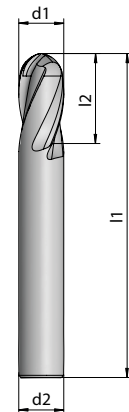
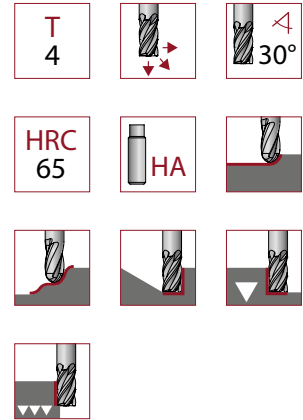


# BALL END MILLS

## K 1050

Short version				
Article no.	d1	d2	l1	l2
10500400	4	6	57	12
10500500	5	6	57	14
10500600	6	6	57	14
10500800	8	8	63	20
10501000	10	10	72	24
10501200	12	12	83	28
10501600	16	16	92	34
10502000	20	20	104	40



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 <sup>2</sup>	v <sub>c</sub> m/min		
<b>P</b>	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	90	80
<b>K</b>	Cast iron GG25   GG40   GGG40	< 450	100-180	100-160
	Spherical cast iron GGG50   GGG60   GGG70	< 650	100-130	80-130
<b>H</b>	Hardened steel HRC 45–50	–	130	130
	Hardened steel HRC 51–58	–	100	100
	Hardened steel HRC 59–65	–	60	60

	Ball track	Copy
d1	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
12	0.085	0.070
16	0.085	0.070
20	0.085	0.070