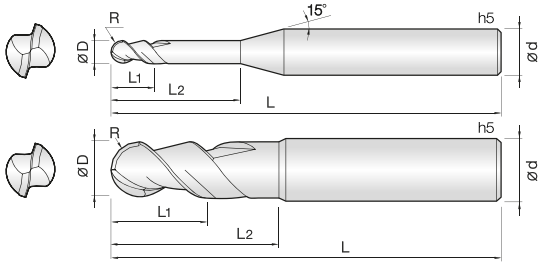
2COB

2 Flutes 45 ° Helix Rib Ball End Mills for Copper

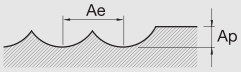


0.25 ~ 2.5R 3R ~ 6R 8R

D Size	D Tolerance
ø0.5 ~ 5	+0 ~ −0.01 mm
ø6 ~ 12	−0.005 ~ −0.015 mm
ø16	−0.01 ~ −0.02 mm

2COB Cutting Condition

• RPM : rev./min • Feed : mm/min

Material	Copper Alloys							
Corner Radius	$\alpha \leqq 15°$				$\alpha > 15°$			
	RPM	FEED	Ap Axial Depth	Ae Radial Depth	RPM	FEED	Ap Axial Depth	Ae Radial Depth
R 0.5	40,000	8,000	0.06	0.1	40,000	3,200	0.06	0.1
R 0.75	40,000	9,600	0.09	0.15	40,000	4,000	0.09	0.15
R 1	40,000	9,600	0.11	0.2	39,000	4,700	0.11	0.2
R 1.5	40,000	12,000	0.12	0.3	30,000	4,500	0.12	0.3
R 2	40,000	12,000	0.13	0.4	27,000	4,300	0.13	0.4
R 2.5	32,000	11,000	0.15	0.5	20,000	3,600	0.15	0.5
R 3	25,000	9,000	0.2	0.6	16,000	2,900	0.2	0.6
R 4	21,000	8,400	0.25	0.8	13,000	2,600	0.25	0.8
R 5	16,000	6,400	0.3	1	10,000	2,000	0.3	1
R 6	13,000	5,200	0.5	1.2	8,000	1,700	0.5	1.2
R 8	9,000	3,600	0.5	1.6	6,000	1,300	0.5	1.6
Depth of Cut								

- α value represents a slope of workpiece.
- If the effective length is long, reduce the RPM and feed in the same proportion.
- Using Water-soluble oil is recommended for smooth chip emission.
- If the parameters exceed the maximum RPM and feed of your machine, reduce the RPM and feed in the same proportion.