00 | 0,200 | 6369 | 2548 | 0,180 | 5573 | 2006 | 0,200 | 8758 | 3503 |