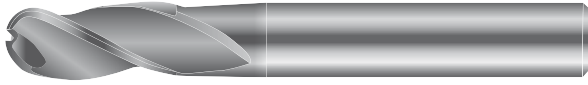


3UEBS

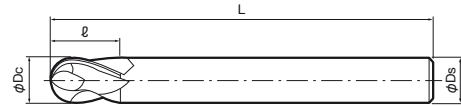
Number of Flutes: 3

Copying (Ball-nose end mill with 3 flutes)



Recommended Material

★ 1st Recommendation



Lineup

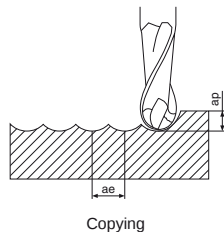
(Unit: mm)

Description	Std.	Radius of Ball Nose	External	Mill Dia. tolerance	Edge Length	Shank Dia.	Total length	Number of Flutes
		R	øDc		ℓ	øDs	L	Z
3UEBS030-070-06	●	R1.5	3	-0.014 -0.028	7	6	57	3
3UEBS040-080-06	●	R2	4	-0.020 -0.038	8	6	57	3
3UEBS050-100-06	●	R2.5	5	-0.020 -0.038	10	6	57	3
3UEBS060-100-06	●	R3	6	-0.020 -0.038	10	6	57	3
3UEBS080-160-08	●	R4	8	-0.025 -0.047	16	8	63	3
3UEBS100-190-10	●	R5	10	-0.025 -0.047	19	10	72	3
3UEBS120-220-12	●	R6	12	-0.032 -0.059	22	12	83	3

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

- Ball-nose end mill with well-balanced three flutes. Also applicable for difficult-to-cut materials.

Recommended Cutting Conditions



Copying

Workpiece Materials	Depth of Cut (ap×ae) (mm)	Outside Dia. (mm)	ø3	ø4	ø5	ø6	ø8	ø10	ø12
Carbon Steel < 20HRC	0.2Dc×0.3Dc	Spindle Revolution (min ⁻¹)	13,300	10,000	8,000	6,600	5,000	4,000	3,300
		Feed Rate (mm/min)	600	870	840	850	1,400	1,200	990
Alloy Steel < 35HRC	0.2Dc×0.3Dc	Spindle Revolution (min ⁻¹)	10,600	8,000	6,400	5,300	4,000	3,200	2,700
		Feed Rate (mm/min)	410	500	610	640	940	830	730
Pre-hardened Steel 30~45HRC	0.1Dc×0.2Dc	Spindle Revolution (min ⁻¹)	7,400	5,600	4,500	3,700	2,800	2,200	1,900
		Feed Rate (mm/min)	220	250	257	280	250	240	230
Stainless Steel	0.05.0Dc×0.1Dc	Spindle Revolution (min ⁻¹)	5,800	4,400	3,500	2,900	2,200	1,800	1,500
		Feed Rate (mm/min)	160	180	190	180	190	190	170

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