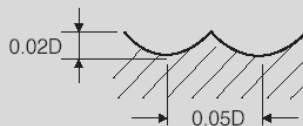


2 FLUTE BALL NOSE MINIATURE END MILLS

104350, 105350



MATERIAL	HARDENED STEELS HEAT RESISTANT STEELS		HARDENED STEELS									
	HRc 30 ~ HRc 40		HRc 40 ~ HRc 50		HRc 50 ~ HRc 55		HRc 55 ~ HRc 60		HRc 60 ~ HRc 65		HRc 65 ~ HRc 70	
HARDNESS	RPM	FEED	RPM	FEED	RPM	FEED	RPM	FEED	RPM	FEED	RPM	FEED
R0.1	50000	1200	50000	1050	45000	960	40000	770	35000	674	31500	570
R0.15	50000	1500	50000	1350	45000	1200	40000	965	35000	840	31500	700
R0.2	50000	1900	50000	1700	45000	1500	40000	1200	35000	1050	31500	890
R0.25	50000	2400	50000	2100	45000	1900	40000	1500	35000	1300	31500	1100
R0.3	50000	2900	50000	2500	45000	2200	40000	1800	35000	1600	31500	1400
R0.4	50000	3900	50000	3300	45000	3000	40000	2400	35000	2100	31500	1800
R0.5	50000	4800	50000	4200	45000	3800	40000	3000	35000	2600	35000	2300
R0.6	50000	5100	48000	4300	43000	3850	38000	3000	34000	2700	30600	2300
R0.75	50000	5400	48000	4500	43000	4000	37000	3100	33000	2700	29700	2300
R1	49700	5700	47800	4800	40000	4000	35000	3150	32000	2800	28500	2300
R1.5	33100	6000	31800	5300	26500	4000	23500	3150	21000	2800	19000	2300
R2	24900	6000	23900	5300	20000	4000	17500	3150	16000	2800	14500	2300
R2.5	18600	5800	17800	4900	15000	3750	13500	3050	11500	2550	10500	2100
R3	13900	4850	13400	4100	11000	3100	10000	2500	8800	2150	8000	1750
R4	11100	4200	10700	3500	9000	2700	8000	2150	7000	1850	6500	1550
R5	9300	3700	8900	3100	7500	2400	6600	1900	5800	1650	5300	1380
R6	6950	2950	6680	2500	5600	1900	5000	1550	4400	1250	4000	1050
R8	5570	2650	5350	2200	4500	1700	4000	1350	3500	1000	3200	850
R10	4450	2350	4300	1950	3600	1500	3200	1200	2800	800	2550	660



RPM = rev./min.
Feed = mm/min.