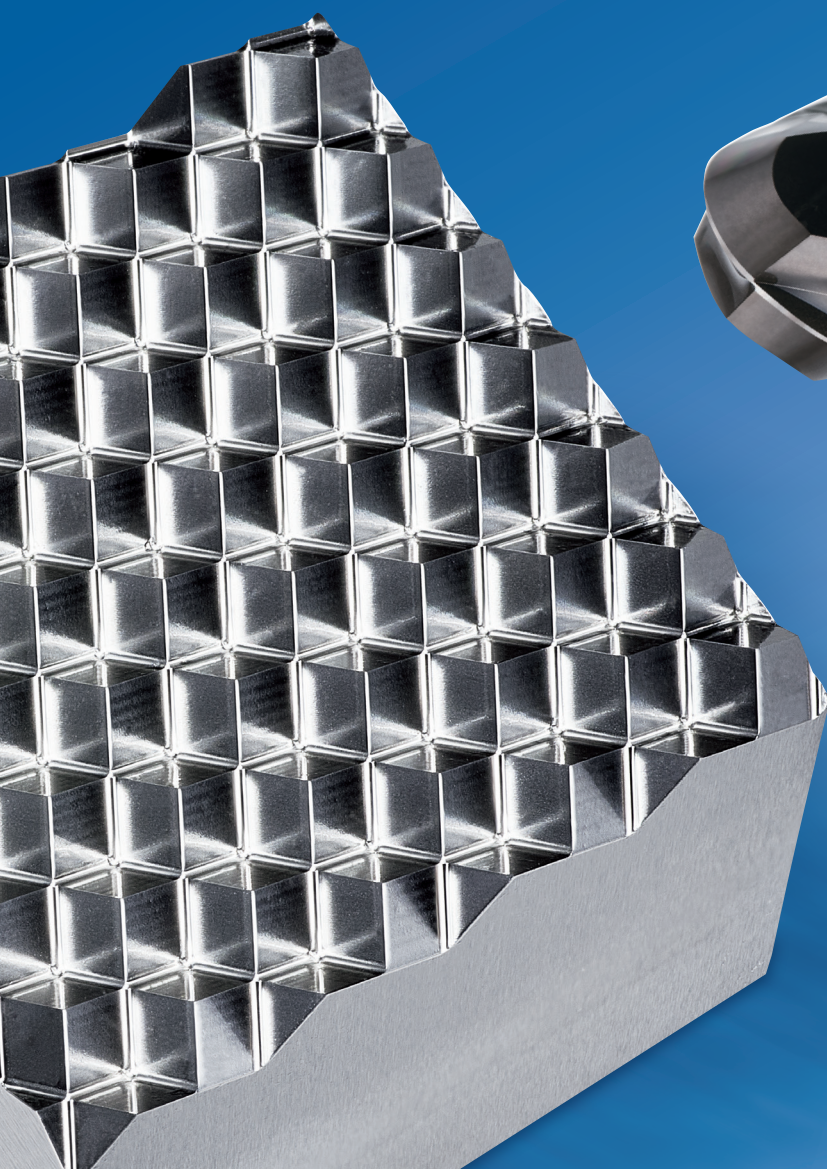




2-flute CBN Ball End Mill

CBN-FB2

Vol. 1



KEY FEATURES & BENEFITS

CBN-FB2

2-flute CBN Ball End Mill

Looking to eliminate tool changes during the finishing process?

CBN-FB2, crafted from sintered CBN with superior wear and heat resistance, significantly reduces edge wear even during high-speed machining of high-hardness steel. By consistently maintaining cutting precision over long durations, it contributes to shorter lead times and enhanced operational efficiency.

Microrelief

Suppresses shape deformation caused by wear

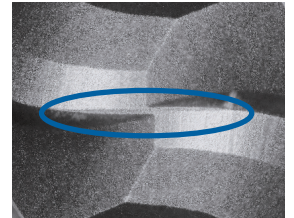
Superior ball R precision

High-accuracy shank Optimized shank length

Challenges in high-precision mold machining

- ▶ Short tool life
- ▶ Inconsistent machining accuracy due to tool wear
- ▶ Variation in product quality caused by tool replacement
- ▶ Limited machining efficiency

Primary
cause:
tool wear



Even minimal wear can impact finishing accuracy.

Delivers high-quality surface finish even during prolonged machining

Work Material : ELMAX (60HRC)

Tool : CBN-FB2 R0,3X1,2

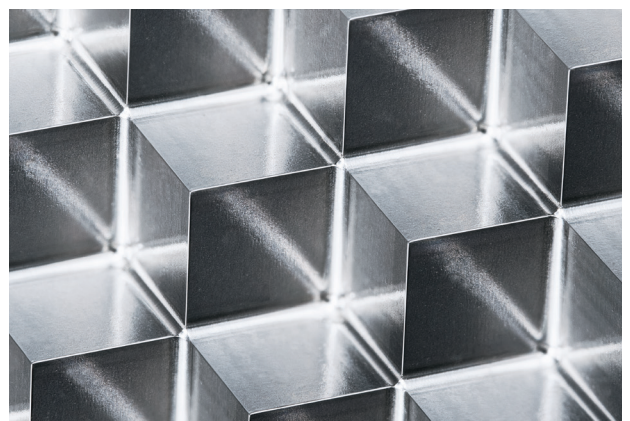
Cutting Speed : 56,5m/min
(30.000 min⁻¹)

Feed : 800mm/min

Depth of Cut : ap=0,01mm
Pf= 0,01mm

Machining Time : Approx. 7 hours
and 30 minutes

Enlarged image of reflector mold model



Regrinding available

Tool reconditioning contributes to resource conservation by bringing worn cutting tools back to life, which is environmentally friendly and sustainable.

