



Being the best through innovation

CBN (Cubic Boron Nitride) END MILLS

- Cubic Boron Nitride, Machining High Hardened Steels up to HRC70,
Mirror Finish

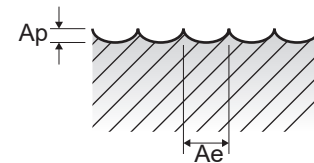
YG CBN
END MILLS

RECOMMENDED CUTTING CONDITIONS

SFM(Vc) = ft./min.
IPT(fz) = in./tooth
RPM = rev./min.
IPM(Feed) = in./min.

ESB94 SERIES 2 FLUTE BALL NOSE

ISO	VDI 3323	Material Description	Ae	Ap	Parameter	Diameter (Ø)									
						0.4	0.5	0.6	0.8	1.0	1.2	1.5	2.0	3.0	
H	38.2-39.1	Non-alloy steel	Ø0.4~Ø0.8 = .0002" Ø1.0~Ø3.0 = .0004"	Ø0.4~Ø0.8 = .0002" Ø1.0~Ø3.0 = .0004"	SFM (Vc)	205	260	310	410	515	620	775	825	820	
					IPT (fz)	.0005	.0006	.0008	.0008	.0012	.0012	.0012	.0016	.0016	
					RPM	50000	50000	50000	50000	50000	50000	50000	40000	26500	
	IPM (FEED)		47	59	79	79	118	118	118	126	83				
	39.2-39.3		High alloyed steel, and tool steel	Ø0.4~Ø0.8 = .0002" Ø1.0~Ø3.0 = .0004"	Ø0.4~Ø0.8 = .0002" Ø1.0~Ø3.0 = .0004"	SFM (Vc)	205	260	310	410	515	620	775	825	820
						IPT (fz)	.0005	.0006	.0008	.0008	.0012	.0012	.0012	.0015	.0016
RPM		50000				50000	50000	50000	50000	50000	50000	32000	21500		
IPM (FEED)	47	59	79	79	118	118	118	98	67						
41	High alloyed steel, and tool steel	Ø0.4~Ø0.8 = .0002" Ø1.0~Ø3.0 = .0004"	Ø0.4~Ø0.8 = .0002" Ø1.0~Ø3.0 = .0004"	SFM (Vc)	205	260	310	410	515	620	775	825	820		
IPT (fz)				.0005	.0006	.0008	.0008	.0012	.0012	.0012	.0016	.0016			
RPM				50000	50000	50000	50000	50000	50000	50000	40000	26500			
IPM (FEED)	47	59	79	79	118	118	118	126	83						



ESD02 SERIES 2FLUTE CORNER RADIUS

ISO	VDI 3323	Material Description	Ae	Ap	Parameter	Diameter (Ø)				
						0.5	1.0	1.5	2.0	
H	38.2-39.1	Hardened steel	Ø0.5 = .0039" Ø1.0 = .0079" Ø1.5 = .0158" Ø2.0 = .0236"	Ø0.5 = .0004" Ø1.0 = .0004" Ø1.5 = .0008" Ø2.0 = .0012"	SFM (Vc)	260	445	465	455	
					IPT (fz)	.0003	.0005	.0007	.0008	
					RPM	50000	43000	30000	22000	
	IPM (FEED)		28	39	39	35				
	39.2-39.3		Hardened Cast Iron	Ø0.5 = .0039" Ø1.0 = .0079" Ø1.5 = .0158" Ø2.0 = .0236"	Ø0.5 = .0004" Ø1.0 = .0004" Ø1.5 = .0008" Ø2.0 = .0012"	SFM (Vc)	260	310	295	290
						IPT (fz)	.0002	.0005	.0007	.0011
RPM		50000				30000	19000	14000		
IPM (FEED)	22	28	28	32						
41	Hardened Cast Iron	Ø0.5 = .0039" Ø1.0 = .0079" Ø1.5 = .0158" Ø2.0 = .0236"	Ø0.5 = .0004" Ø1.0 = .0004" Ø1.5 = .0008" Ø2.0 = .0012"	SFM (Vc)	205	260	310	410		
IPT (fz)				.0005	.0006	.0008	.0008			
RPM				50000	50000	50000	50000			
IPM (FEED)	47	59	79	79						

