

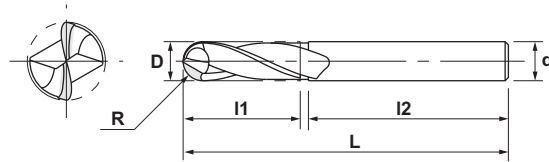


**METRIC**

# Beam Ball Nose End Mill for Aluminum

## VN-ALBS2 Type

- For aluminum cutting
- S shape curved cutting edge
- Positive cutting edge at radius provides smooth cutting



CATALOG NUMBER	STK	DIMENSIONS					
		D	R	l1	l2	L	d
VN-ALBS2-020	•	2	1	7	66	80	4
VN-ALBS2-030	•	3	1.5	10	66	80	4
VN-ALBS2-040	•	4	2	15	62	80	4
VN-ALBS2-050	•	5	2.5	18	74	100	6
VN-ALBS2-060	•	6	3	20	77	100	6
VN-ALBS2-080	•	8	4	30	77	110	8

- Stocked standard
- Inquire regarding delivery

## Recommended Cutting Data

Material	Graphite		Carbon		Aluminum Alloy		Copper Alloy	
Type of Machining	Vc=200m/min ap=0.1D ae=0.3D		Vc=150m/min ap=0.1D ae=0.3D		Vc=250m/min ap=0.1D ae=0.3D		Vc=130m/min ap=0.1D ae=0.3D	
Diameter	N (min <sup>-1</sup> )	Vc (mm/min)	N (min <sup>-1</sup> )	Vc (mm/min)	N (min <sup>-1</sup> )	Vc (mm/min)	N (min <sup>-1</sup> )	Vc (mm/min)
2	53,000	900	40,000	700	65,000	1,000	34,000	550
3	35,000	1,000	26,000	750	44,000	1,300	23,000	700
4	26,000	1,100	20,000	800	33,000	1,300	17,000	700
5	21,000	1,400	16,000	1,000	27,000	1,700	14,000	900
6	17,500	1,700	13,000	1,300	22,000	2,300	11,500	1,200
8	13,000	2,300	10,000	1,700	16,000	2,900	8,500	1,500