

BLS, BLM, BLL



unit: mm

- Co 10%
- Wc 90%
- Dia 0.6µm

Long Shank / Ball Nose End Mills

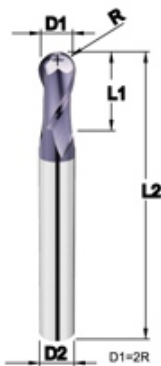


Order No.	Radius	Flute Length	O.A.L.	Shank Dia
	R	L1	L2	D2
BLS 0104	R0.5	2	75	4
BLS 0106	R0.5	2	75	6
BLS 0154	R0.75	3	75	4
BLS 0156	R0.75	3	75	6
BLS 0206	R1	4	75	6
BLS 0256	R1.25	5	75	6
BLS 0306	R1.5	6	75	6
BLS 0406	R2	8	75	6
BLS 0506	R2.5	10	75	6
BLS 0606	R3	12	75	6
BLM 0206	R1	4	100	6
BLM 0306	R1.5	6	100	6
BLM 0406	R2	8	100	6
BLM 0606	R3	12	100	6
BLM 0808	R4	16	100	8
BLM 1010	R5	20	100	10
BLM 1212	R6	24	100	12
BLL 0606	R3	12	150	6
BLL 0808	R4	16	150	8
BLL 1010	R5	20	150	10
BLL 1212	R6	24	150	12

Dyaleco CNC
Herramientas de corte

Recommended cutting condition for BLS / BLM / BLL

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
R0.5	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
R3	8000	1100	6000	700	3500	300
R4	6000	1200	5000	800	2500	350
R5	5000	1100	4000	800	2000	350
R6	4000	1000	3000	700	1500	300
R8	3000	1000	2000	700	1000	300

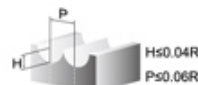


DEPTH OF CUT



R=Radius

HRC45 ↓



HRC45 ↑



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Herramientas de corte