

MillLine
BALLFINISH
NOSE

www.tungaloy.com

Tungaloy Report No. 431-G

BALLFINISHNOSE

Indexable endmill **for high-precision finishing**



Member IMC Group
Tungaloy



ACCELERATED MACHINING

MillLine

BALLFINISH NOSE

TUNGALOY



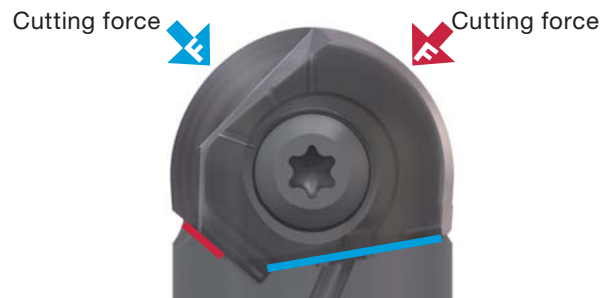
Excellent surface finish and stable machining due to secure clamping and minimum run-out

New indexable endmill for die & mold and aerospace industries.

Secure clamping mechanism



Clamping force gathers on the flat part of the insert hole as the screw is tightened. The force pushes the insert towards the cutter body, providing high repeatability and rigidity as well as minimum run-out.



Asymmetric shape of the insert and directed clamping force maintains centrality of the insert under 3 dimensional cutting force.

Unique coolant delivery system



- The coolant channel on insert surface, delivers coolant to the cutting edge from three directions.
- Excellent chip evacuation and cooling effect provides good surface finish and long tool life in machining of hardened steel.

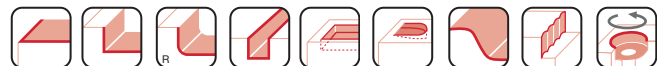
Two insert varieties

MJ chipbreaker

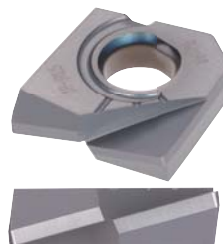
Ball nose type: ZFBM



- Suitable for finishing and three-dimensional milling of die & mold
- Applicable for a wide range of operations



Radius type: ZFRM

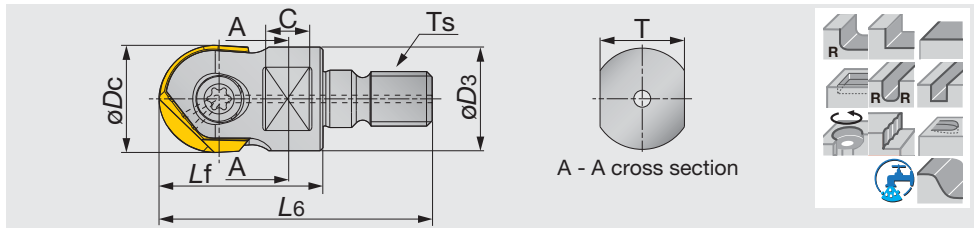


- Suitable for finishing of die & mold
- Designed for milling with high productivity

MODULAR TYPE

HBFM

Indexable endmills with TungFlex threaded adaptation for high precision finish



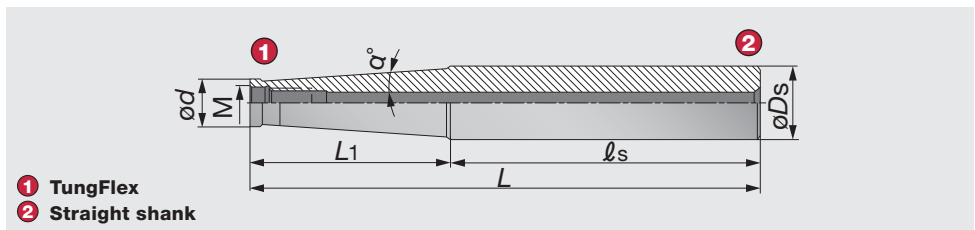
Designation	ϕD_c	L_6	L_f	C	T	ϕD_3	T_s	Air hole	Insert
HBFM10M06	10	34.5	20	5	7	9.7	M6	with	ZF*M100...
HBFM12M06	12	37.5	23	5	7	11.5	M6	with	ZF*M120...
HBFM12M08	12	40	23	8	10	13	M8	with	ZF*M120...
HBFM16M08	16	47	30	8	10	13	M8	with	ZF*M160...
HBFM20M10	20	49	30	10	15	19	M10	with	ZF*M200...
HBFM25M12	25	57	35	10	17	24	M12	with	ZF*M250...
HBFM30M16	30	66	43	12	22	29	M16	with	ZF*M300...
HBFM32M16	32	66	43	12	22	29.5	M16	with	ZF*M320...

