



## List 9192: 2 Flute, Ball End, Super Long Neck, CBN, Stub Length

### Standard Milling

Hardness	30-45 HRC		45-55 HRC		55-60 HRC		60-68 HRC	
Work Material	Hardened Steels Pre-hardened Steels		Hardened Steels					
Depth of Cut	$a_a=0.015D$ $a_r=0.04D$						$a_a=0.01D$ $a_r=0.03D$	
Mill Dia. (mm)	Speed RPM	Feed in/min	Speed RPM	Feed in/min	Speed RPM	Feed in/min	Speed RPM	Feed in/min
0.4	25,000	39.4	25,000	39.4	25,000	39.4	25,000	39.4
0.6	25,000	39.4	25,000	39.4	25,000	39.4	25,000	39.4
1.0	25,000	59.1	25,000	59.1	25,000	59.1	25,000	59.1
2.0	25,000	78.8	25,000	78.8	25,000	78.8	25,000	76.9
3.0	25,000	78.4	25,000	78.4	25,000	78.0	21,500	66.9

1. Use a rigid and precise machine and holder.
2. We suggest using air blow or MQL (mist).
3. When using low speed machines, use the maximum speed and adjust feed rate.
4. During heavy load operations such as corner processing, reduce the speed and feed.
5. The run out of the end mill should be within 10 microns (.0004") after chucking.

