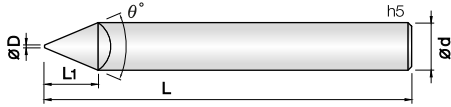
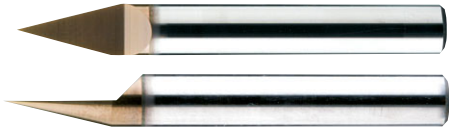




1 Flute Straight Flute Taper End Mills



1

WC

TISIN
Coating

D
+0.05 -0
ø0

D
+0 -0.02
ø0.1 ~ 0.2

0°
Helix Angle

D Size	D Tolerance
ø0	+0.05 ~ -0mm
ø0.1 ~ 0.2	+0 ~ -0.02 mm

1STE / 2STE / 4STE

• RPM: rev./min • Feed: mm/min

Material	S45C ~ S55C		SKD/ SUS/ SCM		NAK/HPM	
	Outside Diameter	RPM	FEED	RPM	FEED	RPM
ø2	5,500	85	4,000	75	3,000	50
ø3	4,000	70	3,000	55	2,000	40
ø4	3,000	60	2,500	45	1,800	35
ø5	2,500	50	2,000	40	1,500	30
ø6	2,000	45	1,600	35	1,200	25
ø7	1,800	40	1,300	30	1,150	25
ø8	1,500	35	1,250	30	900	23
ø9	1,350	35	1,100	30	850	20
ø10	1,200	35	900	25	800	20
ø11	1,100	35	850	25	750	20
ø12	1,000	30	800	25	600	15

Depth of Cut

Ad : 0.05D

- The parameters on the table is based on 2 flutes. To change the number of flutes, refer to the same diameter of other parameter and then adjust it.
- For engrave machining, check the edge of the flutes.
- Use this table for your reference. Adjust the parameters depending on your machining geometry, machining purpose and CNC.

Available Cutting Shape

