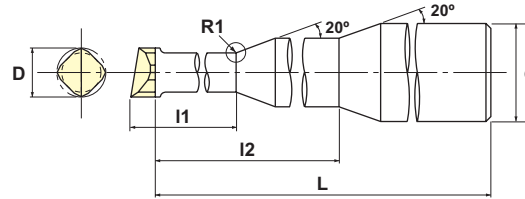


Beam End Mill - Nano

METRIC

MCE Type

- For Glass, Alumina, Zirconia, Silicon, SiC and Graphite



CATALOG NUMBER	STK	DIMENSIONS				
		D	I1	I2	L	d
MCE-010	•	0.1	.35	1.2	40	3
MCE-030	•	0.3	.65	1.2	40	3
MCE-050	•	0.5	.95	1.2	40	3

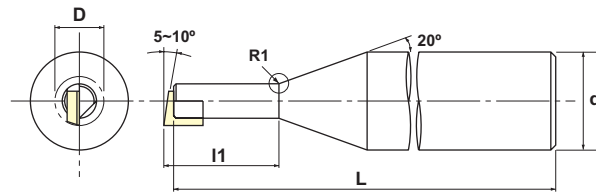
NOTE: Other sizes can be made by special order.

Recommended Cutting Data

Diameter	Materials								
	Glass			Alumina			Zirconia		
	n (min ⁻¹)	Vf (mm/min)	z (mm)	n (min ⁻¹)	Vf (mm/min)	z (mm)	n (min ⁻¹)	Vf (mm/min)	z (mm)
0.1	12,000	2.0	0.01	12,000	2.0	0.01	12,000	2.0	0.01
0.3	10,000	2.0	0.02	10,000	2.0	0.02	10,000	2.0	0.02
0.5	10,000	5.0	0.03	10,000	5.0	0.03	10,000	5.0	0.03

MCCA Type

- For Non-steel materials, resin, cemented carbide & hard fragile materials



CATALOG NUMBER	STK	DIMENSIONS			
		D	I1	L	d
MCCA-100	•	1.0	2.2	50	4
MCCA-150	•	1.5	3.2	50	4
MCCA-200	•	2.0	4.2	50	4

NOTE: Other sizes can be made by special order.

Recommended Cutting Data

Diameter	Materials								
	Hard Fragile Material			Cemented Carbide			Non-Steel Materials (Resin)		
	ap (mm)	n (min ⁻¹)	Vf (mm/min)	ap (mm)	n (min ⁻¹)	Vf (mm/min)	ap (mm)	n (min ⁻¹)	Vf (mm/min)
0.1	0.01	12,000	2	0.002	12,000	2	0.01	High spindle speed where heat is not transferred to work part.	1.0 ~ 30
0.3	0.02	10,000	2	0.002	10,000	2	0.02		1.0 ~ 30
0.5	0.03	10,000	5	0.003	10,000	3	0.03		1.0 ~ 30
1.0	0.05	8,000	5	0.005	8,000	3	0.05		1.0 ~ 30
2.0	0.05	6,000	5	0.005	6,000	3	0.05		1.0 ~ 30