SM

Endmills - modular shank



TUNGFLEX



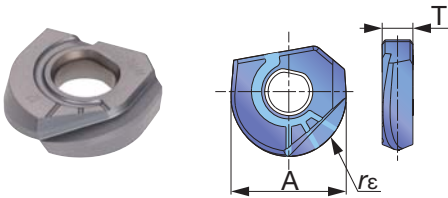
Designation	ϕD_s	L	l_s	L_1	ϕd	M	α°	Shank type
L60C10-SM06	10	60	40	20	9.7	M6	0	Cylindrical
C12-L125-SM06	12	105	45	60	9.7	M6	1.2	Cylindrical
C16-L125-SM06	16	125	65	60	9.7	M6	3.3	Cylindrical
L73C16-SM08	16	73	48	25	13	M8	0	Cylindrical
C16-L128-SM08	16	128	48	80	13	M8	0.9	Cylindrical
C20-L170-SM08	20	170	103.2	66.8	13	M8	3.3	Cylindrical
C20-L80-SM10	20	80	50	30	18	M10	0	Cylindrical
C20-L130-SM10	20	130	50	80	18	M10	0.6	Cylindrical
C25-L200-SM10	25	200	142.8	57.2	19	M10	3.3	Cylindrical
C25-L86-SM12	25	86	56	30	21	M12	5.1	Cylindrical
C32-L200-SM12	32	200	122	78	21	M12	4.4	Cylindrical
C32-L95-SM16	32	95	60	35	29	M16	1.7	Cylindrical
C32-L230-SM16	32	230	180	50	29	M16	1.8	Cylindrical

SPARE PARTS

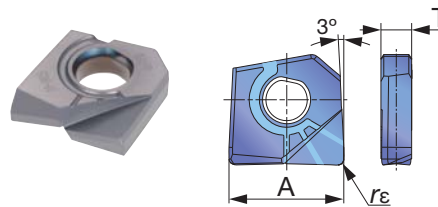
Designation	Clamping screw	Torx bit	Grip	Wrench
HBFM10...	TS 30F100A	-	-	T-10D
HBFM12...	TS 40F120A	-	-	T-15D
HBFM16...	TS 50F160A	BT20S	H-TB2W	-
HBFM20...	TS 60F200A	BLDT25/M7	H-TB2W	-
HBFM25...	TS 70F250A	BLDT25/M7	H-TB2W	-
HBFM30...	TS 80F300A	-	-	T-T30
HBFM32...	TS 80F300A	-	-	T-T30

INSERT

ZFBM-MJ



ZFRM-MJ



P	Steel	☆	★
M	Stainless		☆
K	Cast iron	★	☆
N	Non-ferrous		☆
S	Superalloys		★
H	Hard materials	★	☆

★ : First choice
☆ : Second choice

Designation	rε	Coating										A	T	
		AH710	AH725											
ZFBM080R00-MJ	4	●	●										8	2.4
ZFBM100R00-MJ	5	●	●										10	2.9
ZFBM120R00-MJ	6	●	●										12	3.4
ZFBM160R00-MJ	8	●	●										16	4.4
ZFBM200R00-MJ	10	●	●										20	5.4
ZFBM250R00-MJ	12.5	●	●										25	6.4
ZFBM300R00-MJ	15	●	●										30	7.4
ZFBM320R00-MJ	16	●	●										32	7.4
ZFRM120R05-MJ	0.5	●	●										12	3.4
ZFRM120R10-MJ	1	●	●										12	3.4
ZFRM160R05-MJ	0.5	●	●										16	4.4
ZFRM160R10-MJ	1	●	●										16	4.4
ZFRM160R15-MJ	1.5	●	●										16	4.4
ZFRM200R10-MJ	1	●	●										20	5.4
ZFRM200R15-MJ	1.5	●	●										20	5.4

