## **EFFICIENCY MILLS**



L2

D1=2R

















# ► Small Shank / Ball Nose / for P

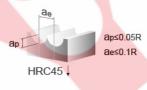


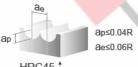


unit: mm

		1		
Order No.	Radius <b>R</b>	Flute Length <b>L1</b>	O.A.L. <b>L2</b>	Shank Dia <b>D2</b>
BS <b>0103</b>	R0.5	2	50	3
BS <b>0153</b>	R0.75	3	50	3
BS <b>0203</b>	R1	4	50	3
BS <b>0253</b>	R1.25	5	50	3
BS <b>0303</b>	R1.5	6	50	3
BS <b>0303A</b>	R1.5	6	75	3
BS <b>0303B</b>	R1.5	6	100	3
BS <b>0404</b>	R2	8	75	4
BS <b>0404A</b>	R2	8	100	4

## Depth of cut





HRC45 R=Radius

### Recommended cutting condition for BS

MATERIAL	Carbon Steels . Alloy Steels S45C , FC , FCD , SCM , S50C , SKS		Alloy Steels . Tool Steels SCr , SNCM , SKD11 , SKD61 , NAK80		Hardened Steels SKD11	
HARDNESS	~HRC30		~HRC50		~HRC60	
Radius (R)	SPEED (min <sup>-1</sup> )	FEED mm / min	SPEED (min <sup>-1</sup> )	FEED mm/min	SPEED (min <sup>-1</sup> )	FEED mm/min
R0.5	45000	800	35000	600	20000	200
R1	23000	800	18000	600	10000	200
R1.5	16000	1000	12000	600	6500	200
R2	12000	1000	9500	700	5000	300