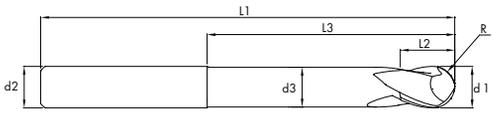
SOLID CARBIDE BALL NOSE END MILLS

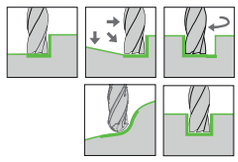
heikenei.com

VOLLHARTMETALL RADIUSFRASER

KARBÜR KÜRE FREZE ALUCAST BALL NOSE LONG







ALUCAST BALL NOSE LONG



TYPE



QUALITY



DIAMETER



NORM

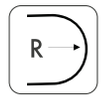

2 FLUTES



SHAFT TYPE



HELICAL

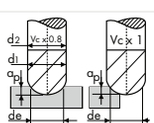


RADIUS



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 1.7311 - 1.7323			1.8509 - 1.2713 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