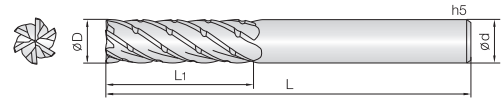


5&6 Flute Trochoidal Chip Splitter End Mills

5&6TROE

- Roughing End Mills for alloy steel, SUS, Inconel, Mild steel and various hard-to-cut materials.
- Chip breaker designed for side flute and TISN-R coating provides wear resistance improvement.
- Variable helix design minimises cutting resistance.
- Minimize fracturing at high feed by high TRS fine WC grade.



D Size	D Tolerance
06 - 12	-0.01 - -0.025mm
016 - 20	-0.015 - -0.03mm

Part Number	D	L1	L2	L	d	z
	6TROE 060 140 060	6	14	-	60	6
6TROE 060 200 065	6	20	-	65	6	6
5TROE 060 260 070	6	26	-	70	6	5
6TROE 060 300 070	6	16	30	70	6	6
6TROE 080 180 065	8	18	-	65	8	6
6TROE 080 260 070	8	26	-	70	8	6
5TROE 080 340 080	8	34	-	80	8	5
6TROE 080 400 080	8	21	40	80	8	6
6TROE 100 220 075	10	22	-	75	10	6
6TROE 100 330 080	10	33	-	80	10	6
5TROE 100 430 090	10	43	-	90	10	5
6TROE 100 500 100	10	26	50	100	10	6
6TROE 120 270 080	12	27	-	80	12	6
6TROE 120 390 095	12	39	-	95	12	6
5TROE 120 510 110	12	51	-	110	12	5
6TROE 120 600 110	12	31	60	110	12	6
6TROE 160 360 100	16	36	-	100	16	6
6TROE 160 520 120	16	52	-	120	16	6
5TROE 160 680 130	16	68	-	130	16	5
6TROE 160 800 130	16	41	80	130	16	6
6TROE 200 450 110	20	45	-	110	20	6
6TROE 200 650 130	20	65	-	130	20	6
5TROE 200 850 150	20	85	-	150	20	5
6TROE 200 900 150	20	51	90	150	20	6

SUS SERIES - END MILLS FOR STAINLESS STEEL & TITANIUM

Cutting Data

5 & 6 TROE

Cutting Condition

• RPM: rev./min • Feed: mm/min

Material	Alloy Steels / Tools Steel				Stainless Steels / Titanium Alloy Steels				Hardened Steels			
	SKD61 / NAK				SUS304 / SUS 316 / Ti6A				Inconel 718			
Outside Diameter	RPM	FEED	Ap Axial Depth	Ae Radial Depth	RPM	FEED	Ap Axial Depth	Ae Radial Depth	RPM	FEED	Ap Axial Depth	Ae Radial Depth
∅6	3,700	450	6	0.3	3,200	380	6	0.3	1,100	65	6	0.3
∅8	2,800	400	8	0.4	2,350	420	8	0.4	950	60	8	0.4
∅10	2,250	325	10	0.5	1,990	350	10	0.5	750	60	10	0.5
∅12	1,990	300	12	0.6	1,550	270	12	0.6	600	55	12	0.6
∅16	1,550	250	16	0.8	1,250	250	16	0.8	500	50	16	0.8
∅20	1,200	180	20	1	900	150	20	1	350	50	20	1

Depth of Cut

- If the effective length is long, reduce the RPM and feed in the same proportion.
- When entering the tool to the workpiece, enter the tool from outside to the workpiece.
- If the diameter or effective length of your tool are not on the table, adjust it compared similarity value on the table.
- Use this table for your reference. Adjust the parameters depending on your machining geometry, machining purpose and CNC.
- 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 proportion.
- Air blow or mist coolants are recommended and note for chip emission, heat, or ignition.