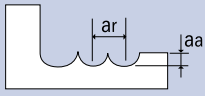




List 7230: Ball End, Long Reach, 2 & 4 Flute

List 7231: Ball End, Regular Length, 2 & 4 Flute, Long Reach

Side Milling

Work Material	Graphite											
Cutting Speed	160-300 SFM											
Depth of Cut	<table border="1"> <thead> <tr> <th>Dia</th> <th>a_a</th> <th>a_r</th> </tr> </thead> <tbody> <tr> <td>D ≤ 1/8</td> <td>0.02D</td> <td>0.05D</td> </tr> <tr> <td>D > 1/8</td> <td>0.10D</td> <td>0.20D</td> </tr> </tbody> </table> 			Dia	a _a	a _r	D ≤ 1/8	0.02D	0.05D	D > 1/8	0.10D	0.20D
Dia	a _a	a _r										
D ≤ 1/8	0.02D	0.05D										
D > 1/8	0.10D	0.20D										
Mill Dia.	Style	Speed RPM	Feed in/tooth									
1/64	Regular	25,000	0.0002-0.0005									
1/64	Long	25,000	0.0001-0.0003									
1/32	Regular	25,000	0.0005-0.0010									
1/32	Long	25,000	0.0003-0.0007									
1/16	Regular	14,000	0.0010-0.0020									
1/16	Long	13,700	0.0006-0.0012									
3/32	Regular	9,500	0.0010-0.0020									
3/32	Long	9,300	0.0006-0.0012									
1/8	Regular	7,000	0.0010-0.0020									
1/8	Long	6,850	0.0006-0.0012									
3/16	Regular	4,700	0.0010-0.0020									
3/16	Long	4,600	0.0006-0.0012									
1/4	Regular	3,500	0.0020-0.0040									
1/4	Long	3,430	0.0012-0.0024									

1. Please reduce speed and feed by 20% when L/D > 3D.
2. Please reduce speed and feed by 30% when slotting > 0.5D.
3. Please reduce depth of cut if running at elevated speed and feed.

