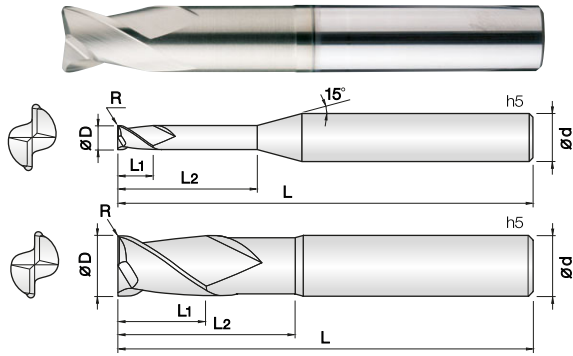




## 2 Flutes Rib Corner Radius End Mills for Copper



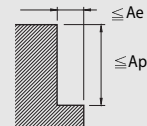
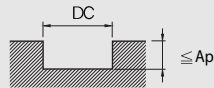
D Size	D Tolerance
Ø1 ~ 4	+0 ~ -0.01 mm
Ø6 ~ 12	-0.005 ~ -0.015 mm

### 2COR / 3COR Cutting Condition

• RPM : rev./min • Feed : mm/min

Material			Slotting				Side Cutting			
Copper / Copper Alloys			Copper / Copper Alloys				Copper / Copper Alloys			
Outside Diameter	Corner Radius	Effective Length	RPM	FEED	Ap Axial Depth	Ap Radial Depth	RPM	FEED	Ap Axial Depth	Ap Radial Depth
Ø1	R0.1, R0.2	3	45,000	2,500	0.036	1	45,000	4,500	0.036	0.2
		6	40,000	2,000	0.03	1	40,000	3,000	0.03	0.2
		10	35,000	1,600	0.025	1	35,000	2,000	0.025	0.2
Ø1.5	R0.1, R0.2	5	23,000	1,800	0.08	1.5	50,000	6,000	0.08	0.3
		8	26,000	1,600	0.06	1.5	45,000	5,500	0.06	0.3
		12	30,000	1,500	0.05	1.5	40,000	4,500	0.04	0.3
Ø2	R0.1, R0.2	6	35,000	1,800	0.14	2	45,000	5,000	0.12	0.8
		10	30,000	1,600	0.12	2	40,000	4,700	0.1	0.6
		14	30,000	1,200	0.08	2	30,000	3,800	0.06	0.4
Ø3	R0.2, R0.3	10	30,000	2,200	0.14	3	40,000	6,500	0.12	1
		16	20,000	2,000	0.12	3	35,000	6,000	0.1	0.6
		20	20,000	2,000	0.12	3	35,000	6,000	0.1	0.6
	R0.5	10	20,000	2,600	0.14	3	38,000	10,000	0.12	0.8
		16	20,000	2,200	0.12	3	35,000	8,000	0.1	0.6
		20	20,000	2,200	0.12	3	35,000	8,000	0.1	0.6
Ø4	R0.2, R0.3	12	20,000	2,600	0.5	4	40,000	8,000	0.18	0.12
		16	15,000	2,400	0.3	4	32,000	5,000	0.16	0.1
		20	15,000	2,000	0.25	4	32,000	5,000	0.15	0.8
	R0.5	12	20,000	2,400	0.5	4	35,000	10,000	0.3	0.1
		16	15,000	2,200	0.25	4	32,000	7,000	0.15	0.8
		20	15,000	2,200	0.25	4	32,000	7,000	0.15	0.8

Depth of Cut



- Above the parameters are based on V/C 100 with Fz 0.03. Actual machining can be changed depending on your machining purpose and condition of your machine.
- If the table over the maximum RPM and feed of your machine, or found red heat on the material, adjust RPM and feed in the same proportion.
- Air blow or mist coolants are recommended and note for chip emission, heat, or ignition.