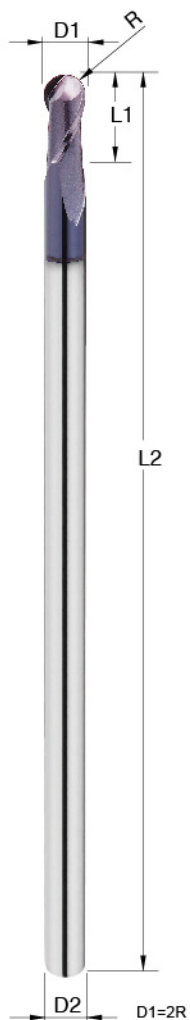


EFFICIENCY MILLS

BS



MG

2 Flutes

30°

HRC 55

TiAlN

Finishing
Semi-Finishing

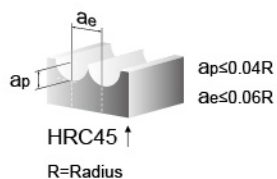
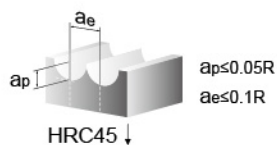
Profiling

► Small Shank / Ball Nose / for **P** **K**

unit: mm

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

▼ Depth of cut



▼ 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 ⁻¹)	FEED mm / min	SPEED (min ⁻¹)	FEED mm / min	SPEED (min ⁻¹)	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