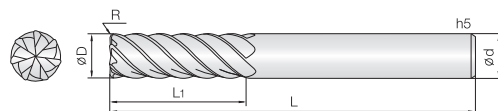


7SUC

7 Flute Non-Symmetry Corner Radius End Mills for SUS

- 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
Ø6 - 12	-0.005 ~ -0.015mm
Ø16 - 20	-0.01 ~ -0.02mm

Part Number	D x R	L1	L	d
	7SUC 060 050 060	6 x R0.5	15	60
7SUC 080 050 070	8 x R0.5	25	70	8
7SUC 100 005 075	10 x R0.5	25	75	10
7SUC 120 005 085	12 x R0.5	30	85	12
7SUC 160 005 100	16 x R0.5	42	100	16
7SUC 200 005 110	20 x R0.5	48	110	20

SUS SERIES - END MILLS FOR STAINLESS STEEL & TITANIUM

Cutting Data

4LSUC

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
ø1	10,000	400	1	1	9,600	310	0.5	1	3,200	80	0.2	1
ø2	10,000	400	2	2	9,600	310	1	2	3,200	80	0.4	2
ø3	6,900	410	3	3	7,400	380	1.5	3	2,700	110	0.6	3
ø4	5,600	490	4	4	5,600	400	2	4	2,000	120	0.8	4
ø5	4,500	630	5	5	4,500	410	2.5	5	1,600	130	1	5
ø6	3,700	740	6	6	3,700	440	3	6	1,300	160	1.2	6
ø7	3,200	700	7	7	3,200	410	3.5	7	1,100	140	1.4	7
ø8	2,800	670	8	8	2,800	390	4	8	1,000	130	1.6	8
ø10	2,200	530	10	10	2,200	350	5	10	800	130	2	10
ø11	2,000	530	11	11	2,000	320	5.5	11	720	120	2.2	11
ø12	1,900	530	12	12	1,900	300	6	12	660	110	2.4	12
ø16	1,400	390	16	16	1,400	280	8	16	500	80	3.2	16
ø20	1,100	350	20	20	1,100	260	10	20	400	60	4	20

Depth of Cut			
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7SUC

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
ø6	4,070	925	6	6	4,070	550	3	6	1,430	200	1.2	6
ø8	3,080	838	8	8	3,080	488	4	8	1,100	163	1.6	8
ø10	2,420	663	10	10	2,420	438	5	10	880	163	2	10
ø12	2,090	663	12	12	2,090	375	6	12	726	138	2.4	12
ø16	1,540	488	16	16	1,540	350	8	16	550	100	3.2	16
ø20	1,210	438	20	20	1,210	325	10	20	440	75	4	20

Depth of Cut			
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- 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.