

- Endmills for Mild steel, Acryl, A.B.S, Aluminum, non-ferrous and non-metallic materials.
- Reinforced edge design for preventing edge chipping.
- Minimize chattering by short flute design
- Excellent wear resistance by applying fine WC grade.



D Size	D Tolerance
ø0.3 ~ 4	+0 ~ -0.01 mm
ø6	-0.01 ~ -0.025 mm

: mm

# 2MEM

• RPM : rev./min • Feed : mm/min

Material	Carbon Steels				Alloy Steels				Aluminum			
	Outside Diameter	RPM	FEED	Ap Axial Depth	Ae Radial Depth	RPM	FEED	Ap Axial Depth	Ae Radial Depth	RPM	FEED	Ap Axial Depth
∅1	12,900	125	0.15	0.07	11,400	90	0.15	0.07	43,000	510	0.15	0.07
∅1.5	8,600	125	0.75	0.11	7,700	90	0.75	0.11	29,000	580	0.75	0.11
∅2	6,500	125	1.00	0.14	5,800	110	1.00	0.14	22,000	650	1.00	0.14
∅2.5	5,100	150	1.25	0.18	4,600	110	1.25	0.18	17,200	680	1.25	0.18
∅3	4,300	170	1.50	0.45	3,800	120	1.50	0.45	14,300	720	1.50	0.45
∅4	3,200	200	3.00	0.60	2,900	120	3.00	0.60	10,700	750	3.00	0.60
∅5	2,600	210	3.75	0.75	2,300	135	3.75	0.75	8,600	775	3.75	0.75
∅6	2,200	220	4.50	0.90	1,900	150	4.50	0.90	7,200	790	4.50	0.90
∅8	1,600	200	6.00	1.20	1,400	145	6.00	1.20	5,400	700	6.00	1.20
∅10	1,300	180	7.50	1.50	1,200	145	7.50	1.50	4,300	650	7.50	1.50
∅12	1,100	170	9.00	1.80	1,000	135	9.00	1.80	3,600	610	9.00	1.80

# 3MEM

• RPM : rev./min • Feed : mm/min

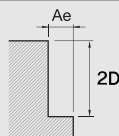
Material	Carbon Steels				Alloy Steels				Aluminum			
	Outside Diameter	RPM	FEED	Ap Axial Depth	Ae Radial Depth	RPM	FEED	Ap Axial Depth	Ae Radial Depth	RPM	FEED	Ap Axial Depth
∅1	13,674	141	0.15	0.07	12,084	101	0.15	0.07	45,580	566	0.15	0.07
∅1.5	9,116	141	0.75	0.11	8,162	101	0.75	0.11	30,740	644	0.75	0.11
∅2	6,890	141	1.00	0.14	6,148	123	1.00	0.14	23,320	722	1.00	0.14
∅2.5	5,406	170	1.25	0.18	4,876	123	1.25	0.18	18,232	769	1.25	0.18
∅3	4,558	192	1.50	0.45	4,028	134	1.50	0.45	15,158	799	1.50	0.45
∅4	3,392	226	3.00	0.60	3,074	134	3.00	0.60	11,342	833	3.00	0.60
∅6	2,332	249	4.50	0.90	2,014	168	4.50	0.90	7,632	877	4.50	0.90

# 4MEM

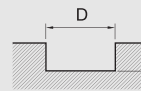
• RPM : rev./min • Feed : mm/min

Material	Carbon Steels				Alloy Steels				Prehardened Steels			
	Outside Diameter	RPM	FEED	Ap Axial Depth	Ae Radial Depth	RPM	FEED	Ap Axial Depth	Ae Radial Depth	RPM	FEED	Ap Axial Depth
∅1	14,084	153	0.15	0.07	12,483	107	0.15	0.07	46,583	594	0.15	0.07
∅1.5	9,389	153	0.75	0.11	8,431	107	0.75	0.11	31,416	676	0.75	0.11
∅2	7,097	153	1.00	0.14	6,351	131	1.00	0.14	23,833	758	1.00	0.14
∅2.5	5,568	183	1.25	0.18	5,037	131	1.25	0.18	18,633	808	1.25	0.18
∅3	4,695	207	1.50	0.45	4,161	142	1.50	0.45	15,491	839	1.50	0.45
∅4	3,494	244	3.00	0.60	3,175	142	3.00	0.60	11,592	874	3.00	0.60
∅6	2,402	268	4.50	0.90	2,080	178	4.50	0.90	7,800	921	4.50	0.90
∅8	2,509	258	6.00	1.20	1,957	156	6.00	1.20	6,006	889	6.00	1.20
∅10	1,720	234	7.50	1.50	1,342	133	7.50	1.50	4,625	826	7.50	1.50
∅12	1,279	210	9.00	1.80	998	116	9.00	1.80	3,561	744	9.00	1.80

Depth of Cut



Ae  
 $\varnothing 1 \sim 2.9 = 0.07D$   
 $\varnothing 3 \sim = 0.15D$



Ap  
 $\varnothing 1 \sim 1.2 = 0.15D$   
 $\varnothing 1.5 \sim 3.5 = 0.5D$   
 $\varnothing 4 \sim = 0.75D$

- The edge of the flute precisely grinded. If you want to measure the tool, and to avoid damaging on the flutes, use non-contact measuring method.
- When entering the tool to the workpiece, enter the tool from outside to the workpiece.
- 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, or found red heat on the material, adjust RPM and feed in the same proportion.