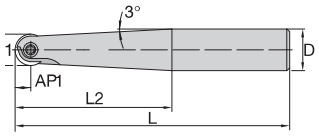
Ball Nose Finisher — End Mills

NEW!

- Cutting diameter ranges from .313" to 1.250".
- Ball nose finishers for 3-dimensional milling applications.
- Enables productive, precise, and economical machining.



Tapered End Mills — Steel Shank

D1	order number	catalog number	Z	Z U	D	L2	L	Ap1 max	Max Ramp Angle	lbs.	insert screw	Torx wrench
.313	2878444	KDMB0312R551A031ST	1	2	.500	1.970	5.510	.156	3.0°	.25	193.395	KT8
.375	2878445	KDMB0375R591A038ST	1	2	.500	1.380	5.910	.188	3.0°	.29	193.394	KT15
.500	2878446	KDMB0500R630A050ST	1	2	.625	2.360	6.300	.250	3.0°	.47	193.393	KT20
.625	2878447	KDMB0625R689A063ST	1	2	.750	2.640	6.890	.313	3.0°	.76	193.392	KT20
.750	2878448	KDMB0750R748A075ST	1	2	1.000	3.150	7.480	.375	3.0°	1.41	193.391	KT20
1.000	2878449	KDMB1000R827A100ST	1	2	1.250	3.940	8.270	.500	3.0°	2.45	193.390	KT30
1.250	2878450	KDMB1250R945A125ST	1	2	1.500	4.840	9.450	.625	3.0°	3.82	193.389	KT30

Maximum speed capability up to 20,000 RPM.

Recommended Starting Speeds (sfm)

Semi-finish and Finishing Tools - Ball Nose only (KDMB)

Material Group	K115M			KC515M			KC530M		
P1				900	**800**	700	750	**650**	550
P2				850	**750**	650	650	**550**	450
P3				750	**650**	550	550	**500**	450
P4				650	**550**	450	500	**450**	400
P5				550	**450**	350	450	**400**	350
P6				450	**350**	300	350	**300**	250
M1				900	**750**	650	750	**600**	500
M2				750	**600**	450	500	**400**	350
M3				600	**500**	400	400	**350**	300
K1	600	**500**	400	1200	**900**	600			
K2	500	**400**	300	900	**700**	500			
K3	300	**250**	200	400	**300**	200			
N1	1200	**900**	600						
N2	800	**600**	500						
S1									
S2									
S3									
S4									
H1				300	**200**	150			

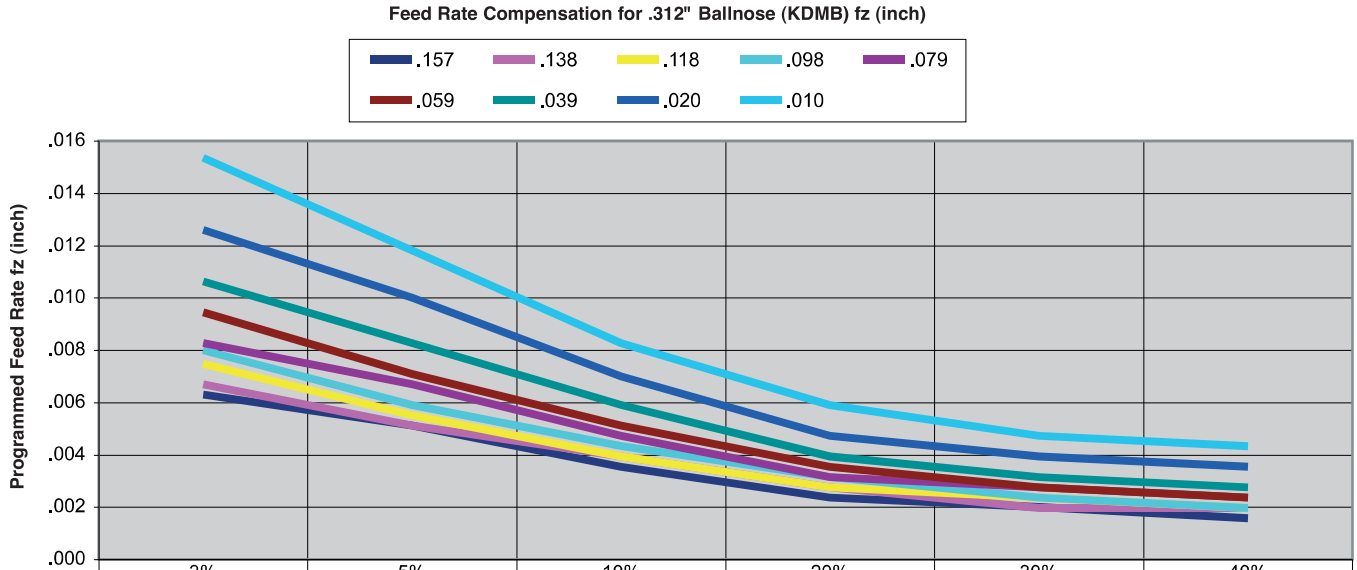
FIRST choice starting speeds are in bold type.
As the average chip thickness goes higher the speed should be decreased.

Ordering Example:
1 x KDMB0500R630A050ST
10 x KDMB0500MOERGC KC515M

Recommended Starting Feeds

KDMB Ball Nose - .313"

Semi-Finish - Finishing only



	3%	5%	10%	20%	30%	40%
.157	.006	.005	.004	.002	.002	.002
.138	.007	.005	.004	.003	.002	.002
.118	.007	.006	.004	.003	.002	.002
.098	.008	.006	.004	.003	.002	.002
.079	.008	.007	.005	.003	.003	.002
.059	.009	.007	.005	.004	.003	.002
.039	.011	.008	.006	.004	.003	.003
.020	.013	.010	.007	.005	.004	.004
.010	.015	.012	.008	.006	.005	.004

Percentage of the Cutter Diameter in Cut

KDMB Ball Nose - .312"

	Axial depth of cut for .312" Ø								
	.157	.138	.118	.098	.079	.059	.039	.020	.010
	Working Diameter (inch)								
Working Diameter	.315	.313	.305	.292	.273	.246	.208	.152	.109