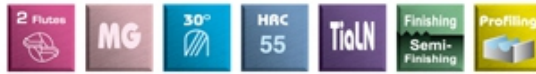


BF



unit: mm

- Co 10%
- Wc 90%
- Dia 0.6µm

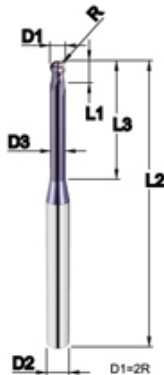
Long Neck / Ball Nose End Mills



Order No.	Radius R	Neck Dia D3	Flute Length L1	Effective Length L3	O.A.L. L2	Shank Dia D2
BF 01006	R0.5	0.95	2	6	50	4
BF 01008	R0.5	0.95	2	8	50	4
BF 01010	R0.5	0.95	2	10	50	4
BF 01012	R0.5	0.95	2	12	50	4
BF 01508	R0.75	1.45	3	8	50	4
BF 01510	R0.75	1.45	3	10	50	4
BF 01512	R0.75	1.45	3	12	50	4
BF 01516	R0.75	1.45	3	16	50	4
BF 01520	R0.75	1.45	3	20	50	4
BF 02008	R1.0	1.92	4	8	50	4
BF 02010	R1.0	1.92	4	10	50	4
BF 02012	R1.0	1.92	4	12	50	4
BF 02016	R1.0	1.92	4	16	50	4
BF 02020	R1.0	1.92	4	20	50	4
BF 03008	R1.5	2.90	6	8	50	6
BF 03010	R1.5	2.90	6	10	50	6
BF 03012	R1.5	2.90	6	12	50	6
BF 03016	R1.5	2.90	6	16	50	6
BF 03020	R1.5	2.90	6	20	75	6
BF 03025	R1.5	2.90	6	25	75	6
BF 04012	R2.0	3.88	8	12	50	6
BF 04016	R2.0	3.88	8	16	50	6
BF 04020	R2.0	3.88	8	20	50	6
BF 04025	R2.0	3.88	8	25	75	6
BF 04030	R2.0	3.88	8	30	75	6

Recommended cutting condition for BF

MATERIAL	Alloy Steels . Tool Steels . Hardened Steels S45C, SCM, S50C, SKS, SCr, SNCM, SKD11, SKD61, NAK80				
RADIUS	EFFECTIVE LENGTH	SPEED (mm ¹)	FEED mm / min	DEPTH OF CUT H (mm)	
R0.5	6	20000 - 32000	300 - 750	0.04	
	8	20000 - 32000	300 - 750	0.03	
	10	20000 - 32000	300 - 750	0.025	
	12	20000 - 32000	300 - 750	0.015	
R0.75	8	18000 - 20000	350 - 550	0.07	
	12	18000 - 20000	350 - 550	0.04	
	16	18000 - 20000	350 - 550	0.03	
	20	18000 - 20000	350 - 550	0.02	
R1.0	8	12000 - 17000	500 - 900	0.1	
	12	12000 - 17000	500 - 900	0.1	
	16	12000 - 17000	500 - 900	0.07	
	20	12000 - 17000	500 - 900	0.04	
R1.5	8	8000 - 11000	500 - 700	0.17	
	10	8000 - 11000	500 - 700	0.15	
	16	8000 - 11000	500 - 700	0.14	
	20	8000 - 11000	500 - 700	0.12	
R2.0	25	8000 - 11000	500 - 700	0.1	
	10	5000 - 8000	400 - 600	0.18	
	15	5000 - 8000	400 - 600	0.17	
	20	5000 - 8000	400 - 600	0.16	
	25	5000 - 8000	400 - 600	0.15	
	30	5000 - 8000	400 - 600	0.14	



R<1 P<0.1R
R>1 P<0.2R



R=Radius

