

203

Ball Nose Endmill

Short Series

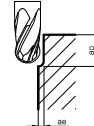
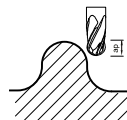
S	Order No	Code	d1f8	d2h6	d3	L1	L2	L3	Corner
*	22100	203.2.0100.0500.R0050.0020.0100.0045.00.S04G1A02.01	1	4	1	50	2	4,5	R 0.50
*	22102	203.2.0150.0500.R0075.0030.0150.0050.00.S04G1A02.01	1,5	4	1,5	50	3	5	R 0.75
*	22104	203.2.0200.0500.R0100.0040.0200.0060.00.S04G1A02.01	2	4	2	50	4	6	R 1.00
*	22106	203.2.0300.0570.R0150.0060.0300.0115.00.S06G1A02.01	3	6	3	57	6	11,5	R 1.50
*	22108	203.2.0400.0570.R0200.0090.0400.0148.00.S06G1A02.01	4	6	4	57	9	14,8	R 2.00
*	22110	203.2.0500.0570.R0250.0100.0500.0156.00.S06G1A02.01	5	6	5	57	10	15,6	R 2.50
*	22112	203.2.0600.0570.R0300.0120.0000.0000.00.S06G1A02.01	6	6	-	57	12	-	R 3.00
*	22114	203.2.0800.0630.R0400.0150.0000.0000.00.S08G1A02.01	8	8	-	63	15	-	R 4.00
*	22116	203.2.1000.0720.R0500.0200.0000.0000.00.S10G1A02.01	10	10	-	72	20	-	R 5.00
*	22118	203.2.1200.0830.R0600.0220.0000.0000.00.S12G1A02.01	12	12	-	83	22	-	R 6.00

Long Series

S	Order No	Code	d1f8	d2h6	d3	L1	L2	L3	Corner
*	22120	203.2.0300.0510.R0150.0050.0290.0150.00.S03G1A02.01	3	3	2,9	51	5	15	R 1.50
*	22122	203.2.0300.0750.R0150.0050.0290.0300.00.S03G1A02.01	3	3	2,9	75	5	30	R 1.50
*	22124	203.2.0400.0500.R0200.0060.0380.0150.00.S04G1A02.01	4	4	3,8	50	6	15	R 2.00
*	22126	203.2.0400.0800.R0200.0060.0380.0350.00.S04G1A02.01	4	4	3,8	80	6	35	R 2.00
*	22128	203.2.0500.0500.R0250.0070.0480.0150.00.S05G1A02.01	5	5	4,8	50	7	15	R 2.50
*	22130	203.2.0500.0750.R0250.0100.0480.0350.00.S05G1A02.01	5	5	4,8	75	10	35	R 2.50
*	22132	203.2.0600.0800.R0300.0100.0580.0350.00.S06G1A02.01	6	6	5,8	80	10	35	R 3.00
*	22134	203.2.0600.1000.R0300.0100.0580.0450.00.S06G1A02.01	6	6	5,8	100	10	45	R 3.00
*	22136	203.2.0800.1000.R0400.0120.0770.0450.00.S08G1A02.01	8	8	7,7	100	12	45	R 4.00
*	22138	203.2.1000.1100.R0500.0140.0970.0550.00.S10G1A02.01	10	10	9,7	110	14	55	R 5.00
*	22140	203.2.1200.1100.R0600.0160.1170.0550.00.S12G1A02.01	12	12	11,7	110	16	55	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	Cold Work Tool Steel	170-200	190-230
	Hot Work Tool Steel	160-190	180-220
Stainless Steel	AISI 304 - 416 - 420	90-120	120-150
	AISI 316 - 440	80-110	110-140
	17-4 PH 15-5 PH	80-110	110-140
Hardened Steel	Chrome-Cobalt Alloy	70-100	100-130
	≤ 54 HRC	90-120	120-150
	>54 HRC	60-90	90-120

Feed Per Tooth (mm/tooth)

	ae=0.0250	ae=0.0200	ae=0.0150	ae=0.0100
0				
3	0,050	0,054	0,059	0,062
4	0,051	0,058	0,065	0,070
6	0,059	0,070	0,083	0,087
8	0,061	0,073	0,086	0,091
10	0,069	0,082	0,095	0,107
12	0,080	0,09	0,110	0,122

Z2



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

● Recommended ● Acceptable ○ Not Recommended