

- Endmill for various work materials, graphite, hardened steel (HRC~48), pre-hardened steel, tool steel and cast iron.
- Excellent performance with low cutting force by ALTiN coating.
- Long flute length optimized for deep-side wall machining of graphite.
- Applied fine WC grade optimized for various non-ferrous and non-metallic work materials.



D Size	D Tolerance
Ø0.5 ~ 5	+0 ~ -0.01 mm
Ø6 ~ 12	-0.005 ~ -0.015 mm
Ø16 ~ 25	-0.01 ~ -0.02 mm

mm

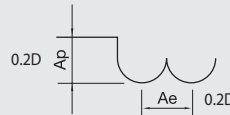
2GBE

Cutting Condition

• RPM: rev./min • Feed: mm/min

Material		흑연 Graphite			
Radius	Effective Length	RPM	FEED	Ap Axial Depth	Ae Radial Depth
R 0.25	5	25,000	320	0.05	0.05
R 0.5	10	21,850	380	0.10	0.10
"	20	19,665	342	0.09	0.09
"	30	18,682	325	0.08	0.08
R 0.75	10	21,850	646	0.15	0.15
"	20	19,665	630	0.14	0.14
"	30	18,682	580	0.11	0.11
R 1	15	19,950	760	0.20	0.20
"	20	17,955	684	0.18	0.18
"	30	16,160	616	0.16	0.16
"	40	13,736	523	0.13	0.13
"	50	10,988	419	0.10	0.10
R 1.5	20	17,575	1,378	0.30	0.30
"	30	15,818	1,240	0.27	0.27
"	40	14,236	1,116	0.24	0.24
"	50	12,100	948	0.22	0.22
R 2	20	15,200	1,995	0.40	0.40
"	35	13,680	1,796	0.36	0.36
"	45	12,312	1,616	0.31	0.31
R 2.5	25	14,725	2,423	0.50	0.50
"	50	11,780	1,938	0.40	0.40
R 3	25	14,250	2,803	0.60	0.60
R 4	30	12,350	2,850	0.80	0.80
R 5	-	10,925	2,898	1.00	1.00
R 6	-	9,975	2,993	1.20	1.20
R 8	-	7,600	2,375	1.60	1.60
R 10	-	6,175	1,900	2.00	2.00

Depth of Cut



- In case of long effective length, reduce the RPM and feed by 20% or less.
- If the effective length of your tool does not show above the table, use the shorten effective length of parameter and reduce the parameters in the same proportion.
- Use this table for your reference. Adjust the parameters depending on your machining geometry, machining purpose and CNC.
- In case of workpiece and machine do not have enough rigidity and make vibration, reduce the RPM and feed in same proportion.