- **Regrindable sizes:** R0,2 and above (For details, please contact our sales department)

Excessive tool damage may make regrinding unfeasible.
Please consult with us to determine the appropriate timing for regrinding.

Suppresses wear and achieves high-quality surface finish

- **Microrelief**

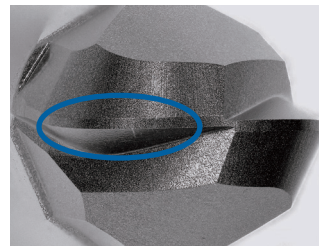
Minimizes shape distortion in the ball R section, enabling precision machining

- **Superior ball R precision**

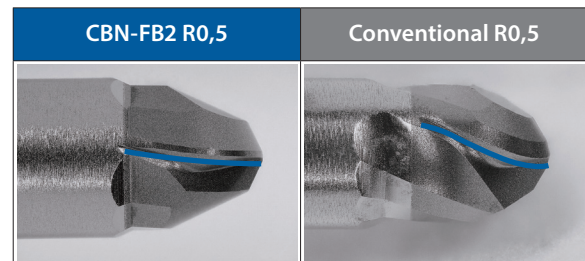
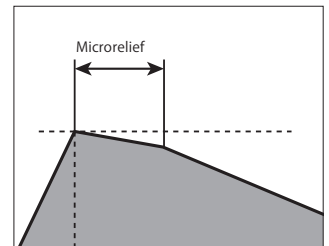


- **Low spiral design**

Balances cutting sharpness and rigidity



CBN-FB2 R0.5



Shank design that maximizes machine performance

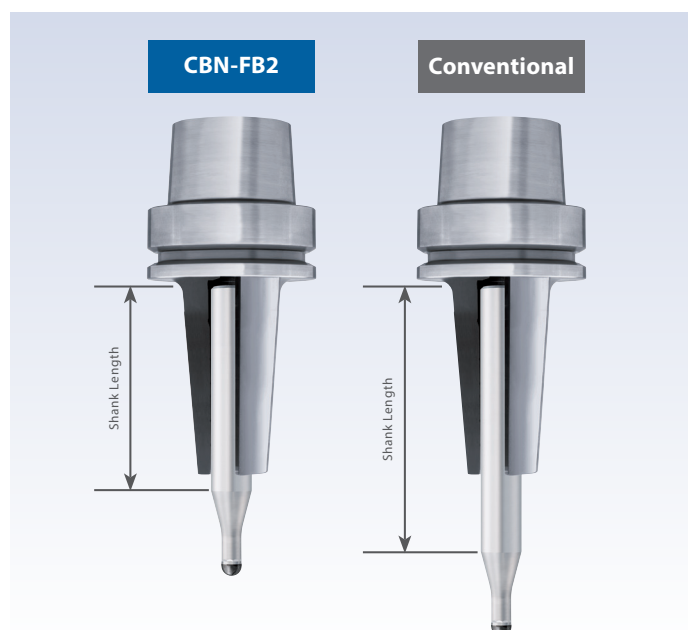
- **Ultra-high precision specifications ensure stable machining accuracy**

Shank accuracy: -0.001 / -0.003

- **Optimized shank length enhances the performance of high-precision compact machining centers**

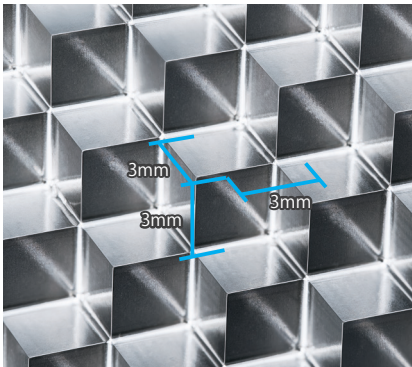
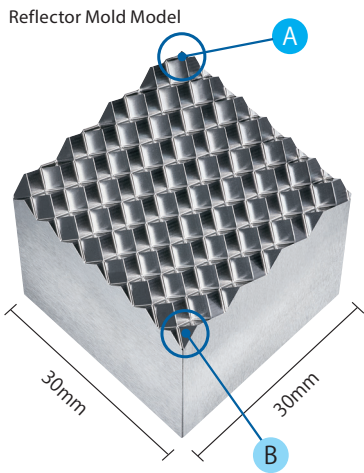
Shank length engineered to reduce deflection, suitable for maximum tool insertion depth in high-precision holders

