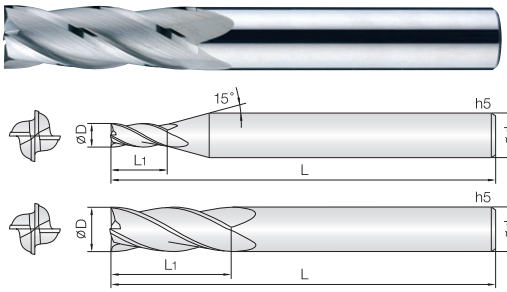


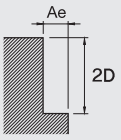
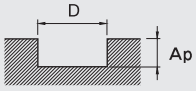
- Endmills for Mild steel, Acryl, A.B.S, Aluminum, non-ferrous and non-metallic materials.
- Reinforced edge design for preventing edge chipping.
- Minimize chattering by even run-out and tolerance control.
- Excellent wear resistance by applying fine WC grade.

Ø1 ~ 5 Ø6 ~ 12 Sharp Edge

D Size	D Tolerance
Ø1 ~ 5	+0 ~ −0.01 mm
Ø6 ~ 12	−0.01 ~ −0.025 mm

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	Ae Radial Depth
Ø 1	14,084	153	0.15	0.07	12,483	107	0.15	0.07	46,583	594	0.15	0.07
Ø 1.5	9,389	153	0.75	0.11	8,431	107	0.75	0.11	31,416	676	0.75	0.11
Ø 2	7,097	153	1.00	0.14	6,351	131	1.00	0.14	23,833	758	1.00	0.14
Ø 2.5	5,568	183	1.25	0.18	5,037	131	1.25	0.18	18,633	808	1.25	0.18
Ø 3	4,695	207	1.50	0.45	4,161	142	1.50	0.45	15,491	839	1.50	0.45
Ø 4	3,494	244	3.00	0.60	3,175	142	3.00	0.60	11,592	874	3.00	0.60
Ø 6	2,402	268	4.50	0.90	2,080	178	4.50	0.90	7,800	921	4.50	0.90
Ø 8	2,509	258	6.00	1.20	1,957	156	6.00	1.20	6,006	889	6.00	1.20
Ø 10	1,720	234	7.50	1.50	1,342	133	7.50	1.50	4,625	826	7.50	1.50
Ø 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 Ø1 ~ 2.9 = 0.07D Ø3 ~ = 0.15D				 Ap Ø1 ~ 1.2 = 0.15D Ø1.5 ~ 3.5 = 0.5D Ø4 ~ = 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.