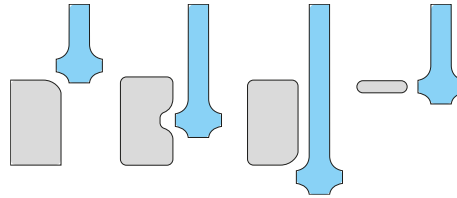


No flutes - in the bottom

Endmills for various work materials, hardened steel (HRC ~50), pre-hardened steel, tool steel and cast iron. JCRO coating provides wear resistance improvement as well as avoid edge stress in various applications. Minimize edge chipping by applying straight 3flutes design. Various shapes and length provides optimum efficiency.

Available Cutting Shape



D Size	D Tolerance
$\phi 1.9 \sim 12$	$+0 \sim -0.03$ mm

: mm



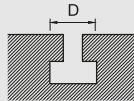
4TES / 4TRS / 3TRC / 4 & 6TDA / 4 & 6TAC

■ Use the same RPM and reduce the feed by 30% for 3TRC.

Slotting

Material	Mild Steels / Carbon Steels		Alloy Steels		Prehardened Steels	
	RPM	FEED	RPM	FEED	RPM	FEED
$\phi 1.5$	3,050	117	1,890	77	1,530	59
$\phi 2$	2,850	110	1,790	72	1,440	55
$\phi 2.5$	2,680	99	1,700	66	1,350	50
$\phi 3$	2,500	92	1,610	60	1,260	45
$\phi 4$	2,150	81	1,430	54	1,080	41
$\phi 5$	1,800	70	1,200	47	900	35
$\phi 6$	1,430	59	950	39	720	30
$\phi 8$	1,070	44	720	30	540	22
$\phi 10$	860	35	580	23	430	17
$\phi 12$	720	30	480	20	360	14

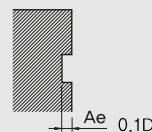
Depth of Cut



Side Cutting

Material	Mild Steels / Carbon Steels		Alloy Steels		Prehardened Steels	
	RPM	FEED	RPM	FEED	RPM	FEED
$\phi 1.5$	3,050	162	1,890	94	1,530	76
$\phi 2$	2,850	149	1,790	88	1,440	70
$\phi 2.5$	2,680	135	1,700	83	1,350	65
$\phi 3$	2,500	122	1,610	79	1,260	59
$\phi 4$	2,150	108	1,430	72	1,080	54
$\phi 5$	1,800	95	1,200	65	900	49
$\phi 6$	1,430	86	950	58	720	43
$\phi 8$	1,070	64	720	43	540	32
$\phi 10$	860	52	580	34	430	26
$\phi 12$	720	43	480	29	360	22

Depth of Cut



- When entering the tool to the workpiece, enter the tool from outside to the workpiece.
- The parameters in the table are based on 4 flutes. For using 3TRC, use the same RPM and reduce the feed by 30%.
- Use this table for your reference. Adjust the parameters depending on your machining geometry, machining purpose and CNC.
- If the table is over the maximum RPM and feed of your machine, or if you find red heat on the material, adjust RPM and feed in the same proportion.
- If a vibration occurs while side milling, reduce the feed.