Enables high-quality machining with optimized protrusion length without cutting the shank

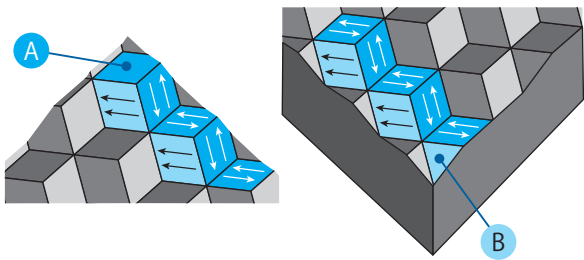


High-quality surface finish even during extended machining

Work Material : ELMAX (60HRC)
Main Spindle : HSK-E25
Coolant : MQL
Holder : Shrink Fit
Machining Time : Approx. 7 hours
and 30 minutes

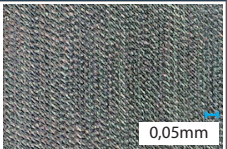
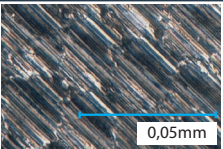
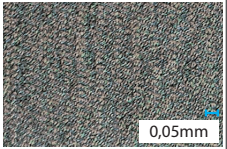
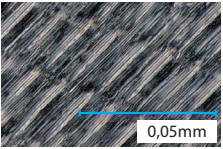


Machining paths (visual reference) and surface roughness measurement points



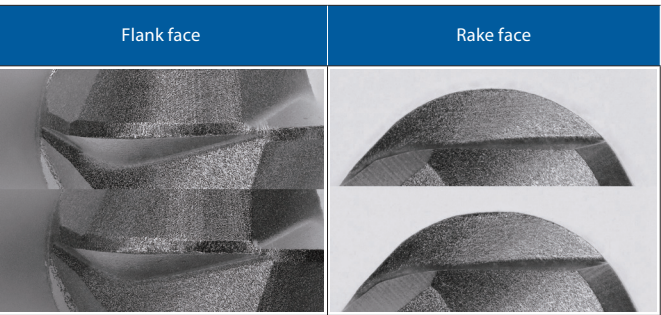
Milling Process	Tool	Cutting Speed (m/min)	Feed (mm/min)	ap (mm)	Pf (mm)
High-precision Finishing	CBN-FB2 R0,3x1,2	56.5 (30,000min ⁻¹)	800 (0.013mm/t)	0.01	0.01

Surface Finish Accuracy

Ra(μm) Surface Roughness		100x Magnification	2000x Magnification
A Surface roughness measurement point (initial stage of machining)	0,075		
B Surface roughness measurement point (final stage of machining)	0,070		

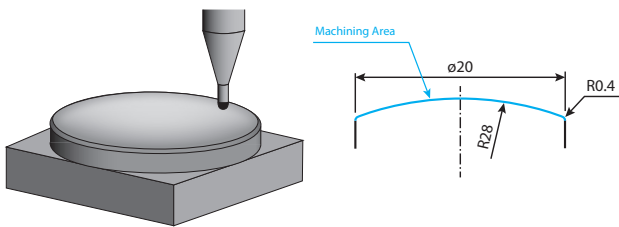
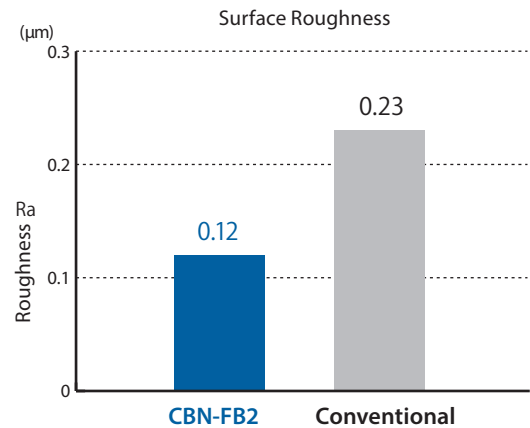
Excellent surface finish maintained even after approximately 7 hours and 30 minutes of machining

Wear condition after approximately 7 hours and 30 minutes (cutting length: 164m)

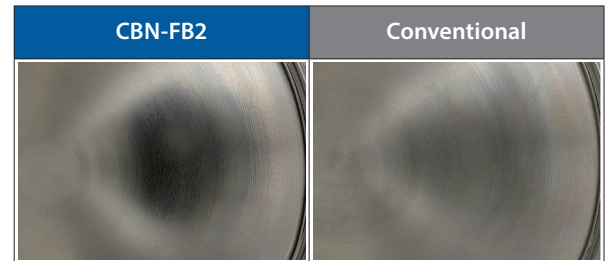


Achieved excellent surface finish on high-hardness steel (65 HRC) modeled after a convex lens mold

Tool	CBN-FB2 R0,5X2,5
Work Material	HAP40 (65HRC)
Cutting Speed	125,6m/min (40.000 min ⁻¹)
Feed	1.000mm/min (0,0125 mm/t)
Depth of Cut	ap = 0,01mm Pf = 0,02mm
Coolant	MQL
Machine	Vertical Machining Center (HSK-E25)



