



- 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
ø16 ~ 20	-0.01 ~ -0.025 mm

4SURE

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	13760	496	1	1	12600	464	0.5	1	6000	80	0.2	1
ø2	11740	720	2	2	10920	464	1	2	4990	112	0.4	2
ø3	8390	816	3	3	8270	704	1.5	3	4370	160	0.6	3
ø4	6150	912	4	4	6240	800	2	4	3330	184	0.8	4
ø5	5370	1232	5	5	4990	832	2.5	5	2600	208	1	5
ø6	4480	1440	6	6	4130	832	3	6	2180	208	1.2	6
ø8	3350	1040	8	8	3120	784	4	8	1660	208	1.6	8
ø10	2680	912	10	10	2500	640	5	10	1350	176	2	10
ø12	2240	800	12	12	2100	640	6	12	1140	144	2.4	12
ø16	1680	752	16	16	1560	464	8	16	830	112	3.2	16
ø20	1340	561	20	20	1250	416	10	20	620	80	4	20

Depth of Cut	Alloy Steels / Tools Steel	Stainless Steels / Titanium Alloy Steels	Hardened Steels
	≤1D (MAX. 12mm)	≤0.5D	≤0.2D

- 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.
- 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.
- 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.