



- Endmills for alloy steel, SUS, Ti/Ni base alloy, Inconel and hard to cut materials.
- JCRO coating provides wear resistance improvement as well as avoid edge stress in various applications.
- Strong design for protection against chattering..
- Preventing bottom edge chipping by corner R.
- Minimize fracturing at high feed by high TRS fine WC grade.



D Size	D Tolerance
ø6 ~ 12	-0.005 ~ -0.015 mm
ø16 ~ 20	-0.01 ~ -0.02 mm

4LSUC

Cutting Condition

• RPM : rev./min • Feed : mm/min

Material	Alloy Steels / Tools Steel				Stainless Steels / Titanium Alloy Steels				Hardened Steels			
	SKD61 / NAK				SUS304 / SUS 316 / Ti6A				Inconel 718			
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
ø1	10,000	400	1	1	9,600	310	0.5	1	3,200	80	0.2	1
ø2	10,000	400	2	2	9,600	310	1	2	3,200	80	0.4	2
ø3	6,900	410	3	3	7,400	380	1.5	3	2,700	110	0.6	3
ø4	5,600	490	4	4	5,600	400	2	4	2,000	120	0.8	4
ø5	4,500	630	5	5	4,500	410	2.5	5	1,600	130	1	5
ø6	3,700	740	6	6	3,700	440	3	6	1,300	160	1.2	6
ø7	3,200	700	7	7	3,200	410	3.5	7	1,100	140	1.4	7
ø8	2,800	670	8	8	2,800	390	4	8	1,000	130	1.6	8
ø10	2,200	530	10	10	2,200	350	5	10	800	130	2	10
ø11	2,000	530	11	11	2,000	320	5.5	11	720	120	2.2	11
ø12	1,900	530	12	12	1,900	300	6	12	660	110	2.4	12
ø16	1,400	390	16	16	1,400	280	8	16	500	80	3.2	16
ø20	1,100	350	20	20	1,100	260	10	20	400	60	4	20

Depth of Cut	Alloy Steels / Tools Steel	Stainless Steels / Titanium Alloy Steels	Hardened Steels