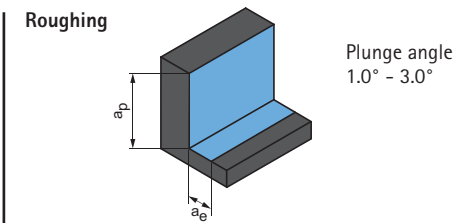


Cutting data recommendations for ball nose milling cutters

Feed and cutting speed



OptiMill-3D-BN-Graphite-MT | MBN112

MMG*			Workpiece material		Strength/hardness [N/mm²] [HRC]	Cooling				a _p [mm]	a _e [mm]	v _c [m/min]	f _z [mm]						
													Diameter of milling cutter [mm]						
						Dry	Air/MQL	KSS					4.00	5.00	6.00	8.00	10.00	12.00	16.00
N	N3	N3.1	Graphite, > 8 µm		✓	✓	✓		1xD	0.2xD	500-600	0.250	0.280	0.300	0.350	0.380	0.400	0.450	
		N3.2	Graphite, ≤ 8 µm		✓	✓	✓		1xD	0.2xD	400-500	0.250	0.280	0.300	0.350	0.380	0.400	0.450	

* MAPAL machining groups

The specified machining values are guide values.
The optimum data for the respective machining task should be determined during the test or machining.