■ Surface condition at 22.3m of machining

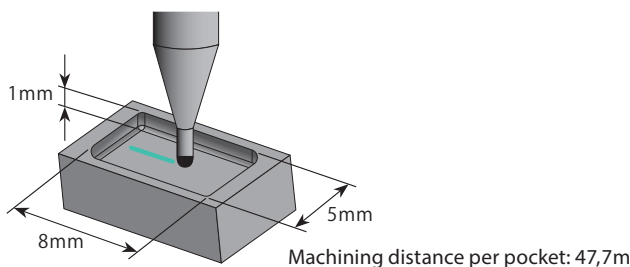
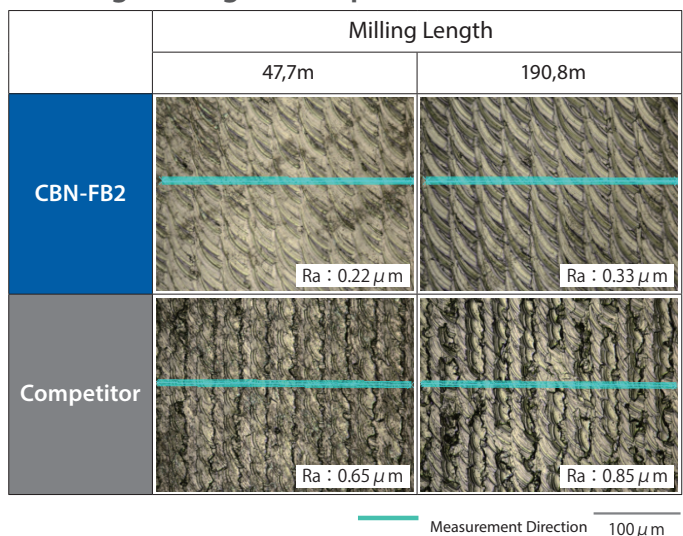


The black area is a reflection of the camera lens during image capture.

Stable machining quality in pocket machining of matrix high-speed steel (60 HRC)

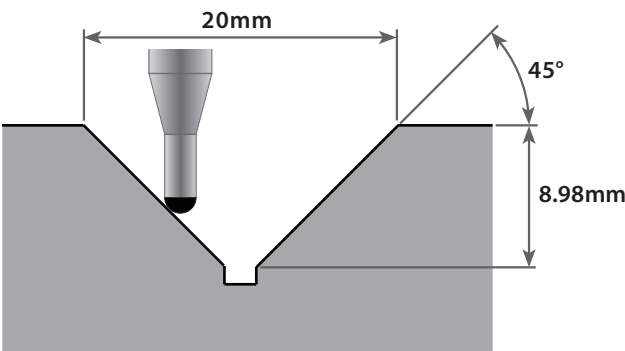
Tool	CBN-FB2 R0,5X2,5
Work Material	YXR3 (60HRC)
Milling Method	Pocket Milling
Pocket Shape	5mm x 8mm x Depth 1mm
Cutting Speed	125,6m/min (40.000 min ⁻¹)
Feed	1.500mm/min (0,01875 mm/t)
Depth of Cut	ap = 0,02mm Pf = 0,03mm
Coolant	MQL
Machine	Vertical Machining Center (HSK-E25)

■ Enlarged image of the pocket bottom surface



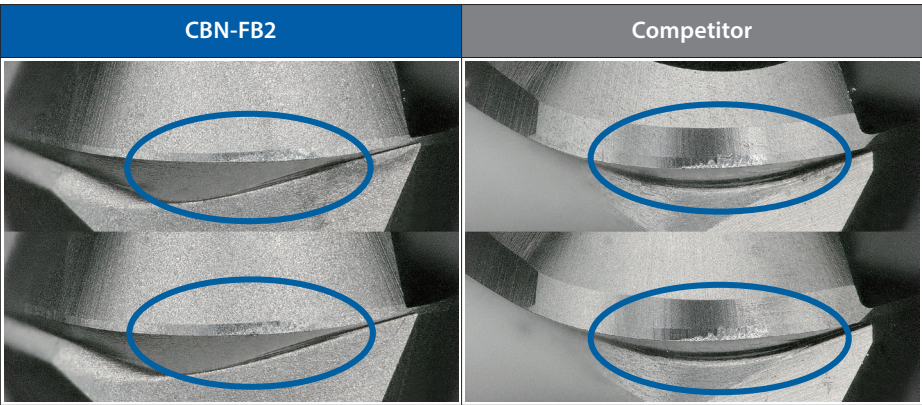
Stable surface finish even in long-distance machining

Tool	CBN-FB2 R1X4
Work Material	SLD (60HRC)
Cutting Speed	125,6m/min (20.000 min ⁻¹)
Feed	1.500mm/min (0,0375 mm/t)
Depth of Cut	ap = 0,02mm Pf = 0,005mm
Coolant	MQL
Machine	Vertical Machining Center (BT-40)

