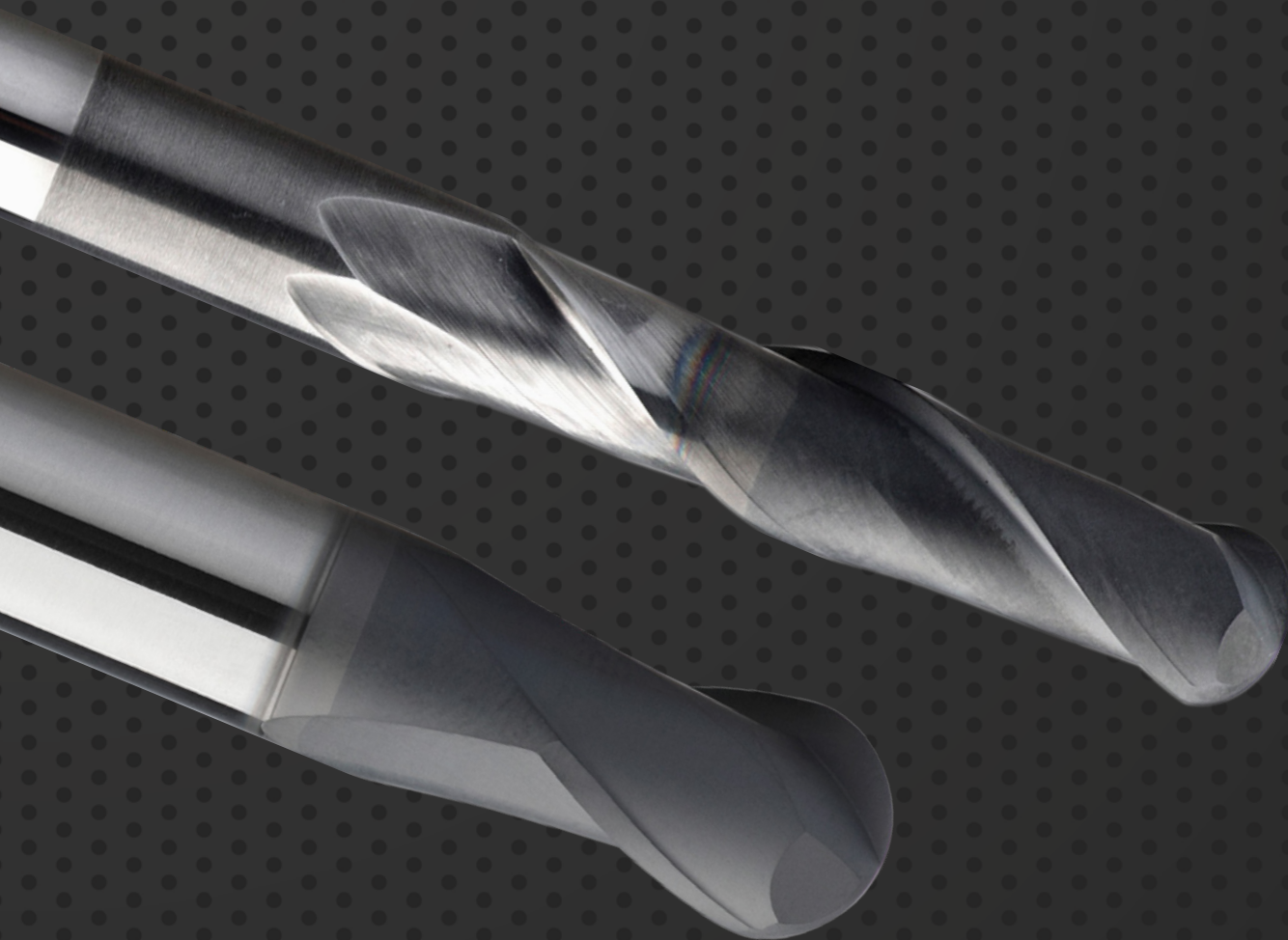




BALLNOSE

BN GR

Diamond coated end mills special for machining graphite and composite reinforced plastic fiber glass (CRP)

Index - BN GR, For Thermoplastic & Graphite

 Suitable for Material Groups
  Adapté pour les matériaux
  适用于材料
 Geeignet für die Materialgruppen
  Adatto per il materiale

o

EDP Number	Type	No. Z	Helix Angle	Coating	Performance	Page Number
754 	BN GR	2	30°	DCT01	G	437
756 	BN GR Long	2	30°	DCT01	G	438
B85 	BN GR Extra-Long	2	30°	DCT01	G	439

G - General P - Performance

BN GR BALLNOSE CUTTERS, 2 FLUTES

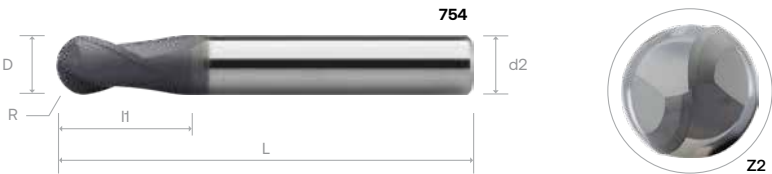
- 

VHM BN GR Radiusschaftfräser, 2 Zähne, DIAMANT bzw. DLC beschichtet zur Bearbeitung von Grafit
- 

