D Size	D Tolerance
Ø6 ~ 5	+0 ~ −0.01 mm
Ø6	−0.005 ~ −0.015 mm

2 WC (R) ±0.005 (R) ±0.01 **30°** Helix Angle

0.1 ~ 2.5R   3R

2MRB / 3MRB

■ 3MRB
■ raise up the RPM and feed by 10% for 3MRB.

• RPM : rev./min   • Feed : mm/min

Material		Aluminum Alloys				Plastic			
Corner Radius	Effective Length	RPM	FEED	Ap Axial Depth	Ap Radial Depth	RPM	FEED	Ap Axial Depth	Ap Radial Depth
R 0.1	1	35,000	420	0.003	0.03	35,000	1,000	0.05	0.03
R 0.15	2	35,000	490	0.004	0.04	35,000	1,050	0.06	0.04
R 0.2	3	35,000	560	0.005	0.06	35,000	1,100	0.07	0.06
R 0.25	4	35,000	700	0.006	0.07	28,000	1,200	0.08	0.07
"	10	27,300	504	0.004	0.05	21,840	864	0.06	0.04
R 0.3	4	35,000	910	0.007	0.09	24,000	1,200	0.1	0.09
"	10	27,300	655	0.005	0.07	18,720	864	0.07	0.05
R 0.4	4	26,000	940	0.008	0.12	18,000	900	0.13	0.12
"	10	19,500	658	0.006	0.1	13,500	576	0.11	0.1
R 0.5	6	21,000	970	0.008	0.15	14,000	700	0.17	0.15
"	16	14,700	631	0.006	0.1	9,800	455	0.1	0.09
R 0.6	6	18,000	1,010	0.009	0.18	12,000	600	0.2	0.18
"	16	12,780	616	0.007	0.11	8,520	366	0.13	0.12
R 0.7	6	15,000	1,020	0.01	0.21	10,000	500	0.23	0.21
"	16	10,800	622	0.008	0.16	7,200	305	0.17	0.15
R 0.75	6	14,000	1,010	0.012	0.24	9,500	480	0.25	0.24
"	16	10,220	636	0.01	0.19	6,935	302	0.19	0.17
"	25	8,483	477	0.08	0.14	5,756	227	0.13	0.11
R 1	8	11,000	1,100	0.18	0.35	7,000	350	0.4	0.35
"	20	8,140	704	0.16	0.3	5,180	224	0.35	0.33
"	30	6,919	528	0.14	0.25	4,403	168	0.3	0.28
R 1.5	8	6,900	760	0.2	0.5	4,800	240	0.5	0.5
"	20	5,313	486	0.18	0.45	4,080	151	0.45	0.45
"	30	4,516	365	0.16	0.4	3,142	113	0.4	0.4
R 2	16	5,200	690	0.25	0.65	3,600	180	0.6	0.65
"	25	4,056	449	0.22	0.6	3,060	113	0.56	0.61
"	35	3,488	336	0.2	0.55	2,356	85	0.54	0.57
R 2.5	16	4,200	590	0.3	0.8	2,900	150	0.8	0.85
"	25	3,234	401	0.27	0.75	2,233	102	0.76	0.81
"	35	2,652	309	0.24	0.7	1,831	79	0.72	0.75
R 3	25	3,500	550	0.35	0.9	2,400	120	1	1.2
"	35	2,940	468	0.33	0.8	2,016	102	0.95	1.1
"	50	2,323	355	0.3	0.7	1,593	78	0.9	1

Depth of Cut
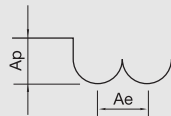
Ap : Axial Depth   (mm)
Ae : Radial Depth   (mm)
D : Outside Diameter   (mm)
n : Speed   (min⁻¹)
Vf : Feed   (mm/min)

- The parameters on the table is based on 2 flutes. For using 3 flutes, use the same RPM and raise up the feed up to 10% in stable milling condition.
- Use this table for your reference. Adjust the parameters depending on your machining geometry, machining purpose and CNC.
- If the table over the maximum RPM and feed of your machine, adjust RPM and feed in the same proportion.