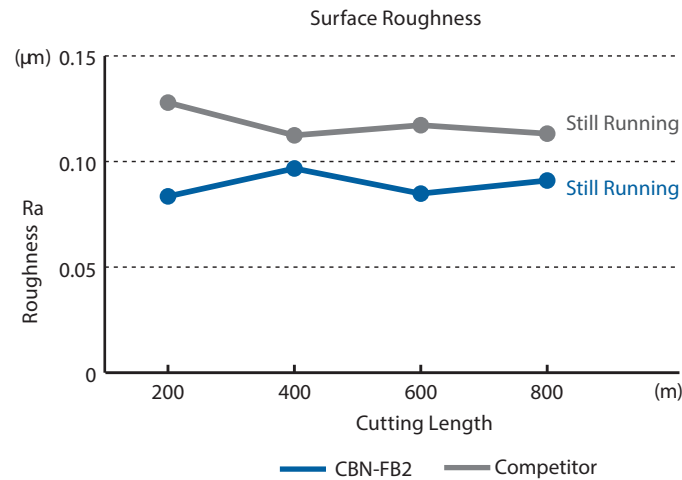


Contour machining of a V-groove (90°)

Wear condition after 800m of machining

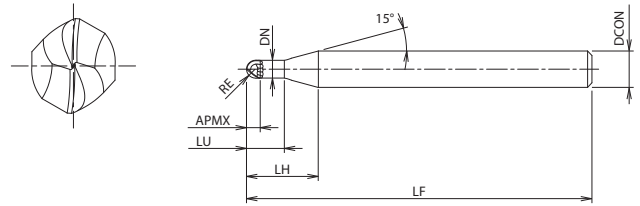


Compared to the competitor product, CBN-FB2 exhibited less wear and maintained high-quality surface roughness throughout extended cutting distances.

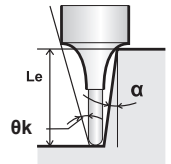


CBN-FB2

Milling | CBN



- 2 flutes CBN ball end mill
- Excellent ball radius accuracy for high-quality surface finishing
- Optimized shank design for ultra-high precision

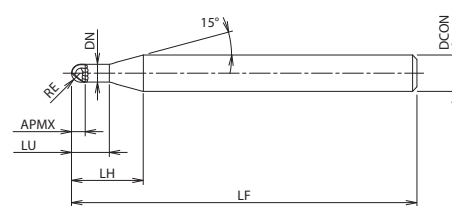
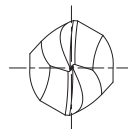