Frese sferiche BN GR, 2 taglienti, diamantate per lavorazioni in grafite
- 

Fraises BN GR standard à bout hémisphérique, 2 dents, diamanté pour usinage de graphite
- 

整体硬质合金 BN GR 系列 DLC 钻石涂层2刃石墨球头铣刀



Order Number	Dimension (mm)						DCT01
	D	R	l1	l2	L	d2 (h6)	
754 0100 040 03	1	0.5	3		40	3	•
754 0150 040 03	1.5	0.75			40	3	•
754 0200 040 03	2	1	4		40	3	◦
754 0250 040 03	2.5	1.25			40	3	◦
754 0300	3	1.5	5		40	3	•
754 0400	4	2	8		50	4	•
754 0600	6	3	10		60	6	•
754 0800	8	4	12		64	8	•
754 1000	10	5	14		70	10	•
754 1200	12	6	16		75	12	•

Material Group | Material-Gruppe | Groupe Matiere | Gruppo Materiali | 材质主类

Cutting Parameter

N01	N02	N03	K01	K02	P01	P02	P03	M01	M02	S01	S02	S03	H01	H02	O01	O02	440
-----	-----	-----	-----	-----	-----	-----	-----	-----	-----	-----	-----	-----	-----	-----	-----	-----	-----



BN GR BALLNOSE CUTTERS WITH LONG NECK, 2 FLUTES

🇩🇪 VHM BN GR Radiusschaftfräser 2 Zähne, mit Freistellung, DIAMANT bzw. DLC beschichtet, zur Bearbeitung von Graphit

🇮🇹 Frese sferiche lunghe BN GR, con codolo ridotto, 2 taglienti, diamantate per lavorazioni in grafite

🇫🇷 Fraises BN GR à bout hémisphérique, 2 dents, diamanté pour usinage de graphite

🇨🇳 整体硬质合金 BN GR 系列 DLC 钻石涂层2刃长型长颈石墨球头铣刀



Order Number	Dimension (mm)							DCT01
	D	R	I1	I2	L	d1	d2 (h6)	
756 0050 050 0300 060	0.5	0.25	1	6	50	0.45	3	•
756 0050 050 0300 080				8	50	0.45	3	•
756 0060 050 0300 060				6	50	0.55	3	•
756 0060 050 0300 080	0.6	0.3	1.2	8	50	0.55	3	•
756 0060 050 0300 100				10	50	0.55	3	•
756 0080 050 0300 080				8	50	0.75	3	•
756 0080 050 0300 100	0.8	0.4	1.6	10	50	0.75	3	•
756 0080 050 0300 120				12	50	0.75	3	•
756 0100 060 0300 100				10	60	0.9	3	•
756 0100 060 0300 120	1	0.5	3	12	60	0.9	3	•
756 0100 060 0300 160				16	60	0.9	3	•
756 0100 060 0400 100				10	60	0.9	4	•
756 0100 060 0400 120				12	60	0.9	4	•
756 0100 060 0400 160				16	60	0.9	4	•
756 0150 060 0300 100	1.5	0.75	3	10	60	1.4	3	◦
756 0150 060 0300 160				16	60	1.4	3	•
756 0150 060 0300 180				18	60	1.4	3	◦
756 0150 060 0300 200				20	60	1.4	3	◦
756 0150 060 0400 100				10	60	1.4	4	•
756 0150 060 0400 160				16	60	1.4	4	•
756 0150 060 0400 180				18	60	1.4	4	•
756 0150 060 0400 200	2	1	4	20	60	1.4	4	•
756 0200 060 0300 100				10	60	1.9	3	•
756 0200 060 0300 160				16	60	1.9	3	•
756 0200 060 0300 200				20	60	1.9	3	•
756 0200 060 0400 100				10	50	1.9	4	•
756 0200 060 0400 160	3	1.5	5	16	50	1.9	4	•
756 0200 060 0400 200				20	60	1.9	4	•
756 0300 075 03					75		3	•
756 0300 075 0400 150				15	75	2.8	4	•
756 0300 075 0400 300				30	75	2.8	4	•
756 0400 075 04	4	2	6		75		4	◦
756 0400 100 04			8		100		4	•
756 0600 075 06	6	3	10		75		6	•
756 0600 100 06					100		6	•
756 0800 100 08	8	4	12		100		8	•
756 0800 150 08					150		8	•
756 1000 100 10	10	5	14		100		10	•
756 1000 150 10					150		10	◦
756 1200 100 12					100		12	•
756 1200 150 12	12	6	16		150		12	◦

