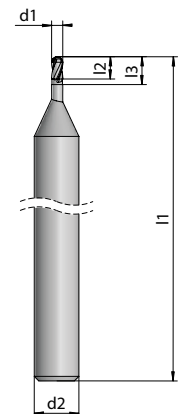
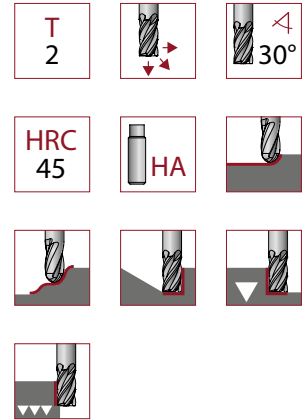


BALL END MILLS

MINI | K 1103

Short version Cutting edge-Ø 1-1.5					
Article no.	d1	d2	l1	l2	l3
11030100	1	6	64	2	5
11030101	1	6	64	2	10
11030102	1	6	64	2	15
11030120	1.2	6	64	2.4	6
11030121	1.2	6	64	2.4	12
11030140	1.4	6	64	2.8	7
11030141	1.4	6	64	2.8	14
11030150	1.5	6	64	3	7.5
11030151	1.5	6	64	3	10
11030152	1.5	6	64	3	15

Short version Cutting edge-Ø 1.6-4					
Article no.	d1	d2	l1	l2	l3
11030160	1.6	6	64	3.2	8
11030161	1.6	6	64	3.2	16
11030180	1.8	6	64	3.6	9
11030181	1.8	6	64	3.6	18
11030200	2	6	64	4	10
11030201	2	6	64	4	15
11030202	2	6	64	4	20
11030250	2.5	6	64	5	12.5
11030251	2.5	6	64	5	20
11030300	3	6	64	6	15
11030301	3	6	64	6	25
11030400	4	6	64	6	15



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	100	80
	Tool/ tempering steels 1.2367 1.2379 1.7225	< 1100	95	75
	Alloyed/ cold work steels 1.2312 1.2767 1.3505 1.7707	< 1400	90	70
K	Cast iron GG25 GG40 GGG40	< 450	100	80
	Spherical cast iron GGG50 GGG60 GGG70	< 650	85	65

	Ball track	Copy
d1	fz mm	
1	0.007	0.006
1.2	0.009	0.007
1.4	0.010	0.008
1.5	0.013	0.011
1.6	0.017	0.011
1.8	0.019	0.013
2	0.022	0.014
2.5	0.027	0.018
3	0.032	0.021
4	0.043	0.031