

S	Order No	Code	d1h9	d2h6	d3	l1	l2	l3
*	60100	219.2.0300.0580.R0150.0060.0260.0120.00.S06B1Y01.01	3	6	2,6	58	6	12
*	60102	219.2.0400.0580.R0200.0060.0370.0130.00.S06B1Y01.01	4	6	3,7	58	6	13
*	60104	219.2.0500.0580.R0250.0080.0450.0150.00.S06B1Y01.01	5	6	4,5	58	8	15
*	60106	219.2.0600.0580.R0300.0080.0550.0150.00.S06B1Y01.01	6	6	5,5	58	8	15
*	60108	219.2.0800.0640.R0400.0100.0750.0190.00.S08B1Y01.01	8	8	7,5	64	10	19
*	60110	219.2.1000.0730.R0500.0120.0940.0290.00.S10B1Y01.01	10	10	9,4	73	12	29
*	60112	219.2.1200.0820.R0600.0150.1130.0290.00.S12B1Y01.01	12	12	11,3	82	15	29

Cutting Parameters

Material	Shoulder Milling ae=0,1-0,2xØ ap=0,03xØ	Shoulder Milling ae=0,3-0,4xØ ap=0,03xØ	Shoulder Milling ae=0,6-1xØ ap=0,03xØ
	Vc (m/min)	Vc (m/min)	Vc (m/min)
Non Ferrous Material			
	Aluminum Alloys 250-400 Copper Alloys 175-200	230-380 160-190	200-350 150-180

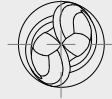
Feed Per Tooth (mm/tooth)

Ø	ae=0,1-0,2xØ ap=1xØ	ae=0,3-0,4xØ ap=1xØ	ae=0,6-1xØ ap=1xØ
3	0,027-0,054	0,021-0,042	0,015-0,03
4	0,036-0,072	0,028-0,055	0,2-0,4
5	0,05-0,09	0,037-0,067	0,025-0,045
6	0,06-0,1	0,045-0,075	0,03-0,05
8	0,08-0,012	0,06-0,089	0,04-0,06
10	0,1-0,14	0,075-0,104	0,05-0,07
12	0,12-0,16	0,089-0,119	0,06-0,08

219

High Performance
Ball Nose Endmill

Z2



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

● Recommended ○ Acceptable ○ Not Recommended