Material Group | Material-Gruppe | Groupe Matière | Gruppo Materiali | 材质主类

Cutting Parameter

N01	N02	N03	K01	K02	P01	P02	P03	M01	M02	S01	S02	S03	H01	H02	O01	O02	440
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BN GR EXTRA-LONG BALLNOSE CUTTERS, 2 FLUTES

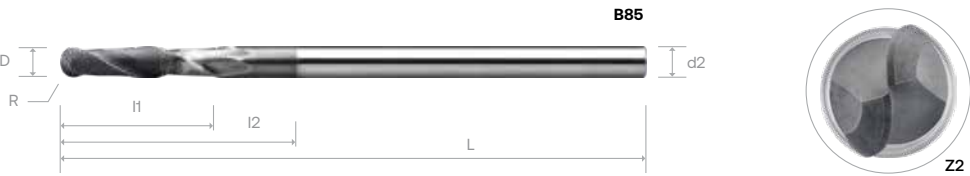
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VHM BN GR Radiusschaftfräser, extra-lang, 2 Zähne, DIAMANT bzw. DLC beschichtet, zur Bearbeitung von Grafit
- 

Frese sferiche extra-lunghe tipo BN GR, 2 taglienti, diamantate per lavorazioni in grafite
- 

Fraises BN GR extra-longues à bout hémisphérique, 2 dents, diamanté pour usinage de graphite
- 

整体硬质合金 BN GR 系列 DLC 钻石涂层2刃加长型石墨球头铣刀



Order Number	Dimension (mm)						DCT01
	D	R	l1	l2	L	d2 (h6)	
B85 0200 080 03	2	1	10	20	80	3	•
B85 0300 080 03	3	1.5	15	25	80	3	•
B85 0400	4	2	20	30	100	4	•
B85 0500	5	2.5	30	50	120	5	•
B85 0600	6	3		50	150	6	•
B85 0800	8	4	40	60	150	8	•

Material Group | Material-Gruppe | Groupe Matiere | Gruppo Materiali | 材质主类

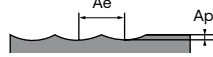
Cutting Parameter

N01	N02	N03	K01	K02	P01	P02	P03	M01	M02	S01	S02	S03	H01	H02	O01	O02	440
-----	-----	-----	-----	-----	-----	-----	-----	-----	-----	-----	-----	-----	-----	-----	-----	-----	-----

Note: These recommended cutting data indicators are just for reference. They should be adjusted according to the different cutting condition

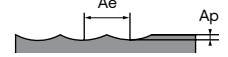


BN GR Ballnose Cutters, 2 Flutes - 754



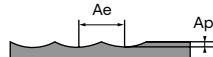
Roughing		
O		
Working Material	Graphite	
Properties	-	
Cutting depth, ap	$0.10 \times D$	
Cutting Width, ae	$0.30 \times D$	
D	Vc	Fz
1	280	0.007
2		0.015
3		0.025
4		0.034
6		0.052
8		0.071
10		0.090
12		0.109

BN GR Ballnose Cutters, 2 Flutes - 754



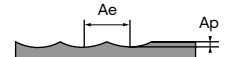
Finishing		
O		
Working Material	Graphite	
Properties	-	
Cutting depth, ap	$0.05 \times D$	
Cutting Width, ae	$0.02 \times D$	
D	Vc	Fz
1	300	0.005
2		0.011
3		0.018
4		0.026
6		0.040
8		0.054
10		0.068
12		0.082

BN GR Ballnose Cutters with Long Neck, 2 Flutes - 756



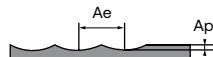
Roughing		
O		
Working Material	Graphite	
Properties	-	
Cutting depth, ap	$0.10 \times D$	
Cutting Width, ae	$0.15 \times D$	
D	Vc	Fz
1	210	0.004
2		0.013
3		0.022
4		0.030
6		0.046
8		0.063
10		0.081
12		0.098

BN GR Ballnose Cutters with Long Neck, 2 Flutes - 756



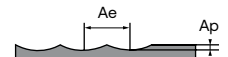
Finishing		
O		
Working Material	Graphite	
Properties	-	
Cutting depth, ap	$0.05 \times D$	
Cutting Width, ae	$0.02 \times D$	
D	Vc	Fz
1	230	0.002
2		0.011
3		0.019
4		0.026
6		0.040
8		0.055
10		0.070
12		0.085

BN GR Extra- Long Ballnose Cutters, 2 Flutes - B85



Roughing		
O		
Working Material	Graphite	
Properties	-	
Cutting depth, ap	$0.10 \times D$	
Cutting Width, ae	$0.30 \times D$	
D	Vc	Fz
2	240	0.011
3		0.025
4		0.035
5		0.045
6		0.055
8		0.075

BN GR Extra- Long Ballnose Cutters, 2 Flutes - B85



Finishing		
O		
Working Material	Graphite	
Properties	-	
Cutting depth, ap	$0.05 \times D$	
Cutting Width, ae	$0.02 \times D$	
D	Vc	Fz
2	260	0.009
3		0.020
4		0.028
5		0.037
6		0.047
8		0.065