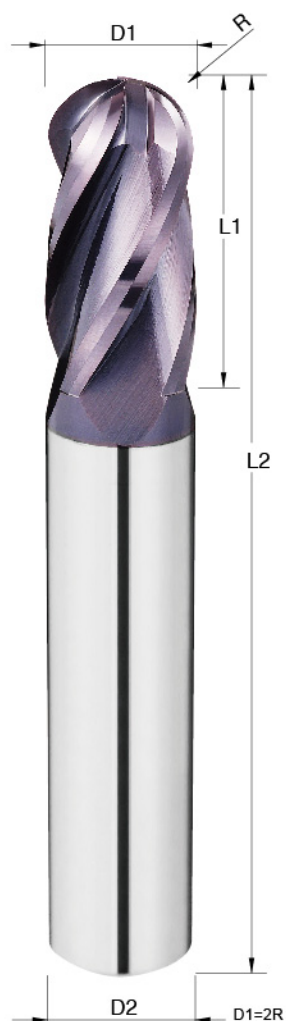


SUPER MILL

SBB

► Ball Nose / for H P K

unit: mm

S
MG

4 Flutes

30°

HRC
60

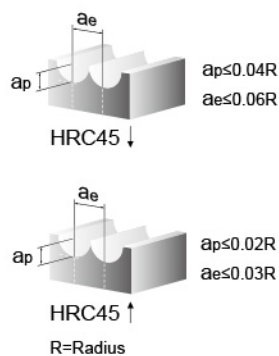
ALTiN

Finishing
Semi-
Finishing

Profiling

Order No.	Radius R	Flute Length L1	O.A.L. L2	Shank Dia D2
SBB 0104	R0.5	2	50	4
SBB 0154	R0.75	3	50	4
SBB 0204	R1	4	50	4
SBB 0254	R1.25	5	50	4
SBB 0304	R1.5	6	50	4
SBB 0404	R2	8	50	4
SBB 0506	R2.5	10	50	6
SBB 0606	R3	12	50	6
SBB 0808	R4	16	60	8
SBB 1010	R5	20	75	10
SBB 1212	R6	24	75	12
SBB 1616	R8	32	100	16

▼ Depth of cut



▼ Recommended cutting condition for SBB

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
R2	15000	3000	14000	2600	10000	1700
R3	13000	4000	11000	2600	9000	1900
R4	9000	2900	8000	1900	6200	1800
R5	7500	2400	6500	1500	5200	1100
R6	6300	2100	5500	1300	4300	1000
R8	4500	1500	3800	1000	3300	900
R10	3700	1200	3200	750	2600	600