● : Line-up

STANDARD CUTTING CONDITIONS

ISO	Workpiece materials	Hardness	Priority	Grades	Max. depth of cut (mm)	Cutting speed Vc (m/min)	Feed per tooth: fz (mm/t)							
							D8	D10	D12	D16	D20	D25	D30	D32
P	Low carbon steel, alloy steel	85 - 180 HB	First choice	AH725	≤ 0.04D	180 - 260	0.15	0.2	0.2	0.25	0.25	0.3	0.35	0.35
		85 - 180 HB	For wear resistance	AH710	≤ 0.04D	180 - 260	0.15	0.2	0.2	0.25	0.25	0.3	0.35	0.35
	High carbon steel, alloy steel	180 - 280 HB	First choice	AH725	≤ 0.03D	150 - 230	0.15	0.2	0.2	0.25	0.25	0.3	0.35	0.35
		180 - 280 HB	For wear resistance	AH710	≤ 0.03D	180 - 230	0.15	0.2	0.2	0.25	0.25	0.3	0.35	0.35
	Prehardened steel Die & mold tool steel	40 - 48 HRC	First choice	AH710	≤ 0.03D	180 - 300	0.15	0.15	0.2	0.2	0.25	0.25	0.3	0.3
		40 - 48 HRC	For fracture resistance	AH725	≤ 0.03D	180 - 300	0.15	0.15	0.2	0.2	0.25	0.25	0.3	0.3
M	Stainless steel	135 - 200 HB	First choice	AH725	≤ 0.03D	100 - 250	0.1	0.15	0.2	0.2	0.25	0.25	0.3	0.3
K	Cast iron	150 - 240 HB	First choice	AH710	≤ 0.04D	90 - 350	0.2	0.2	0.25	0.3	0.3	0.35	0.4	0.4
		150 - 240 HB	For fracture resistance	AH725	≤ 0.04D	90 - 350	0.2	0.2	0.25	0.3	0.3	0.35	0.4	0.4
N	Aluminium	-	First choice	AH725	≤ 0.03D	200 - 400	0.25	0.25	0.35	0.35	0.35	0.4	0.4	0.45
H	High hardened steel	48 - 65 HRC	First choice	AH710	≤ 0.02D	100 - 350	0.08	0.08	0.1	0.13	0.15	0.2	0.2	0.25

- Remove excessive chip accumulation with an air blast.
- For the operation with depth of cut which varies (ex.casting skin) and machining of workpiece materials with interrupted surface, the feed per tooth (fz) should be set to the lower recommended value shown in the above table.

- Cutting conditions maybe limited depending on machine power, workpiece rigidity, and spindle output. When the cutting width, depth, or overhang length is large, set Vc and fz to the lower recommended values and check the machine power and vibration.

How to clamp the insert

1. Clear chips and dust from the pocket.
2. Place the insert in the pocket. The insert can be placed only in one direction.
3. Tighten the screw while pressing the insert into the pocket.

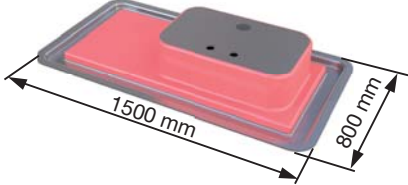
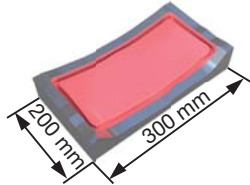
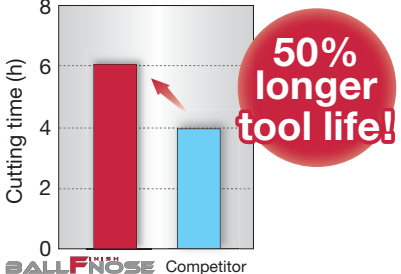
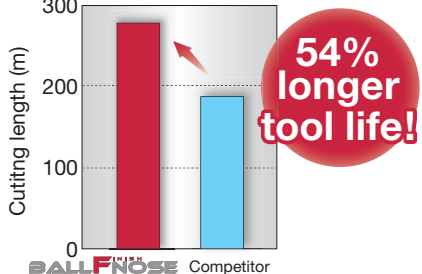
How to check the run-out

1. Clamp the insert on the shank.
2. Clamp the shank on a high-precision arbor.
3. Measure the run-out on tool presetter or by dial gauge.

Notes:

1. Due to the helical cutting edge, it is important that the run-out is inspected with the insert clamped on the shank.
2. Do not use micrometer or caliper to inspect the insert diameter as inaccurate dimensions may be provided.

PRACTICAL EXAMPLES

Workpiece type		Mold part	Mold part	
Cutter		EBFM20S20C220	EBFM12S12S110	
Insert		ZFBM200R00-MJ	ZFBM120R00-MJ	
Grade		AH725	AH725	
		SKD11	STAVAX	
Workpiece material		 H	 H	
Cutting conditions	Cutting speed: V_c (m/min)	350	360	
	Feed per tooth: f_z (mm/t)	0.15	0.09	
	Depth of cut: a_p (mm)	0.2	0.5	
	Pick feed: pf (mm)	0.3	1.0	
	Method of machining	Profiling	Profiling	
	Coolant	Dry	Internal supply, water-soluble coolant	
	Machine	M/C, BT50	M/C, BT40	
Results	 <p>50% longer tool life!</p> <p>TungFineBall's tool life was 50% longer than the competitor's due to high wear resistance.</p>		 <p>54% longer tool life!</p> <p>TungFineBall's cutting length was 54% longer than the competitor's due to excellent chip evacuation.</p>	





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