

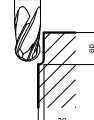
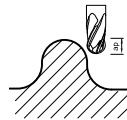
PLUS 203

Ball Nose Endmill

S	Order No	Code	d1f8	d2h6	d3	l1	l2	l3	Corner
	22142	203P.2.0100.0500.R0050.0020.0100.0045.00.S04E2S01.01	1	4	1	50	2	4,5	R 0.50
	22144	203P.2.0200.0500.R0100.0040.0200.0060.00.S04E2S01.01	2	4	2	50	4	6	R 1.00
	22146	203P.2.0300.0570.R0150.0060.0000.0000.00.S06E2S01.01	3	6	-	57	6	-	R 1.50
	22148	203P.2.0400.0570.R0200.0090.0000.0000.00.S06E2S01.01	4	6	-	57	9	-	R 2.00
	22150	203P.2.0500.0570.R0250.0100.0000.0000.00.S06E2S01.01	5	6	-	57	10	-	R 2.50
	22152	203P.2.0600.0570.R0300.0120.0000.0000.00.S06E2S01.01	6	6	-	57	12	-	R 3.00
	22154	203P.2.0800.0630.R0400.0150.0000.0000.00.S08E2S01.01	8	8	-	63	15	-	R 4.00
	22156	203P.2.1000.0720.R0500.0200.0000.0000.00.S10E2S01.01	10	10	-	72	20	-	R 5.00
	22158	203P.2.1200.0820.R0600.0220.0000.0000.00.S12E2S01.01	12	12	-	82	22	-	R 6.00

Cutting Parameters

Material	Copy Milling ap=0.25 - 0.100 / ae=0.025 - 0.0100	Finish Milling ap=0.100 / ae=0.0100
	Vc (m/min)	Vc (m/min)



Steel	Unalloyed Steel	120-140	230-260
	Steel	120-140	200-230
	Tempered Steel	120-140	230-260
	Cold Work Tool Steel	90-110	200-230
	Hot Work Tool Steel	90-110	200-230
Stainless Steel	AISI 304-416-420	90-120	180-210
	AISI 316-440	80-110	170-200
	17-4 PH 15-5 PH	80-110	120-150
	Cobalt-Chrome Alloys	80-110	110-140
	Duplex F51	80-110	110-140
Hardened Steel	Super Duplex F55	80-110	110-140
	> 54 HRC	30-60	50-70

Feed Per Tooth (mm/tooth)

Ø	ae=0.0250	ae=0.0200	ae=0.0150	ae=0.0100
1	0.020	0.025	0.030	0.033
2	0.020	0.025	0.030	0.033
3	0.026	0.031	0.037	0.04
4	0.032	0.037	0.041	0.045
5	0.032	0.037	0.042	0.046
6	0.041	0.046	0.052	0.057
8	0.047	0.052	0.061	0.066
10	0.052	0.057	0.066	0.072
12	0.051	0.058	0.072	0.079

Z2



+TiSiN



Steel	●
Stainless Steel	●
Hardened Steel ≤54 HRC	●
Hardened Steel >54 HRC	●
Cast Iron	○
Graphite	○
Non Ferrous Material	○
HRSA	○
Titanium	○

● Recommended ● Acceptable ○ Not Recommended