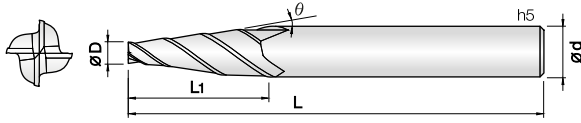


4CTE

4 Flutes Taper End Mills



D Size	D Tolerance
$\phi 0.3 \sim 5$	+0 ~ -0.01 mm
$\phi 6 \sim 8$	-0.01 ~ -0.025 mm

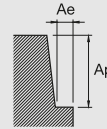
4CTE

• 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	
	RPM	FEED	RPM	FEED	RPM	FEED	RPM	FEED	RPM	FEED
3mm	5,300	225	4,450	225	4,450	180	4,100	130	3,500	130
4mm	3,950	245	3,300	245	3,300	195	3,100	150	2,600	150
5mm	3,150	275	2,650	275	2,650	225	2,450	160	2,100	160
6mm	2,200	275	2,200	275	2,200	225	2,050	175	1,750	175
8mm	1,950	270	1,650	270	1,650	225	1,550	190	1,300	190
10mm	1,550	270	1,300	270	1,300	225	1,200	180	1,050	180

Depth of Cut

Ap	Ae
2.5D	0.02D



- Use a rigid and precise machine and holder.
- When chattering occurs, reduce the speed and feed simultaneously.
- Use a suitable cutting fluid with high smoke retardant properties.