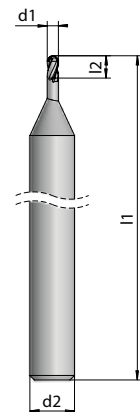
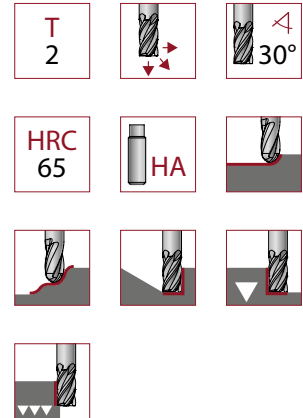


BALL END MILLS

HPC MINI | K 1102

Short version				
Article no.	d1	d2	l1	l2
11020050	0,5	6	64	1
11020060	0,6	6	64	1,2
11020080	0,8	6	64	1,6
11020100	1	6	64	2
11020120	1,2	6	64	2,4
11020140	1,4	6	64	2,8
11020150	1,5	6	64	3
11020160	1,6	6	64	3,2
11020180	1,8	6	64	3,6
11020200	2	6	64	4



Ball track milling	$a_p \times a_e = 0,1d \times 0,2d$
Copy milling	$a_p \times a_e = 0,04d \times 0,04d$



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	< 800	150	120
	Tool/ tempering steels 1.2367 1.2379 1.7225	< 1100	110	90
	Alloyed/ cold work steels 1.2312 1.2767 1.3505 1.7707	< 1400	85	65
K	Cast iron GG25 GG40 GGG40	< 450	140	120
	Spherical cast iron GGG50 GGG60 GGG70	< 650	120	100
H	Hardened steel HRC 45–50	–	120	100
	Hardened steel HRC 51–58	–	100	80
	Hardened steel HRC 59–65	–	60	40

d1	Ball track	Copy
	fz mm	
0,5	0,012	0,016
0,6	0,015	0,017
0,8	0,020	0,018
1	0,028	0,022
1,2	0,032	0,024
1,4	0,036	0,026
1,5	0,040	0,028
1,6	0,044	0,028
1,8	0,048	0,029
2	0,052	0,030