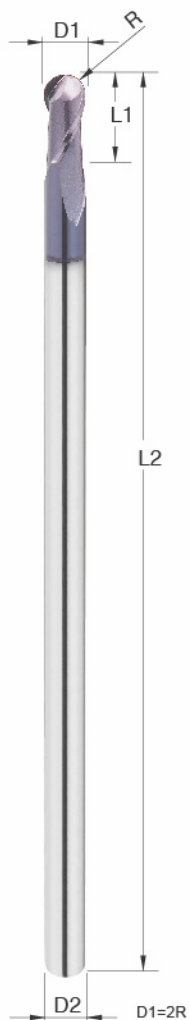


## EFFICIENCY MILLS

BS

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

unit: mm



MG

2 Flutes



30°



HRC 55



TiAlN



Finishing

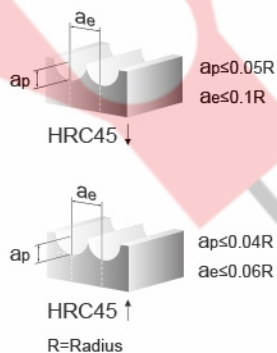
Semi-Finishing



Profiling



## ▼ 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	
	~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