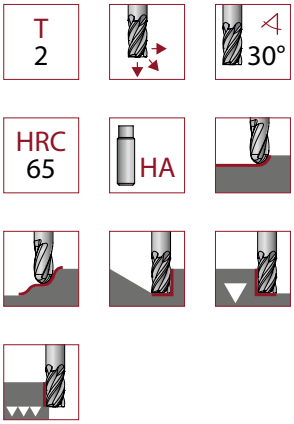
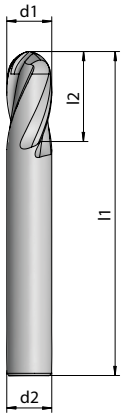
BALL END MILLS
K 1150

BOGERBENZ

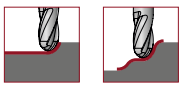
Short version				
Article no.	d1	d2	l1	l2
11500301	3	4	50	5
11500401	4	4	50	6
11500501	5	5	57	8
11500601	6	6	57	9
11500801	8	8	63	12
11501001	10	10	72	15
11501201	12	12	83	18
11501601	16	16	92	24
11502001	20	20	104	30

Long version				
Article no.	d1	d2	l1	l2
11500300	3	4	78	5
11500400	4	4	78	6
11500500	5	5	78	8
11500600	6	6	98	9
11500800	8	8	98	12
11501000	10	10	98	15
11501200	12	12	118	18
11501600	16	16	152	24
11502000	20	20	152	30





Ball track milling	a_p x a_e = 0.3d x 0.3d
Copy milling	a_p x a_e = 0.65d x 1d



Cutting data for short version			Ball track	Copy
Material		N/mm²	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	90	80
K	Cast iron GG25 | GG40 | GGG40	< 450	100-180	100-160
	Spherical cast iron GGG50 | GGG60 | GGG70	< 650	80-130	80-130
H	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	
3	0.050	0.020
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