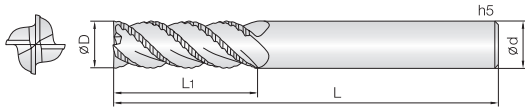


3&4&5 SUR

3&4&5 Flutes 45° Helix Roughing Core R End Mills for SUS



- Roughing Endmills for alloy steel, SUS, Inconel, Mild steel and various hard-to-cut materials.
- JCRO coating provides wear resistance improvement as well as avoid edge stress in various applications.
- 45 helix Design for minimizing cutting resistance and long time process.
- High speed and roughing work applicable by fine pitch flute.



D Size	D Tolerance
ø3 ~ 9	-0.02 ~ -0.04 mm
ø10 ~ 20	-0.02 ~ -0.05 mm

3 & 4 & 5 SUR

Cutting Condition

• RPM: rev./min • Feed: mm/min

Material	Stainless Steels / Titanium Alloy Steels			
	SUS304 / SUS 316 / Ti6A			
Outside Diameter	RPM	FEED	Ap Axial Depth	Ae Radial Depth
ø3	5,000	380	0.9	3
ø4	4,800	350	1.2	4
ø5	4,700	350	1.5	5
ø6	4,400	340	1.5	6
ø7	3,800	340	1.75	7
ø8	3,300	340	2	8
ø9	3,000	340	2.25	9
ø10	2,700	330	2.5	10
ø12	2,200	330	1.8	12
ø14	2,000	310	2.1	14
ø16	1,750	300	2.4	16
ø20	1,300	210	2	20

Depth of Cut		$A :$ <ul style="list-style-type: none"> ø3 ~ 5 = 0.3 × D ø6 ~ 10 = 0.25 × D ø12 ~ 16 = 0.15 × D ø18 ~ 20 = 0.1 × D
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When entering the tool to the workpiece, enter the tool from outside to the workpiece.

If the effective length is long, reduce the RPM and feed maximum 30%.

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.
- In case of workpiece and machine do not have enough rigidity and make vibration, reduce the RPM and feed in same proportion.
- Depending on the workpiece and shape, use adequate coolant.
- For parting off stainless or heat resistant alloy, using water-soluble oil is the most effective way.