EDP	RE	LU	DCON	LF	APMX	LH	DN	θk	Effective length by inclined angles Le (α)*				
									0,5°	1°	1,5°	2°	3°
8526505	0,1	0,3	4	38	0,12	7,4	0,19	14,49°	0,31	0,33	0,35	0,36	0,4
8526506	0,1	0,5	4	38	0,12	7,6	0,19	14,12°	0,53	0,56	0,58	0,61	0,66
8526507	0,1	0,6	4	38	0,12	7,7	0,19	13,95°	0,63	0,67	0,7	0,73	0,78
8526508	0,1	1	4	38	0,12	8,1	0,19	13,28°	1,06	1,11	1,15	1,19	1,28
8526509	0,1	2	4	38	0,12	9,1	0,19	11,86°	2,11	2,18	2,26	2,34	2,52
8526510	0,15	0,3	4	38	0,18	7,3	0,29	14,56°	0,31	0,32	0,34	0,35	0,38
8526511	0,15	0,5	4	38	0,18	7,5	0,29	14,18°	0,52	0,55	0,58	0,6	0,64
8526512	0,15	0,75	4	38	0,18	7,8	0,29	13,73°	0,79	0,83	0,86	0,89	0,95
8526513	0,15	0,9	4	38	0,18	7,9	0,29	13,48°	0,95	0,99	1,03	1,07	1,14
8526514	0,15	1,5	4	38	0,18	8,5	0,29	12,54°	1,58	1,64	1,7	1,76	1,89
8526515	0,2	0,5	4	38	0,24	7,2	0,38	14,29°	0,51	0,53	0,55	0,57	0,6
8526516	0,2	0,75	4	38	0,24	7,5	0,38	13,82°	0,78	0,81	0,83	0,86	0,91
8526517	0,2	1	4	38	0,24	7,7	0,38	13,38°	1,04	1,08	1,11	1,15	1,23
8526518	0,2	1,2	4	38	0,24	7,9	0,38	13,05°	1,25	1,29	1,33	1,38	1,47
8526519	0,2	2	4	38	0,24	8,7	0,38	11,87°	2,08	2,15	2,22	2,3	2,47
8526520	0,2	3	4	38	0,24	9,7	0,38	10,66°	3,12	3,22	3,33	3,45	3,71
8526521	0,25	1	4	38	0,3	7,6	0,48	13,42°	1,04	1,07	1,11	1,14	1,21
8526522	0,25	1,5	4	38	0,3	8,1	0,48	12,59°	1,56	1,61	1,66	1,72	1,84
8526523	0,25	2,5	4	38	0,3	9,1	0,48	11,21°	2,6	2,68	2,77	2,86	3,08
8526524	0,25	3,5	4	38	0,3	10,1	0,48	10,1°	3,63	3,75	3,88	4,01	4,32
8526525	0,3	1,2	4	38	0,36	7,6	0,58	13,1°	1,24	1,29	1,32	1,36	1,45
8526526	0,3	1,5	4	38	0,36	7,9	0,58	12,6°	1,56	1,61	1,66	1,71	1,82
8526527	0,3	1,8	4	38	0,36	8,2	0,58	12,14°	1,87	1,93	1,99	2,05	2,2
8526528	0,3	2	4	38	0,36	8,4	0,58	11,85°	2,08	2,14	2,21	2,28	2,44
8526529	0,3	3	4	38	0,36	9,4	0,58	10,59°	3,11	3,21	3,32	3,43	3,69
8526530	0,3	4	4	38	0,36	10,4	0,58	9,56°	4,15	4,28	4,43	4,58	4,93
8526531	0,3	4,5	4	40	0,36	10,9	0,58	9,12°	4,67	4,82	4,98	5,16	5,55
8526532	0,3	5	4	40	0,36	11,4	0,58	8,72°	5,18	5,35	5,54	5,73	6,17
8526533	0,3	6	4	40	0,36	12,4	0,58	8,01°	6,22	6,42	6,64	6,88	7,42
8526534	0,4	1,5	4	38	0,48	7,5	0,78	12,63°	1,55	1,6	1,65	1,69	1,8
8526535	0,4	1,6	4	38	0,48	7,6	0,78	12,46°	1,66	1,71	1,76	1,81	1,92
8526536	0,4	2	4	38	0,48	8	0,78	11,83°	2,07	2,14	2,2	2,27	2,42
8526537	0,4	2,4	4	38	0,48	8,4	0,78	11,26°	2,49	2,56	2,64	2,73	2,92
8526538	0,4	4	4	40	0,48	10	0,78	9,44°	4,15	4,28	4,42	4,57	4,91
8526539	0,4	6	4	40	0,48	12	0,78	7,84°	6,21	6,42	6,63	6,87	7,39
8526540	0,5	2	4	38	0,6	7,6	0,98	11,81°	2,07	2,13	2,19	2,25	2,4
8526541	0,5	2,5	4	38	0,6	8,1	0,98	11,06°	2,59	2,66	2,74	2,83	3,02
8526542	0,5	3	4	38	0,6	8,6	0,98	10,41°	3,11	3,2	3,3	3,4	3,64
8526543	0,5	4	4	38	0,6	9,6	0,98	9,3°	4,14	4,27	4,41	4,55	4,88
8526544	0,5	6	4	45	0,6	11,6	0,98	7,66°	6,21	6,41	6,62	6,85	7,37
8526545	0,5	8	4	45	0,6	13,6	0,98	6,51°	8,28	8,55	8,84	9,15	9,86
8526546	0,5	10	4	45	0,6	15,6	0,98	5,66°	10,34	10,69	11,06	11,45	12,34
8526547	0,6	2,4	4	38	0,72	7,8	1,18	10,91°	2,55	2,68	2,78	2,88	3,07
8526548	0,6	3	4	38	0,72	8,4	1,18	10,1°	3,19	3,34	3,46	3,57	3,82

*If there is no value in the actual effective length (Le column) for the work gradient angle α, it indicates no interference.



