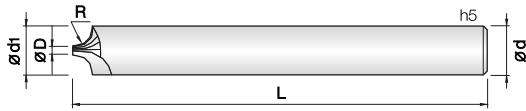


4CRC

4 Flutes Corner Rounding Cutter



D Size	D Tolerance
Ø1.4 ~ 5.9	+0 ~ -0.02 mm

4CRC

• RPM : rev./min • Feed : mm/min

Material	Carbon Steels S54C ~ S55C		Alloy Steels / Tool Steels SKD / SUS / SCM		(35 ~ 45Hrc) Hardened Steels NAK / HPM	
	RPM	FEED	RPM	FEED	RPM	FEED
Outside Diameter						
1.9mm	5,940	1,260	4,950	1,050	3,960	840
2.9mm	5,280	1,130	4,400	940	3,520	750
3.9mm	4,700	1,010	3,910	840	3,100	670
4.9mm	4,200	910	3,400	750	2,800	600
5.9mm	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.