

BM



unit: mm

Co
10%

Wc
90%

Dia
0.6µm

Micro Diameter / Ball Nose End Mills



Order No.	Radius	Flute Length	O.A.L.	Shank Dia
	R	L1	L2	D2
BM 0044	R0.2	0.8	50	4
BM 0054	R0.25	1.0	50	4
BM 0064	R0.3	1.2	50	4
BM 0074	R0.35	1.4	50	4
BM 0084	R0.4	1.6	50	4
BM 0094	R0.45	1.8	50	4
BM 0124	R0.6	2.4	50	4
BM 0144	R0.7	2.8	50	4
BM 0164	R0.8	3.2	50	4
BM 0184	R0.9	3.6	50	4

Dyalco CNC

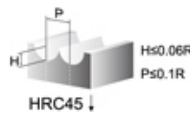
Herramientas de corte

Recommended cutting condition for BM

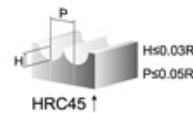
MATERIAL	Carbon Steels . Alloy Steels		Alloy Steels . Tool Steels		Hardened Steels	
	S45C, FC, FCD, SCM, S50C, SKS...		SCr, SNCM, SKD11, SKD61, NAK80...		SKD11	
HARDNESS	~HRC30		~HRC50		~HRC60	
RADIUS	SPEED (mm ⁻¹)	FEED mm / min	SPEED (mm ⁻¹)	FEED mm / min	SPEED (mm ⁻¹)	FEED mm / min
R0.1	32000	500 - 600	32000	400 - 500	25000	300 - 400
R0.15	32000	500 - 600	32000	400 - 500	25000	300 - 400
R0.2	32000	500 - 600	32000	400 - 500	25000	300 - 400
R0.25	32000	600 - 700	32000	500 - 600	25000	400 - 500
R0.3	32000	600 - 700	32000	500 - 600	25000	400 - 500
R0.35	32000	700 - 800	32000	600 - 700	25000	500 - 600
R0.4	32000	900 - 1000	32000	800 - 900	25000	600 - 700
R0.45	32000	1000 - 1100	32000	900 - 1000	25000	600 - 700



DEPTH OF CUT



HRC45 ↓



HRC45 ↑

R=Radius



Dyalco CNC

Herramientas de corte