Milling | CBN



-



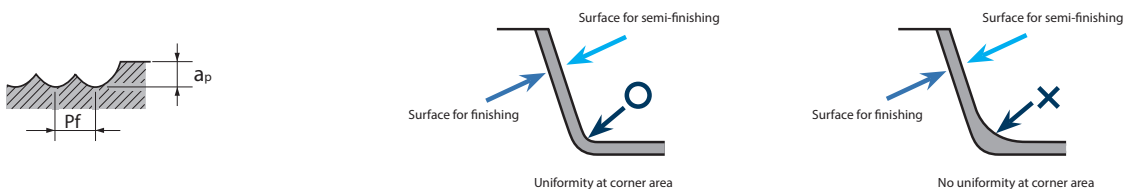
CUTTING CONDITIONS

Milling | Endmills | Cutting conditions

CBN-FB2

Hardened Steel																	
RE	LU	STAVAX - HPM38 ~55HRC				SKD11 - YXR3 - HAP10 ~62HRC				SKH51 - YXR7 - HAP40 ~66HRC				SKH57 - HAP72 ~70HRC			
		S (mm)	F (mm/min)	ap (mm)	Pf (mm)	S (mm)	F (mm/min)	ap (mm)	Pf (mm)	S (mm)	F (mm/min)	ap (mm)	Pf (mm)	S (mm)	F (mm/min)	ap (mm)	Pf (mm)
R0,1	0,3	40.000	660	0,005	0,005	40.000	530	0,005	0,005	40.000	430	0,004	0,004	40.000	360	0,003	0,003
R0,1	0,5	40.000	500	0,005	0,005	40.000	400	0,005	0,005	40.000	330	0,004	0,004	40.000	280	0,003	0,003
R0,1	0,6	40.000	450	0,005	0,005	40.000	360	0,005	0,005	40.000	290	0,004	0,004	40.000	250	0,003	0,003
R0,1	1	40.000	300	0,005	0,005	40.000	240	0,005	0,005	40.000	200	0,004	0,004	40.000	170	0,003	0,003
R0,1	2	40.000	200	0,005	0,005	40.000	160	0,005	0,005	40.000	130	0,004	0,004	40.000	110	0,003	0,003
R0,15	0,3	40.000	900	0,005	0,005	40.000	720	0,005	0,005	40.000	590	0,004	0,004	40.000	500	0,003	0,003
R0,15	0,5	40.000	800	0,005	0,005	40.000	640	0,005	0,005	40.000	520	0,004	0,004	40.000	440	0,003	0,003
R0,15	0,75	40.000	680	0,005	0,005	40.000	540	0,005	0,005	40.000	440	0,004	0,004	40.000	370	0,003	0,003
R0,15	0,9	40.000	600	0,005	0,005	40.000	480	0,005	0,005	40.000	390	0,004	0,004	40.000	330	0,003	0,003
R0,15	1,5	40.000	300	0,005	0,005	40.000	240	0,005	0,005	40.000	200	0,004	0,004	40.000	170	0,003	0,003
R0,2	0,5	40.000	1.200	0,005	0,01	40.000	960	0,005	0,009	40.000	780	0,004	0,007	40.000	660	0,003	0,006
R0,2	0,75	40.000	1.100	0,005	0,01	40.000	880	0,005	0,009	40.000	720	0,004	0,007	40.000	610	0,003	0,006
R0,2	1	40.000	1.000	0,005	0,01	40.000	800	0,005	0,009	40.000	650	0,004	0,007	40.000	550	0,003	0,006
R0,2	1,2	40.000	920	0,005	0,01	40.000	740	0,005	0,009	40.000	600	0,004	0,007	40.000	510	0,003	0,006
R0,2	2	40.000	600	0,005	0,01	40.000	480	0,005	0,009	40.000	390	0,004	0,007	40.000	330	0,003	0,006
R0,2	3	40.000	250	0,005	0,005	40.000	200	0,005	0,005	40.000	160	0,004	0,004	40.000	140	0,003	0,003
R0,25	1	40.000	1.200	0,01	0,01	40.000	960	0,009	0,009	40.000	780	0,007	0,007	40.000	660	0,006	0,006
R0,25	1,5	40.000	1.100	0,01	0,01	40.000	880	0,009	0,009	40.000	720	0,007	0,007	40.000	610	0,006	0,006
R0,25	2,5	40.000	800	0,01	0,01	40.000	640	0,009	0,009	40.000	520	0,007	0,007	40.000	440	0,006	0,006
R0,25	3,5	38.000	400	0,01	0,01	38.000	320	0,009	0,009	38.000	260	0,007	0,007	38.000	220	0,006	0,006
R0,3	1,2	40.000	1.800	0,01	0,02	40.000	1.440	0,009	0,018	40.000	1.170	0,007	0,014	40.000	990	0,006	0,011
R0,3	1,5	40.000	1.700	0,01	0,02	40.000	1.360	0,009	0,018	40.000	1.110	0,007	0,014	40.000	940	0,006	0,011
R0,3	1,8	40.000	1.600	0,01	0,02	40.000	1.280	0,009	0,018	40.000	1.040	0,007	0,014	40.000	880	0,006	0,011
R0,3	2	40.000	1.500	0,01	0,02	40.000	1.200	0,009	0,018	40.000	980	0,007	0,014	40.000	830	0,006	0,011
R0,3	3	40.000	1.100	0,01	0,02	40.000	880	0,009	0,018	40.000	720	0,007	0,014	40.000	610	0,006	0,011
R0,3	4	35.000	600	0,01	0,015	35.000	480	0,009	0,014	35.000	390	0,007	0,011	35.000	330	0,006	0,008
R0,3	4,5	32.000	400	0,01	0,01	32.000	320	0,009	0,009	32.000	260	0,007	0,007	32.000	220	0,006	0,006
R0,3	5	29.000	300	0,008	0,008	29.000	240	0,007	0,007	29.000	200	0,006	0,006	29.000	170	0,004	0,004
R0,3	6	24.000	200	0,005	0,005	24.000	160	0,005	0,005	24.000	130	0,004	0,004	24.000	110	0,003	0,003
R0,4	1,5	40.000	1.900	0,01	0,02	40.000	1.520	0,009	0,018	40.000	1.240	0,007	0,014	40.000	1.050	0,006	0,011
R0,4	1,6	40.000	1.800	0,01	0,02	40.000	1.440	0,009	0,018	40.000	1.170	0,007	0,014	40.000	990	0,006	0,011
