



- Endmills for various work materials, hardened steel (HRC ~52), pre-hardened steel, tool steel and cast iron.
- Good wear resistance by Si-based PVD coating.
- High precise edge tolerance.
- Very nice work surface finish.
- Minimize fracturing by high TRS fine(0.5 μm) WC grade.



D Size	D Tolerance
ø0.5 ~ 0.9	+0 ~ -0.01 mm
ø1.4 ~ 5.9	+0 ~ -0.02 mm

2CRC Cutting Condition

• RPM : rev./min • Feed : mm/min

Material	Carbon Steels		Alloy Steels		Hardened Steels	
Hardness					35~ 40HRC	
Outside Diameter	RPM	FEED	RPM	FEED	RPM	FEED
ø 1.9	3,200	60	2,300	50	2,500	40
ø 2.9	2,500	60	1,800	50	1,800	40
ø 3.9	1,850	60	1,400	50	1,400	40
ø 4.9	1,600	60	1,100	50	1,200	40
ø 5.9	1,400	60	900	50	1,000	40

4CRC

• RPM : rev./min • Feed : mm/min

Material	Carbon Steels		Alloy Steels		Hardened Steels	
Hardness					35~ 40HRC	
Outside Diameter	RPM	FEED	RPM	FEED	RPM	FEED
ø 1.9	5,940	1,260	4,950	1,050	3,960	840
ø 2.9	5,280	1,130	4,400	940	3,520	750
ø 3.9	4,700	1,010	3,910	840	3,100	670
ø 4.9	4,200	910	3,400	750	2,800	600
ø 5.9	3,700	820	3,000	670	2,400	540

- When entering the tool to the workpiece, enter the tool from outside to the workpiece.
- Measure after cutting through the R gauge.
- Use this table for your reference. Adjust the parameters depending on your machining geometry, machining purpose and CNC.