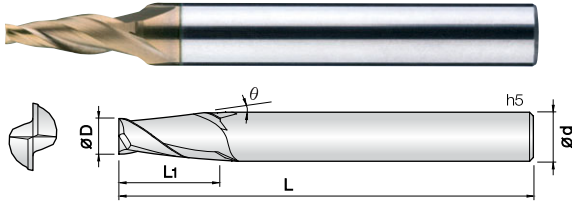


2CTE

2 Flutes Taper End Mills



D Size	D Tolerance
Ø0.3 ~ 4	+0 ~ -0.01 mm
Ø6 ~ 8	-0.01 ~ -0.025 mm



2CTE

• RPM: rev./min • Feed: mm/min

Material	Mild Steels / Carbon Steels SS400 / S55C		Alloy Steels / Tool Steels SCM / SKT / SKS / SKD		Hardened Steels / Prehardened Steels SKT / SKD / NAK55 / HPM1		Hardened Steels / Stainless Steels SUS304 / SKD		Hardened Steels	
	Hardness ~750HN/mm ²		~30HRC		30 ~ 38HRC		38 ~ 45HRC		45 ~ 55HRC	
Outside Diameter	RPM	FEED	RPM	FEED	RPM	FEED	RPM	FEED	RPM	FEED
1mm	15,500	155	15,500	130	13,000	90	12,000	90	10,500	40
1.5mm	10,500	155	10,500	130	8,900	90	8,250	90	7,000	40
2mm	7,950	155	7,950	130	6,650	90	6,200	90	5,250	40
2.5mm	6,200	145	6,200	125	5,300	90	4,950	90	4,200	40
3mm	5,150	145	5,150	125	4,450	90	4,100	90	3,500	40
4mm	3,850	145	3,850	125	3,300	90	3,100	85	2,600	40
5mm	3,100	145	3,100	125	2,650	90	2,450	85	2,100	40
6mm	2,600	145	2,600	125	2,200	90	2,050	85	1,750	40
8mm	1,950	145	1,950	125	1,650	90	1,550	85	1,300	40
10mm	1,550	145	1,550	120	1,300	90	1,200	85	1,050	40

Ap	Ae
2.5D	0.02D

- 2CTE and 4CTE type can be used the same depth of cut.
- Consider the RPM and feed based on the taper angle and adjust it with milling condition.
- Using shrink-fit chuck is recommended.
- 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
- Air blow or mist coolants are recommended and note for chip emission, heat, or ignition.