R0,4	2	40.000	1.500	0,01	0,02	40.000	1.200	0,009	0,018	40.000	980	0,007	0,014	40.000	830	0,006	0,011
R0,4	2,4	40.000	1.300	0,01	0,02	40.000	1.040	0,009	0,018	40.000	850	0,007	0,014	40.000	720	0,006	0,011
R0,4	4	40.000	1.000	0,01	0,015	40.000	800	0,009	0,014	40.000	650	0,007	0,011	40.000	550	0,006	0,008
R0,4	6	30.000	650	0,005	0,01	30.000	520	0,005	0,009	30.000	420	0,004	0,007	30.000	360	0,003	0,006
R0,5	2	40.000	2.500	0,02	0,04	40.000	2.000	0,018	0,036	40.000	1.630	0,014	0,028	40.000	1.380	0,011	0,022
R0,5	2,5	40.000	2.200	0,02	0,04	40.000	1.760	0,018	0,036	40.000	1.430	0,014	0,028	40.000	1.210	0,011	0,022
R0,5	3	40.000	2.000	0,02	0,035	40.000	1.600	0,018	0,032	40.000	1.300	0,014	0,025	40.000	1.100	0,011	0,019
R0,5	4	40.000	1.700	0,02	0,03	40.000	1.360	0,018	0,027	40.000	1.110	0,014	0,021	40.000	940	0,011	0,017
R0,5	6	30.000	1.100	0,015	0,02	30.000	880	0,014	0,018	30.000	720	0,011	0,014	30.000	610	0,008	0,011
R0,5	8	22.000	750	0,015	0,015	22.000	600	0,014	0,014	22.000	490	0,011	0,011	22.000	410	0,008	0,008
R0,5	10	16.000	540	0,01	0,01	16.000	430	0,009	0,009	16.000	350	0,007	0,007	16.000	300	0,006	0,006
R0,6	2,4	40.000	2.500	0,02	0,04	40.000	2.000	0,018	0,036	40.000	1.630	0,014	0,028	40.000	1.380	0,011	0,022
R0,6	3	40.000	2.500	0,02	0,04	40.000	2.000	0,018	0,036	40.000	1.630	0,014	0,028	40.000	1.380	0,011	0,022
R0,6	6	30.000	1.310	0,02	0,02	30.000	1.050	0,018	0,018	30.000	850	0,014	0,014	30.000	720	0,011	0,011
R0,75	3	40.000	3.000	0,03	0,05	40.000	2.400	0,027	0,045	40.000	1.950	0,021	0,035	40.000	1.650	0,017	0,028
R0,75	3,8	40.000	2.800	0,03	0,05	40.000	2.240	0,027	0,045	40.000	1.820	0,021	0,035	40.000	1.540	0,017	0,028
R0,75	7,5	30.000	1.600	0,02	0,03	30.000	1.280	0,018	0,027	30.000	1.040	0,014	0,021	30.000	880	0,011	0,017
R0,75	10	23.000	1.040	0,015	0,02	23.000	830	0,014	0,018	23.000	680	0,011	0,014	23.000	570	0,008	0,011
R0,75	15	12.000	480	0,01	0,02	12.000	380	0,009	0,018	12.000	310	0,007	0,014	12.000	260	0,006	0,011
R1	4	30.000	2.400	0,05	0,1	30.000	1.920	0,045	0,09	30.000	1.560	0,035	0,07	30.000	1.320	0,028	0,055
R1	5	29.000	2.030	0,05	0,08	29.000	1.620	0,045	0,072	29.000	1.320	0,035	0,056	29.000	1.120	0,028	0,044
R1	6	28.000	1.680	0,04	0,05	28.000	1.340	0,036	0,045	28.000	1.090	0,028	0,035	28.000	920	0,022	0,028
R1	8	25.000	1.350	0,03	0,05	25.000	1.080	0,027	0,045	25.000	880	0,021	0,035	25.000	740	0,017	0,028
R1	10	22.000	1.100	0,03	0,03	22.000	880	0,027	0,027	22.000	720	0,021	0,021	22.000	610	0,017	0,017
R1	14	16.000	720	0,02	0,02	16.000	580	0,018	0,018	16.000	470	0,014	0,014	16.000	400	0,011	0,011
R1	20	8.000	360	0,02	0,02	8.000	290	0,018	0,018	8.000	230	0,014	0,014	8.000	200	0,011	0,011
R1,5	6	20.000	2.000	0,1	0,15	20.000	1.600	0,09	0,135	20.000	1.300	0,07	0,105	20.000	1.100	0,055	0,083
R1,5	9	20.000	1.600	0,08	0,1	20.000	1.280	0,072	0,09	20.000	1.040	0,056	0,07	20.000	880	0,044	0,055

1. Use a rigid and precise machine and holder.
2. Using air blow or MQL (oil mist coolant) is recommended.
3. Please use the tool while minimizing runout accuracy.
4. The above cutting conditions are for contouring operation with low-load and stable condition. Refer to the table above to set the milling conditions in accordance with the actual situation.
5. Please adjust conditions based on machining accuracy, machining shape and machining path.
6. When RPM are insufficient, please reduce the RPM and feed rates at same ratio as listed above.
7. Uneven finishing allowance may negatively impact tool life and machining accuracy. Therefore, please ensure the allowance is as uniform as possible during pre-machining.



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