

BALL END MILLS

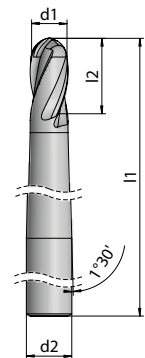
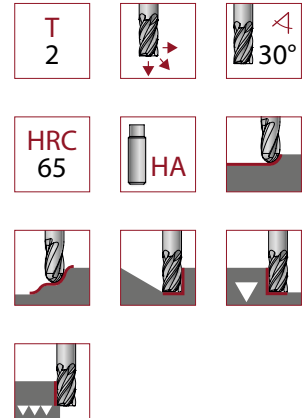
HPC | K 1110

Short version Neck angle 1°30'				
Article no.	d1	d2	l1	l2
11100401	4	6	85	6
11100502	5	6	85	8
11100600	6	8	98	9
11100802	8	10	110	12
11101001	10	12	110	15

Medium version Neck angle 1°30'				
Article no.	d1	d2	l1	l2
11100500	5	6	98	8
11100601	6	8	118	9
11100800	8	10	138	12

Long version Neck angle 1°30'				
Article no.	d1	d2	l1	l2
11100400	4	6	98	6
11100501	5	6	118	8
11100602	6	8	138	9
11100801	8	10	152	12
11101000	10	12	152	15

Extra long version Neck angle 1°30'				
Article no.	d1	d2	l1	l2
11100603	6	8	152	9



Ball track milling	$a_p \times a_e = 0,3d \times 0,3d$
Copy milling	$a_p \times a_e = 0,65d \times 1d$



Cutting data for short version		Ball track	Copy
Material	N/mm ²	v _c m/min	
P Gen. structural/ case hard. steels 1.0037 1.0570 1.0503 1.7131 Tool/ tempering steels 1.2367 1.2379 1.7225 Alloyed/ cold work steels 1.2312 1.2767 1.3505 1.7707	< 800	170	120
	< 1100	130	90
	< 1400	90	80
K Cast iron GG25 GG40 GGG40 Spherical cast iron GGG50 GGG60 GGG70	< 450	160–230	100–160
	< 650	100–150	80–130
H Hardened steel HRC 45–50 Hardened steel HRC 51–58 Hardened steel HRC 59–65	–	250	200
	–	210	180
	–	190	130

d1	Ball track	Copy
	fz mm	
4	0,060	0,025
5	0,065	0,035
6	0,070	0,040
8	0,080	0,045
10	0,085	0,050