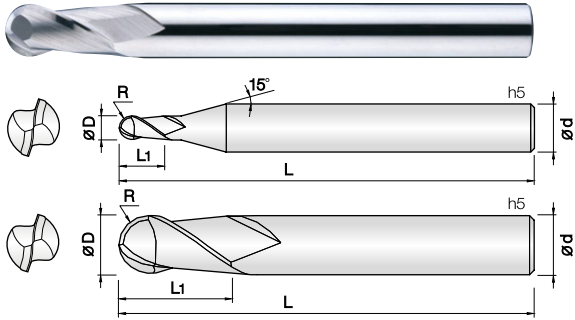


# 2MBE

## 2 Flutes Ball End Mills



D Size	D Tolerance
Ø0.1 ~ 0.15	+0 ~ -0.005 mm
Ø0.2 ~ 5	+0 ~ -0.01 mm
Ø6 ~ 12	-0.005 ~ -0.015 mm

## 2MBE / 3MBE

■ 3MBE  
 ■ Raise up the RPM and feed by 10% for 3MBE.

•RPM: rev./min •Feed: mm/min

Material	Carbon Steels				Alloy Steels				Prehardened Steels			
	Corner Radius	RPM	FEED	Ap Axial Depth	Ae Radial Depth	RPM	FEED	Ap Axial Depth	Ae Radial Depth	RPM	FEED	Ap Axial Depth
R 0.2	36,000	630	0.02	0.04	34,200	520	0.02	0.04	33,174	400	0.02	0.04
R 0.3	24,300	630	0.03	0.06	23,085	520	0.03	0.06	22,392	400	0.03	0.06
R 0.4	21,000	630	0.04	0.08	19,950	520	0.04	0.08	19,352	400	0.04	0.08
R 0.5	12,000	630	0.05	0.10	12,300	520	0.1	0.10	10,179	400	0.05	0.10
R 1	11,400	630	0.10	0.20	10,000	520	0.1	0.20	8,700	400	0.10	0.20
R 1.5	7,700	630	0.15	0.30	6,700	520	0.2	0.30	5,800	400	0.15	0.30
R 2	5,800	630	0.20	0.40	5,000	520	0.2	0.40	4,300	400	0.20	0.40
R 3	3,800	630	0.30	0.60	3,300	520	0.3	0.60	2,900	400	0.30	0.60
R 4	2,900	630	0.40	0.80	2,500	520	0.4	0.80	2,200	400	0.40	0.80
R 5	2,300	630	0.50	1.00	2,000	520	0.5	1.00	1,700	400	0.50	1.00
R 6	1,900	630	0.60	1.20	1,700	520	0.6	1.20	1,400	400	0.60	1.20

Depth of Cut	
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- The parameters on the table is based on 2 flutes. For using 3 flutes, use the same RPM and raise up the feed up to 10% in stable milling condition.
- Below 0.5mm of front diameter tool, set up the lower RPM
- Use this table for your reference. Adjust the parameters depending on your machining geometry, machining purpose and CNC.
- If the table over the maximum RPM and feed of your machine, adjust RPM and feed in the same proportion.