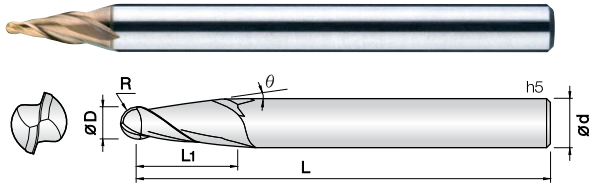




2 Flutes Taper Ball End Mills

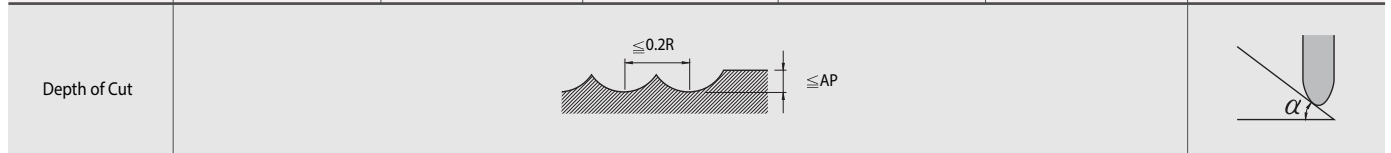


D Size	D Tolerance
Ø0.4 ~ 3	-0.01 ~ -0.025 mm
Ø3 ~ 6	-0.015 ~ -0.03 mm

2CTB Cutting Condition

• RPM: rev./min • Feed: mm/min

Material	Alloy/ Tools Steels/ Prehardened Steels						Hardened Steels					
	30 ~ 45HRC						45 ~ 55HRC					
	$\alpha \leq 15^\circ$		$\alpha > 15^\circ$		Ap	Ae	$\alpha \leq 15^\circ$		$\alpha > 15^\circ$		Ap	Ae
Radius	RPM	FEED	RPM	FEED	Ap Axial Depth	Ae Radial Depth	RPM	FEED	RPM	FEED	Ap Axial Depth	Ae Radial Depth
R0.5	40,000	5,600	40,000	3,200	0.06	0.1	40,000	5,600	40,000	3,000	0.05	0.1
R0.75	40,000	6,500	40,000	4,000	0.09	0.15	40,000	6,500	32,000	3,200	0.08	0.15
R1	40,000	6,500	39,000	4,700	0.11	0.2	40,000	6,500	31,000	3,500	0.11	0.2
R1.25	40,000	7,000	30,000	4,500	0.12	0.25	36,000	6,500	26,000	3,500	0.12	0.25
R1.5	40,000	7,500	27,000	4,300	0.13	0.3	32,000	6,000	22,000	3,400	0.13	0.3
R2	32,000	7,500	20,000	3,600	0.15	0.4	25,000	6,000	16,000	2,700	0.15	0.4
R2.5	25,000	6,000	16,000	2,900	0.2	0.5	20,000	5,400	13,000	2,300	0.2	0.5
R3	21,000	5,800	13,000	2,600	0.25	0.6	17,000	4,700	10,000	2,000	0.25	0.6
R4	16,000	4,500	10,000	2,000	0.3	0.8	13,000	3,600	8,000	1,500	0.3	0.8
R5	13,000	3,600	8,000	1,700	0.5	1	10,000	2,900	6,400	1,200	0.5	1
R6	9,000	2,500	6,000	1,300	0.5	1.2	7,200	2,000	4,800	1,000	0.5	1.2



- α value represents the inclined angle.
- Consider the RPM and feed based on the taper angle and adjust it with milling condition.
- Air blow or mist coolant is recommended.
- Use this table for your reference. Adjust the parameters depending on your machining geometry, machining purpose and CNC.
- During the chip evacuation, note for heat and ignition.