

2UEBS

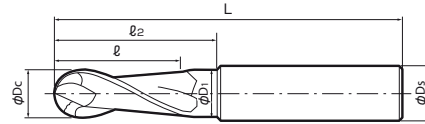
Number of Flutes: 2

Copying (Ball-nose end mill with 2 flutes)



Recommended Material

★ 1st Recommendation



Lineup

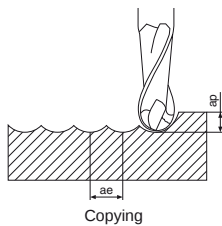
(Unit: mm)

Description	Std.	Radius of Ball Nose	Outside Dia.	Outside Dia. tolerance	Edge Length	Neck Dia.	Under Neck Length	Shank Dia.	Total length	Number of Flutes
		R	øDc		ℓ	øD1	ℓ2	øDs	L	Z
2UEBS010-030-04	●	R0.5	1	-0.014 -0.028	3	-	-	4	50	2
2UEBS020-030-04	●	R1	2	-0.014 -0.028	3	-	-	4	50	2
2UEBS030-095-06	●	R1.5	3	-0.014 -0.028	9.5	-	-	6	58	2
2UEBS040-120-06	●	R2	4	-0.020 -0.038	12	-	-	6	76	2
2UEBS050-140-06	●	R2.5	5	-0.020 -0.038	14	-	-	6	76	2
2UEBS060-160-06	●	R3	6	-0.020 -0.038	16	5.5	40	6	100	2
2UEBS080-200-08	●	R4	8	-0.025 -0.047	20	7.5	40	8	100	2
2UEBS100-220-10	●	R5	10	-0.025 -0.047	22	9.5	35	10	100	2
2UEBS120-250-12	●	R6	12	-0.032 -0.059	25	11.5	50	12	125	2
2UEBS160-320-16	●	R8	16	-0.032 -0.059	32	15.5	60	16	150	2
2UEBS200-380-20	●	R10	20	-0.040 -0.073	38	19.5	60	20	150	2

* Actual ball-nose radius will be half of actual measurement of outer diameter.

● Ball-nose end mill with two flutes.

Recommended Cutting Conditions



Workpiece Materials		Depth of Cut (ap×ae) (mm)	Outside Dia. (mm)	ø4	ø6	ø8	ø10	ø12	ø16	ø20
Steel	< 42HRC	0.3Dc×0.7Dc	Spindle Revolution (min ⁻¹)	9,600	6,400	4,800	3,800	3,200	2,400	1,900
			Feed Rate (mm/min)	380	420	380	380	340	300	310
	42~48HRC	0.3Dc×0.7Dc	Spindle Revolution (min ⁻¹)	8,000	5,300	4,000	3,200	2,700	2,000	1,600
			Feed Rate (mm/min)	300	330	300	290	270	240	240
	48~52HRC	0.3Dc×0.7Dc	Spindle Revolution (min ⁻¹)	6,400	4,200	3,200	2,500	2,100	1,600	1,300
			Feed Rate (mm/min)	190	210	190	190	170	150	150
Cast Iron	< 180HB	0.3Dc×0.7Dc	Spindle Revolution (min ⁻¹)	12,700	8,500	6,400	5,100	4,200	3,200	2,500
			Feed Rate (mm/min)	760	850	760	750	690	610	610
	> 180HB	0.3Dc×0.7Dc	Spindle Revolution (min ⁻¹)	11,100	7,400	5,600	4,500	3,700	2,800	2,200
			Feed Rate (mm/min)	540	590	540	530	480	420	430

● : Std. Item ○ : Check Availability R : Std. Item (R-hand Only) L : Std. Item (L-hand Only)

