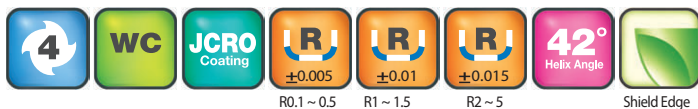


- Endmills for alloy steel, SUS, Ti/Ni base alloy, Inconel and hard to cut materials.
- JCRO coating provides wear resistance improvement as well as avoid edge stress in various applications.
- Strong design for protection against chattering.
- Excellent work surface finish by 4 flute and deep chip pocket.
- Minimize fracturing at high feed by high TRS fine WC grade.



D Size	D Tolerance
Ø1 ~ 5	+0 ~ -0.01 mm
Ø6 ~ 12	-0.005 ~ -0.015 mm
Ø16 ~ 20	-0.01 ~ -0.02 mm

mm

4SUCR

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	13,210	476	0.5	0.8	10,836	399	0.3	0.5	5,820	78	0.1	0.3
Ø2	11,270	691	1.0	1.6	9,391	399	0.6	1.0	4,840	109	0.2	0.6
Ø3	8,054	783	1.5	2.4	7,112	605	0.9	1.5	4,239	155	0.3	0.9
Ø4	5,904	876	2.0	3.2	5,366	688	1.2	2.0	3,230	178	0.4	1.2
Ø5	5,155	1183	2.5	4.0	4,291	716	1.5	2.5	2,522	202	0.5	1.5
Ø6	4,301	1382	3.0	4.8	3,552	716	1.8	3.0	2,115	202	0.6	1.8
Ø8	3,216	998	4.0	6.4	2,683	674	2.4	4.0	1,610	202	0.8	2.4
Ø10	2,573	876	5.0	8.0	2,150	550	3.0	5.0	1,310	171	1.0	3.0
Ø12	2,150	768	6.0	9.6	1,806	550	3.6	6.0	1,106	140	1.2	3.6
Ø16	1,613	722	8.0	12.8	1,342	399	4.8	8.0	805	109	1.6	4.8
Ø20	1,286	538	10.0	16.0	1,075	358	6.0	10.0	601	78	2.0	6.0
Depth of Cut												

- If the effective length is long, reduce the RPM and feed in the same proportion.
- If the diameter or effective length of your tool are not on the table, adjust it compared similarity value on the table.
- Consider the corner radius value when you set up the Ae value.
- 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.
- Use a machine with low vibration and good rigidity (Ø1 or less, the vibration tolerance management should be within 5 µm).
- 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.