



- 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
Ø1 ~ 5	+0 ~ -0.01 mm
Ø6 ~ 12	-0.005 ~ -0.015 mm

: mm

### 2TGB Cutting Condition

Material		Graphite				
Radius	Effective Length	Angle $\theta$	RPM	FEED	Ap Axial Depth	Ae Radial Depth
R 0.5	20	0°30	18,000	300	0.10	0.10
"	30	0°30	17,100	285	0.10	0.10
"	40	0°30	16,245	271	0.09	0.09
"	25	1°	16,740	279	0.10	0.10
"	35	1°	15,903	265	0.09	0.09
"	50	1°	15,108	252	0.08	0.08
R 0.75	30	0°30	17,000	320	0.15	0.15
"	40	0°30	16,150	304	0.14	0.14
"	50	0°30	15,343	289	0.12	0.12
"	30	1°	15,300	288	0.14	0.14
"	50	1°	14,229	268	0.13	0.13
"	60	1°	13,233	249	0.12	0.12
R 1	40	0°30	16,500	600	0.20	0.20
"	50	0°30	14,850	540	0.19	0.19
"	70	0°30	13,365	486	0.18	0.18
"	60	1°	12,029	437	0.20	0.20
"	90	1°	10,224	372	0.19	0.19
R 2	70	0°30	13,500	1,600	0.40	0.40
"	80	1°	12,825	1,520	0.36	0.36
R 3	100	0°30	11,000	2,200	0.60	0.60
"	100	1°	10,780	2,156	0.59	0.59
R 5	83	0°30	9,600	2,250	1.00	1.00
R 6	110	0°30	7,500	2,300	1.20	1.20

  

Depth of Cut	
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- 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.
- If there is no parameter for the angle of your tool, refer to the previous angle, and adjust compare to it.
- Adjust the value of the feed and Ap based on the effective length and taper angle, and adjust the milling condition.
- 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.