

MEGAMILL BALL APPLICATION DATA

 MATERIALS SPEEDS FEED RATES	CAST IRON FONTES FUNCTION		STEELS ACIERS ACEROS			STAINLESS STEELS ACIERS INOXIDABLE ACEROS INOXIDABLE		NICKEL BASED ALLOYS	TITANIUM	ALUMINUM ALUMINIO
	GREY GRIS	NUDULAR	LOW CARBON up to: 240 BHN 80 Kg / mm ²	HIGH CARBON MEDIUM TENSILE 240-300 BHN up to 105 Kg / mm ²	HIGH ALLOY TOOL STEEL 300-400 BHN 105-140 Kg / mm ²	300 SERIES 304, 316	400 SERIES 15-5 PH 17-4 PH	INCONEL WASPALLOY HASTALLOY	6AL 4 V	6061 T6 7075 T6
	500-1000 SFM 150-300 M/min	400-600 SFM 120-240 M/min	500-1000 SFM 150-300 M/min	400-600 SFM 120-240 M/min	300-600 SFM 90-180 M/min	300-700 SFM 90-210 M/min	400-600 SFM 120-240 M/min	100-200 SFM 30-60 M/min	200-300 SFM 60-90 M/min	1500-5000 SFM 450-1515 M/min
	K-20	K-20	P-30	P-30	P-30	P-30	K-20	K-20	K-20	K-10
	K-10/K-20		K-10/K-20			K-10/K-20		K-10/K-20	K-10/K-20	K-10
IPR	INCH METRIC		INCH METRIC			INCH METRIC		INCH METRIC	INCH METRIC	INCH METRIC
	.006 / .010 15 / 25		.006 / .010 15 / 25			.006 / .010 15 / 25		.004 / .009 10 / 22	.006 / .010 15 / 25	.010 / .030 30 / 75

EFFECTIVE CUTTING DIAMETER DIAMÈTRE DE COUPE EFFECTIF SOBRE EL DIAMETRO EFFECTIVE DE CORTE

INCH SERIES

Insert Dia. "DC" Depth of cut	0.250	0.312	0.375	0.500	0.625	0.750	1.000	1.250
	"DE"							
0.010	0.098	0.110	0.121	0.140	0.157	0.172	0.199	0.223
0.015	0.119	0.134	0.147	0.171	0.191	0.210	0.243	0.272
0.020	0.139	0.153	0.169	0.196	0.220	0.242	0.280	0.314
0.050	0.200	0.229	0.255	0.300	0.339	0.374	0.436	0.490
0.075	0.229	0.267	0.300	0.357	0.406	0.450	0.527	0.504
0.100	0.245	0.292	0.332	0.400	0.458	0.510	0.600	0.678
0.125	0.250	0.306	0.354	0.433	0.500	0.559	0.661	0.750
0.156	—	0.312	0.370	0.463	0.541	0.609	0.726	0.826
0.188	—	—	0.375	0.484	0.573	0.660	0.781	0.894
0.250	—	—	—	0.500	0.612	0.707	0.866	1.000
0.312	—	—	—	—	0.625	0.739	0.927	1.082
0.375	—	—	—	—	—	0.750	0.959	1.146
0.500	—	—	—	—	—	—	1.000	1.225
0.625	—	—	—	—	—	—	—	1.250

METRIC SERIES

Insert Dia. "DC" Depth of cut	6	8	10	12	16	20	25	30	32
	"DE"								
0.25	2.41	2.79	3.10	3.50	4.00	4.45	5.00	5.45	5.65
0.38	2.92	3.40	3.80	4.20	4.90	5.45	6.10	6.70	6.95
0.5	3.35	3.91	4.35	4.80	5.55	6.25	7.00	7.70	7.95
1.25	4.90	5.84	6.60	7.30	8.60	9.70	10.90	12.00	12.40
2	5.59	6.80	8.00	8.90	10.60	12.00	13.60	15.00	15.50
2.5	5.92	7.44	8.65	9.75	11.60	13.20	15.00	16.60	17.20
3.2	6.0	7.82	9.30	10.60	12.80	14.70	16.70	18.50	19.20
4	—	8.00	11.30	13.85	16.00	18.30	20.40	21.15	—
5	—	—	10.00	11.80	14.80	17.30	20.00	22.35	23.25
6	—	—	—	12.00	15.50	18.30	21.35	24.00	25.00
7	—	—	—	—	15.90	19.10	22.45	25.40	26.45
8	—	—	—	—	16.00	19.60	23.30	26.55	27.70
10	—	—	—	—	—	20.00	24.30	28.30	29.65
12.5	—	—	—	—	—	—	25.00	29.60	31.22
15	—	—	—	—	—	—	—	30.00	31.60
16	—	—	—	—	—	—	—	—	32.00



HOW TO MOUNT THE TWO-HOLE TYPE INSERT

- 1• Place the insert in the holder slot.
- 2• Tighten the bottom screw (A).
- 3• Tighten the top screw (B).

COMMENT MONTER UNE PLAQUETTE À DEUX TROUS

- 1• Insérez la plaquette dans l'ouverture.
- 2• Serrez la vis du bas (A).
- 3• Serrez la vis du haut (B).

CÓMO MONTAR UNA PLAQUETA DE DOS AGUJERO

- 1• Pizar la plaqueta en la caja de la fresa.
- 2• Aprieta el tornillo de abajo primero.
- 3• Aprieta el tornillo de arriba.

