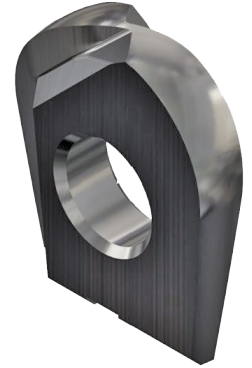


DAPRA®

PRISMA BALL NOSE

A finishing insert that
outshines them all.



DAPRA®

COMPATIBILITY

Works with legacy BNEM
Ball Nose bodies.

OPTIMIZED PERFORMANCE

Achieves superior
surface finishes —
28-32 Ra (µin) typical.

ADVANCED GRADES

Nanograin substrates and cutting-edge
coatings provide excellent thermal
stability and superior adhesion.

RE-ENGINEERED GEOMETRIES

Improved helical geometries allow for
reduced drag and tool pressure.

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NEW Prisma Series Ball Nose Inserts

GEOMETRIES:

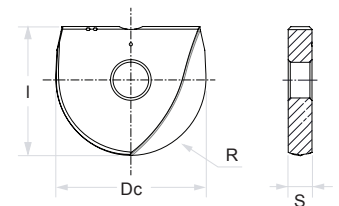
- › **SG** – Improved helix with a more neutral rake angle adapted for general application finishing
- › **SH** – Improved helix angle and negative rake face for stronger edge

GRADES:

- › **DMF603** – For finishing operations in steels and hardened steels; wear resistant; first choice when using the SH geometry
- › **DMF910** – For semi-finishing operations in steels and hardened steels; tougher substrate; first choice when using the SG geometry

Prisma Ball Nose Inserts

EDP	Catalog ID	Grade	Edge Geometry	Coating	Dimensions (Inch)			
					Dc	I	R	S
110000177	BNR0500-SH-DMF603	DMF603	Helical	PVD	0.500	0.488	0.250	0.098
110000178	BNR0500-SH-DMF910	DMF910	Helical	PVD		0.488	0.250	0.098
110000179	BNR0500-SG-DMF603	DMF603	Helical	PVD		0.488	0.250	0.098
110000180	BNR0500-SG-DMF910	DMF910	Helical	PVD		0.488	0.250	0.098
110000181	BNR0750-SH-DMF603	DMF603	Helical	PVD	0.750	0.612	0.375	0.118
110000182	BNR0750-SH-DMF910	DMF910	Helical	PVD		0.612	0.375	0.118
110000183	BNR0750-SG-DMF603	DMF603	Helical	PVD		0.612	0.375	0.118
110000184	BNR0750-SG-DMF910	DMF910	Helical	PVD		0.612	0.375	0.118
110000185	BNR1000-SH-DMF603	DMF603	Helical	PVD	1.000	0.855	0.500	0.157
110000186	BNR1000-SH-DMF910	DMF910	Helical	PVD		0.855	0.500	0.157
110000187	BNR1000-SG-DMF603	DMF603	Helical	PVD		0.855	0.500	0.157
110000188	BNR1000-SG-DMF910	DMF910	Helical	PVD		0.855	0.500	0.157



*Please note: 1.000 will be available by the end of 2025.

Machining Parameters

Grade	Size	Speed / Feed	P			M			K			H
			Non-Alloy Steel	Low-Alloy Steel	High-Alloy / Tool Steel	Austenitic Stainless	Ferritic / Martensitic Stainless	Austenitic-Ferritic Stainless (Duplex)	Malleable Cast Iron	Gray Cast Iron	Nodular Cast Iron	Hardened Steel (> 55 HRC)
DMF603	0.500"	SFM (feet/min.)	590-1310	590-1275	590-1210	520-950	555-980	490-885	655-1245	590-1180	520-1015	225-885
		FPR (in./rev.)	.008-.018	.006-.016	.006-.016	.006-.014	.006-.014	.004-.012	.008-.020	.008-.018	.008-.016	.004-.012
	0.750"	SFM (feet/min.)	590-1310	590-1275	590-1210	520-950	555-980	490-885	655-1245	590-1180	520-1015	225-885
		FPR (in./rev.)	.010-.020	.010-.018	.008-.018	.008-.016	.008-.016	.006-.014	.010-.024	.010-.020	.010-.020	.004-.014
	1.000"	SFM (feet/min.)	590-1310	590-1275	590-1210	520-950	555-980	490-885	655-1245	590-1180	520-1015	225-885
		FPR (in./rev.)	.010-.022	.010-.020	.008-.020	.008-.018	.008-.018	.006-.016	.010-.026	.010-.024	.010-.022	.004-.015
DMF910	0.500"	SFM (feet/min.)	455-1145	455-1115	455-980	425-850	390-820	360-750	590-1210	590-1145	520-950	225-850
		FPR (in./rev.)	.008-.018	.006-.016	.006-.016	.006-.014	.006-.014	.004-.012	.008-.020	.008-.018	.008-.016	.004-.012
	0.750"	SFM (feet/min.)	455-1145	455-1115	455-980	425-850	390-820	360-750	590-1210	590-1145	520-950	225-850
		FPR (in./rev.)	.010-.020	.010-.018	.008-.018	.008-.016	.008-.016	.006-.014	.010-.024	.010-.020	.010-.020	.004-.014
	1.000"	SFM (feet/min.)	455-1145	455-1115	455-980	425-850	390-820	360-750	590-1210	590-1145	520-950	225-850
		FPR (in./rev.)	.010-.022	.010-.020	.008-.020	.008-.018	.008-.018	.006-.018	.010-.026	.010-.024	.010-.022	.004-.015