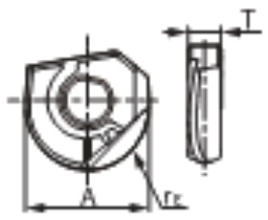
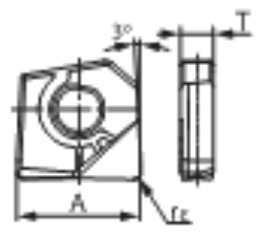
GEOMETRY AND CUTTING CONDITIONS - BALL FINISH NOSE

BALL FINOSE

ZFBM080R00-MJ - A = 8,0mm T = 2,4mm rε = 4,0mm
ZFBM100R00-MJ - A = 10,0mm T = 2,9mm rε = 5,0mm
ZFBM120R00-MJ - A = 12,0mm T = 3,4mm rε = 6,0mm
ZFBM160R00-MJ - A = 16,0mm T = 4,4mm rε = 8,0mm
ZFBM200R00-MJ - A = 20,0mm T = 5,4mm rε = 10,0mm
ZFBM250R00-MJ - A = 25,0mm T = 6,4mm rε = 12,5mm



ZFRM120R05-MJ - A = 12,0mm T = 3,4mm rε = 0,5mm
ZFRM120R10-MJ - A = 12,0mm T = 3,4mm rε = 1,0mm
ZFRM160R05-MJ - A = 16,0mm T = 4,4mm rε = 0,5mm
ZFRM160R10-MJ - A = 16,0mm T = 4,4mm rε = 1,0mm
ZFRM200R10-MJ - A = 20,0mm T = 5,4mm rε = 1,0mm
ZFRM200R15-MJ - A = 20,0mm T = 5,4mm rε = 1,5mm



			Description	Grade	Tech. Code	P <500 N/mm²	P <850 N/mm²	P <1200 N/mm²	M <600 N/mm²	M <850 N/mm²	K <240 HB	K <300 HB	N Alu	S HTA	H <60 HRC
MEDIUM CUTTING	MJ		ZFBM080R00-MJ	AH710	B6C05MJ0805	○	●	●			●	●			●
				AH725	B6C05MJ0806	●	●	●		○	○				□
			ZFBM100R00-MJ	AH710	B6C05MJ1007	○	●	●			●	●			●
				AH725	B6C05MJ1008	●	●	●		○	○				○
			ZFBM120R00-MJ	AH710	B6C05MJ1209	○	●	●			●	●			●
				AH725	B6C05MJ1210	●	●	●		○	○				□
			ZFBM160R00-MJ	AH710	B6C05MJ1611	○	●	●			●	●			●
				AH725	B6C05MJ1612	●	●	●		○	○				○
			ZFBM200R00-MJ	AH710	B6C05MJ2013	○	●	●			●	●			●
				AH725	B6C05MJ2014	●	●	●		○	○				○
			ZFBM250R00-MJ	AH710	B6C05MJ2515	○	●	●			●	●			●
				AH725	B6C05MJ2516	●	●	●		○	○				○
			ZFRM120R05-MJ	AH710	B6C10MJ1205	○	●	●			●	●			●
				AH725	B6C10MJ1206	●	●	●	○		○				○
			ZFRM120R10-MJ	AH710	B6C10MJ1207	○	●	●			●	●			●
				AH725	B6C10MJ1208	●	●	●	○		○				○
			ZFRM160R05-MJ	AH710	B6C10MJ1609	○	●	●			●	●			●
				AH725	B6C10MJ1610	●	●	●	○		○				○
			ZFRM160R10-MJ	AH710	B6C10MJ1611	○	●	●			●	●			●
				AH725	B6C10MJ1612	●	●	●	○		○				○
			ZFRM160R15-MJ	AH710	B6C10MJ1613	○	●	●			●	●			●
				AH725	B6C10MJ1614	●	●	●	○		○				○
			ZFRM200R10-MJ	AH710	B6C10MJ2015	○	●	●			●	●			●
				AH725	B6C10MJ2016	●	●	●	○		○				□
			ZFRM200R15-MJ	AH710	B6C10MJ2017	○	●	●			●	●			●
				AH725	B6C10MJ2018	●	●	●	○		○				○

● RECOMMENDED FOR... ○ USABLE FOR...

RECOMMENDED CUTTING DATA

Material	Hardness Brinnel HB	Recommended grades	Cutting speed VC (m/min)	SIDE SLOTS Cutting speed	SIDE SLOTS Feed
Low carbon content steels (C15 etc.)	~ 200	AH725 - GH130	180 ~ 260	110 ~ 140	0,05 - 0,15
Carbon steels (C45-C55 etc.)	200 ~ 300	AH725 - GH130	150 ~ 230	100 ~ 120	0,05 - 0,15
Alloyed steel (42CRMo4, 17Cr3 etc.)	150 ~ 300	AH725 - GH130	180 ~ 300	100 120	0,05 - 0,15
Stainless steels (ex. X5CrNi 18-9, etc.)	-	AH725 - GH130	100 ~ 250	60 ~ 120	0,03 - 0,12
Cast irons (GG25, GG30 etc.)	150 ~ 200	AH725 - GH130	90 ~ 350	90~ 160	0,03 - 0,12
Spheroidal cast irons (GGG40 etc)	150 ~ 200	AH725 - GH130	90 ~ 350	90 ~ 160	0,03 - 0,12
Aluminium alloys (Si<13%)	-	AH725 - GH130	200 ~ 400	700 ~ 900	0,05 - 0,15

Indivisible package ◒ Suggested retail package - Unit price